



2022

DIN EN ISO  
9001 certified





**Orbitec-**

Orbitec



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## EVO 200 WP LITE

Industry 4.0.



## EVO Cool-

EVO 200 WP LITE



## EVO Modular WP EVO LITE

4.0



## EVO-

10-

EVO (

1:1).



(  
WP.

) EVO



## TIGTRONIC Orbital 5.4

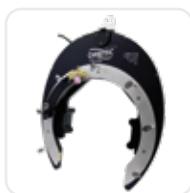
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Tigtronic



## OSK 13 S -

OSK 13 S



## OSW 275

OSW 275

OSW  
88,9–273 / 3,500–10,748"



## Turn 230 S



## RBK 38 S

36,7 (1,445 )



## RBK 60 S

120 (4,724")  
/ AVC

60,5 (2,381"),

99,10 (3,901")



## Oxy EVO bzw. Oxy EVO PPA

Bluetooth

# COMPANY



Orbitec GmbH

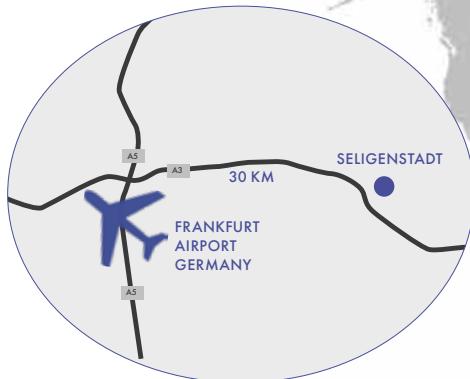
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Orbitec

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Orbitec

Orbitec —  
Industry 4.0

Tigtronic  
2019

1996

EVO

Orbitec  
Orbitec.



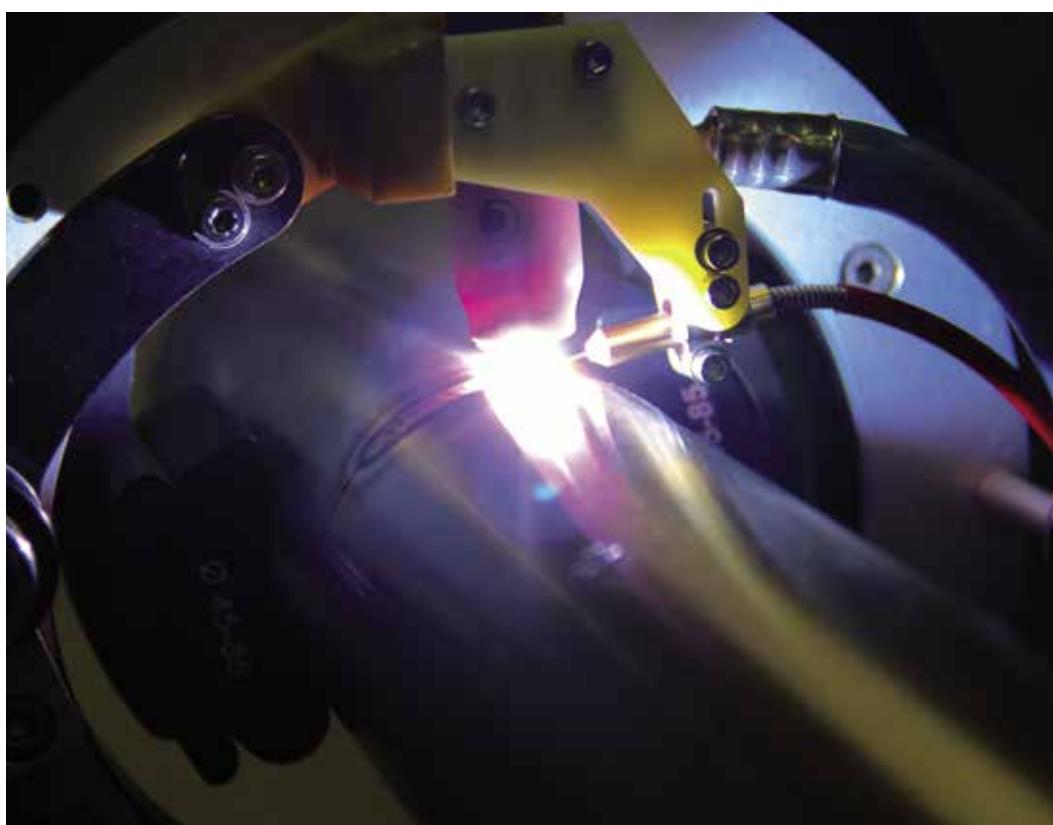
Measuring  
devices

Service /  
general

TIG (=  
TIG,

(        ).

TIG.



: OSW



/





The EVO Industry 4.0 series is new to the market. Several systems, initially compact as the 200 A Autorange and now also modular in connection with the Tetrix inverters.

The systems are small, lightweight and handy and offer a high-resolution colour display, multilingual intuitive user guidance due to a colour touch interface, or alternatively operation using a membrane keyboard, a stable operating system (without data loss during power outages and quickly ready for use again), full access through tablet with QR-code scanner, data transfer via USB, LAN and WLAN, fault analysis program, manufacturer support via remote maintenance, a mountable cooling unit as an option, and many other functions.

Depending on the model, the systems are equipped with different features. Individual features can be added for a surcharge.

The EVO 200 WP, for example, has an analogue Turbo Purge function as standard. When the Turbo Purge function is activated, before and after the welding process the cassette weld head is purged with an increased amount of gas (setting using the analogue knob on the controller and digital display). Shortly before the welding process, the amount of gas is reduced to the amount required for the cassette weld head. This substantially shortens the welding process and achieves better welding results by precisely controlling the amount of gas.

In the case of the optional digital Turbo Purge function available for the EVO WP series, the gas flow is continuously measured and regulated by a gas flow controller. The amount of gas is set digitally on the display and saved in the program for future welding processes.

With the optional available Gas Controller Box, the Turbo Purge function can also be used with the EVO Modular WP.

During periods of high productivity, the cassette weld head can be preserved by activating the permanent gas function to extend the service life of the tungsten electrodes.

	<b>EVO 200 LITE</b>	<b>EVO 200 WP</b>	<b>EVO MODULAR LITE</b>	<b>EVO MODULAR WP</b>
10.1"	•	•	•	•
Robust display transport protection	•	•	•	•
Separate control panel for alternative operation	•	•	•	•
Extremely simple, intuitive user guidance with autoprogramming	•	•	•	•
Graphics-supported multilingual user interface	•	•	•	•
Metric and imperial units	•	•	•	•
Orbital tacking mode activatable			•	•
Integrated wire card			•	•
Analogue Turbo Purge			•	•
Permanent gas function	•	•	•	•
Real-time monitoring of the welding parameters	•	•	•	•
Continuous monitoring of all parameters such as welding speed, arc voltage, welding current, welding time, angle degrees, gas, water, residual oxygen, pressure	•	•	•	•
Rotor stop function for increased safety	•	•	•	•
4 GB flash memory for programs and documentation	•	•	•	•
Integrated thermal printer (longlife paper) with multilingual printing of actual /target parameters		•		•
USB	•	•	•	•
LAN / WLAN		•		•
Integrated help menu in the device	•	•	•	•
Fault analysis program	•	•	•	•
Remote maintenance	•	•	•	•

	EVO 200 LITE	EVO 200 WP	EVO MODULAR LITE	EVO MODULAR WP	Item number
<b>EXTERNAL PC SOFTWARE, ALSO WITH OFFLINE EDITING AND PROGRAMMING, DATA TRANSFER, EXTERNAL QUALITY CONTROL</b>		•		•	1.3.7008
<b>QR CODE SCANNER INCL. SOFTWARE AND QR CODE GENERATOR FOR PC FOR USER LOGIN AND ACCESSING THE WELDING PROGRAMS</b>		•		•	1.3.7009
<b>OPTION OF CONNECTING COMPETITOR WELD HEADS</b>		•		•	1.3.7005
<b>DIGITAL TURBO PURGE</b>		•			1.3.7007
<b>AVC CARD FOR DC MOTORS (TURN)</b>	•	•	•	•	1.3.7003
<b>AVC CARD FOR STEP MOTORS (RBK S) INCL. Y-CABLE</b>	•	•	•	•	1.3.7004
<b>WIRE CARD</b>	•	▲	•		1.3.7006
<b>COOLING UNIT THAT CAN BE MOUNTED AS AN OPTION</b>	•	•	•	•	

▲ = EVO 200 WP STANDARD EQUIPMENT

	<b>EVO 200 WP ORBITAL WELDING SYSTEM (Autorange)</b>	
	Type of current	DC
EVO	Mains voltage	AC 1 x 230 V +/- 15%
	Mains frequency	AC 1 x 115 V +/- 15%
	Max. primary reserve power	50 / 60 Hz
	Rec. generator output	6 kVA
		9 kVA
		5 – 200 A
		25% ED TIG 200 A
		60% ED TIG 150 A
		100% ED TIG 120 A
	(L x W x H):	16.8 kg
		500 x 340 x 360 mm
	<b>EVO COOL</b>	
EVO COOL		EVO
	<b>COOL 50</b>	<b>EVO COOL</b>
	<b>QR CODE</b>	<b>1.3.7009</b>
	EVO	<b>1.3.0035</b>

# ORBITAL WELDING CONTROLLERS

EVO REMOTE



10-  
EVO  
WLAN/LAN  
EVO.  
1:1,  
WLAN/LAN,  
2D-  
QR-



CPU:	10.1" (25.65 cm)
	Intel® Atom™ Intel® Burst Frequency technology
	GPU Intel® HD 400 Graphics
	4 GB RAM, 64 GB eMMC
	WLAN, Bluetooth
	QR-code scanner
	1x USB 2.0, 1x micro USB 2.0, HDMI, audio, docking port
	MIL-STD 810G
	IP65
	8
(LxWxH):	22 x 275.5 x 187.5
	1

Item number

**1.3.7010**

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general





# ORBITAL WELDING CONTROLLERS

**ORBITEC®**

Item number



( , , , , )  
EVO WP.  
TIG, EVO.

:  
1 – 54 / .  
Ar, He, N2, H2 ( )  
6 ,  
0.9  
(L x W x H) 180 x 220 x 100

- -
- 1, 2 3
- EVO WP

1  
2  
3

**1.3.7201**  
**1.3.7202**  
**1.3.7203**

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**to benefit from free software updates and to receive information  
about new products, etc.**

**ONLINE  
REGISTRATION**



# ORBITAL WELDING CONTROLLERS

TIGTRONIC BASIC

**ORBITEC®**

Item number

**TIGTRONIC**  
BASIC 2



The tried-and-tested

## BASIC 2:

- OSK
- OSW
- TURN
- RBK
- (AVC)

## TIGTRONIC BASIC 2 CONTROLLER (Autorange)

Affordable, compact microprocessor-based controller for orbital welding with open tongs, enclosed heads, tube-to-tubesheet weld heads and turn tables. The controller is based on the tried-and-tested, reliable TIGTRONIC ORBITAL controller. Can be connected to TETRIX 200 or TETRIX 351.

1.3.0200

- 5.7" display, fixed
- Extremely simple multilingual user guidance thanks to programming support: Managed input of the tube outer diameter, wall thickness and weld head indicator
- Monitoring of gas and water cooling
- Option of welding in up to SIX sectors, in continuous or step travel mode
- Individual modification of the calculated program parameters, also using current percentage button
- Graphic display of the welding progress
- Real-time monitoring of the welding parameters
- Integrated day counter (assignment to isometries and weld joint numbers)
- Storage of up to 99 welding programs
- Storage of up to 400 actual parameters
- Software updates possible
- Error tracking program
- Option for connecting a remote control  
(The controller can also be operated from the display without a remote control)
- Connection for oxygen analysers
- Data transfer of target / actual parameters and programs over the USB interface
- Compact and lightweight with outer dimensions of (L x W x H)  
340 x 295 x 150 mm and a weight of only 5.5 kg
- Autorange 90 – 260 V

## BASIC 3:

- OSK
- OSW
- TURN
- ORBIFEED
- RBK
- (AVC)



## TIGTRONIC BASIC 3 CONTROLLER (Autorange)

As for BASIC 2

- Also with integrated wire card

1.3.0201

## TIGTRONIC BASIC 4 CONTROLLER (Autorange)

As for BASIC 3

- With special software only for RBK tube-to tubesheet weld heads

1.3.0204

## BASIC 4:

- RBK
- (AVC)



## For BASIC 2/3/4, package includes:

- Controller
- Power cable
- Controller / power source interface cable
- USB stick

# ORBITAL WELDING CONTROLLERS

TIGTRONIC ORBITAL 5.4



## TIGTRONIC ORBITAL 5.4 CONTROLLER (Autorange)

The 5<sup>th</sup> generation of our reliable, tried-and-tested standard controller.  
Can be connected to TETRIX 200 or TETRIX 351.



