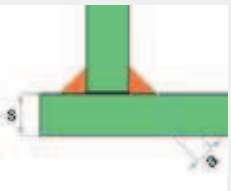
Possibilities of welding seams

Fillet welding seam



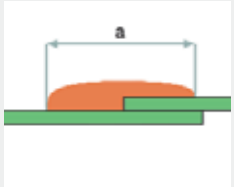
X-seam

s = 10 – 40 mm = α 60°
s = 50 – 60 mm = α 50°

V-seam

s = 5 – 20 mm = α 60°
s = 25 – 30 mm = α 50°

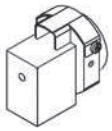
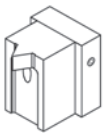
Overlap



Legend: **a** = seam size **s** = material thickness α = milling angle

Accessories hand extruders

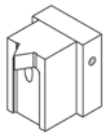
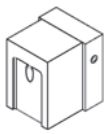
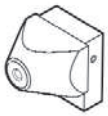
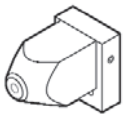
	112.629	Welding shoe complete, V-seam 5 mm
	112.621	Welding shoe complete, V-seam 6 mm
	112.623	Welding shoe complete, V-seam 8 mm
	112.624	Welding shoe complete, V-seam 10 mm **> WELDMAX**
	112.630	Welding shoe complete, for fillet weld 5 mm (a = 3.5 mm)
	112.625	Welding shoe complete, for fillet weld 6 mm (a = 4.2 mm)
	112.627	Welding shoe complete, for fillet weld 8 mm (a = 5.6 mm)
	112.628	Welding shoe complete, for fillet weld 10 mm (a = 7 mm) **> WELDMAX**
	112.626	Welding shoe complete, overlap 20 mm **> WELDMAX**
	112.830	Welding shoe blank complete **> WELDMAX**
	118.888	Welding shoe complete, V-seam 5/6 and X-seam 10/12 mm
	118.889	Welding shoe complete, V-seam 8/10 and X-seam 15/20 mm
	119.202	Welding shoe complete, V-seam 12 and X-seam 25 mm
	119.203	Welding shoe complete, V-seam 15 and X-seam 30 mm
	119.204	Welding shoe complete, V-seam 20 and X-seam 35/40 mm
	119.205	Welding shoe complete, V-seam 25 mm
	119.206	Welding shoe complete, V-seam 30 mm **> FUSION 2 > FUSION 3** **> FUSION 3C > WELDPLAST S2**

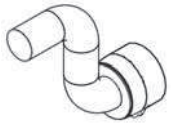
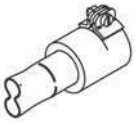
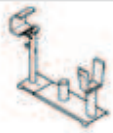
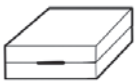
	118.887	Welding shoe complete, for fillet weld 5/6 mm (a = 4.2 mm)
	118.885	Welding shoe complete, for fillet weld 8/10 mm (a = 7 mm)
	119.139	Welding shoe complete, for fillet weld 15 mm (a = 10.5)
	119.140	Welding shoe complete, for fillet weld 20 mm (a = 14 mm)
	119.141	Welding shoe complete, for fillet weld 25 mm (a = 17.5 mm)
	119.142	Welding shoe complete, for fillet weld 30 mm (a = 21 mm) **> FUSION 2 > FUSION 3** **> FUSION 3C > WELDPLAST S2**
	118.890	Welding shoe complete, overlap 25 mm
	119.185	Welding shoe complete, overlap 35 mm **> FUSION 2 > FUSION 3** **> FUSION 3C > WELDPLAST S2**
	129.008	Welding shoe complete, corner, short ∅ 20 mm **> FUSION 2 > FUSION 3** **> FUSION 3C > WELDPLAST S2**
	129.010	Welding shoe complete, corner, long ∅ 14 mm **> FUSION 2 > FUSION 3** **> FUSION 3C > WELDPLAST S2**
	**118.094**	Welding shoe complete, blank 50 × 30 × 38 mm
	119.214	Welding shoe complete, blank 70 × 50 × 47.5 mm **> FUSION 2 > FUSION 3** **> FUSION 3C > WELDPLAST S2**
	**119.193**	Welding shoe complete, V-seam 5/6 and X-seam 10/12 mm
	119.194	Welding shoe complete, V-seam 8/10 and X-seam 15/20 mm
	119.195	Welding shoe complete, V-seam 12 and X-seam 25 mm
	119.196	Welding shoe complete, V-seam 15 and X-seam 30 mm
	119.197	Welding shoe complete, V-seam 20 and X-seam 35/40 mm **> WELDPLAST S4** **> WELDPLAST EC4**

