SR 18
water-cooled



Different modular switch units available:
single push-button
double push-button
up/down (4 push-buttons)
single push-button
with potentiometer

SR 18F
water-cooled



320 Amp./60% duty cycle (DC)
240 Amp./60% duty cycle (AC)

HSN 570AB

SR 18 / SR 18F

water-cooled

Equipment:
A standard
B gas lens
D gas lens jumbo
E gas lens mini
F standard mini





O-ring red ID8-W2mm included
17189001



Insulator
17289021



Kir Royal argon nozzle
fits equipment line **E**

17930006
for 1,0 - 3,2

with firmly built-in sieves
for perfect gas circulation

A **B** **D** **E** **F**



Gas lens insulator
17089021



Gas lens insulator jumbo
17089031



Collet L50mm
17□□5002 **for** 1,0/1,6/2,4
18□□5002 **for** 3,2/4,0
□□**Please fill in size**



Collet L50mm
17□□5002 **for** 1,0/1,6/2,4
18□□5002 **for** 3,2/4,0
□□**Please fill in size**



Collet L50mm
17□□5002 **for** 1,0/1,6/2,4
18□□5002 **for** 3,2/4,0
□□**Please fill in size**



Collet L29mm
17□□3002 **for** 1,0/1,6/2,4
18323002 **for** 3,2
□□**Please fill in size**



Collet L29mm
17□□3002 **for** 1,0/1,6/2,4
18323002 **for** 3,2
□□**Please fill in size**



Collet body
1796□□02 **for** 1,0/1,6/2,4
1896□□02 **for** 3,2/4,0
□□**Please fill in size**



Gas lens
1796□□11 **for** 1,0/1,6/2,4
1896□□11 **for** 3,2/4,0
□□**Please fill in size**



Gas lens jumbo
1796□□21 **for** 1,0/1,6/2,4
1896□□21 **for** 3,2/4,0
□□**Please fill in size**



Gas lens mini
1796□□31 **for** 1,0/1,6/2,4
18963231 **for** 3,2
□□**Please fill in size**



Collet body mini
1796□□03 **for** 1,0/1,6/2,4
18963203 **for** 3,2
□□**Please fill in size**



Ceramic nozzle L47mm
for standard collet body
Please state size
Also available in
special length L76mm



Ceramic nozzle L42mm
for gas lens
Please state size
Also available in
special length L76mm



Ceramic nozzle L 48mm
for gas lens jumbo
Please state size



Ceramic nozzle L20mm
for gas lens mini
Please state size



Ceramic nozzle L30mm
for standard collet body mini
Please state size
Also available in special
lengths L48mm / L63mm
and L89mm

