

# 1 - MMA welding



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(*electrode holder with cable + clamp with cable*).. 1-6
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*For: clamps, connectors, cables,  
hammers, miscellaneous, ceramic backings,  
see chapter “Other arc welding”*



## The choice of an electrode holder follows several criteria.

- In Europe it is mandatory that the supplier conforms to the European standards on these products, for Health and Safety reasons.  
The **CE** marking confirms conformity of the product to these standards

### **DON'T BUY ELECTRODE HOLDERS WITHOUT THIS MARKING.**

- Selection criteria - the maximum electrode diameter required, that in turn dictates the maximum amperage and subsequently the size of the welding cable.
- Once the above criteria are established the remaining choice is one of personal preference.

### **Screw type**

Very secure grip of the electrode that gives the possibility of twisting the electrode once tightened.

### **Lever type**

Secure grip of the electrode between the jaws with pre defined angles for the electrode position, easy butt ejection.

**EN 60974-11**

*Selection criteria for the different type of electrode holders can be seen on the enclosed pages. Naturally the electrode holder will accept all sizes of electrode to the maximum diameter stated.*

*The lever type electrode holders are divided into two sections, large opening type - that has the optional pre defined angles and closed head type - that has only a single position option.*

## Screw type electrode holders

### Choice criteria

		mm	mm²	
		Maximum	Maximum	
Screw type straight	TWIST 200		3.2	25
	TWIST 400		5.0	50
	VESTALETTE		4.0	35
	STUBBY		6.3	50
	MASTER		8.0	95
	VESTALE		8.0	95
Screw type curve	CURVA 400		5.0	50
	CURVA 600		6.3	70

Name	Cat N°	A (35%)	Ø cable (mm²)	Electrode diameter (mm)	Weight (g)	Customer's benefit
TWIST 200	W 000 010 565	200	25	3.2	335	Economical electrode holders. Insulation class: A. Well balanced, rubber handle, left hand thread.
TWIST 400	W 000 010 566	300	50	5.0	480	
VESTALETTE	W 000 010 035 W 000 010 883*	250	35	4.0	295	Light and totally insulated, fibre glass head long life duration, left hand thread. Insulation class: A.
STUBBY	W 000 010 036 W 000 010 879*	400	50	6.3	450	Well known, fibre glass single part head. Spare parts available, right hand thread. Insulation class: A.
MASTER	W 000 010 037 W 000 010 882*	500	95	8.0	530	Well known, fibre glass single part head. Spare parts available, right hand thread. Insulation class: A.
VESTALE	W 000 010 038 W 000 010 880*	500	95	8.0	470	THE heavy duty electrode holder. Insulation class: A. High resistance. Fibre glass head, left hand thread.
CURVA 400	W 000 010 573	300	50	5.0	540	Curved electrode holders. Insulation class: B.
CURVA 600	W 000 010 574	400	70	6.3	720	





\* Cat. number for display

Spare parts	Cat N°
MASTER - Head	W 000 011 082
STUBBY - Head	W 000 260 716
MASTER - Insulation	W 000 011 083
STUBBY/MASTER - Spring	W 000 011 084
STUBBY/MASTER - Handle	W 000 011 077

Spare parts	Cat N°
STUBBY - Body	W 000 011 085
VESTALE - Handle	W 000 011 086
VESTALE - Head	W 000 011 087

## Lever type opened head electrode holders

### Choice criteria

		 Maximum	 Maximum
CAÏMAN 200		3.2	25
CAÏMAN 400		5.0	50
CAÏMAN 600		6.3	70
SAMSON ECO 300		6.3	70
SAMSON ECO 500		8.0	95

Name	Cat N°	A (35%)	Ø cable (mm²)	Electrode diameter (mm)	Weight (g)	Customer's benefit
CAÏMAN 200	W 000 010 567	200	25	3.2	370	Economical electrode holders. Polyamide handle, fibre glass reinforced. Brass jaws. Insulation class: B.
CAÏMAN 400	W 000 010 568	300	50	5.0	425	
CAÏMAN 600	W 000 010 569	400	70	6.3	500	
SAMSON ECO 300	W 000 010 622	300	70	6.3	450	Light version, well known SAMSON electrode grip. Insulation class: A.
SAMSON ECO 500	W 000 010 623	500	95	8.0	530	

## Lever type closed head electrode holders

### Choice criteria

		Maximum	Maximum
SEGURA 300		4.0	35
SEGURA 400		5.0	50
SEGURA 600		6.3	70
COBRA		6.3	50
OPTIMUS 300		6.3	70
OPTIMUS 400		8.0	95
OPTIMUS 500		8.0	95