Welding wire roll-off device

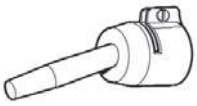
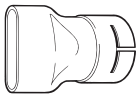
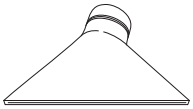
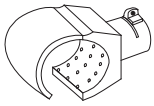
Device stand for WELDPLAST S2

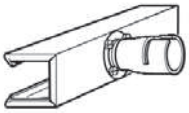
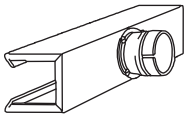
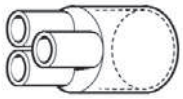
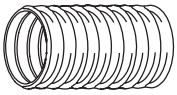
Device stand for WELDPLAST S4/EC4 and FUSION 3C with welding wire roll-off device and welding shoe pre-heater

	**119.198**	Welding shoe complete, V-seam 25 mm
	119.199	Welding shoe complete, V-seam 30 mm **> WELDPLAST S4** **> WELDPLAST EC4**
	119.159	Welding shoe complete, for fillet weld 5/6 mm (a = 4.2 mm)
	119.161	Welding shoe complete, for fillet weld 8/10 mm (a = 7 mm)
	119.163	Welding shoe complete, for fillet weld 15 mm (a = 10.5 mm)
	119.164	Welding shoe complete, for fillet weld 20 mm (a = 14 mm)
	119.165	Welding shoe complete, for fillet weld 25 mm (a = 17.5 mm)
	119.166	Welding shoe complete, for fillet weld 30 mm (a = 21 mm) **> WELDPLAST S4** **> WELDPLAST EC4**
	**119.188**	Welding shoe complete, overlap 25 mm
	119.190	Welding shoe complete, overlap 35 mm **> WELDPLAST S4** **> WELDPLAST EC4**
	**129.009**	Welding shoe complete, across, small ∅ 20 mm **> WELDPLAST S4** **> WELDPLAST EC4**
	**129.011**	Welding shoe complete, across, large ∅ 14 mm **> WELDPLAST S4** **> WELDPLAST EC4**
	119.217	Welding shoe complete, blank 50 × 40 × 38 mm
	119.222	Welding shoe complete, blank 70 × 50 × 47.5 mm **> WELDPLAST S4** **> WELDPLAST EC4**

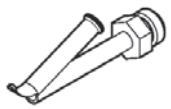
	**117.064**	Hot air guide on top **> WELDPLAST S4** **> WELDPLAST EC4**
	117.065	Hot air guide on top **> WELDPLAST S4** **> WELDPLAST EC4**
	117.053	Preheating nozzle small **> WELDPLAST S4** **> WELDPLAST EC4**
	**117.518**	Preheating nozzle medium **> WELDPLAST S4** **> WELDPLAST EC4**
	117.055	Preheating nozzle large **> WELDPLAST S4** **> WELDPLAST EC4**
	131.451	Tool rest **> WELDPLAST S2**
	**118.804**	Tool rest **> WELDPLAST S4** **> WELDPLAST EC4** **> FUSION 3C**
	118.188	Welding rod de-reeler **> WELDPLAST S4** **> WELDPLAST EC4** **> FUSION 3**
	**112.852**	Storage case **> WELDMAX**