HSN 736AB-1

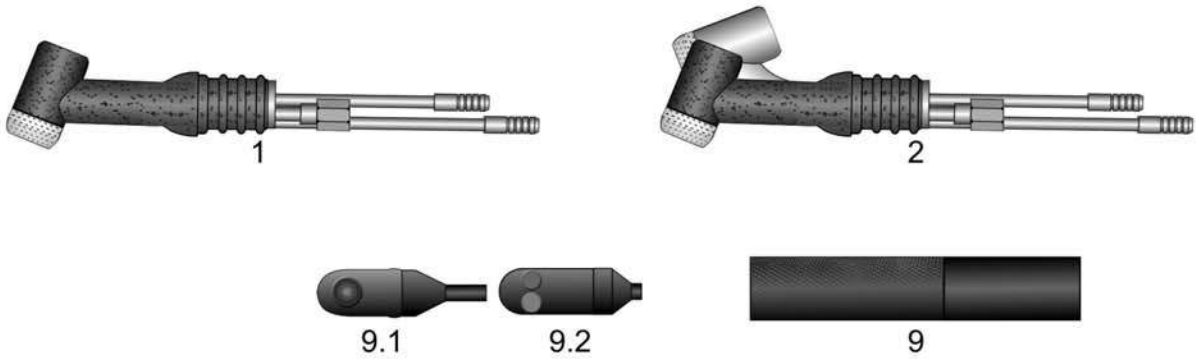
Holch Schweißbrenner

GETESTET EN 60974-7 ISO 9001:2015

www.holch-siegen.de

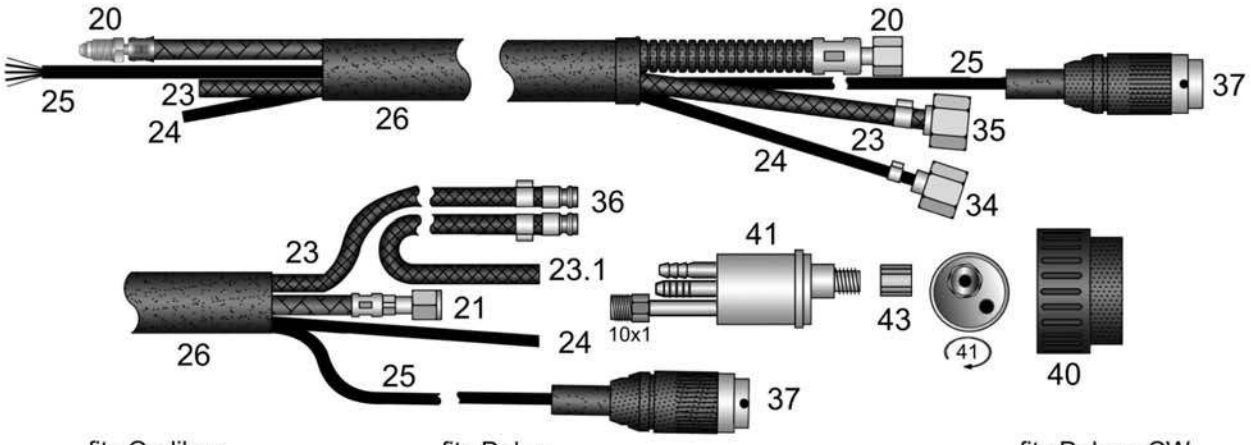
SR 18 water-cooled

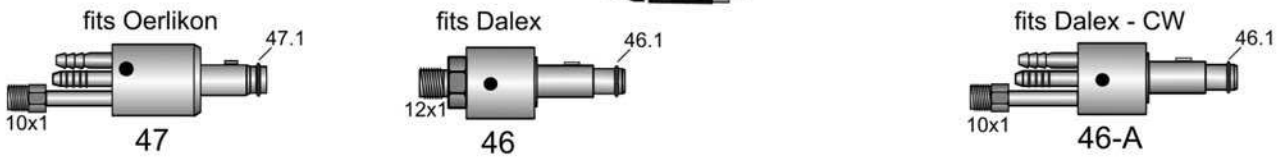
320 Ampere at 60% duty cycle (DC) - 240 Ampere at 60% duty cycle (AC)

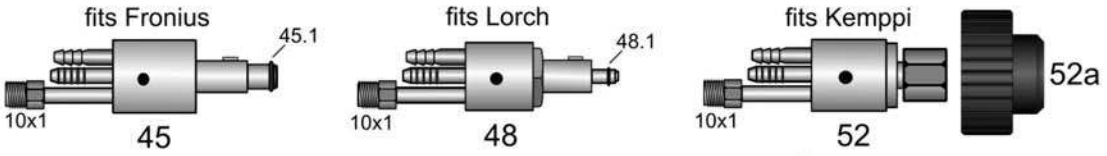


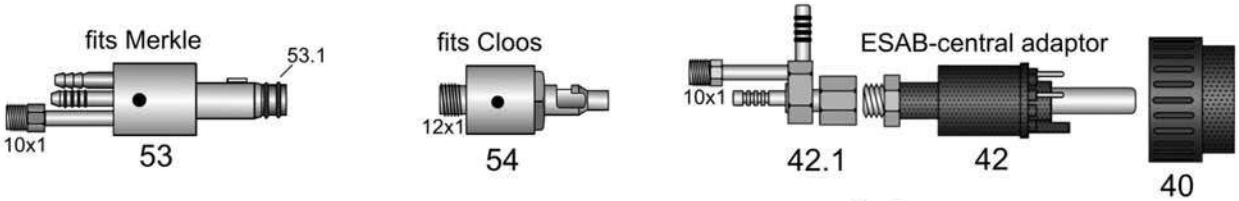
Forma WIG-handle with ball joint - different modular switch units - special switching modules on request

