













## Collets

Torch	Part Number	Size	
		in.	mm
<b>HW-20, HW-9, HW-25</b> 	13N20	.020	0.5
	13N21	.040	1.0
	13N22	1/16	1.6
	13N23	3/32	2.4
	13N24	1/8	3.2
<b>HW-17, HW-18, HW-26</b> 	10N21	.020	0.5
	10N22	.040	1.0
	10N23	1/16	1.6
	10N24	3/32	2.4
	10N25	1/8	3.2
	54N20	5/32	4.0
	<b>HW-24</b> Standard  Gas Lens 	53N15	.020
53N16		.040	1.0
53N14		1/16	1.6
53N62		.020	0.5
53N63		.040	1.0
53N64		1/16	1.6
<b>HW-90</b> 	84Z35	.040	1.0
	84Z33	1/16	1.6
<b>HW-27</b> 	57N45	.040	1.0
	57N46	1/16	1.6
	57N47	3/32	2.4
	57N48	1/8	3.2
	57N49	5/32	4.0
	57N50	3/16	4.8
	57N51	1/4	6.4

## Large Diameter Gas Lens Collet Bodies




Torch	Part Number	Size	
		in.	mm
<b>HW-17, HW-18, HW-26</b> 	45V64	3/32	2.4
	995795	1/8	3.2
	45V63	5/32	4.0

## Collet Bodies

Torch	Part Number	Size		
		in.	mm	
<b>HW-20, HW-9, HW-25</b> 	13N25	.020	0.5	
	13N26	.040	1.0	
	13N27	1/16	1.6	
	13N28	3/32	2.4	
	13N29	1/8	3.2	
	<b>HW-17, HW-18, HW-26</b> 	10N29	.020	0.5
10N30		.040	1.0	
10N31		1/16	1.6	
10N32		3/32	2.4	
10N28		1/8	3.2	
406488		5/32	4.0	
<b>HW-24 Standard<sup>1</sup></b> 		53N17	.020	0.5
		53N18	.040	1.0
	53N19	1/16	1.6	
<b>HW-90</b> 	105Z27	All Sizes		
<b>HW-27</b> 	49V24	3/32	2.4	
	49V25	1/8	3.2	
	49V26	5/32	4.0	
	49V27	3/16	4.8	
	49V28	1/4	6.4	

<sup>1</sup>Order wrench #53N20 for HW-24 collect body.

## Gas Lens Collet Bodies

Torch	Part Number	Size	
		in.	mm
<b>HW-20, HW-9, HW-25</b> 	45V41	.020	0.5
	45V42	.040	1.0
	45V43	1/16	1.6
	45V44	3/32	2.4
	45V45	1/8	3.2
<b>HW-17, HW-18, HW-26</b> 	45V29	.020	0.5
	45V24	.040	1.0
	45V25	1/16	1.6
	45V26	3/32	2.4
	45V27	1/8	3.2
	45V28	5/32	4.0
	<b>HW-90<sup>2</sup>, HW-24<sup>2</sup></b> 	45V41	.020
45V42		.040	1.0
45V43		1/16	1.6

<sup>1</sup>Requires adaptor #45V52/insulator #53N85. <sup>2</sup>Requires Insulator #53N66.

# Genuine Heliarc® Accessories



## Gas Lens

To meet increasingly stringent weld quality standards, we developed the patented GENUINE HELIARC Gas Lens. This stack of concentric, fine-mesh stainless steel screens produces an exceptionally stable stream of shielding gas (see Figure 1). By forcing the gas into a coherent stream, an effective shielding pattern can be projected greater distances (see Figure 2).

Welding is possible at nozzle distances up to 1 in. from the plate surface, allowing greater welder visibility and access to tight joints.

Extending the electrode from the gas cup also increases the current capacity of some torch models. For example, a gas lens increases the 100 percent duty rating of our popular Heliarc HW-18 torch from 300 to 375A.