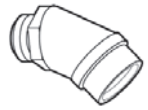
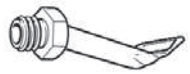
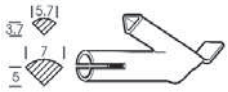
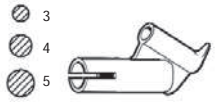
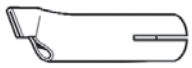
Accessories for hand tools

	107.144	Pipe nozzle ∅ 5 mm, push-on **> HOT JET S**
	**100.303**	Pipe nozzle ∅ 5 mm, for versions nozzles, push-on **> DIODE PID > DIODE S** **> TRIAC PID > TRIAC S**
	**107.258**	Wide slot nozzle 70 × 10 mm, push-on **> ELECTRON**
	**107.270**	Wide slot nozzle 150 × 12 mm, push-on **> ELECTRON**
	**107.331**	Folding reflector 72 × 70 mm, push-on **> ELECTRON**
	107.346	Welding mirror 270 mm, push-on **> ELECTRON**
	107.344	Welding mirror 135 mm, push-on **> DIODE PID > DIODE S** **> TRIAC PID > TRIAC S**

	**107.326**	Shell reflector 25 × 150 mm, push-on **> DIODE PID > DIODE S** **> TRIAC PID > TRIAC S**
	**107.340**	Shell reflector 45 × 250 mm, push-on **> ELECTRON**
	107.354	Stainless steel filter, push-on **> ROBUST**
	**107.281**	Hose coupling (∅ 38 mm) 3 outlets **> ROBUST**
	**101.681**	Air hose ∅ 14 mm **> DIODE PID > DIODE S** **> WELDING PEN R > WELDING PEN S**
	101.031	Hose clamp for air hose ∅ 14 mm

Combination of angular adapter and pulling nozzle.

	113.666 **113.399**	Draw nozzle round, ∅ 3 mm Draw nozzle round, ∅ 4 mm, with tacking tip, screw on **> DIODE PID/S > TRIAC PID/S > WELDING PEN R/S**
	113.876 **113.874**	Draw nozzle round, ∅ 3 mm Draw nozzle round, ∅ 4 mm, without tacking tip, screw on **> DIODE PID/S > TRIAC PID/S > WELDING PEN R/S**
	113.670	Draw nozzle triangle shaped, 5.7 mm with tacking tip, screw on **> DIODE PID/S > TRIAC PID/S > WELDING PEN/S**
	113.877 **106.986**	Draw nozzle triangle shaped, without tacking tip, screw on draw nozzle 5.7 mm, profile A draw nozzle 7 mm, profile B **> DIODE PID/S > TRIAC PID/S > WELDING PEN R/S**
	**126.552**	Draw nozzle ∅ 4 mm, screw on for Fluorplastics **> DIODE PID/S > TRIAC PID/S > WELDING PEN/S**

	**127.726** **127.727**	Angular adapter for nozzle, screw on 30° 45°
	**106.988**	Tacking nozzle, screw on **> DIODE PID/S > TRIAC PID/S > WELDING PEN/S**
	105.622	Tacking nozzle ∅ 5 mm, screw on **> DIODE PID/S > TRIAC PID/S > WELDING PEN/S**
	**106.992** **106.993**	Speed welding nozzle 5.7 mm, Profil A Speed welding nozzle 7 mm, Profil B push-on on tubular nozzle ∅ 5 mm
	**106.989** **106.990** **106.991**	Speed welding nozzle 3 mm Speed welding nozzle 4 mm Speed welding nozzle 5 mm, push-on on tubular nozzle ∅ 5 mm
	**106.996**	Tacking nozzle, push-on on tubular nozzle ∅ 5 mm

Technical data is subject to change without notice.