- OSK
- OSW
- TURN
- ORBIFEED
- RBK
- (AVC)

- 5.7" display
- Extremely simple multilingual user guidance thanks to programming support (entry of tube outer diameter, wall thickness and weld head indicator)
- Monitoring of gas and water cooling
- Orbital tracking mode can be activated
- Option of welding in up to SIX sectors, in continuous or step travel mode
- Individual modification of the calculated program parameters, also using current percentage button
- The current and wire feed parameters can also be changed during welding
- Graphic display of the welding progress
- Real-time monitoring of the welding parameters
- Integrated day counter (assignment to isometries and weld joint numbers)
- Storage of up to 99 welding programs
- Storage of up to 400 actual parameters
- Data transfer of welding parameters and programs via USB interface
- Software updates via USB possible
- Error tracking program
- Option of connecting a remote control (the controller can also be operated from the display without a remote control)
- Connection for oxygen and purge pressure analysers
- Integrated wire card
- Integrated thermo printer (longlife paper) with multilingual printout of actual / target parameters
- Compact and lightweight with outer dimensions of (L x W x H) 405 x 325 x 170 mm and a weight of only 8.3 kg
- Autorange 100 – 240 V

### Optional:

- COOL 50 or EVO COOL cooling unit
- AVC upgrade kit

### Package includes:

- Controller
- Power cable
- Controller / power source interface cable
- USB stick
- 2 pieces tungsten boxes
- Pen with touch screen function and LED light

Item number

**1.3.0054**

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

**1.3.0031**

**AVC UPGRADE KIT FOR TIGTRONIC CONTROLLERS**  
**AVC CARD FOR DC MOTORS UPGRADE KIT (Turn)**  
for Tigtronic controllers

**1.3.0036**

**AVC CARD FOR STEP MOTORS UPGRADE KIT (RBK S)**  
for Tigtronic controllers

Measuring  
devices

Service /  
general



# ORBITAL WELDING CONTROLLERS

## ACCESSORIES



Item number



### DOCUTRONIC 2.2 SOFTWARE FOR DOCUMENTATION

For all Tigtronic controllers for backing up, managing and editing the weld joint documentation (actual / target parameters) at the PC in German and English

1.3.0207



### ORBICONTROL 3 REMOTE CONTROL

8 m cable remote control for all orbital welding controllers.

- Activation and deactivation of the welding process
- Rotary movement control
- Wire feed control
- AVC control
- Visual status display

1.3.0030



### SPARE PAPER ROLLS FOR TIGTRONIC CONTROLLERS

Paper rolls for integrated printer, pack of three

1.3.0002



### SPARE RIBBON CARTRIDGE FOR CONTROLLERS WITH INTEGRATED PRINTER

Ribbon cartridge for TIGTRONIC ORBITAL 4 integrated printer

1.3.0003



# INVERTERS

TETRIX 200, TETRIX 351



Item number



## **TETRIX 200 INVERTER**, control range 5 – 200 A / 230 V

Lightweight and compact inverter power source for TIG manual or orbital welding (automatic detection) in conjunction with all Orbitec controllers.

**Optional:** COOL 50 water cooling unit.

### **Technical data:**

Type of current	DC
Mains voltage	AC 1 x 230 V
Mains frequency	50 / 60 Hz
Max. primary reserve power	4.4 kVA
Rec. generator output	7.5 kVA
Control range	5 A – 200 A
Welding current	
• 25% ED TIG	200 A
• 60% ED TIG	150 A
• 100% ED TIG	120 A
Weight	8.9 kg
Dimensions (L x W x H)	475 x 180 x 295 mm

### **Package includes:**

- Inverter
- Primary cable

## **TETRIX 200 INVERTER (Autorange)**, Control range 5 – 200 A / 110 / 230 V

As TETRIX 200 inverter, but it recognises the 115 V AC or 230 V AC

Input voltage and adjusts automatically.

(Note: With 115 V AC input voltage, the maximum current is 150 A)

**1.2.0119**

Orbital  
welding systems



## **TETRIX 351 INVERTER**, control range 5 – 350 A / 400 V

Mobile inverter power source for TIG manual or orbital welding with integrated cooling unit and gas level monitor. Can be used in conjunction with all Orbitec controllers, particularly with higher welding current and ED demands during tube-in-tubesheet applications.

**1.2.0120**

Welding  
tools

### **Technical data:**

Type of current	DC
Mains voltage	3 x 400 V (-25% – +20%)
Mains frequency	50 / 60 Hz
Max. primary reserve power	15 kVA
Rec. generator output	20.3 kVA
Control range	5 A – 350 A
Welding current	
• 60% ED TIG	350 A
• 100% ED TIG	300 A
Cooling efficiency	1.500 W
Water column	35 m / 5 l / min.
Tank capacity	12 l
Weight	131 kg
Dimensions (L x W x H)	1.100 x 455 x 1.000 mm

**1.2.0117**

Joint  
preparation

### **Package includes:**

- Inverter
- Cooling unit
- Primary cable
- 10 l coolant

Service /  
general



# COOLING UNITS

COOL 50, EVO COOL

**ORBITEC®**

Item number



## COOL 50 WATER COOLING UNIT, 230 V

Water cooling unit for use with the TETRIX 200 inverter and EVO controllers in conjunction with water-cooled welding tools.

### Technical data:

Supply voltage	230 V AC
Cooling system	F / IP 23
Weight	16.5 kg
Dimensions (L x W x H)	610 x 298 x 330 mm
Cooling capacity	1.000 W (1 l/min.)
Max. tank capacity	approx. 4 l
Water column	35 m / 5 l / min.

### Package includes:

- Water cooling unit
- Inverter / cooling unit connection cable
- 5 l coolant

1.2.0118

## COOL 50 WATER COOLING UNIT, 115 V

As for COOL 50 water cooling unit, but for 115 V input voltage.

1.1.0118



## EVO COOL WATER COOLING UNIT (AUTORANGE)

Water cooling unit for use with the EVO 200 WP or LITE controller and TETRIX 200 in conjunction with water-cooled welding tools.

1.3.8000

### Technical data:

Supply voltage	110 – 240 V (1.4 – 0.6A)
Cooling system	F / IP 23
Weight (without coolant)	10.5 kg
Dimensions (L x W x H)	500 x 340 x 190 mm
Cooling efficiency	1.000 W (1 l/min.)
Max. tank capacity	approx. 4 l
Max. flow rate	4 l/min
Max. outlet pressure	3.5 bar
Mains frequency	50 / 60 Hz



EVO Cool mounted on  
EVO 200 WP

- Standalone or continuous operation possible
- Temperature-regulated fan control
- Water flow feedback through in-built flowmeter

### Package includes:

- Water cooling unit
- Inverter / cooling unit (permanently mounted) connection cable
- Fasteners for EVO series
- 4 l blueCool 10i-5 coolant



## blueCool 10i-5 COOLANT

Frost protection down to -10 °C (PU = 5 l canister)

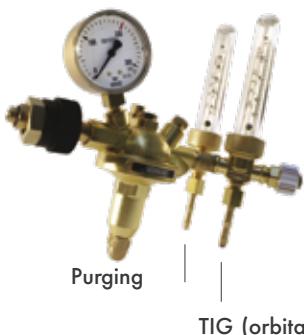
1.1.2501

# ACCESSORIES

PRESSURE REGULATORS, GAS HOSE, GROUND CABLES

**ORBITEC®**

Item number



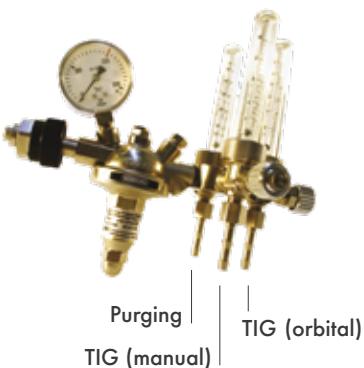
The cylinder pressure regulator with manual connection reduces the cylinder pressure of compressed gases and gases dissolved under pressure of max. 200 bar (300 bar on request) to a pressure corresponding to the flowmeter. The desired flow rate in l/min can be constantly set on the flowmeter.

**Important:** This pressure regulator has a constant working pressure of 2.5 bar to protect the orbital system's gas flow sensor.

Control range:

Twin flow	1 – 15 l/min, 3 – 25 l/min
Triple flow	1 – 15 l/min, 3 – 25 l/min, 5 – 50 l/min

Orbital welding systems



**SPECIAL ARGON PRESSURE REGULATOR** with twin flowmeter, brass

**1.2.0123**

**SPECIAL PRESSURE REGULATOR** with twin flowmeter for H<sub>2</sub> gases, brass

**1.2.0144**

**SPECIAL ARGON PRESSURE REGULATOR** with triple flowmeter, brass

**1.2.0134**

Welding tools



**200 / 10 BAR ARGON PRESSURE REGULATOR**  
(for RBK 60 S pneumatic connection)

**1.2.0150**



**0.5 – 10 BAR COMPRESSED AIR PRESSURE REGULATOR**  
incl. mounting bracket and inlet and outlet coupling  
(for RBK 60 S pneumatic connection)

**1.2.0151**

Pressure regulators with different connections and for other gas types or nickel-plated version available on request.

Joint preparation



**GAS HOSE**, 3 m

**1.3.0121**



**GROUND CABLE**, 5 m, 35 mm<sup>2</sup>, up to 300 A

**1.3.0125**



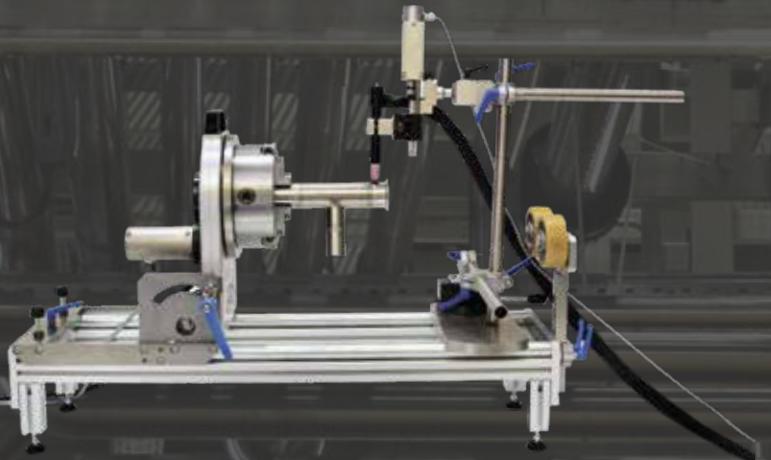
**GROUND CABLE**, 5 m, 50 mm<sup>2</sup>, up to 500 A

**1.3.0146**

Purging accessories

Measuring devices

Service / general



# ORBITAL WELDING TOOLS

Smart, flexible and totally precise



# ENCLOSED WELD HEADS

OSK 13 S

**ORBITEC®**



Due to their design, enclosed weld heads offer complete top layer protection of the weld joint due to continuous weld joint fluting during the welding process with protective gas. This reduces the joints' tempering colours.

A corresponding set of collets is also required for each tube outer diameter due to the design.

The wire cannot be fed cold.

The welds are made in the I-joint with precise joint preparation (90° – saw cut, face if necessary).

Advantage: Enclosed weld heads are comparably narrow and particularly suited to environments where space is tight.



## OSK 13 S MICROFIT WELD HEAD incl. handle and cable assembly, 6 m

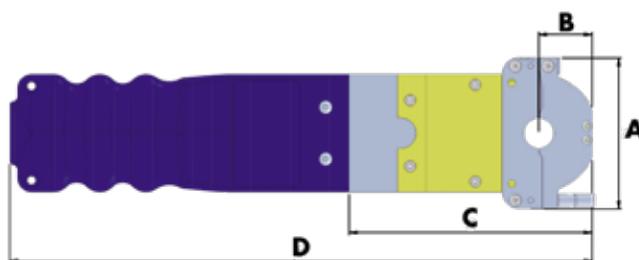
Gas-cooled weld head for applications with extremely narrow space requirements, e.g. in the semiconductor industry. Specially designed to weld micro-fittings too. The design (specific gas flow management) and the material selection enable high thermal capacity, even without water cooling.