## Patented Genuine Heliarc Gas Lens

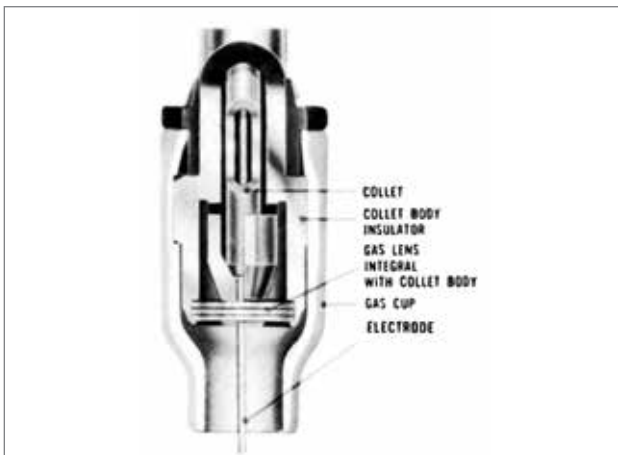


FIG. 1

## Conventional Torch

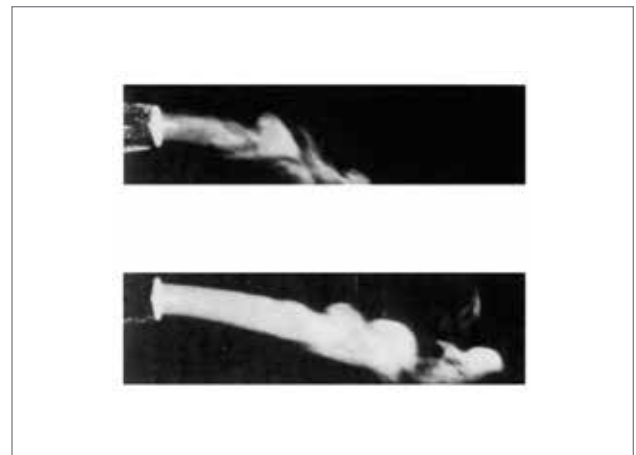


FIG. 2







## High Impact Cups



Made from high strength alumina, these high-impact cups have very good electrical insulating properties and exceptionally high impact resistance, heat resistance,

thermal conductivity and spatter build-up resistance. They are recommended for most welding operations except for use in confined areas.


### Standard High-Impact Cups

Torch	Length, in.	Part Number	Size	Orifice	
				in.	mm
 HW-90	1-5/16	14N65	4	1/4	6.4
		14N66	5	5/16	8
		14N67	6	3/8	10
 HW-17, HW-18, HW-26	1-27/32	10N50	4	1/4	6.4
		10N49	5	5/16	8
		10N48	6	3/8	10
		10N47	7	7/16	11
		10N46	8	1/2	12.5
		10N45	10	5/8	16
 HW-20, HW-9, HW-25	1-5/32	13N08	4	1/4	6.4
		13N09	5	5/16	8
		13N10	6	3/8	10
		13N11	7	7/16	11
		13N12	8	1/2	12.5
 HW-27	1-27/32	57N75	6	3/8	10
		57N74	8	1/2	12.5
		53N88	10	5/8	16
		53N87	12	3/4	19
	1-5/16	53N89	15	15/16	24

### Gas Lens High-Impact Cups

Torch	Length, in.	Part Number	Size	Orifice	
				in.	mm
 HW-17, HW-18, HW-26	1-5/8	54N18	4	1/4	6.4
		54N17	5	5/16	8
		54N16	6	3/8	10
		54N15	7	7/16	11
	1-1/8	54N14	8	1/2	12.5
 HW-90, HW-20, HW-24, HW-9, HW-25	1	54N19	Short	11/16	17
		53N58	4	1/4	6.4
		53N59	5	5/16	8
		53N60	6	3/8	10
		53N61	7	7/16	11
		53N61S	8	1/2	12.7