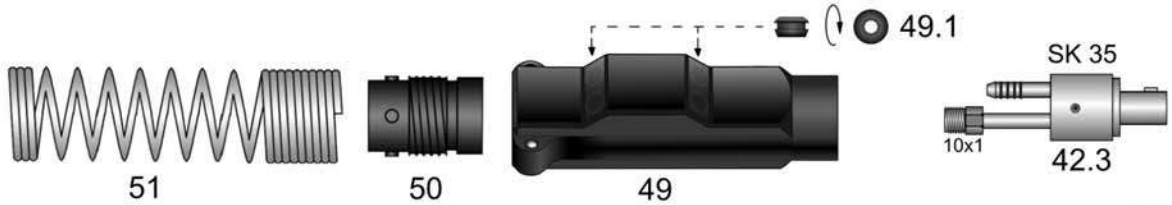






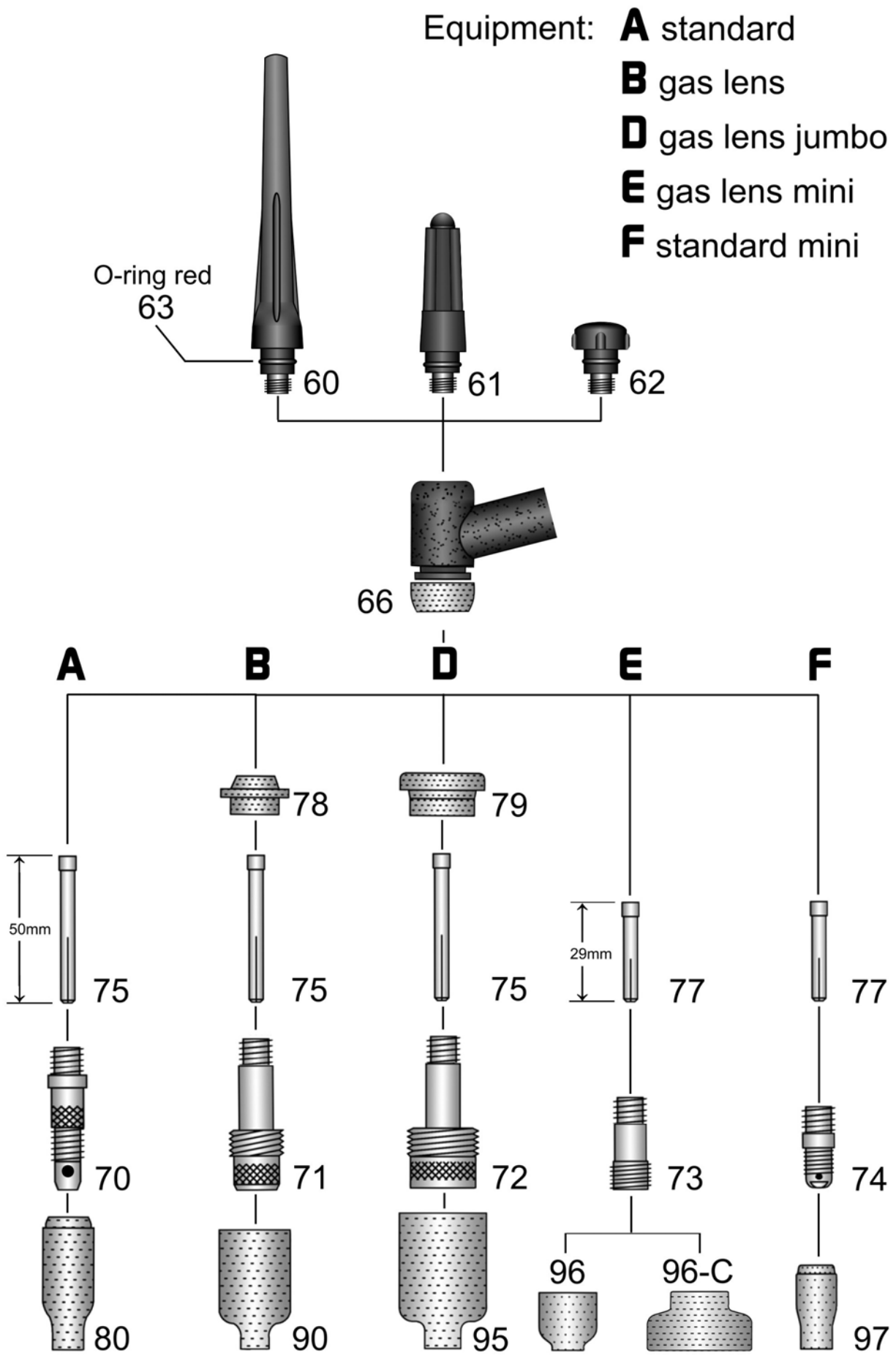






HSN 530AB-2

SR 18 / SR 18 F water-cooled spare parts



SR 18

Welding-torch TIG water-cooled with import torch body

320A at 60% duty cycle (DC) - 240A at 60% duty cycle (AC)

	Art.-No.	
		Torches with first meter leather hose. Machine side seperate connections with Tuchel-plug.
		In varation to the torches listed below, the torches can also be produced with other power/water cables (e.g. HT 180 silicone superflexible). This can also be combined with hoses in a lot of different qualities. Torches and cable assemblies can be produced in excess lengths. Please find the different options and surcharges in the appendix C "Custom made products". We produce torches for more than 40 different brands of machines with differnt connection systems.
	18200401	Torch SR 18 / 4m cable assembly ST 80 PVC-NIT
	18200801	Torch SR 18 / 8m cable assembly ST 80 PVC-NIT
		The following torches are equipped with highly flexible and heat resistant rubber fabric hoses.
	1820040P	Torch SR 18-PLUS / 4m cable assembly HT 110
	1820080P	Torch SR 18-PLUS / 8m cable assembly HT 110
	1830040P	FLEX-torch SR 18F-PLUS / 4m neck flexible cable-assembly HT 110
	1830080P	FLEX-torch SR 18F-PLUS / 8m neck flexible cable-assembly HT 110
		TIG-spare cable assemblies, either with separate connections, or for the following connection systems.
	wig92402	TIG-spare cable assembly water-cooled 4m - please state desired design!
	wig92802	TIG-spare cable assembly water-cooled 8m - please state desired design!