- Extremely narrow / compact design.
- The head assembly is arranged in a way that makes it very easy to maintain.
- 6 m handle and cable assembly with practical handle (start/stop button and status display).
- Weld head compatible with 9-500 clamping cassettes from Arc Machines

Weld head:	Tube size range mm	Inch	Weight
OSK 13 S	OD 3.17 – 12.7 mm	0.125" – 0.500"	2.4 kg

1.3.4000

Dimensions table for OSK 13 S enclosed weld heads



Weld head	A		B		C		D		E		F	
	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
OSK 13 S	64	2.520	24.4	0.960	105	4.133	279.2	10.992	12	0.472	6	0.236

## OSK 13 S MICROFIT CLAMPING CASSETTE

For welding where space is extremely tight



- Orbitec TCA clamping cassette, structural width 12 mm (0.472 inch)
- Clamping cassettes compatible with model 9-500 from Arc Machines
- Cassette can be mounted in both directions

1.3.4001+Ø

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general



# ENCLOSED WELD HEADS

OSK 13 S CLAMPING BLOCK FOR MICRO FITTING

**ORBITEC®**

Item number

## **OSK 13 S CLAMPING BLOCK FOR MICRO FITTING**

OSK 13 S clamping blocks for tube-tube connections with the matching collets and for tube-fitting connections.



### **OSK 13 S CONVERSION KIT**

Required for the use using clamping blocks

**1.3.4004**



### **OSK 13 S CLAMPING BLOCKS FOR TUBE-TUBE CONNECTIONS**

incl. setting gauge for tube

**1.3.4005**



### **COLLETS FOR OSK 13 S CLAMPING BLOCK**

(1 set = 4 collets) incl. setting gauge for tungsten

**1.3.4006+Ø**



### **FITTING MOUNTING KIT FOR CLAMPING BLOCK OSK 13 S**

Tube to tube clamping block needed

**1.3.4008+Ø**

# ENCLOSED WELD HEADS

OSK CS/CW, HANDLE AND CABLE ASSEMBLIES



Item number



## OSK CS GAS-COOLED WELD HEADS

Our new generation of two gas-cooled, compact weld heads that have been technically optimised and redesigned, for smaller nominal widths and featuring clamping levers. The heads were also designed for particularly tight space conditions with a narrow handle.



### Weld head:

**OSK 21 CS**

**OSK 38 CS**

### Tube size range mm

OD 3.17 – 21.3 mm

OD 3.17 – 38.1 mm

### inch

0.125" – 0.839"

0.125" – 1.500"

### Weight

0.8 kg

1.3 kg

**1.0.2820**

**1.0.2920**

**1.3.2003**

Orbital  
welding systems



## OSK C HANDLE AND CABLE ASSEMBLY, 8 m

Handle and cable assembly for OSK C and CS, consisting of a handle with control element (start/stop button and status display), weld head interface, motor / gearbox unit and 8 m hose package.

Optional:



## OSK G OR S ADAPTER FLANGE ON C OR CS

### Advantage:

While using this flange, you can also use the OSK C and CS weld heads with the OSK G or S handle and cable assembly.

**1.3.2011**

Welding  
tools



## OSK CW WATER-COOLED WELD HEADS

Our new generation of compact weld heads for high thermal capacities with a water-cooled collet housing and clamping levers.



### Weld head:

**OSK 21 CW**

**OSK 38 CW**

### Tube size range mm

OD 3.17 – 21.3 mm

OD 3.17 – 38.1 mm

### inch

0.125" – 0.839"

0.125" – 1.500"

### Weight

1.0 kg

1.4 kg

**1.0.2820W**

**1.0.2920W**

**1.3.2059**

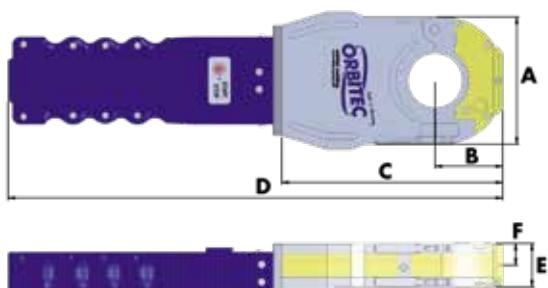
Purging  
accessories



## OSK CW HANDLE AND CABLE ASSEMBLY, 8 m

Consisting of a handle with control element (start/stop button and status display), weld head interface, motor / gearbox unit and 8 m hose package.

## Dimensions table for OSK CS and CW enclosed orbital weld heads



Weld head	A		B		C		D		E		F	
	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
OSK 21 CS	70	2.756	40	1.575	150	5.906	370	14.567	35	1.377	17.5	0.689
OSK 38 CS	102	4.016	54	2.156	177	6.969	396	15.591	35	1.377	17.5	0.689
OSK 21 CW	70	2.756	39.5	1.555	146	5.748	365.5	14.390	35	1.378	17.5	0.689
OSK 38 CW	102	4.016	54	2.156	177	6.969	396	15.591	35	1.378	17.5	0.689

Measuring  
devices

Service /  
general

# ENCLOSED WELD HEADS

OSK S/SW/GW, HANDLE AND CABLE ASSEMBLIES



Item number



## OSK S GAS-COOLED WELD HEADS

Our new generation of THREE gas-cooled weld heads that have been technically optimised and redesigned and have a tube size range of OD 6 – 114.3 mm / 0.250" – 4.500".

Special design features and the material selection enable high thermal capacity, even without water cooling.

The heads are even narrower and have a quick clamp system for the collets.

**Weld head:**

**OSK 53 S**

**OSK 76 S**

**OSK 115 S**

**Tube size range mm**

OD 6 – 53 mm

OD 6 – 76.2 mm

OD 9.53 – 114.3 mm

**inch**

0.250" – 2.087"

0.250" – 3.000"

0.375" – 4.500"

**Weight**

2.1 kg

2.6 kg

3.4 kg

**1.0.2520**

**1.0.2620**

**1.1.2720**

**1.3.2057**

## OSK S HANDLE AND CABLE ASSEMBLY, 8 m

Handle and cable assemblies consisting of a handle with control element (start/stop button and status display), weld head interface, motor / gearbox unit and 8 m hose package.

The OSK G and S handle and cable assemblies and weld heads are compatible with one another!

## OSK SW WATER-COOLED WELD HEADS

Our new generation of three OSK SW weld heads – even narrower, technically optimised and redesigned. For very high thermal capacities, we also offer the gas-cooled S series weld heads in a water-cooled SW version (the structural width stays the same). The closed water cooling system covers the bottom collet housing area.

**Weld head:**

**OSK 53 SW**

**OSK 76 SW**

**OSK 115 SW**

**Tube size range mm**

OD 6 – 53 mm

OD 6 – 76.2 mm

OD 9.53 – 114.3 mm

**inch**

0.250" – 2.087"

0.250" – 3.000"

0.375" – 4.500"

**Weight**

2.1 kg

2.6 kg

3.4 kg

**1.0.2520W**

**1.0.2620W**

**1.1.2720W**

**1.3.2899**

**1.3.2058**

## OSK 170 GW WATER-COOLED WELD HEAD

**OSK 170 GW**

OD 50 – 168.3 mm

1.969" – 6.626"

7.5 kg

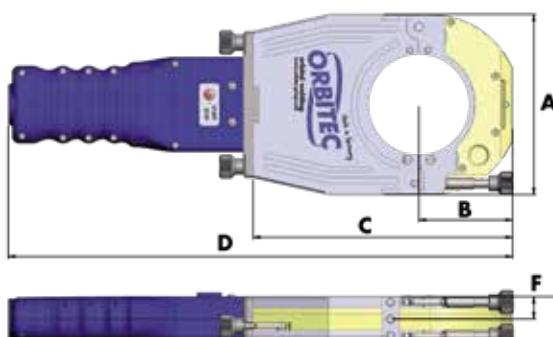
## OSK SW HANDLE AND CABLE ASSEMBLY, 8 m

Handle and cable assemblies consisting of a handle with control element (start/stop button and status display), weld head interface, motor / gearbox unit and 8 m hose package.

The OSK GW and SW handle and cable assemblies and weld heads are compatible with one another!



**Dimensions table for OSK SW and GW enclosed orbital weld heads**



Weld head	A		B		C		D		E		F	
	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
OSK 53 S / SW	130	5.118	70	2.756	205	8.071	425	16.732	40	1.575	20	0.787
OSK 76 S / SW	160	6.299	83	3.268	230	9.055	450	17.717	40	1.575	20	0.787
OSK 115 S / SW	200	7.874	103	4.055	270	10.630	487.5	19.192	40	1.575	20	0.787
OSK 170 GW	270	10.630	132	5.197	343	13.504	563	22.165	44	1.732	22	0.866

# ENCLOSED WELD HEADS

OSK COLLETS, ACCESSORIES



Item number



## OSK COLLETS

Maximum availability

We have a comprehensive range of collets in stock for all OSK heads.

1 set per tube outer diameter = 4 half-shells.

### COLLETS FOR OSK 21

### COLLETS FOR OSK 38

### COLLETS FOR OSK 53

### COLLETS FOR OSK 76

### COLLETS FOR OSK 115

### COLLETS FOR OSK 170 HP

### ADAPTER COLLETS OSK 170 ON OSK 115



All collet Ø in stock can be found in the table on page 66.

Other Ø and collets with a common contact surface are available as custom designs on request.

**HP collets (OSK 53/76/115) for optimising the tempering colours in clean rooms available on request.**



## OFFSET ELECTRODE HOLDERS

(from OSK 53)

The weld head size's maximum tube size range is then reduced.

**OFFSET ELECTRODE HOLDER** for an electrode Ø OF 1.6 mm | 0.063"

1.3.3106

**OFFSET ELECTRODE HOLDER** for an electrode Ø OF 2.4 mm | 0.094"

1.3.3101



## MULTI-POSITION ELECTRODE HOLDER

(from OSK 53)

The weld head size's maximum tube size range is then reduced.

**MULTI-POSITION ELECTRODE HOLDER** for an electrode Ø OF 1.6 mm | 0.063"

1.3.3102

**MULTI-POSITION ELECTRODE HOLDER** for an electrode Ø OF 2.4 mm | 0.094"

1.3.3107



## GAS-SHIELD COLLETS

GAS-shield collets are particularly narrow and have an aluminium base collet and a screw-on gas-shield collet made of heat-resistant GRP material. They are used to weld fittings, flanges and components with short welded hexagon nipples. In conjunction with offset or multi-position electrode holders, the weld can be completed very close to one side of the weld head. A collet set with a common contact surface is recommended for secure fixing. GAS-SHIELD collets are available for OSK 53 / 76 / 115 weld heads (the max. tube size range is limited).



GAS-SHIELD base collets and gas shields (1 set = 2 half-shells)

1.2.3305

1.2.3304

1.2.3303



### GAS-SHIELD BASE COLLET FOR OSK 53

### GAS-SHIELD BASE COLLET FOR OSK 76

### GAS-SHIELD BASE COLLET FOR OSK 115

1.2.3308

1.2.3307

1.2.3306

**Gas-shield COLLET (GRP)** for OSK 53

(adaptation by the customer) for OSK 76

for OSK 115

1.2.3308

1.2.3307

1.2.3306

**Gas-shield COLLET (GRP)** for OSK 53

(prefabricated with through-hole) for OSK 76

for OSK 115

1.2.3309

1.2.3310

1.2.3311

Orbital welding systems

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# OPEN WELD HEADS

OSW

**ORBITEC®**

Item number



Open weld heads are clamped on one side of the weld joint. During welding, the gas- or water-cooled torch with hose package rotates around the tube.

