



# GENUINE HELIARC® WATER-COOLED TORCHES

## HW-25 Torch Family - 200 amp

- Small, Lightweight
- Flexible head to access difficult joints



## Specifications

### Capacity

200 Amps, 100% duty cycle, ac or dc with standard accessories  
210 Amps, 50% duty cycle, ac or dc with standard or gas lens accessories

### Size

OVERALL LENGTH ..... 10-1/2 in. (267mm)  
HANDLE DIAMETER ..... 3/4 in. (19 mm)  
LENGTH OF HEAD ..... 4-7/8 in. (124 mm)  
DIAMETER OF HEAD ..... 3/4 in. (19 mm)  
WEIGHT (less cable) ..... 14 oz. (400 gm)  
HEAD ANGLE: HW-25 ..... FLEXIBLE  
COOLING REQUIREMENTS ..... 1 qt. min. (0.94 l/min)

## Torch Assemblies

DESCRIPTION	HW-25 SILICON RUBBER
FLEXIBLE HEAD	
HW-25 – 12 w/12 ft. cable	45V36
HW-25 – 25 w/25 ft. cable	45V37

## Cups, Collets, & Collet Bodies

ELECTRODE SIZE, in.	.020	.040	1/16	3/32	1/8	—
STANDARD COLLET	13N20	13N21	13N22	13N23	13N24	—
STANDARD COLLET BODY	13N25	13N26	13N27	13N28	13N29	—
GAS LENS COLLET BODY	45V41	45V42	45V43	45V44	45V45	—
CUP NUMBER	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16	8 = 1/2	10 = 5/8
HIGH-IMPACT CUP	13N08	13N09	13N10	13N11	13N12	13N13
CERAMIC CUP	13N14	13N15	13N16	13N17	13N18	13N19
GAS LENS HIGH-IMPACT CUP	53N58	53N59	53N60	53N61	—	—

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

## Torch Parts & Accessories

ITEM	PART NO.	DESCRIPTION	HW-25 TORCH
1	45V38	BODY, HW-25	
2	53N55	HANDLE, HW-25	
3	53N45	FLEX SLEEVE INSULATOR	
4	53N47	INSULATOR	
5	—	COLLET (see table above)	
6	—	COLLET BODY (see table above)	
7	—	CERAMIC CUP (see table above)	
	45V03	POWER CABLE, 12-1/2 ft.	
	45V04	POWER CABLE, 25 ft.	
	45V07	WATER HOSE, 12-1/2 ft.	
	45V08	WATER HOSE, 25 ft.	
	45V09	GAS HOSE, 12-1/2 ft.	
	45V10	GAS HOSE, 25 ft.	
	11N16	WATER ADAPTOR (5/8-18 LH TO 1/4 NPT) (not shown)	





## 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

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

<sup>2</sup> *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