		The following machine side connections are only listed for fast price finding purposes. In our catalogue "TIG machine side connections" you´ll find technical information specifying a machine side connection.
	29002102	Surcharge: machine side power/water plug SK35 bayonet connection AD13mm
	29000201	Surcharge: machine side with EURO central adapter
	29002109	Surcharge: machine side power/water plug fits Merkle with 2 O-rings
	29002106	Surcharge: machine side power/water plug fits Fronius with 1 O-ring
	29002101	Surcharge: machine side power/water plug fits Dalex with 1 O-ring
	29002108	Surcharge: machine side power/water plug fits Oerlikon with 1 O-ring
	29002104	Surcharge: machine side power/water plug fits Lorch SK35 + gas-nipple
	29002105	Surcharge: machine side power/water plug fits Kemppi IT-G1/4"
	29002110	Surcharge: machine side power/water plug fits Cloos
	29000212	Surcharge: machine side fits ESAB central adapter, 4 pins installed at position 3,4,5,6
		Please be aware that further surcharges may apply for some special control-line plugs. See appendix D.
1	18291001	Torch body SR 18
2	18391001	Torch body SR 18F neck flexible (FLEX)
9	26088003	Handle H-200 fits SR 18 / SR 26
9.1	10089001	Single stroke button (rubber)
9.2	91921301	Doublepush button red/green
N.i.	10089011	One-hole shrinking hose switch sleeve ID50mm - min 25mm
N.i.	10089012	Two-hole shrinking hose switch sleeve ID50mm - min 25mm
11.1	91914601	Forma TIG handle with screws, ball joint, without modular switch unit
11.2	91914602	Forma screw for handle

SR 18

Welding-torch TIG water-cooled with import torch body

320A at 60% duty cycle (DC) - 240A at 60% duty cycle (AC)