Name	Cat N°	A (35%)	Ø cable (mm²)	Electrode diameter (mm)	Weight (g)	Customer's benefit
SEGURA 300	W 000 010 570	300	35	4.0	415	Economical models. Nylon handle. Brass jaws. Insulation class: B.
SEGURA 400	W 000 010 571	300	50	5.0	570	
SEGURA 600	W 000 010 572	400	70	6.3	590	
COBRA	W 000 010 039 W 000 010 881*	300	50	6.3	420	Light and multi purpose. Insulation class: A.
OPTIMUS 300	W 000 010 410	300	70	6.3	460	High quality electrode holder. Well-known for intensive use and powerful grip on the electrodes. Specially design for heavy duty works with a comfortable handle. Insulation class: A.
OPTIMUS 400	W 000 010 411	400	95	8.0	560	
OPTIMUS 500	W 000 010 412	500	95	8.0	620	

\* Cat. number for display

Spare parts OPTIMUS	Cat N°
300 Insulating head	W 000 010 107
300-400-500 Screw M 4X6	W 000 010 108
300 Lever	W 000 010 109
300-400-500 Spring	W 000 010 110
300 Spring cap	W 000 010 111
300 Hinge pin	W 000 010 112
300 Body	W 000 010 113
300 Cable screw	W 000 010 116

Spare parts COBRA	Cat N°
Head	W 000 011 088

Spare parts OPTIMUS	Cat N°
300 Handle	W 000 010 114
400-500 Insulating head	W 000 010 115
400-500 Lever	W 000 010 117
400-500 Spring cap	W 000 010 119
400-500 Hinge pin	W 000 010 120
400-500 Body	W 000 010 121
400-500 Cable screw	W 000 010 122
400-500 Handle	W 000 010 123



## Hobby electrode holders

### Choice criteria

		Maximum	Maximum
<b>HOBBY 200</b>		4.0	25

Name	Cat N°	A (35%)	Ø cable (mm²)	Electrode diameter (mm)	Weight (g)	Customer's benefit
<b>HOBBY 200</b>	<b>W 000 010 575</b>	200	25	4.0	135	An industrial design for a "DIY" use. Insulation class: B.

## Light duty electrode holders

### Choice criteria

		Maximum	Maximum
<b>CAÏMY 200</b>		3.2	25

Name	Cat N°	A (35%)	Ø cable (mm²)	Electrode diameter (mm)	Weight (g)	Customer's benefit
<b>CAÏMY 200</b>	<b>W 000 010 576</b>	200	25	3.2	220	A small professional tool for light works. Insulation class: B.

**Kits of accessories for MMA welding: electrode holders, earth clamps, cables and connectors, already assembled.**

### Advantages:

- "Ready to weld".
- A simple and full range in relation with all welding machines.
- Save 30 minutes of assembly time, before to weld.
- Recommendations in relation to welding processes.

### The kits choice depends of several criteria:

- **Sections of machine sockets:**
  - Plugs of 9 mm diameter correspond to a cable cross-section between 16 mm<sup>2</sup> and 25 mm<sup>2</sup>.
  - Plugs of 13 mm diameter correspond to a cable cross-section between 35 mm<sup>2</sup> and 50 mm<sup>2</sup> (max 90 mm<sup>2</sup>).
- **Application & intensity**



### The range:

- First digits describe cable diameter.
- Second digits describe type of connector.

Cat N°	Kit	I max at 35%	Electrode holder	Cable length	Earth clamp	Cable length	Plug diameter	MMA power sources' types and applications
W 000 260 680	16C25	200 A	HOBBY 200	3 m	HIPPO 200	2 m	9 mm	<b>Small</b> intensity power sources for occasionnal welding
W 000 011 138	25C25	200 A	CAIMAN 200	3 m	HIPPO 200	3 m	9 mm	<b>Small</b> intensity power sources for semi professional welding
W 000 260 683	25C25+	300 A	SEGURA 300	3 m	HIPPO 400	2 m	9 mm	<b>Small</b> intensity power sources for working site up to Ø 4 mm
W 000 260 684	25C50	300 A	SEGURA 300	3 m	HIPPO 400	3 m	13 mm	<b>High</b> intensity power sources for intensive use (up to Ø 4 mm) or work site
W 000 011 139	35C50	300 A	SEGURA 300	4 m	HIPPO 400	4 m	13 mm	<b>High</b> intensity power sources for intensive use (up to Ø 4 mm) or work site
W 000 260 681	50C50	300 A	SEGURA 400	4 m	HIPPO 400	4 m	13 mm	<b>High</b> intensity power sources for intensive use (up to Ø 5 mm) or work site
W 000 260 682	50C50+	400 A	SEGURA 600	4 m	HIPPO 600	4 m	13 mm	<b>High</b> intensity power sources for intensive use (up to Ø 6.3 mm) or work site

# Gouging torches

EN 60974-11 type B  
EN 60245-6



**WELDLINE**

## FLAIR®

The FLAIR® gouging torch is a high quality torch. The airflow can be regulated on the torch. Recommended air pressure is 7 bar.