Advantages of open weld heads:

- Robust design
- Extremely easy to use
- Option of using additional wire
- Stepless tube size range
- Torch bracket has 90° tilting function

## OSW WELD HEADS

Five weld heads for the OD 8 – 273 mm tube size range



Weld head:	Tube size range mm	inch	Weight	Item number
<b>OSW 40</b>	OD 8 – 40 mm	0.315" – 1.575"	2 kg	<b>1.3.1001</b>
<b>OSW 80</b>	OD 10 – 76.2 mm	0.394" – 3.000"	3 kg	<b>1.3.1101</b>
<b>OSW 115</b>	OD 20 – 114.3 mm	0.787" – 4.500"	4.5 kg	<b>1.3.1201</b>
<b>OSW 170</b>	OD 40 – 168.3 mm	1.575" – 6.626"	6.5 kg	<b>1.3.1301</b>
<b>OSW 275</b>	OD 88.9 – 273 mm	3.500" – 10.748"	19 kg	<b>1.3.1401</b>

In the case of the OSW 275, the rotor can be decoupled and the tongs can be rotated manually.



### Package includes:

- Weld head
- Integrated start/stop button on the handle
- Top jaw
- OSW torch bracket (with roll scanning in the case of OSW 275)
- Mechanical headway control



### Optional:

**OSW 40 WITH ANGULAR GEARBOX**

**OSW 80 WITH ANGULAR GEARBOX**

**OSW 115 WITH ANGULAR GEARBOX**

**OSW 170 WITH ANGULAR GEARBOX**



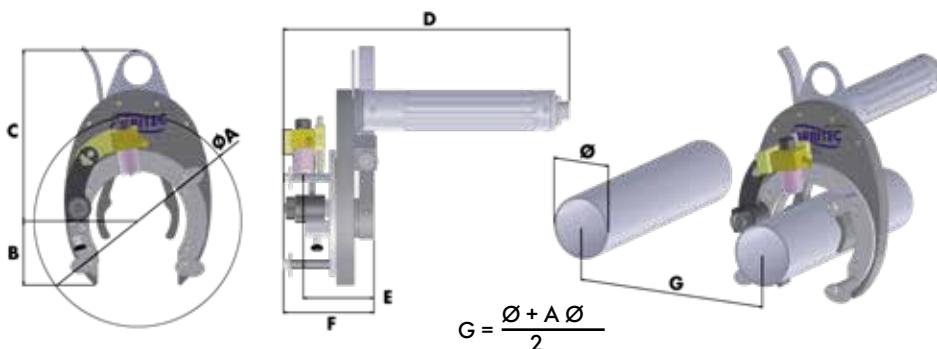
**1.0.1001**

**1.0.1101**

**1.0.1201**

**1.0.1301**

### Dimensions table for OSW open orbital weld heads



Weld head	Ø A		B		C		D		E		F	
	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
OSW 40	120	4.724	40	1.575	145	5.709	310	12.205	81	3.189	91	3.583
OSW 80	210	8.268	64	2.520	171	6.732	290	11.417	69	2.717	91	3.583
OSW 115	243	9.567	90	3.543	210	8.268	290	11.417	69	2.717	91	3.583
OSW 170	310	12.205	134	5.276	266	10.472	290	11.417	69	2.717	91	3.583
OSW 275	465	18.307	180	7.086	410	16.141	310	12.204	105	4.133	125	4.921



# OPEN WELD HEADS

## HOSE PACKAGES



Item number



**BJ INTERCONNECTION CABLE, 8 m**

1.3.1626



**BJ INTERCONNECTION CABLE WITH WIRE OUTLET, 8 m**

1.3.1629



**TIG TORCH WITH HOSE PACKAGE, GAS- OR WATER-COOLED FOR OSW**

1.3.1602

'MINI' TIG TORCH with hose package, 8.5 m, gas-cooled, equipped with torch consumables and tungsten electrode Ø 1.6 mm

1.3.1625

'MINI' TIG TORCH with hose package, 6 m, water-cooled, equipped with torch consumables and tungsten electrode Ø 2.4 mm



'STANDARD' TIG TORCH with BJ hose package, 8.5 m, gas-cooled, equipped with torch consumables and tungsten electrode Ø 2.4 mm

1.3.1631

'STANDARD' TIG TORCH with BJ hose package, 8.5 m, water-cooled, equipped with torch consumables and tungsten electrode Ø 2.4 mm

1.3.1634



**SPARE 2.5 m silicone hose package**, gas-cooled, for OSW 40  
(Special tooling required)

1.1.1615

**SPARE 2.5 m silicone hose package**, gas-cooled, for OSW 80 – 275

1.3.1615



**EXTENSION HOSE PACKAGES FOR OSK / OSW  
TURN AND RBK**

1.3.2005

**EXTENSION HOSE PACKAGE**, 8 m, gas-cooled

1.3.2006

**EXTENSION HOSE PACKAGE**, 8 m, combined gas- and water-cooled

Orbital  
welding systems

Welding  
tools

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accessories

Joint  
preparation

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general



# OPEN WELD HEADS

TORCH BRACKETS, MANUAL TIG HOSE PACKAGE



Item number

## TIG TORCH BRACKET (isolator)



'MINI' TORCH BRACKET FOR OSW 40

1.3.1617



'MINI' TORCH BRACKET, CAN BE SCREWED IN 45°, FOR OSW 40

1.3.1609



MULTI-POSITION TORCH BRACKET FOR OSW 80 - 170

1.3.1635



TORCH BRACKET WITH ROLL SCANNING FOR OSW 80 - 275

1.3.1640



HIGH-FLEX MANUAL TIG HOSE PACKAGE, SR 9.8 m, gas-cooled

1.3.1909

- High-flex hose package
- Torch consumables as for OSW
- 5-pin Tuchel plug

Water-cooled version available on request.

# TURN TABLE

TURN 230 S

**ORBITEC®**

Item number

**1.2.1858**



## TURN 230 S TURN TABLE

Turn table, especially suitable for none orbital components with higher quantities and can be connected to all Orbitec controllers.

### Scope of application:

Tube size range: OD 10 – 230 mm | 0.393 – 9.055"  
Max. load in horizontal position: 50 kg

### Technical data:

Chuck: Three-jaw chuck with axis adjustment  
Swivel range: 0 – 90° stepless  
Power transmission: max. 300 A  
Weight: 88 kg  
Dimensions (L x W x H): 1.020 x 360 x 750 mm

### Package includes:

- Turn table
- Three-jaw chuck
- Interchangeable jaws
- Chuck key
- Robust articulated arm with central mechanical clamping
- Ground cable
- Interconnection cable with wire and AVC outlet

### Special versions available on request:

- Pneumatic torch adjustment
- Pneumatic centring and clamping
- Pneumatic tailstock
- Special diameters up to 1.000 mm
- Special lengths and complete workstation equipment available on request
- Special torch consumables

Orbital welding systems

Welding tools

Welding accessories

Joint preparation

Purging accessories

Measuring devices

Service / general



# TURN TABLE

ACCESSORIES, UPGRADE KITS



Item number



**TURN 230 S MACHINE TORCH WITH 4 m hose package**, gas-cooled,  
equipped with torch consumables and tungsten electrode Ø 2.4 mm  
ED: AC: 105 A, DC: 150 A, 60% (10 min.)

1.2.1814

**TURN 230 S MACHINE TORCH WITH 4 m hose package**, water-cooled,  
equipped with torch consumables and tungsten electrode Ø 2.4 mm  
ED: AC: 160 A, DC: 220 A, 100% (10 min.)

1.2.1815

Special lengths and versions with a higher ED available on request.



## MANUAL ADJUSTMENT UNIT FOR TURN 230 S USING CROSS SUPPORT

Slide width 50 mm, torch travel 50 mm, lateral adjustment 30 mm incl. torch clamp  
OD 20 mm incl. mounting flange  
(Special torch clamp OD 30 mm available on request)

1.2.1861



## AVC UNIT ASSEMBLY FOR TURN 230 S

incl. AVC motor with limit switching and 8 m connection cable, slide width 50 mm, torch  
travel 50 mm, lateral adjustment 30 mm incl. torch clamp OD 20 mm incl. mounting flange  
(Special torch clamp OD 30 mm available on request)

1.2.1859



## WIRE CONSOLE FOR TURN 230 S

incl. wire outlet nozzle and three nozzle tips for 0.8 / 1.0 / 1.2 mm

1.2.1852



## COMFORT WIRE FEED CONSOLE FOR TURN 230 S

(3D adjustable via linear unit)

1.2.1869



## TUBE SUPPORT FOR TURN 230 S

1.2.1860

# WIRE FEED UNITS

ORBIFEED



**ORBITEC®**

Item number

## ORBIFEED WIRE FEED UNITS

Compact and lightweight wire feed units in a Peli case for 5 kg or 15 kg standard spools.



### ORBIFEED 5 WIRE FEED UNIT, for 5 kg spools

1.3.1701

### ORBIFEED 15 WIRE FEED UNIT, for 15 kg spools

1.3.1702

#### Technical data:

Motor voltage / power  
Weight  
Dimensions (L x W x H)  
Wire spools  
Wire diameter

#### ORBIFEED 5

24 V DC, 6 W  
approx. 7 kg  
406 x 330 x 174 mm  
Standard spools 5 kg  
0.8 / 1.0 mm

#### ORBIFEED 15

24 V DC, 6 W  
approx. 8 kg  
525 x 436 x 217 mm  
Standard spools 5 & 15 kg  
0.8 / 1.0 mm

Orbital welding systems

Welding tools

Welding accessories

Joint preparation

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Measuring devices

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#### Package includes:

- Water-resistant and dust-proof Peli case
- Four-roller drive mechanism
- Delivery hose with inlet and outlet nozzles
- Spool adapter
- Wire feed console on OSW / TURN
- Wire feed unit / controller connection cable

### SPARE DELIVERY HOSE FOR ORBIFEED, COMPLETE, 4.5 m

1.3.1706



### SPARE WIRE FEED SPIRAL, RED, 4.5 m

1.3.1719



### SPARE TEFILON WIRE CORE FOR ORBIFEED, 4.7 m

1.3.1712



### SPARE WIRE INLET NOZZLE

1.3.1704



SPARE WIRE OUTLET NOZZLE (WIRE Ø 0.8 mm)  
SPARE WIRE OUTLET NOZZLE (WIRE Ø 1.0 mm)

1.3.1720

1.3.1705

### WIRE FEED CONSOLES,

cpl., can be mounted on TIG OSW torch



### OSW 40 WIRE FEED CONSOLE

1.3.1710

### 'STANDARD' OSW 80 - 275 WIRE FEED CONSOLE

1.3.1708

### OSW 80 - 275 WIRE FEED CONSOLE, INTERNAL

1.3.1709

### OSW 80 - 275 WIRE FEED CONSOLE, COMFORT

1.3.1725

(3D adjustable through linear guide units)

### SPARE OSW 40 GRP WIRE HOLDER

1.0.1619

### SPARE OSW 80 - 275 GRP 'STANDARD' WIRE HOLDER

1.0.1630

### SPARE OSW 80 - 275 GRP WIRE HOLDER, INTERNAL

1.0.1638

### SPARE OSW 40 ALU WIRE HOLDER

1.0.1639

### SPARE OSW 80 - 275 ALU WIRE HOLDER

1.0.1634

# TUBE-TO-TUBESHEET WELD HEADS

RBK 38 S

**ORBITEC®**

Item number

With tube-to-tubesheet weld heads, it is possible to achieve consistently high-quality, reproducible welding of tubes to tubesheets, with or without additional wire. The tubes to be welded can be flush with the tubesheet, offset, protruding or behind the tubesheet.

The RBK 38 S and the RBK 60 S are our two new tube-to-tubesheet weld heads.

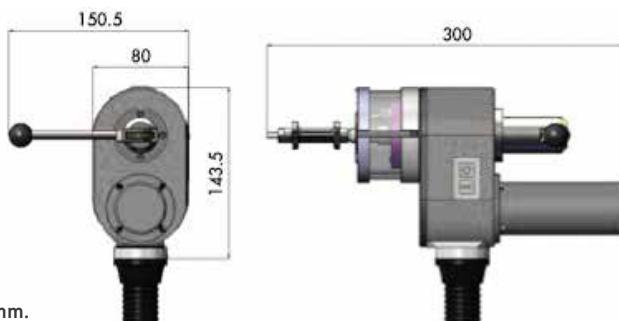
The RBK 38 S is a small, handy water-cooled head for welding tubes to tubesheets up to an ID of 36.7 mm, without additional wire.



**RBK 38 S WELD HEAD** incl. 8 m hose package

1.3.3703

Dimensions table for the RBK 38 S tube-to-tubesheet weld head



Dimensions in mm.