	Art.-No.	
11.3	91914603	Forma hose bracket with ball joint ID21,5mm (also fits MG-handle)
11.4	91914611	Forma modular switch unit: 1 button with connecting adapter
11.5	91914621	Forma modular switch unit: 2 buttons with connecting adapter
11.6	91914631	Forma modular switch unit: 1 button + potentiometer (10k) with connecting adapter
11.7	91914641	Forma modular switch unit: 2 buttons + up/down (4 switches) with connecting adapter
11.8	91914651	Forma connecting adapter fits control line to modular switch unit
N.i.	91914661	Forma switch module safety nipple
		Please state the machine side connection for the following power/ water cables.
		For 4m long torches:
20	18941401	ST 80 PVC-NIT power/water cable 10mm² SR 18 / 4m
20	18941403	HT 110 rubber fabric hose power/water cable 10mm² SR 18 / 4m
20	18941405	HT 130 TPE power/water cable 10mm² SR 18 / 4m
20	18941408	HT 180 silicone super flexible power/water cable 10mm² SR 18 / 4m
		For 8m long torches:
20	18941801	ST 80 PVC-NIT power/water cable 10mm² SR 18 / 8m
20	18941803	HT 110 rubber fabric hose power/water cable 10mm² SR 18 / 8m
20	18941805	HT 130 TPE power/water cable 10mm² SR 18 / 8m
20	18941808	HT 180 silicone super flexible power/water cable 10mm² SR 18 / 8m
		The following power/ -water cables are produced with a machine side connection inner thread M10x1 to fit an EURO central adaptor (fits all Holch connection systems with outer thread M10x1).
		For 4m long torches:
21	18941411	ST 80 PVC-NIT power/water cable 10mm² SR 18 / 4m
21	18941413	HT 110 rubber fabric hose power/water cable 10mm² SR 18 / 4m
21	18941415	HT 130 TPE power/water cable 10mm² SR 18 / 4m
21	18941418	HT 180 silicone super flexible power/water cable 10mm² SR 18 / 4m
		For 8m long torches:
21	18941811	ST 80 PVC-NIT power/water cable 10mm² SR 18 / 8m
21	18941813	HT 110 rubber fabric hose power/water cable 10mm² SR 18 / 8m
21	18941815	HT 130 TPE power/water cable 10mm² SR 18 / 8m
21	18941818	HT 180 silicone super flexible power/water cable 10mm² SR 18 / 8m
		Reel goods:
		Prices are given per meter and only valid for purchase of complete reels
23	50150001	Meter ST 80 PVC-NIT fabric hose ID5,0-W1,5mm blue for water (100m)
23	51700002	Meter HT 110 rubber fabric hose ID5,0-W1,7mm blue for water (150m)
23.1	50151001	Meter ST 80 PVC-NIT fabric hose ID5,0-W1,5mm red for water (100m)
23.1	51700003	Meter HT 110 rubber fabric hose ID5,0-W1,7mm red for water (150m)
24	31000001	Meter ST 70 PVC hose ID3,0-W1,0mm black for gas (100m)
24	31200002	Meter HT 130 TPE hose ID3-W1,2mm yellow for gas (100m)
N.i.	91902701	Meter control line 3x0,34mm² shielded black (100m)
N.i.	91902711	Meter control line 3x0,5mm² green (100m)
25	91902721	Meter control line 5x0,25mm² grey (100m)
26	22150002	Meter neoprene protective hose ID22mm black (40m)
N.i.	91915004	Leather protective hose ID22mm / 1 meter long
N.i.	91915007	Leather protective hose ID22mm / 1 meter long with ball joint and hose connector

SR 18

Welding-torch TIG water-cooled with import torch body

320A at 60% duty cycle (DC) - 240A at 60% duty cycle (AC)