### Large Diameter Gas Lens High-Impact Cups

Torch	Length, in.	Part Number	Size	Orifice	
				in.	mm
 HW-17, HW-18, HW-26	1-7/8	57N75	6	3/8	10
		57N74	8	1/2	12.5
		53N88	10	5/8	16
		53N87	12	3/4	19
	1-5/16	53N89	Short	15/16	24



## Ceramic Cups

Made from Grade "A" lava materials are less impact and heat resistant than the high-impact cups, but can be expected to give very good service and long life. They perform very well in confined areas where excessive heat is reflected back into the nozzle. These cups can be used at currents up to 250A DC or AC, depending on arc time and cup size.

### Ceramic Cups

Torch	Length, in.	Part Number	Size	Orifice	
				in.	mm
 HW-24	5/8	53N23	.165	.165	4
		53N24	4	1/4	6.4
		53N25	5	5/16	8
		53N27	6	3/8	10

### Special Ceramic Long Cups

Torch	Length, in.	Part Number	Size	Orifice	
				in.	mm
 HW-20, HW-9, HW-25	1-7/8	796F70	3L	3/16	4.8
		796F71	4L	1/4	6.4
		796F72	5L	5/16	8
		796F73	6L	3/8	10
 HW-20 (X-Long), HW-9, HW-25	2-1/2	796F74	3XL	3/16	4.8
		796F75	4XL	1/4	6.4

# Genuine Heliarc® Accessories

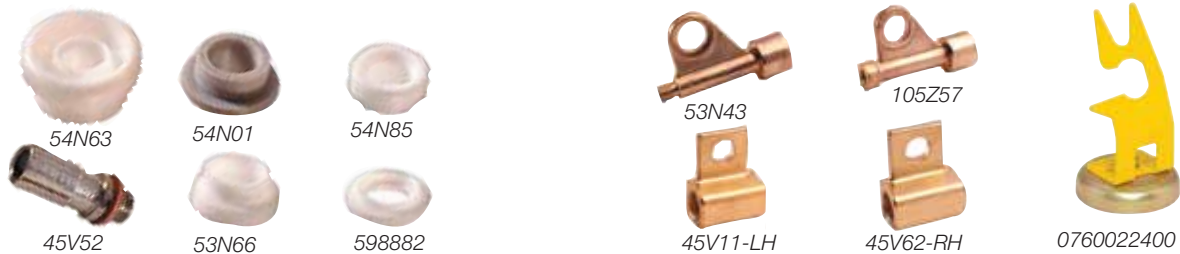


Each spare parts kit contains those accessory items most requested by our customers for use on our most popular GTAW torches, in easy-to-order kit form, packaged in durable plastic boxes.



## Spare Parts Kit

Description	999126 HW-17, 18, 26 TXH-151, 201	999127 HW-20 TXH-121, 251w	999124 HW-90	0558101886 TXH-401w	Quantity
Short torch cap	57Y04	-	-	57Y04	1
Long torch cap	-	41V24	56Y40	-	1
Collet .040 in. (1.0 mm)	-	-	84Z35	-	1
Collet 1/16 in. (1.6 mm)	10N23	13N22	84Z33	10N23	1
Collet 3/32 in. (2.4 mm)	10N24	13N23	-	0157123077	1
Collet 1/8 in. (1.4 mm)	10N25	13N24	-	0157123078	1
Collet body, .020/.040/1/16 in. (0.5/1.0/1.6 mm)	-	-	105Z27	-	1
Collet body, .040-3/32 in. (1.0-2.4 mm)				0157123081	
Collet body, 1/8-3/16 in. (3.2-5.0 mm)				0157123082	
Collet body, 1/16 in. (1.6 mm)	10N31	13N27	-	-	1
Collet body, 3/32 in. (2.4 mm)	10N32	13N28	-	-	1
Collet body, 1/8 in. (1.4 mm)	10N28	13N29	-	-	1
High-impact cup No. 4	-	-	14N65	-	1
High-impact cup No. 5	10N49	13N09	14N66	-	1
High-impact cup No. 6	10N48	13N10	14N67	54N16	1
High-impact cup No. 7	-	13N11	-	54N15	1
High-impact cup No. 8	10N46	-	-	54N14	1
.040 in. dia. x 7 in. long, Ground Finish Tungsten Electrode	-	-	Q796F55	-	1
1/16 in. dia. x 7 in. long, Ground Finish Tungsten Electrode	Q796F58	Q796F58	Q796F58	Q796F58	1
3/32 in. dia. x 7 in. long, Ground Finish Tungsten Electrode	Q796F63	Q796F63		Q796F63	1
1/8 in. dia. x 7 in. long, Ground Finish Tungsten Electrode	Q796F68	Q796F68		Q796F68	1