**Technical data:**

Tube size range mm   inch	RBK 38 S
	ID 9.3 – 36.7 mm   0.366" – 1.445"
	(optional from ID 6.0 mm   0.236")
Max. welding current	200 A
Rotation speed	Max. 5 rpm
Centring	mechanical
Weight	5 kg

**Package includes:**

- Weld head
- Water-cooled hose package, 6 m
- Pull bar B
- Gas hood ID 35 mm
- 0° electrode holder
- Transport case



**0° ELECTRODE HOLDER FOR TUNGSTEN Ø 2.4 MM**

1.3.3004

**7° ELECTRODE HOLDER FOR TUNGSTEN Ø 2.4 MM**

1.3.3005

**MULTI-POSITION ELECTRODE HOLDER FOR AN ELECTRODE Ø OF 1.6 MM**

1.3.3703004

**MULTI-POSITION ELECTRODE HOLDER FOR AN ELECTRODE Ø OF 2.4 MM**

1.3.3703003



**GAS HOOD ID 28 MM FOR RBK 38 S**

1.3.3007

**GAS HOOD ID 35 MM FOR RBK 38 S**

1.3.3006

**GAS HOOD ID 48 MM FOR RBK 38 S**

1.3.3008

# TUBE-TO-TUBESHEET WELD HEADS

RBK 38 S, SPRING SLEEVES



Spring sleeve for RBK 38 S

## PULL BAR SET A

Tube size range 9.3 mm – 16.2 mm  
(0.366" – 0.638")

**1.3.3002**



## PULL BAR SET B

Tube size range 16 mm – 36.7 mm  
(0.630" – 1.445")

**1.3.3003**



Tube size range ID	
mm	inch
9.3 – 9.7	0.366 – 0.382
9.8 – 10.2	0.386 – 0.406
10.7 – 11.1	0.421 – 0.437
11.3 – 11.7	0.445 – 0.461
11.8 – 12.2	0.465 – 0.480
12.8 – 13.2	0.504 – 0.520
13.8 – 14.2	0.543 – 0.559
14.0 – 14.4	0.551 – 0.567
14.6 – 15.0	0.574 – 0.591
15.8 – 16.2	0.622 – 0.638
16.0 – 16.4	0.630 – 0.646
16.4 – 16.8	0.646 – 0.661
16.8 – 17.2	0.661 – 0.677
17.2 – 17.6	0.677 – 0.693
17.8 – 18.2	0.701 – 0.717
18.4 – 18.8	0.724 – 0.740
18.8 – 19.2	0.740 – 0.756
19.4 – 19.8	0.764 – 0.780
19.8 – 20.2	0.780 – 0.795
20.4 – 20.8	0.803 – 0.819
20.8 – 21.2	0.819 – 0.834
21.0 – 21.4	0.827 – 0.843
21.3 – 21.7	0.839 – 0.854
21.8 – 22.2	0.858 – 0.874
22.3 – 22.7	0.877 – 0.894
22.8 – 23.2	0.897 – 0.913
23.2 – 23.6	0.913 – 0.929
23.4 – 23.8	0.921 – 0.937
23.6 – 24.0	0.929 – 0.945
23.8 – 24.2	0.937 – 0.952
24.3 – 24.7	0.957 – 0.974
25.4 – 25.8	1.000 – 1.016
25.8 – 26.2	1.016 – 1.031
26.4 – 26.8	1.039 – 1.055
26.8 – 27.2	1.055 – 1.071
27.4 – 27.8	1.079 – 1.094
28.4 – 28.8	1.118 – 1.134
28.8 – 29.2	1.134 – 1.150
29.4 – 29.8	1.157 – 1.173
29.8 – 30.2	1.173 – 1.189
30.4 – 30.8	1.197 – 1.213
30.8 – 31.2	1.213 – 1.228
31.5 – 31.9	1.240 – 1.256
33.8 – 34.2	1.331 – 1.346
34.8 – 35.2	1.370 – 1.386
35.5 – 35.9	1.398 – 1.413
35.8 – 36.2	1.409 – 1.425
36.3 – 36.7	1.429 – 1.445

Gas hood DI 28 mm

Gas hood DI 35 mm

Gas hood DI 48 mm

**ORBITEC®**

Item number

**1.3.370493**

**1.3.370498**

**1.3.3704107**

**1.3.3704113**

**1.3.3704118**

**1.3.3704128**

**1.3.3704138**

**1.3.370414**

**1.3.3704146**

**1.3.3704158**

**1.3.370416**

**1.3.3704164**

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**1.3.3704184**

**1.3.3704188**

**1.3.3704194**

**1.3.3704198**

**1.3.3704204**

**1.3.3704208**

**1.3.370421**

**1.3.3704213**

**1.3.3704218**

**1.3.3704223**

**1.3.3704228**

**1.3.3704232**

**1.3.3704234**

**1.3.3704236**

**1.3.3704238**

**1.3.3704243**

**1.3.3704254**

**1.3.3704258**

**1.3.3704264**

**1.3.3704268**

**1.3.3704274**

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**1.3.3704294**

**1.3.3704298**

**1.3.3704304**

**1.3.3704308**

**1.3.3704315**

**1.3.3704338**

**1.3.3704348**

**1.3.3704355**

**1.3.3704358**

**1.3.3704368**

Orbital  
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# TUBE-TO-TUBESHEET WELD HEADS

RBK 60 S

**ORBITEC®**

Item number

The RBK 60 S is an extremely robust water-cooled weld head for a standard heat exchanger application up to an ID of 60 mm, modified to an ID of 99 mm or 120 mm. The head is pneumatically centred and is available with a rotating wire device and/or arc voltage control (AVC) as an option. The head can also be used with a pneumatic positioner instead of a balancer.



**RBK 60 S WELD HEAD** with pneumatic centring incl. 8 m hose package, water-cooled

**1.3.3702**

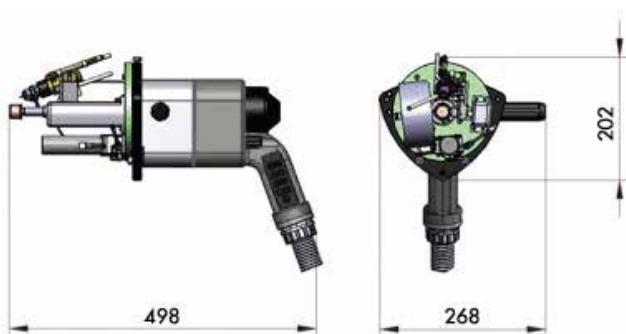
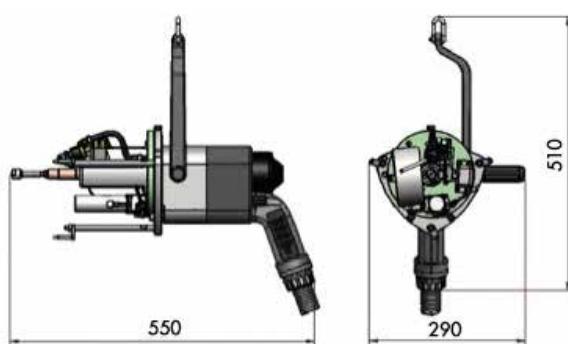
**RBK 60 S WELD HEAD** with pneumatic centring and wire feed unit incl. hose package, 8 m, water-cooled

**1.3.3701**

**RBK 60 S WELD HEAD** with pneumatic centring, wire feed unit and AVC incl. hose package, 8 m, water-cooled

**1.3.3700**

With pneumatic centring



Dimensions in mm.

# TUBE-TO-TUBESHEET WELD HEADS

RBK 60 S, SPRING SLEEVES

With a pneumatic positioner

## Technical data:

Tube size range mm | inch

Max. welding current

Wire motor

Rotation speed

Wire spool

Wire diameter

Weight without wire feed

Weight with wire feed

Weight with wire feed / AVC

Centring

## RBK 60 S

ID 9.5 – 60.5 mm | 0.374" – 2.381"

(optional up to 99.10 mm | 3.901" or 120 mm | 4.724")

200 A

24 V DC

Max. 5 rpm

1 kg, D100

0.8 – 1.2 mm

8 kg

10.5 kg

11 kg

pneumatic

## Package includes:

- Weld head
- Small torch incl. torch consumables and tungsten electrode Ø 2.4 mm
- Water-cooled hose package, 8 m
- Pull bar B
- Transport case

Up to an ID of 30 mm, the spring sleeves are made of steel; in the case of larger diameters, the package also includes four stainless steel jaws.



Spring sleeve for RBK 60 S

Tube size range ID	
mm	inch
9.5 – 10.5	0.374 – 0.413
10.5 – 11.5	0.413 – 0.453
11.5 – 12.5	0.453 – 0.492
12.5 – 13.5	0.492 – 0.531
13.5 – 14.5	0.531 – 0.571
14.5 – 15.5	0.571 – 0.610
15.5 – 16.5	0.610 – 0.650
16.1 – 17.1	0.634 – 0.673
17.2 – 18.2	0.677 – 0.717
18.5 – 19.5	0.728 – 0.768
19.5 – 20.5	0.768 – 0.807
20.5 – 21.5	0.807 – 0.846
21.7 – 22.7	0.854 – 0.894
22.4 – 23.4	0.882 – 0.921
22.7 – 23.7	0.894 – 0.933
23.5 – 24.5	0.925 – 0.965
24.5 – 25.5	0.965 – 1.004
25.5 – 26.5	1.004 – 1.043
26.5 – 27.5	1.043 – 1.083
27.5 – 28.5	1.083 – 1.122
28.5 – 29.5	1.122 – 1.161
29.5 – 30.5	1.161 – 1.201
30.5 – 31.5	1.201 – 1.240
31.5 – 32.5	1.240 – 1.280
32.5 – 33.5	1.280 – 1.319
33.5 – 34.5	1.319 – 1.358
34.5 – 35.5	1.358 – 1.398
35.5 – 36.5	1.398 – 1.437

Item number

**ORBITEC®**

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general

# TUBE-TO-TUBESHEET WELD HEADS

RBK 60 S SPRING SLEEVE, ACCESSORIES

Item number



Spring sleeve for RBK 60 S

## PULL BAR SET A

Tube size range 9.5 mm – 19.5 mm  
(0.374" – 0.768")

**1.3.3065**



## PULL BAR SET B

Tube size range 19.5 mm – 99.1 mm  
(0.768" – 3.902")

**1.3.3069**



36.5 – 37.5	1.437 – 1.476	1.3.3705365
37.5 – 38.5	1.476 – 1.516	1.3.3705375
38.5 – 39.5	1.516 – 1.555	1.3.3705385
39.5 – 40.5	1.555 – 1.594	1.3.3705395
40.5 – 41.5	1.594 – 1.634	1.3.3705405
41.5 – 42.5	1.634 – 1.673	1.3.3705415
42.5 – 43.5	1.673 – 1.713	1.3.3705425
43.5 – 44.5	1.713 – 1.752	1.3.3705435
44.5 – 45.5	1.752 – 1.791	1.3.3705445
45.5 – 46.5	1.791 – 1.831	1.3.3705455
46.5 – 47.5	1.831 – 1.870	1.3.3705465
47.5 – 48.5	1.870 – 1.909	1.3.3705475
48.0 – 49.0	1.890 – 1.929	1.3.370548
49.5 – 50.5	1.949 – 1.988	1.3.3705495
50.5 – 51.5	1.988 – 2.028	1.3.3705505
51.5 – 52.5	2.028 – 2.067	1.3.3705515
52.5 – 53.5	2.067 – 2.106	1.3.3705525
53.5 – 54.5	2.106 – 2.146	1.3.3705535
54.5 – 55.5	2.156 – 2.185	1.3.3705545
55.5 – 56.5	2.185 – 2.224	1.3.3705555
56.5 – 57.5	2.224 – 2.264	1.3.3705565
57.5 – 58.5	2.264 – 2.303	1.3.3705575
58.5 – 59.5	2.303 – 2.343	1.3.3705585
59.5 – 60.5	2.343 – 2.382	1.3.3705595
60.6 – 61.6	2.386 – 2.425	1.3.3705606
61.5 – 62.5	2.421 – 2.461	1.3.3705615
62.5 – 63.5	2.461 – 2.500	1.3.3705625
63.5 – 64.5	2.500 – 2.539	1.3.3705635
64.5 – 65.5	2.539 – 2.579	1.3.3705645
65.5 – 66.5	2.579 – 2.618	1.3.3705655
66.5 – 67.5	2.618 – 2.657	1.3.3705665
67.5 – 68.5	2.657 – 2.697	1.3.3705675
68.5 – 69.5	2.697 – 2.736	1.3.3705685
69.5 – 70.5	2.736 – 2.776	1.3.3705695
70.5 – 71.5	2.776 – 2.815	1.3.3705705
71.5 – 72.5	2.815 – 2.854	1.3.3705715
72.7 – 73.7	2.862 – 2.902	1.3.3705725
73.5 – 74.5	2.894 – 2.933	1.3.3705735
74.5 – 75.5	2.933 – 2.972	1.3.3705745
75.5 – 76.5	2.972 – 3.002	1.3.3705755
76.5 – 77.5	3.012 – 3.051	1.3.3705765
77.5 – 78.5	3.051 – 3.091	1.3.3705775
78.5 – 79.5	3.091 – 3.130	1.3.3705785
79.5 – 80.5	3.130 – 3.169	1.3.3705795
80.5 – 81.5	3.169 – 3.209	1.3.3705805