	Art.-No.	
N.i.	91915013	Hose connector leather protective hose / protection hose ID22,5mm (black) with slot, OD with grooves
34	91901501	Coupling nut IT-G1/4"
N.i.	91901211	Hose connector 4mm fits coupling nut R1/4""
35	91901601	Coupling nut IT-G3/8"
N.i.	91901301	Hose connector 5mm fits Coupling nut R3/8"
36	91901001	Cooling liquid plug nipples EURO
N.i.	91901008	Closing cap blue fits cooling liquid plug nipples EURO
N.i.	91901009	Closing cap red fits cooling liquid plug nipples EURO
37	91904101	Plug 3-poles Tuchel with bayonet-catch
37	91904111	Plug 5-poles Tuchel with bayonet-catch
		More control line plugs please see appendix D.
40	91900701	Terminal nut insulated fits EURO central adapter
41	91900211	TIG central adapter EURO central adapter water cooled
42	91900301	TIG central adapter identical ESAB, 4 contact pins at position 3,4,5,6
42.1	91918571	TIG power/cooling liquid junction fits ESAB central adapter
42.3	91918312	TIG central adapter SK-35 bayonet connection AD13mm
43	91900901	Swivel nut IT-M10x1 (rounded edges) fits EURO central adapter
45	91918327	Power/water plug fits Fronius with 1 O-ring (OT-M10x1 / like EURO central adapter)
45.1	62190001	O-ring ID6,2-W1,9mm fits Fronius
46	9190417e	Power/water plug fits Dalex (1 O-ring) (OT-12x1)
46-A	9190418n	Power-/gasplug fits Dalex with waterdeviation to outside, CW-System with 1 O-ring
46.1	63240001	O-ring ID6,3-W2,4mm fits Dalex
47	9190423n	Power/water plug fits Oerlikon with 1 O-ring (OT-M10x1 / like EURO central adapter)
47.1	60717801	O-ring ID6,07-W1,78mm fits Oerlikon
48	9190420n	Power/water plug fits Lorch SK35 + gas-nipple (OT-10x1 / like EURO central adapter)
48.1	91900801	O-ring ID4-W1mm fits gas-nipple EURO central adapter
49	91900557	TIG cable support short with screws (fits water-cooled)
N.i.	91920702	Screw M3x11,5mm fits Ratio/Industry/RAUCH handle and cable support
N.i.	91920703	M3 mounting socket fits Ratio/Industry/RAUCH handle and cable support
o.A.	91900602	Screw M4x6mm fits TIG cable support short
49.1	91901012	Reduction-eyelet (rubber) from ID10,5mm to ID5mm fits TIG cable support short
N.i.	91921701	PUR hose ID8,5-W1,0mm 150mm long fits leading water hoses into cable support
50	91912801	Spring-socket fits cable support
51	91912601	Cable support spring
52	9190419n	Power/water plug fits Kemppi IT-G1/4“ (AG-M10x1 / like EURO central adapter)
52a	91903503	Insulating sleeve with inner hexagonal shape A/F17 for TIG power-connection IT-G1/4"
53	9190424n	Power/water plug fits Merkle with 2 O-rings (OT-M10x1 / like EURO central adapter)
53.1	81600001	O-ring ID8-W1,6mm fits Lorch/Merkle
54	9190415n	Powerplug fits Cloos (special-plug) (OT-12x1)
o.A	91900552	TIG cable support long (like MIG-MAG) with screws fits ESAB central adapter
N.i.	91900554	Attachment screw M4x8mm fits ESAB central adapter
60	17191312	Import back cap SR 17-18-26 long
61	17191322	Import back cap medium (USA version with red O-ring) SR 17-18-26 57Y03

SR 18

Welding-torch TIG water-cooled with import torch body

320A at 60% duty cycle (DC) - 240A at 60% duty cycle (AC)