## Adaptors & Accessories

Description	Part Number	Used On
Insulator	54N63	HW-17, 18, 26
Insulator	54N01	HW-17, 18, 26
Insulator	53N85	HW-90
Adaptor	45V52	HW-90
Collet body insulator	53N66	HW-24
Cup gasket	598882	HW-20, 9
TIG torch holder	0760022400	All

## Power Cable Adaptors

Description	Part Number	Used On
Adaptor	53N43	HW-90, 24
Adaptor	105Z57	HW-17, 9
Adaptor	45V11	HW-18, 20
Adaptor	45V62	HW-26
Fuse assembly	45V34	HW-18, 20
Replacement fuses (5/pk)	54N26, 25A 54N30, 60A	HW-18, 20

## ESAB Welding and Cutting Products

United States / esabna.com / 1.800.ESAB.123 Canada / esab.ca / 1.877.935.3226 Mexico / esab.com.mx / (81) 8305.3700

## Electrodes - Ground Finish Provides Maximum Smoothness

Diameter, in. (mm)	Length, in. (mm)	Pure (EWP) Green Coded	Zirconiated (EWZr-1) Brown Coded	2% Ceriated (EWCe-2) Orange Coded	1.5% Lanthana (EWG) Gray Coded
.040 (1.0)	7 (175)	-	-	-	Q796F55
1/16 (1.6)	7 (175)	Q76Z51	Q790F47	Q798F92	Q796F58
3/32 (2.4)	7 (175)	Q76Z57	Q790F48	Q798F93	Q796F63
1/8 (3.2)	3 (75)	-	-	-	Q796F66
	7 (175)	Q76Z52	Q790F49	Q798F94	Q796F68
5/32 (4.0)	7 (175)	Q81Z43	Q790F50	Q798F95	Q796F84
3/16 (5.0)	7 (175)	-	Q790F51	-	-

Additional electrodes are available. For ordering information consult your ESAB Sales Representative or Distributor. Each package contains ten electrodes. For additional accessories, consult the Genuine Heliarc® Torch Guide #ARC-23110, available for download at [esabna.com](http://esabna.com).

## Back Caps

Description	Part Number	Used On
Short cap	41V33	HW-20, 9 TXH-121, 251w
Medium cap	41V35	HW-20, 9 TXH-121, 251w
Long cap	57Y02	HW-17, 18, 26 TXH-151, 201
Medium cap	34015	HW-17, 18, 26 TXH-151, 201
Short cap	57Y04	HW-17, 18, 26 TXH-151, 201
Short cap	84Z31	HW-90
Long cap	56Y40	HW-90



## Hoses/Cable Sheaths

Description	Part Number	Used On
<b>Zippered Nylon</b>		
12.5 ft. x 3 in. wide	35453	All
25 ft. x 3 in. wide	35454	All
<b>Non-Zippered</b>		
9 ft. x 7/8 in. I.D.	2075198	HW-20
20 ft. x 7/8 in. I.D.	2075200	
9 ft. x 1-1/4 in. I.D.	2075199	HW-18
10 ft. leather with snaps 6 in. wide	20812	

Widths are as flat.