With extension kit

# TUBE-TO-TUBESHEET WELD HEADS

RBK 60 S SPRING SLEEVE, ACCESSORIES



Item number

81.5 – 82.5	3.209 – 3.248
82.0 – 83.0	3.228 – 3.268
82.5 – 83.5	3.248 – 3.287
84.5 – 85.5	3.327 – 3.366
98.1 – 99.1	3.862 – 3.902

Orbital  
welding systems

1.3.3708



LARGE TORCH FOR RBK 60 S FOR 3.2 MM ELECTRODES

1.3.3707



EXTENSION KIT FOR RBK 60 S FOR AN ID GREATER THAN 60 MM

1.3.3052



TITANIUM DISTRIBUTION NOZZLE SET FOR RBK 60 S

(can only be mounted for large torch)

1.2.3617

1.2.3614

1.1.3615



BALANCER (4,5 – 9 KG)

BALANCER (9 – 15 KG)

BALANCER (15 – 22 KG)

1.3.3001

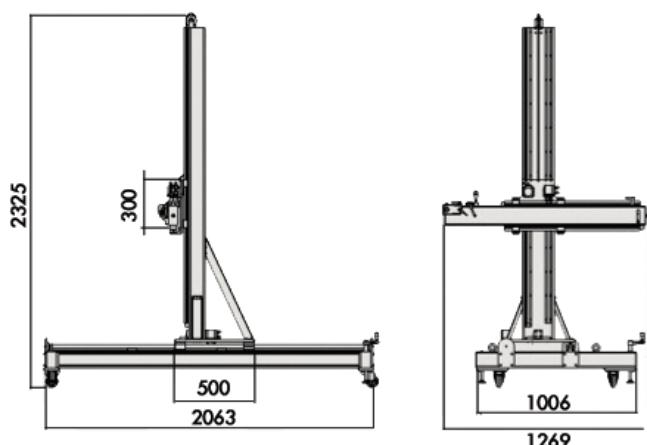


TUBE-TO-TUBESHEET POSITIONER (pneumatic)

With the tube-to-tubesheet positioner, the RBK 60 S can easily be positioned without a balancer and centred pneumatically with the lever on the positioner.

The head is aligned with a matching centring on the tubesheet.

The positioner stands on castors and is fixed in front of the tubesheet with a screw adjustment.



Joint  
preparation

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accessories

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Dimensions in mm.



Centrings for positioner for RBK 60 S available on request.



## WORKSTATION ACCESSORIES

# MOBILE WORKSTATION

MOBILE WORKSTATION

**ORBITEC®**

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.

Dimensions (excluding mounted brackets):

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

Weight: unloaded approx. 70 kg

**1.2.0128**

Orbital  
welding systems

## MOBILE ORBITAL WORKSTATION WITHOUT CYLINDER RACK

**1.2.0146**

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general

## 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**





# WORKSTATION ACCESSORIES

ACCESSORIES

**ORBITEC®**

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



## '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**



## '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**



## OSK 13 S SMALL TOOL KIT

Package includes:

- SIX-piece Allen key set
- Feeler gauge, 13 blade
- Tweezers
- Various screwdrivers
- Case

**1.3.0133**



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

incl. inspection lamp and case

**1.1.4132**

# 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.

<b>Ø</b>	<b>Length</b>	<b>Ø Tip surface</b>	<b>Polished section</b>
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.





# TUNGSTEN GRINDERS

S-TGS\_C AND S-TGS\_CL

**ORBITEC®**

Item number

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
Item number	<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**

# TUNGSTEN GRINDERS

WAG 40.1

**ORBITEC®**



## 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



### 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

1.2.6000

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general



# TORCH CONSUMABLES

OSW, RBK, TURN

**ORBITEC®**

Item number



## TORCH CAPS

- OSW 40 TORCH CAP** for torch, water-cooled
- OSW TORCH CAP**
- TURN TORCH CAP**
- MANUAL TORCH CAP**

**1.0.16155**  
**1.3.1147**  
**1.2.1817**  
**1.3.1910**



## 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**



## TEFLON INSULATORS

- OSW 40 TEFLON INSULATOR**
- OSW 80 - 275 TEFLON INSULATOR**
- TURN TEFLON INSULATOR**, manual torch
- RBK 60 S TEFLON INSULATOR**

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



## 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
- 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**  
**1.3.3079**  
**1.3.3096**



## GAS CUPS

- OSW 40 GAS CUP**
- OSW 80 - 275 GAS CUP, TURN**, size 8
- RBK 60 S GAS CUP**, size 7
- GAS CUP** for manual torch, size 6
- Other gas cups available on request.

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



## 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**



## 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

# JOINT PREPARATION



# TUBE SAWS

ORS, ACCESSORIES

**ORBITEC®**

Item number



## TUBE SAWS

A precise 90° saw cut is absolutely essential to prepare the weld seam in a way that is suitable for orbital welding.

### ORS 115 TUBE SAW, 230 V

1.2.4503

- Low weight
- Perpendicular saw cut
- Two hardened aluminium collets (no reducing collets required)
- Thin-walled tubes are not deformed thanks to concentric clamping
- Also for separating elbows
- Saw blade near the collets for an optimum cut even with small tube Ø
- Cut indication gauge
- Precise scale for adjusting the immersion depth

#### Technical data:

Tube size range mm / inch	OD 5 – 120 mm   0.196" – 4.724"
Wall thickness	0.5 – 5 mm
Electric drive	Single-phase AC motor
Mains voltage	220 / 230 V AC (50 / 60 Hz)
Output	1.100 W / 5.1 A
Protection class	II
Stepless electrical speed control:	20 – 360 rpm
Weight	30 kg



#### Package includes:

- Tube saw with electric drive
- One saw blade
- Tool set
- One bottle of saw blade lubricating oil
- Plastic box with runners (600 x 800 x 600 mm)

### ORS 115 TUBE SAW, 115 V

1.1.4503



### TRIPOD BASE FOR ORS TUBE SAW

1.2.4510

# TUBE SAWS

S-LT, ACCESSORIES

**ORBITEC®**

## TUBE SAWS S-LT

- Robust saws for larger outside diameters and thicker walls
- Powerful drive motor
- Uniform and easy feed control with handwheel
- Different chamfering blades can be mounted
- Perpendicular saw cut
- 5 or 6 clamping jaws made of stainless steel, as well as reducing jaws
- Thin-walled tubes are not deformed thanks to concentric clamping
- Also for separating elbows
- Quick release to change saw blades easily
- Chip removal during cutting with integrated brush
- Convenient adjustment of the plunge depth with adjusting wheel



Technical data	S-150LT	S-200LT
Tube size range mm/inch:	OD 20 -170 mm / 0.787 -6.693"	DA 60 -220 mm / 2.362 -8.661"
Wall thickness:	1 - 8 mm	1 - 8 mm
Electric drive:	Single-phase AC motor	Single-phase AC motor
Main voltage:	200/220 VAC (50/60 Hz)	200/220 VAG (50/60 Hz)
Output:	1000 W / 4.5 A	1000 W / 4.5 A
Protection class:	II	II
Speed control:	6-step control	6-step control
Dimensions:	143 x 466 x 483 mm	145 x 525 x 542 mm
Weight:	66 kg	77 kg
Item number	<b>1.2.4512</b>	<b>1.2.4200</b>

### Package includes:

- Tube saw with electric drive
- One saw blade
- One bottle of saw blade lubricating oil

It is advisable to use standard saw blades for unalloyed and alloyed steels, and premium saw blades for titanium, duplex and Inconel.



**STANDARD SAW BLADE** for wall thicknesses of 1 – 3 mm, Ø 68 mm, 72 teeth, uncoated

**STANDARD SAW BLADE** for wall thicknesses of 2.5 – 7 mm, Ø 68 mm, 44 teeth, uncoated



**PREMIUM SAW BLADE** for wall thicknesses of 1 – 3 mm, Ø 68 mm, 72 teeth, coated

**PREMIUM SAW BLADE** for wall thicknesses of 2.5 – 7 mm, Ø 68 mm, 44 teeth, coated

Chamfering saw blades for 30°, 32°, 35°, 37.5°, 40° and 45° for S-LT tube saws on request.



**SAW BLADE LUBRICATING OIL**, bottle, 250 ml

Item number

**1.3.4520**

**1.3.4521**

**1.3.4522**

**1.3.4523**

**1.3.4525**

Orbital welding systems

Welding tools

Welding accessories

Joint preparation

Purging accessories

Measuring devices

Service / general



Item number

**CUTTING BLOCKS, quick lock system**

- Locking mechanism, tool-free
- For quick and safe clamping during mounting work, without any additional clamping tools
- 90° kerf for separating tubes
- For saw blades measuring up to 1.0 mm thick
- Made of high-quality hardened tool steel

**CUTTING BLOCK, DIN 11850 / ROW 1**

DN	mm	Item number
10	12	1.1.4601
15	18	1.1.4602
20	22	1.1.4603
25	28	1.1.4604
32	34	1.1.4605
40	40	1.1.4606
50	52	1.1.4607
65	70	1.1.4608
80	85	1.1.4609
100	104	1.1.4610
125	129	1.1.4611
150	154	1.1.4612
200	204	1.1.4613

DN	mm	Item number
10	13	1.1.4614
15	19	1.1.4615
20	23	1.1.4616
25	29	1.1.4617
–	30	1.1.4642
32	35	1.1.4618
40	41	1.1.4619
50	53	1.1.4620

inch	Item number
1/4"	1.1.4645
1/2"	1.1.4640
3/8"	1.1.4646
3/4"	1.1.4641
1"	1.1.4621
1 1/4"	1.1.4622
1 1/2"	1.1.4623
2"	1.1.4624
2 1/2"	1.1.4625
3"	1.1.4626
3 1/2"	1.1.4627
4"	1.1.4628
5"	1.1.4649
6"	1.1.4650

mm	Item number
13.5	1.1.4629
17.2	1.1.4630
21.3	1.1.4631
26.9	1.1.4632
33.7	1.1.4633
42.4	1.1.4634
48.3	1.1.4635
60.3	1.1.4636
76.0	1.1.4637
88.9	1.1.4638
114.3	1.1.4639
139.7	1.1.4647
168.3	1.1.4648

**CUTTING BLOCK (INCH)****ISO CUTTING BLOCK**

Other dimensions available on request

# TUBE SQUARING SYSTEMS

PLANFIX 40 S

**ORBITEC®**



## TUBE SQUARING EQUIPMENT

Tube squaring equipment is needed to achieve burr-free and perpendicular joint preparation for orbital welding. That's why Orbitec offers two machines – from the small and handy Planfix 40 S, to the large Planfix 115 S.



## PLANFIX 40 S TUBE SQUARING EQUIPMENT

The Planfix 40 S is a powerful and handy facing device for cordless or mains-powered mobile or stationary use. It has a large inspection window, an indexable insert holder, indexable inserts that can be used on two sides and a feed with 0.1 mm scale graduation. Existing Orbitec planar steels can be used without an indexable insert holder as an alternative. The new indexable inserts are characterised by a long service life and can quickly and reliably machine unalloyed, low-alloyed and high-alloyed steels with high precision.