	Art.-No.	
62	17191302	Import back cap SR 17-18-26 short
63	17189001	O-ring red ID8-W2mm for back cap
65	17289001	PTFE-back-cap gasket ring SR 17-18-26 18-7
66	17289021	PTFE-isolator SR 17-18-26 18CG
70	17961002	Collet body 17-18-26-220 / 1,0 10N30
70	17961602	Collet body 17-18-26-220 / 1,6 10N31
70	17962402	Collet body 17-18-26-220 / 2,4 10N32
70	18963202	Collet body 17-18-26-220 / 3,2 10N28
70	18964002	Collet body 17-18-26-220 / 4,0 406488
71	17961011	Gas lens 17-18-26-220 / 1,0 45V24
71	17961611	Gas lens 17-18-26-220 / 1,6 45V25
71	17962411	Gas lens 17-18-26-220 / 2,4 45V26
71	18963211	Gas lens 17-18-26-220 / 3,2 45V27
71	18964011	Gas lens 17-18-26-220 / 4,0 45V28
72	17961021	Jumbo-Gas lens 17-18-26-220 / 1,0 45V0204
72	17961621	Jumbo-Gas lens 17-18-26-220 / 1,6 45V116
72	17962421	Jumbo-Gas lens 17-18-26-220 / 2,4 45V64
72	18963221	Jumbo-Gas lens 17-18-26-220 / 3,2 995795
72	18964021	Jumbo-Gas lens 17-18-26-220 / 4,0 45V63
73	17961031	Gas lens "Mini" SR 17-18-26 / 1,0 conversion kit
73	17961631	Gas lens "Mini" SR 17-18-26 / 1,6 conversion kit
73	17962431	Gas lens "Mini" SR 17-18-26 / 2,4 conversion kit
73	18963231	Gas lens "Mini" SR 17-18-26 / 3,2 conversion kit
74	18961003	Collet body "Mini" SR 17-18-26 1,0 conversion kit
74	18961603	Collet body "Mini" SR 17-18-26 1,6 conversion kit
74	18962403	Collet body "Mini" SR 17-18-26 2,4 conversion kit
74	18963203	Collet body "Mini" SR 17-18-26 / 1,0 - 3,2 17CB20 conversion kit
		Brazen collets L-50mm for equipment line (A) standard collet body for equipment line (B) gas lens for equipment line (D) Jumbo gas lens
75	17105002	Collet L50mm SR 17-18-26 wp-18SC / 1,0 10N22
75	17165002	Collet L50mm SR 17-18-26 wp-18SC / 1,6 10N23
75	17245002	Collet L50mm SR 17-18-26 wp-18SC / 2,4 10N24
75	18325002	Collet L50mm SR 17-18-26 wp-18SC / 3,2 10N25
75	18405002	Collet L50mm SR 17-18-26 / 4,0 10N20
		Copper collets L-29mm for equipment line (E) gas lens mini for equipment line (F) standard collet body mini
77	17103002	Collet L29mm SR 17-18-26 "Mini" 1,0 10N22S
77	17163002	Collet L29mm SR 17-18-26 "Mini" 1,6 10N23S
77	17243002	Collet L29mm SR 17-18-26 "Mini" 2,4 10N24S
77	18323002	Collet L29mm SR 17-18-26 "Mini" 3,2 10N25S
78	17089021	PTFE-Gas-lens insulator 17-18-26-220 54N01

SR 18

Welding-torch TIG water-cooled with import torch body

320A at 60% duty cycle (DC) - 240A at 60% duty cycle (AC)

