

HW-24 Torch Family - 80 amp



- Designed to reach into tight places
- Ideal for confined, cramped areas
- High flexibility one-piece cable
- Miniature head provides maximum accessibility to corners and tight joints
- Excellent visibility
- Gas lens available for improved shielding

Specifications

Capacity

75 Amps, 100% duty cycle, ac or dc with standard accessories
 100 Amps, 100% duty cycle, ac or dc with gas lens accessories
 80 Amps, 50% duty cycle, ac or dc with standard accessories

Size

OVERALL LENGTH 7-3/4 in. (197 mm)
 HANDLE DIAMETER 3/4 in. (19 mm)
 LENGTH OF HEAD 1-1/16 in. (27 mm)
 DIAMETER OF HEAD 5/8 in. (16 mm)
 WEIGHT (less cable) 2.5 oz. (71 gm)
 HEAD ANGLE: HW-24 60 or 90 degree

Torch Assemblies

DESCRIPTION	HW-24 HARD BODY
HW-24	
60 deg. head w/concentric cable, 12-1/2 ft.	45V17
90 deg. head w/concentric cable, 12-1/2 ft.	527712

Gas Cups, Collets, & Collet Bodies

ELECTRODE SIZE, in.	.020	.040	1/16	—	
STANDARD COLLET	53N15	53N16	53N14	—	
STANDARD COLLET BODY	53N17	53N18	53N19	—	
GAS LENS COLLET	53N62	53N63	53N64	—	
GAS LENS COLLET BODY	45V41	45V42	45V43	—	
CUP NUMBER	.165-in. I.D.	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16
CERAMIC CUP	53N23	53N24	53N25	53N27	—
CERAMIC CUP, LONG	—	53N28	—	53N26	—
GAS LENS HIGH-IMPACT CUP	—	53N58	53N59	53N60	53N61

For selection of special ceramic cups, see Accessories following Torches.

Torch Parts and Accessories

ITEM	PART NO.	DESCRIPTION	HW-24 TORCH
1	45V16	BODY, HW-24 (60 DEG.)	
	527713	BODY, HW-24 (90 DEG.)	
2	105Z55	HANDLE, HW-24	
3	—	COLLET (see table above)	
4	—	COLLET BODY (see table above)*	
5	—	GAS CUPS (see table above)	
6	53N66	INSULATOR, GAS LENS (Required for gas lens)	
7	53N22	INSULATOR GASKET - std	
8	—	GAS LENS COLLET (see table above)	
9	—	GAS LENS COLLET BODY (see table above)	
10	—	GAS LENS CUP (see table above)	
11	53N43	POWER CABLE ADAPTOR	
12	56Y38	POWER CABLE, 12-1/2 ft.	

*Note: Order wrench (53N20) for HW-24 collet body.



Tig Torch Outfits

When it comes to exceptional quality, value, and the convenience of one-part-number ordering, nobody delivers like GENUINE HELIARC®. These Tig Torch Outfits contain everything you need in one easy-to-use package.



Tig Torch Outfits Designed for H-252 & H-352

COMPONENTS	PART NO.	AIR-COOLED OUTFITS		WATER-COOLED OUTFITS	
		HW-17 604622	HW-26 36678	HW-18 36679	HW-20 604623
HW-17, 60 DEG. 25 ft.	16X50	●			
HW-26, 75 DEG. 25 ft.	46V29		●		
HW-18, 65 DEG. 25 ft.	948362			●	
HW-20, 75 DEG. 25 ft.	948085				●
TORCH ACCESSORY KIT, HW-17,18, 26	999126	●	●	●	
TORCH ACCESSORY KIT, HW-20	999127				●
R-33-FM-580 REGULATOR/FLOWMETER	21557	●	●	●	●
WATER HOSE, 6 ft.	20633			●	●
WORK CABLE & CLAMP w/OKC, 15 ft.	35881	●	●	●	●
GENUINE HELIARC® TIG WELDING HANDBOOK	781F29	●	●	●	●