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general

## Scope of application

Tube size range	OD 3 – 40 mm / 0.386" – 1.575"				
Wall thickness	max. 4 mm				
Technical data	Planfix 40 S 230 V battery	Planfix 40 S 120 V battery	Planfix 40 S 230 V mains	Planfix 40 S 120 V mains	Planfix 40 S (without drive)
Dimensions	275 x 250 x 135 mm	275 x 250 x 135 mm	415 x 200 x 135 mm	415 x 200 x 135 mm	155 x 75 x 135 mm
Weight	3.4 kg	3.4 kg	4.0 kg	4.0 kg	1.45 kg
Drive	Metabo	Metabo	Metabo	Metabo	
Idle speed	0 – 500 / 0 – 1.850 rpm	0 – 500 / 0 – 1.850 rpm	0 – 1,100 / 0 – 3.100 / rpm	0 – 1,100 / 0 – 3.100 / rpm	
Li-ion battery voltage	18 V / 5.2 Ah	18 V / 5.2 Ah			
Charger	ASC 30–36 V Air-cooled	ASC 30–36 V Air-cooled			
Mains voltage	230 – 240 V	115 V	230 – 240 V	110 – 120 V	
Mains frequency	50 – 60 Hz	60 Hz	50 – 60 Hz	50 – 60 Hz	
Max. current	3 A	3 A	5.1 A	10.5 A	

## Package includes

Clamping attachment	•	•	•	•	•
Drive	•	•	•	•	
Two Li-ion batteries	•	•			
Battery charging station	•	•			
Indexable insert holder					
Indexable insert					
Special cutting steel					
Tool kit	•	•	•	•	
Transport case	•	•	•	•	
Item number	1.3.41071	1.3.41072	1.3.41073	1.3.41074	1.3.4107



## PLANFIX 40 S STAND

Item number

1.3.41000

## PLANFIX 40 S COLLETS

1 set per tube outer diameter = 2 half-shells

1.3.4102+Ø

The OSK 38 weld head's collets can also be used.

# TUBE SQUARING SYSTEMS

ORBITEC®

PLANFIX 115 S



## PLANFIX 115 S TUBE SQUARING EQUIPMENT

The Planfix 115 S is a powerful facing and chamfering device with an angular gearbox for mains-powered mobile or stationary use. It has a large inspection window, a chip collector and a feed with 0.1 mm scale graduation.

The equipment can be used with an indexable insert holder for indexable inserts that can be used on two sides or with the familiar Orbitec L planar steels as an option.

### SCOPE OF APPLICATION:

Tube size range mm | inch

OD 9.53 – 114.3 mm | 0.375" – 4.500"

Wall thickness

Max. 4.0 mm

Technical data	Planfix 115 S 230 V mains	Planfix 115 S 120 V mains	Planfix 115 S (without drive)
Dimensions	530 x 315 x 295 mm	530 x 315 x 295 mm	300 x 320 x 300 mm
Weight	15 kg	15 kg	13 kg
Drive	Metabo	Metabo	
Idle speed	0 – 1,100 / 0 – 3.100 / rpm	0 – 1,100 / 0 – 3.100 / rpm	
Mains voltage	230 – 240 V	110 – 120 V	
Mains frequency	50 – 60 Hz	50 – 60 Hz	
Max. current	5.1 A	10.5 A	
Package includes			
Clamping attachment	•	•	•
Drive	•	•	
Indexable insert holder			
Indexable insert			
Special cutting steel			
Tool kit	•	•	
Transport box	•	•	
Item number	1.1.4200	1.2.4200	1.0.4200



## PLANFIX 115 S COLLETS

1 SET per tube outer diameter = 2 half-shells

The OSK 115 weld head's collets can also be used.

Item number

1.3.4007+Ø

# TUBE SQUARING SYSTEMS

PLANFIX ACCESSORIES



Item number



## SPECIAL HSS CUTTING STEEL (WITH TIC COATING)

Special HSS cutting steel for chamfering 30° and 37.5° available on request.

1.2.4114

Orbital  
welding systems



## PLANFIX INDEXABLE INSERT HOLDER

1.2.4105

Welding  
tools



## INDEXABLE INSERT (WITH TIC COATING)

Characterised by a long service life and can quickly and reliably machine unalloyed, low-alloyed and high-alloyed steels with high precision.

1.2.4115

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general



## DEBURRING TOOLS

**SEVEN-PIECE UNIVERSAL DEBURRING TOOL SET**  
OD 3 – 16 mm | 0.118" – 0.630"

**1.2.4125**



## INTERNAL DEBURRER WITH NOZZLE

**1.2.4122**



## TRIANGULAR INTERNAL DEBURRER

**1.2.4123**



## EXTERNAL DEBURRER WITH INSERT

**1.2.4124**



## DEBURRING TOOLS AS A SET IN THE CASE

**1.2.4120**



**'UNIVERSAL' INTERNAL / EXTERNAL DEBURRER,**  
Ø 10 – 54 mm | 0.394" – 2.126"

**1.2.4121**



## FOR CLEANING THE WELD JOINT:

**SUPERFINE ABRASIVE PAD**, roll, 10 m | 393.701", 115 mm wide | 4.528"

**1.1.4125**



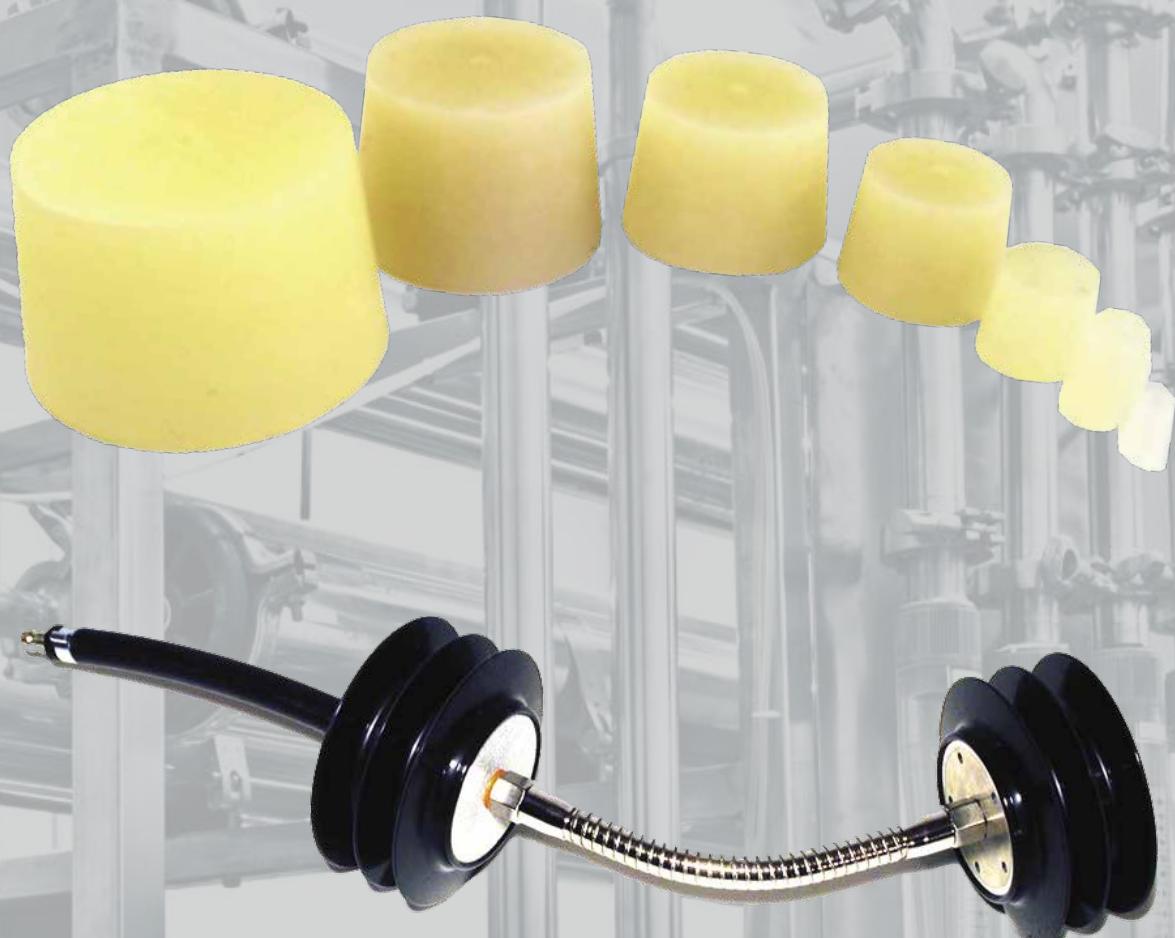
**SC 80 WP POLISHING DISC**, Ø 150 mm | 5.905"

**1.1.4126**



**CLAMP SHAFT FOR POLISHING DISC**

**1.1.4127**



## PURGING ACCESSORIES



# PURGING ACCESSORIES

## PURGE BUNGS



Item number



**PURGE HOSE** with shutoff valve, 8 m

1.3.0126



**SINTERED METAL VENT, 6 X 15 X 48 MM**

(suitable for silicone plugs with 6 mm hole from tube, ID 15 mm)

1.3.0127



**ALUMINIUM ADHESIVE TAPE**, 50 x 0.09 mm, roll measuring 55 m

1.1.4129



**PURGE BUNGS**

Conical

Hole: Ø 6 mm | 0.236"

Material: Silicone, clear

Temperature-resistant up to 250 °C



Purge bungs for ID		
mm	inch	
10.5 – 14.5	0.413 – 0.571	1.3.5510
12.5 – 16.5	0.492 – 0.650	1.3.5512
14.0 – 18.0	0.551 – 0.709	1.3.5514
18.0 – 24.0	0.709 – 0.945	1.3.5518
23.0 – 29.0	0.906 – 1.142	1.3.5523
26.0 – 32.0	1.024 – 1.260	1.3.5526
29.0 – 35.0	1.142 – 1.378	1.3.5529
31.0 – 38.0	1.220 – 1.496	1.3.5531
36.0 – 44.0	1.417 – 1.732	1.3.5536
41.0 – 49.0	1.614 – 1.929	1.3.5541
47.0 – 55.0	1.850 – 2.165	1.3.5547
50.5 – 59.5	1.988 – 2.343	1.3.5550
56.0 – 65.0	2.205 – 2.559	1.3.5556
60.0 – 70.0	2.362 – 2.756	1.3.5560
64.5 – 75.5	2.539 – 2.972	1.3.5564
71.0 – 83.0	2.795 – 3.268	1.3.5571
79.0 – 92.0	3.110 – 3.622	1.3.5579
87.0 – 100.0	3.425 – 3.937	1.3.5587
94.0 – 107.0	3.701 – 4.213	1.3.5594



**PURGE BUNGS SET**

For an ID of 10.5 – 49 mm / 0.413" – 1.929" (10 x 2 bungs) in a case

1.3.5501

**PURGE BUNGS SET**

For an ID of 47 – 107 mm / 1.850" – 4.213" (9 x 2 bungs) in a case

1.3.5502

# PURGING ACCESSORIES

## FLEXIBLE PURGE DAMS



### FLEXIBLE PURGE DAMS

- Saves gas and time
- Heat-resistant up to 340 °C
- Can be used in all positions
- Easy to pull through elbows

**SC Profi, fully mounted with two sealing lips (340 °C), connecting axis and connection hose with a type 21 rectus nipple**

Type	Connection	ID (mm)	ID (inch)
SC Profi Ø 17 mm	80 mm spring connection	13 – 16	0.512" – 0.630"
SC Profi Ø 21 mm		16 – 20	0.630" – 0.787"
SC Profi Ø 24 mm		18 – 23	0.709" – 0.906"
SC Profi Ø 30 mm		23 – 29	0.906" – 1.141"
SC Profi Ø 39 mm		29 – 38	1.141" – 1.496"
SC Profi Ø 45 mm		36 – 43	1.417" – 1.693"
SC Profi Ø 57 mm	120 mm flex connection	42 – 53	1.654" – 2.087"
SC Profi Ø 60 mm		45 – 58	1.772" – 2.283"
SC Profi Ø 70 mm		55 – 67	2.165" – 2.638"
SC Profi Ø 82 mm	150 mm flex connection	68 – 80	2.677" – 3.150"
SC Profi Ø 95 mm		79 – 92	3.110" – 3.622"
SC Profi Ø 117 mm		98 – 114	3.858" – 4.488"
SC Profi Ø 145 mm		120 – 136	4.724" – 5.354"
SC Profi Ø 176 mm		150 – 168	5.905" – 6.614"
SC Profi Ø 182 mm		155 – 170	6.102" – 6.693"
SC Profi Ø 220 mm	250 mm flex connection	190 – 205	7.480" – 8.070"
SC Profi Ø 231 mm		195 – 215	7.677" – 8.464"

### WS PLUS PURGE GAS CYLINDER



Type	ID (mm)	ID (inch)
WS Plus purge gas cylinder, 8" (340 °C)	180 - 215	7.086" – 8.465"
WS Plus purge gas cylinder, 9" (340 °C)	215 - 240	8.465" – 9.449"
WS Plus purge gas cylinder, 10" (340 °C)	240 - 265	9.449" – 10.433"
WS Plus purge gas cylinder, 11" (340 °C)	265 - 290	10.433" – 11.417"
WS Plus purge gas cylinder, 12" (340 °C)	290 - 315	11.417" – 12.402"
WS Plus purge gas cylinder, 13" (340 °C)	315 - 330	12.402" – 12.992"

Other flexible purge dams available on request.



