

[www.tigware.com.au](http://www.tigware.com.au)

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## Product Information Sheet



Aussie Made



All TIGWARE PTFE Units are made here in Melbourne Australia

Sizes #10 - #12 - #14 - #16 - #20 - #32 (Other Sizes can be Manufactured to Order

Contact John ) However the Triple Diffuser System Compensates for Intermediary Cup sizes

### DC Application.

**Avoid Direct contact with HOT Surfaces.**

### Follow Freehand Welding Technique

Colour: White

Material: PTFE

Use with Gas Lens Adapter 17GL332 (Available from TIGWARE) for

#17/#18/#26 Type Torches and or 45V44 Gas Lens for #9/#20 Type Torches. TIGWARE's TEFLON Units thread and seal directly to the Torch Head, No O-rings just a Mechanical Seal.

Welding Parameters:

### DC Use Product

- 2.4mm Tungsten (3/32")
- Stick Out: **25mm.** (Greater Stick Out can be Achieved with Higher Gas Flow)
- 150 amps or Greater Increase Gas Flow as Needed
- Gas Diffuser = TIGWARE's Triple Diffuser System.

For best performance I recommend a greater than normal Tungsten Stick-out with Standard GAS Flow Rates listed below for optimal Product Endurance.

**Note: Grind Each end of the TUNGSTEN Rod to a point and remove the Painted section as the Diffuser System is designed to have a Sliding Fit.**

**Any remaining paint will interfere with the Diffusers during TUNGSTEN insertion and or Removal.**

**I recommend a TWISTING Action when Inserting and or Removing the TUNGSTEN Rod**

Size: #10 20 CFH / 10 > L / Min

Size: #12 24 CFH / 11 > L / Min

Size: #14 28 CFH / 14 > L / Min

Size: #16 32 CFH / 15 > L / Min

Size: #20 40 CFH / 19 > L / Min

Size: #32 64 CFH / 30 > L / Min

#### Diffuser Damage.

Should the primary Mesh Unit become damaged. Simply swap the First and Second diffusers. This will not affect the Gas flow performance.

**Diffusers can be purchased via the TIGWARE website.**

### Recommended Minimum Extended Stick out Dimensions

#10 Unit = 25mm to 35mm

#12 Unit = 25mm to 35mm

#16 Unit = 25mm to 35mm

#20 Unit = 25mm to 40mm

#32 Unit = 25mm to 40mm

**PTO**

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Enjoy you're new product and please let me know if you have any problems.

Regards John +61 (0) 448527996 / [info@tigware.com.au](mailto:info@tigware.com.au)

**All TEFLON Units are HAND made in  
Melbourne Australia  
by TIGWARE.  
Support the Little Guy and  
Buy Australian**



**TIGWARE AUSSIE MADE**



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