	Current (A)	Electrode Ø max	Cat N°
<b>1 FLAIR 600</b>	600	10 mm - 3/8"	<b>W 000 010 136</b>
<b>2 FLAIR 1600</b>	1600	19 mm - 3/4"	<b>W 000 010 118</b>



## ARCAIR K2000 - K4000®

A well known brand name in gouging process.



	Current (A)	Electrode Ø max	Cat N°
<b>K 2000</b>	450	6 mm - 1/4"	<b>W 000 010 999</b>
<b>K 4000</b>	1000	13 mm - 1/2"	<b>W 000 010 992</b>

### Spare parts

	<b>K 2000</b>	<b>K 4000</b>
Jaw	<b>W 000 011 033</b>	<b>W 000 010 991</b>
Cable	-	<b>W 000 010 993</b>
Shell	<b>W 000 011 030</b>	<b>W 000 010 994</b>
Head	<b>W 000 0110 31</b>	<b>W 000 010 995</b>
Lever	<b>W 000 011 032</b>	<b>W 000 010 996</b>
Body	-	<b>W 000 010 997</b>
Pushing kit	-	<b>W 000 010 998</b>
Spring	-	<b>W 000 010 990</b>

# Graphite electrodes

WELDLINE offers a complete range of graphite (carbon) electrodes for gouging.

## CARBONAIR

Pointed electrodes



## CARBONAIR PLUS

Jointed electrodes (no stub loss)





This process requires a MMA direct current (DC) power source, a gouging torch and a compressed air source. Please find hereunder a selection table.

### CARBONAIR

Description diameter x length (mm)	Cat N°	Quantity per box (thousand)	Gross weight per box kg	I mini A	I maxi A	 bars	 m³/h
CARBONAIR 4 x 305	W 000 010 645	0.100	0.78	150	200	4.0	15
CARBONAIR 5 x 305	W 000 010 443	0.100	1.08	200	250	4.0	15
CARBONAIR 6.5 x 305	W 000 010 444	0.050	0.98	320	370	4.0	15
CARBONAIR 8 x 305	W 000 010 445	0.050	1.34	400	450	5.5	40
CARBONAIR 10 x 305	W 000 010 446	0.050	2.15	500	550	5.5	40
CARBONAIR 13 x 305	W 000 010 447	0.050	3.55	800	1 000	5.5	50

### CARBONAIR PLUS

Description diameter x length (mm)	Cat N°	Quantity per box (thousand)	Gross weight per box kg	I mini A	I maxi A	 bars	 m³/h
CARBONAIR PLUS 8 x 355	W 000 010 448	0.050	1.80	500	550	5.5	40
CARBONAIR PLUS 10 x 430	W 000 010 449	0.050	3.22	600	650	5.5	40
CARBONAIR PLUS 13 x 430	W 000 010 450	0.050	4.97	800	1 000	5.5	50
CARBONAIR PLUS 16 x 430	W 000 010 451	0.025	3.70	1000	1 200	6.9	60
CARBONAIR PLUS 19 x 430	W 000 010 452	0.025	5.17	1200	1 400	6.9	60

## WELDRY PW8 and PW 15 Portable quivers

On request: other models  
(without thermostat – with thermometer  
- with different power supply – stainless  
steel or lacquered finishing)

PW8 and PW15 portable quivers are necessary, for electrodes maintenance, near the welding working place. They preserve the electrodes from moisture avoiding hydrogen inclusion in the welding joint.

PW8 and PW15 portable quivers are provided with a handle, useful for moving. They contain also an extractable basket that avoids waste of heat. PW8 and PW15 ovens are provided with build-in adjustable thermostat.

Technical data	WELDRY PW8	WELDRY PW15
Capacity (n. of electrodes)	100 electrodes Ø 3.25 mm	200 electrodes Ø 3.25 mm
Max temperature	180 °C - 200 °C	
Power	0.13 kW	0.275 kW
Capacity	5 kg	10 kg
Power supply	Single-phase 230 V - 50/60 Hz	
Internal size	72 x 72 x 470 mm	100 x 100 x 470 mm
External size	140 x 180 x 630 mm	180 x 220 x 630 mm
Net weight	5 kg	8 kg
Packaging dimension	160 x 210 x 640 mm	210 x 240 x 660 mm
Gross weight	6 kg	9 kg
Cat N°	W 000 120 427	W 000 120 428



## WELDRY MW Holding ovens for MMA electrodes

MW ovens are used for keeping the treatment of electrodes after the drying cycle and before the welding process. They preserve the electrodes from moisture avoiding hydrogen inclusion in the welding joint.