### 10 M PULL ROPE (insulated) with carabiner hook



### FLEXIBLE PURGE DAMS / PURGE HOSE COUPLING

OD 6 mm

Flexible purge dam / OXY measurement connection (from SC Profi Ø 57 mm) available on request.



Item number

**1.1.6017**  
**1.1.6021**  
**1.1.6024**  
**1.1.6030**  
**1.1.6039**  
**1.1.6045**  
**1.1.6057**  
**1.1.6060**  
**1.1.6070**  
**1.1.6082**  
**1.1.6095**  
**1.1.6117**  
**1.1.6145**  
**1.1.6176**  
**1.1.6182**  
**1.1.6220**  
**1.1.6231**

Orbital welding systems

Welding tools

Welding accessories

Joint preparation

Purging accessories

Measuring devices

**1.1.6232**

**1.1.6234**

Service / general

# MEASURING DEVICES

The first step to the perfect weld joint



Proper purging is absolutely essential to guarantee high-quality welding of high-alloyed, corrosion-resistant components.

Our Oxy EVO oxygen analyser can be connected to our orbital welding controllers for the purpose of inspecting and documenting the residual oxygen content and evaluated.

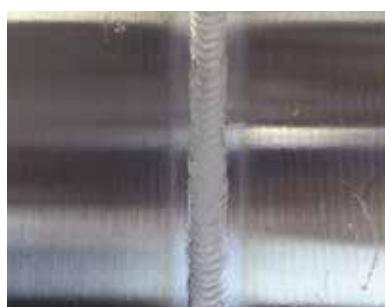
You are free to choose the value in ppm entered in the controller.

Unless specified otherwise, a value < 30 ppm is generally sufficient for starting welding. The controller will not allow welding to commence until the measured value drops below the entered value.

The equipment is calibrated so that it measures with an accuracy of +/- 2 ppm in the welding-related area below 30 ppm in the case of inert gases.

Analysers that display values as percentages are not recommended  
→ 0.1% = 1,000 ppm!

#### Examples of tempering colours:



**7 ppm**  
**0.0007%**



**27 ppm**  
**0.0027%**



**500 ppm**  
**0.05%**

# OXYGEN ANALYSERS

OXY SMART

**ORBITEC®**

Item number

**Oxy-SMART**



## OXY SMART OXYGEN ANALYSER, incl. accessories

- Battery-powered equipment
- For inert gases
- For gases containing H<sub>2</sub> (max. 10%)
- Measuring cell made of zirconium oxide (maintenance-free), long service life thanks to smart software
- Robust for use on construction sites (rubber protective frame)
- Dust- and splash-proof, also for use in high humidity
- Intuitive user guidance due to symbols
- Colour-illuminated display
- Battery charge indicator
- Error message if a fault occurs

**1.2.5004**



## Measuring device technical data:

Measuring range	5 – 999 ppm O <sub>2</sub>
Dimensions (L x W x H)	160 mm x 80 mm x 35 mm
Weight	0.35 kg
Supply voltage	12 V
Charge cable	100 – 240 V with various adapter plugs
Battery life	9 h due to Li-ion technology

## Package includes:

- Oxygen analyser
- Charging cable with adapter plugs for worldwide use
- Hose set, 1 m, incl. filter and probe
- Calibration certificate
- Transport case



**SPARE PLASTIC HOSE for OXY SMART,**  
1 m, with particle filter and stainless steel probe

**1.3.5016**



**SPARE FILTER**

**1.3.5015**

# OXYGEN ANALYSERS AND PURGE PRESSURE ANALYSERS

OXY EVO, OXY EVO PPA



Item number

**Oxy-EVO**



## OXY EVO OXYGEN ANALYSER (Autorange)

- Extremely easy menu navigation
- For inert gases and gases containing H<sub>2</sub> (max. 10%)
- Measuring cell made of zirconium oxide (maintenance-free)
- 3.5" colour touch display
- USB interface for exporting documentation
- Digital and analogue interface and Bluetooth for communication with our orbital welding controllers and other PSPS
- Activation and evaluation exclusively using the digital interface
- User-definable threshold and alarm adjustment
- Acoustic signal generator
- Display has a coloured background outside the target values
- Autorange 100 – 240 V

### Technical data:

Measuring range	5 ppm – 21% O <sub>2</sub>
Ambient temperature	0 – 45 °C
Measuring accuracy	+/- 0.3 mV (EMK sensor)
Heat-up time	3 – 5 min
Response time	approx. 2 seconds for changes
Dimensions (L x W x H)	180 mm x 210 mm x 85 mm without handle
Mains voltage	100 – 240 V AC
Heating cycle load	approx. 40 VA
Standard load	approx. 20 VA
Weight	2.1 kg

### Package includes:

- Oxygen analyser
- Power cable
- Hose set, 3 m, incl. filter and probe
- Calibration certificate
- Transport case



## OXY EVO PPA OXYGEN ANALYSER (Autorange)

The additionally installed purge pressure module can be used to measure the purge gas pressure inside the tube before and during welding. Perfectly flat, repeatable root formations can be achieved by regulating the internal pressure – especially for smaller tube diameters.

Documentation can take place by connecting to the TIGTRONIC ORBITAL, TIGTRONIC COMPACT and EVO controllers. Current values can also be saved on a USB stick following a previously defined interval.

### Technical data (in addition to OXY EVO):

Input voltage	24 V (POWER supplied by Oxy EVO)
Calibrated measuring range	0 – 2,500 Pa

### Package includes (in addition to OXY EVO):

- In-built purge pressure module
- 3 m measuring hose
- 6 mm T-piece
- Calibration certificate (pressure)



Orbital  
welding systems

Welding  
tools

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Service /  
general

1.2.5000

1.2.5003

1.3.5035



### PPA COM CABLE FOR OXY EVO

for connecting to TIGTRONIC ORBITAL and EVO, 3 m

# PURGE PRESSURE ANALYSER

ACCESSORIES, PPA 2500



Item number



## EVO COM CABLE FOR COMMUNICATION AND DOCUMENTATION

**COM CABLE** for EVO for connecting to TIGTRONIC BASIC 2 – 4 controllers

**1.3.5009**

**COM CABLE** for EVO for connecting to TIGTRONIC ORBITAL 4 and EVO controllers

**1.3.5011**



**USB DATA CABLE** for OXY EVO for connecting to EVO and PC controllers, 2 m

**1.2.5008**



**SPARE PLASTIC HOSE** for OXY EVO, 3 m, with particle filter and stainless steel probe

**1.3.5014**



## SPARE FILTER

**1.3.5015**



## PPA 2500 PURGE PRESSURE ANALYSER

The PPA 2500 purge pressure analyser can measure the purge gas pressure inside the tube before and during welding. Perfectly flat, repeatable root formations can be achieved by regulating the internal pressure – especially for smaller tube diameters. Documentation can take place by connecting to the TIGTRONIC ORBITAL and EVO controllers.

**1.3.5200**

### Technical data:

Input voltage	24 V (using the controller)
Calibrated measuring range	0 – 2.500 Pa
Weight	0.6 kg
Dimensions (L x W x H)	41 mm x 80 mm x 160 mm

### Package includes:

- Purge pressure analyser
- Measuring hose
- 6 mm T-piece
- Calibration certificate
- Transport case

# SERVICE



Service

## RENTAL SERVICE – USING INSTEAD OF INVESTING

You can rent all the equipment from our extensive rental stock as needed and at an affordable price.

### The advantages of hiring:

- Equipment capacity that suits your current needs
- Fixed prices per usage period
- Reliable basis for calculating costs
- No investment risk
- High availability to suit changing requirements

### Your business card on the construction site: The orbital workstation

We provide a mobile workstation free of charge when you hire a complete system.



We send complete systems with mobile workstations in special containers.



### Purchase option: How you benefit

If you decide to buy the system within four weeks of the rental period ending, we will deduct the rental costs from the purchase price within 30 calendar days.



### REPAIR AND MAINTENANCE

It goes without saying that we offer a quick and reliable repair and maintenance service. Our comprehensive rental service helps to bridge equipment downtimes.



### HIRE PURCHASE / LEASING

- We'd be delighted to send you ...
- a hire purchase quotation for instalments payable over 3, 6 or 12 months
  - a leasing quote through our leasing partners.

### MEDIATION FOR CONTRACT WORK

We are delighted to act as mediators for our customers (who have suitable orbital welding equipment and qualified staff) with respect to contract work.

# GENERAL TERMS AND CONDITIONS OF WARRANTY



A warranty period of 24 months in one-shift operation is provided with Orbitec equipment. However, batteries, measuring cells, gas level monitors and consumables are not covered by the warranty. The warranty period commences at the time of transfer (in the case of shipment, it commences when the goods leave our factory). During this period, Orbitec guarantees all products against material and manufacturing defects:

- Investigation of any faults free of charge
- Replacement of any defective parts (excluding consumable parts) free of charge
- Professional repair service free of charge
- For the above to apply, the defects must not be caused by improper handling or use, and only genuine Orbitec accessories must be used.



All work covered by the warranty will be performed at Orbitec's head office in Seligenstadt / Germany. This means that the customer must cover all costs incurred in transporting the goods to and from Seligenstadt.

The warranty shall be rendered void if someone not authorised by Orbitec has opened or tampered with the equipment.

This information shall apply without prejudice to the statutory warranty claims and based on our General Terms and Conditions of Business.

# TABLE

TUBE OUTER DIAMETER



Nominal width DN	DIN DIN 11850	ISO EN ISO 1127	inch ASME	OD (mm)	OD (inch)
				3.17	0.125
				6.00	0.236
			1/4"	6.35	0.250
6				8.00	0.315
			3/8"	9.53	0.375
8				10.00	0.394
		10.2		10.20	0.402
				12.00	0.472
			1/2"	12.70	0.500
10				13.00	0.512
8		13.5		13.50	0.531
				15.88	0.625
				16.00	0.630
10		17.2		17.20	0.677
				18.00	0.709
15				19.00	0.748
			3/4"	19.05	0.750
				20.00	0.787
15		21.3		21.30	0.839
				22.00	0.866
		20		23.00	0.906
			1"	25.40	1.000
20		26.9		26.90	1.059
				28.00	1.102
		25		29.00	1.142
				30.00	1.181
25		33.7		33.70	1.327
		32		35.00	1.378
			1 1/2"	38.10	1.500
				40.00	1.575
		40		41.00	1.614
32		42.4		42.40	1.669
				44.50	1.752
40		48.3		48.30	1.902
			2"	50.80	2.000
				51.00	2.008
				52.00	2.047
		50		53.00	2.087
				54.00	2.126
50		60.3		60.30	2.374
			2 1/2"	63.50	2.500
		65		70.00	2.756
65		76.1		76.10	2.996
			3"	76.20	3.000
		80		85.00	3.346
80		88.9		88.90	3.500
			4"	101.60	4.000
		100		104.00	4.094
				108.00	4.252
100		114.3		114.30	4.500
			5"	127.00	5.000
		125		129.00	5.079
125		139.7		139.70	5.500
			6"	152.40	6.000
		150		154.00	6.063
				165.10	6.500
150		168.3		168.30	6.626
				177.80	7.000
				190.50	7.500
		200		204.00	8.031
200		219.1	8"	219.10	8.626
250		273	10"	273.00	10.748

Collets in stock for OSK weld heads:

Special dimensions available on request

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general



Made in Germany

# ORBITEC®

**orbital welding**

[www.orbitec-group.com](http://www.orbitec-group.com)



DIN EN ISO  
9001 certified

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**YOUR LOCAL REPRESENTATIVE:**