Tig Torch Outfit Selections for all Other Power Supplies

COMPONENTS	PART NO.	AIR-COOLED OUTFITS								WATER-COOLED OUTFITS	
		HW-17 600991	HW-17V 600992	HW-17RV 36857	HW-17RV-2 600998	HW-17FV 600997	HW-26 600993	HW-26V 600994	HW-26RV-2 600999	HW-18 600996	HW-20 600995
HW-17, 60 DEG. 25 ft.	16X50	●									
HW-17V, 60 DEG. 25 ft.	634706		●								
HW-17RV, 60 DEG. 25 ft.	634706R			●							
HW-17RV-2, 60 DEG. 25 ft.	33814R				●						
HW-17FV, FLEX, 25 ft.	19884					●					
HW-26, 75 DEG. 25 ft.	46V29						●				
HW-26V, 75 DEG. 25 ft.	46V27							●			
HW-26RV-2, 75 DEG. 25 ft.	948128R								●		
HW-18, 65 DEG. 25 ft.	948362								●		
HW-20, 70 DEG. 25 ft.	948085									●	
TORCH ACCESSORY KIT, HW-17,18, 26	999126	●	●	●	●	●	●	●	●		
TORCH ACCESSORY KIT, HW-20	999127										●
R-33-FM-580 REGULATOR/FLOWMETER	21557	●	●	●	●	●	●	●	●	●	●
GAS HOSE, 25 ft.	34V38			●	●			●			
GAS HOSE, 12-1/2 ft.	40V77	●	●			●	●	●	●	●	●
GAS HOSE, 3 ft.	31504	●	●			●	●	●			
WATER HOSE, 6 ft. (2)	20633								●	●	
POWER CBL. ADPTR., HW-17	105Z57	●	●	●		●					
POWER CBL. ADPTR., HW-26	45V62						●	●			
POWER CBL. ADPTR., HW-18, 20	45V11								●	●	
WORK CBL., 15 ft. w/CLAMP & LUG	34886	●	●	●	●	●	●	●	●	●	●
TIG WELDING HANDBOOK	781F29	●	●	●	●	●	●	●	●	●	●

Heliarc®
Torches

Gas-Cooled Torches

	RATING@ 50% DUTY CYCLE	HARD BODY¹ W/HFC™	SILICON RUBBER²	60 DEG. HEAD ANGLE	70/75 DEG. HEAD ANGLE	90 DEG. HEAD ANGLE	180 DEG. HEAD ANGLE	FLEX HEAD	WITH VALVE	WITHOUT VALVE	COMMENTS
HW-24	80 amp	●		●		●				●	MINIATURE, ULTRA LIGHT TORCH
HW-90	120 amp	●			●		●			●	SMALL, LIGHTWEIGHT TORCH
HW-9	140 amp	●			●					●	COMPACT, AIR-COOLED VERSION OF HW-20
HW-9RV-2	140 amp		●		●				●		SEPARATE POWER CABLE & GAS HOSE
HW-9RV	140 amp		●		●				●		ROTARY VALVE
HW-9F	140 amp		●					●		●	FLEXIBLE HEAD VERSION OF HW-20A
HW-17	150 amp	●		●		●			●	●	ROTARY VALVE & SLIDING VALVE AVAIL.
HW-17-2	150 amp	●		●					●	●	SEPARATE POWER CABLE & GAS HOSE
HW-17R	150 amp		●	●		●			●	●	ROTARY VALVE AVAILABLE
HW-17R-2	150 amp		●	●					●	●	SEPARATE POWER CABLE & GAS HOSE
HW-17F	150 amp		●					●	●	●	FLEXIBLE HEAD VERSION
HW-17F-2	150 amp		●					●	●	●	SEPARATE POWER CABLE & GAS HOSE
HW-26	220 amp	●			●				●	●	POPULAR HEAVY DUTY AIR-COOLED TORCH
HW-26-2	220 amp	●			●				●	●	SEPARATE POWER CABLE & GAS HOSE
HW-26R	220 amp		●		●				●	●	CONCENTRIC POWER CABLE
HW-26R-2	220 amp		●		●				●	●	SEPARATE POWER CABLE & GAS HOSE
HW-26F	220 amp		●					●	●	●	FLEXIBLE HEAD VERSION
HW-26F-2	220 amp		●					●	●		SEPARATE POWER CABLE & GAS HOSE

Water-Cooled Torches

	RATING@ 50% DUTY CYCLE	HARD BODY¹ W/HFC™	SILICON RUBBER²	60 DEG. HEAD ANGLE	70/75 DEG. HEAD ANGLE	90 DEG. HEAD ANGLE	180 DEG. HEAD ANGLE	FLEX HEAD	WITH VALVE	WITHOUT VALVE	COMMENTS
HW-20	300 amp	●			●					●	COMPACT, HIGH CURRENT TORCH
HW-20R	300 amp		●		●					●	COMPACT, HIGH CURRENT TORCH
HW-18	425 amp	●		●		●				●	GENERAL PURPOSE
HW-18R	425 amp		●	●						●	GENERAL PURPOSE
HW-25F	200 amp		●				●	●		●	FLEXIBLE HEAD, WATER TORCH
HW-27	400 amp	●					●			●	REAR LOADING MACHINE TORCH

¹ *Hard Body Torches with HFC™ (High temperature Fiber reinforced Composite material) provide the best performance, heat resistance, abrasion resistance, and high frequency resistance.*

² *Rubber bodies provide improved resistance to breakage in rough duty.*

Notes:

- ESAB has made a model change on the HW-9 series torches. The new designation for that series of torches is HW-90.
- ESAB has made a model change on the HW-20A series torches. The new designation for that series of torches is HW-9.

OLD DESIGNATION	NEW DESIGNATION
HW-9	HW-90
HW-20A	HW-9
HW-20AR	HW-9R
HW-20AF	HW-9F
HW-20ARV	HW-9RV
HW-20ARV2	HW-9RV2