Equipped with a digital control panel and two adjustable thermoregulators for air and heating elements protection, positioned in front of the oven.



Technical data	WELDRY MW2	WELDRY MW4	WELDRY MW6
Shelves number	2	4	6
Capacity for each shelf	1500 electrodes	1500 electrodes	1500 electrodes
Temperature regulation thermostat	up to 300 °C		
Power	2.7 kW	2.7 kW	4.5 kW
Capacity (weight and number of electrodes)	135 kg - 3 000 el. Ø 3.25 mm	270 kg - 6 000 el. Ø 3.25 mm	405 kg - 9 000 el. Ø 3.25 mm
Power supply	Single phase 230 V - 50/60 Hz		Three phase 380 V - 50/60 Hz
Internal size	720 x 510 x 350 mm	720 x 510 x 620 mm	720 x 510 x 890 mm
External size	830 x 690x 760 mm	830 x 690x 1400 mm	820 x 690x 1310 mm
Net weight	90 kg	123 kg	152 kg
Packaging dimension	850 x 710 x 780 mm	850 x 710 x 1420 mm	840 x 710 x 1330 mm
Gross weight	95 kg	135 kg	160 kg
Cat N°	W 000120 430	W 000 120 431	W 000 120 454

## WELDRY CW Re-baking ovens for MMA electrodes

This oven is used for electrode re-baking treatment, heating the electrodes between 350 °C-420 °C for a fixed time. In this way the moisture is removed and a good quality welding without hydrogen intrusion is guaranteed.

Equipped with a digital control panel and two adjustable thermoregulators for air and heating elements protection, positioned in front of the oven, allows to set both drying and keeping cycles.



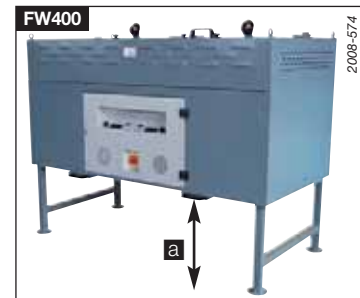
Technical data	WELDRY CW3	WELDRY CW6	WELDRY CW9
Shelves number	3	6	9
Capacity (number of electrodes)	4 500 el. Ø 3.25 mm	9 000 el. Ø 3.25 mm	13 500 el. Ø 3.25 mm
Capacity	203 kg	404 kg	608 kg
Temperature regulation thermostat	up to 500 °C		
Number of resistances	3	6	9
Power	4.6 kW	9.1 kW	13.6 kW
Power supply	Three-phase 380 V - 50/60 Hz		
Internal size	560 x 740 x 560 mm	560 x 740 x 980 mm	560 x 740 x 1430 mm
External size	800 x 880x 1030 mm	800 x 880x 1480 mm	800 x 880x 1880 mm
Net weight	140 kg	200 kg	266 kg
Packaging dimension	820 x 900 x 1050 mm	820 x 900 x 1500 mm	820 x 900 x 1900 mm
Gross weight	150 kg	215 kg	280 kg
Cat N°	W 000 120 466	W 000 120 467	W 000 120 468

## WELDRY FW - Hopper ovens for flux

This model of oven is used for re-baking submerged arc welding fluxes, heating the flux between 350 °C - 420 °C for a fixed time. The inside tank is stainless steel made to prevent from risk of pollution.

The resistances are positioned inside the hopper for a direct contact to flux in order to obtain an optimal heating.

The build-in digital control equipment with double thermoregulator for air and resistances protection avoids the flux being damaged and allows to set both drying and keeping cycles.



Technical data	WELDRY FW100	WELDRY FW200	WELDRY FW400
Load Capacity	60 kg	160 kg	320 kg
Temperature regulation thermostat	up to 500 °C		
Power	4 kW	4 kW	7.9 kW
Power supply	Three-phase 380/220 V - 50/60 Hz		
Internal size	530 x 390 x 640 mm	690 x 690 x 740 mm	690 x 690 x 740 mm (each tank)
External size	670 x 709 x 1300 mm	825 x 819 x 1330 mm	1620 x 850 x 1340 mm
Net weight	90 kg	116 kg	210 kg
Height of the flap door for flux feeding	a = 500 mm	a = 450 mm	
Packaging dimension	690 x 750 x 1 320 mm	850 x 860 x 1 350 mm	1 640 x 870 x 1 360 mm
Gross weight	100 kg	130 kg	225 kg
Cat N°	W 000 120 469	W 000 120 470	W 000 120 471