	Art.-No.	
79	17089031	PTFE-Gas-lens insulator Jumbo 17-18-26-220 54N63
		Ceramic gas nozzles in different lengths for equipment line (A) standard collet body
80	17930401	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.4 10N50 (pu=10pieces)
80	17930501	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.5 10N49 (pu=10pieces)
80	17930601	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.6 10N48 (pu=10pieces)
80	17930701	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.7 10N47 (pu=10pieces)
80	17930801	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.8 10N46 (pu=10pieces)
80	17930101	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.10 10N45 (pu=10pieces)
80	17930121	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.12 10N44 (pu=10pieces)
N.i.	17930404	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.4 10N50L (pu=10pieces)
N.i.	17930504	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.5 10N49L (pu=10pieces)
N.i.	17930604	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.6 10N48L (pu=10pieces)
N.i.	17930704	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.7 10N47L (pu=10pieces)
		Ceramic gas nozzles in different lengths for equipment line (B) gas lens
90	22093041	Gas nozzle for gas lens L42mm / Gr.4 54N18 (pu=10pieces)
90	22093051	Gas nozzle for gas lens L42mm / Gr.5 54N17 (pu=10pieces)
90	22093061	Gas nozzle for gas lens L42mm / Gr.6 54N16 (pu=10pieces)
90	22093071	Gas nozzle for gas lens L42mm / Gr.7 54N15 (pu=10pieces)
90	22093081	Gas nozzle for gas lens L42mm / Gr.8 54N14 (pu=10pieces)
90	22093111	Gas nozzle for gas lens L42mm / Gr.11 54N19-11 (pu=10pieces)
90	22093121	Gas nozzle for gas lens L42mm / Gr.12 54N19 (pu=10pieces)
N.i.	22093054	Gas nozzle for gas lens L76mm / Gr.5 54N17L (pu=10pieces)
N.i.	22093064	Gas nozzle for gas lens L76mm / Gr.6 54N16L (pu=10pieces)
N.i.	22093074	Gas nozzle for gas lens L76mm / Gr.7 54N15L (pu=10pieces)
		Ceramic gas nozzles Jumbo in different lengths for equipment line (D) Jumbo gas lnes
95	22093066	Jumbo gas nozzle L48mm / Gr.6 57N75 (pu=10pieces)
95	22093086	Jumbo gas nozzle L48mm / Gr.8 57N74 (pu=10pieces)
95	22093106	Jumbo gas nozzle L48mm / Gr.10 53N88 (pu=10pieces)
95	22093126	Jumbo gas nozzle L48mm / Gr.12 53N87 (pu=10pieces)
N.i.	22093067	Jumbo gas nozzle L73mm / Gr.6 57N75L (pu=10pieces)
N.i.	22093087	Jumbo gas nozzle L73mm / Gr.8 57N74L (pu=10pieces)
N.i.	22093107	Jumbo gas nozzle L73mm / Gr.10 53N88L (pu=10pieces)
N.i.	22093127	Jumbo gas nozzle L73mm / Gr.12 53N87L (pu=10pieces)
		Ceramic gas nozzle for equipment line (E) gaslenses mini
96	17930502	Ceramic gas nozzle L20mm SR 17-18-26 / Gr.5 fits gas lens "Mini" 53N59MS (pu=10pieces)
96	17930602	Ceramic gas nozzle L20mm SR 17-18-26 / Gr.6 fits gas lens "Mini" 53N60MS (pu=10pieces)
96	17930702	Ceramic gas nozzle L20mm SR 17-18-26 / Gr.7 fits gas lens "Mini" 53N61MS (pu=10pieces)
96-C	17930006	Ceramic nozzle for gas lens Kir Royal 17-18-26 / fits tuncsten electrodes up to 3,2mm
		Ceramic gas nozzles different lengths for equipment line (F). Collet body standard mini
97	20930401	Ceramic gas nozzle L30mm / Gr. 4 13N08 (pu=10pieces)

SR 18

Welding-torch TIG water-cooled with import torch body

320A at 60% duty cycle (DC) - 240A at 60% duty cycle (AC)

	Art.-No.	
97	20930501	Ceramic gas nozzle L30mm / Gr. 5 13N09 (pu=10pieces)
97	20930601	Ceramic gas nozzle L30mm / Gr. 6 13N10 (pu=10pieces)
97	20930701	Ceramic gas nozzle L30mm / Gr. 7 13N11 (pu=10pieces)
97	20930801	Ceramic gas nozzle L30mm / Gr. 8 13N12 (pu=10pieces)
97	20930101	Ceramic gas nozzle L30mm / Gr.10 13N13 (pu=10pieces)
N.i.	20930304	Ceramic gas nozzle L48mm / Gr. 3 796F70 (pu=10pieces)
N.i.	20930404	Ceramic gas nozzle L48mm / Gr. 4 796F71 (pu=10pieces)
N.i.	20930504	Ceramic gas nozzle L48mm / Gr. 5 796F72 (pu=10pieces)
o.A	20930604	Ceramic gas nozzle L48mm / Gr. 6 796F73 (pu=10pieces)
N.i.	20930306	Ceramic gas nozzle L63mm / Gr. 3 796F74 (pu=10pieces)
N.i.	20930406	Ceramic gas nozzle L63mm / Gr. 4 796F75 (pu=10pieces)
N.i.	20930506	Ceramic gas nozzle L63mm / Gr. 5 796F76 (pu=10pieces)
N.i.	20930606	Ceramic gas nozzle L63mm / Gr. 6 796F77 (pu=10pieces)
N.i.	20930408	Ceramic gas nozzle L89mm / Gr. 4 796F79 (pu=10pieces)

Premium tungsten electrodes of 8 different kinds in the appendix A.