

## HW-27 Torch Family - 400 amp



- Front or back loaded
- Internal tungsten adjustment
- Model A with 9" length is designed for clamp-type fixture
- Model B with 20" length is designed for pinion-type fixture

## Specifications

### Capacity

400 Amps, 100% duty cycle, ac or dc with high impact cups  
500 Amps, 100% duty cycle, ac or dc with metal nozzles  
400 Amps, 50% duty cycle, ac or dc

### Size

	27A	27B
OVERALL LENGTH.....	9 in. (230 mm)	20 in. (500 mm)
DIAMETER OF TORCH .....	1-3/8 in. (34 mm)	1-3/8 in. (34 mm)
WEIGHT (less cable) .....	24 oz. (96 gm)	36 oz. (144 gm)
COOLING REQUIREMENTS .....	2 qt. min. (1.91 l/min)	2 qt. min. (1.91 l/min)
MAXIMUM PRESSURE .....	50 psi	50 psi
ELECTRODE CAPACITY .....	.040-1/4" dia.	.040-1/4" dia.

## Torch Assemblies

DESCRIPTION	HW-27 SILICON RUBBER
<b>HW-27A – 9"</b>	
HW-27A – 4 w/4 ft. cable	20955
HW-27A – 12 w/12 ft. cable	20954
<b>HW-27B – 20"</b>	
HW-27BL – 4 w/4 ft. cable	20017
HW-27B – 12 w/12 ft. cable	20018

## Cups, Collets, & Collet Bodies

ELECTRODE SIZE, in.	.040	1/16	3/32	1/8	5/32	3/16	1/4
STANDARD COLLET	57N45	57N46	57N47	57N48	57N49	57N50	57N51
STANDARD COLLET BODY (includes gasket - 57N56)	49V22	49V23	49V24	49V25	49V26	49V27	49V28
<b>CUP NUMBER</b>	<b>6=3/8</b>	<b>8=1/2</b>	<b>10=5/8</b>	<b>12=3/4</b>	<b>15=15/16</b>	<b>SHORT</b>	<b>—</b>
HIGH-IMPACT CUP	—	57N75	57N74	53N88	53N87	53N89	—
METAL NOZZLE*	—	—	57N78	57N77	—	—	—

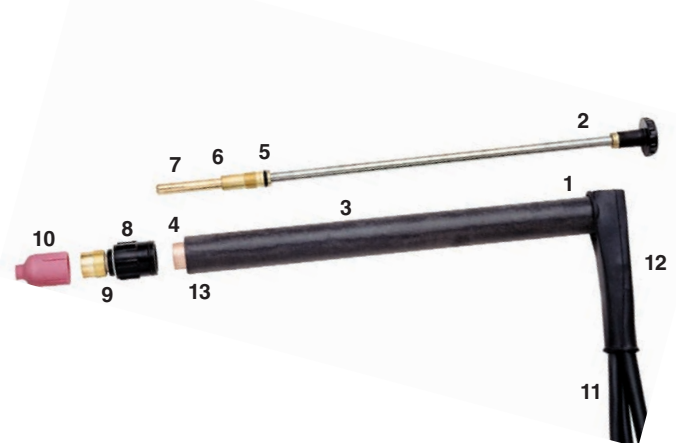
\*Adaptor 57N76 required

Short nozzle not recommended for high frequency current

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

## Torch Parts & Accessories

ITEM	PART NO.	DESCRIPTION	HW-27 TORCH
1	20019	BODY, HW-27	
2	20157	SHAFT & KNOB ASSY. (A-model)	
	20021	SHAFT & KNOB ASSY. (B-model)	
3	20956	BARREL (A-model)	
	20020	BARREL (B-model)	
4	20957	SHAFT ASSY. (A-model)	
	20021	SHAFT ASSY. (B-model)	
5	85W44	O-RING	
6	14K09	O-RING	
7	—	COLLET (see table above)	
8	—	COLLET BODY (see table above)	
9	57N56	GASKET	
10	—	GAS CUP (see table above)	
11	20023	POWER CABLE, 12-1/2 ft.	
	20024	POWER CABLE, 4-1/2 ft.	
	20025	WATER CABLE, 4-1/2 ft.	
	20026	WATER CABLE, 12-1/2 ft..	
	20027	GAS HOSE, 4-1/2 ft.	
	20028	GAS HOSE, 12-1/2 ft.	
12	20022	BOOT	
13	20029	O-RING, TORCH BODY (not shown)	
	20032	OPTIONS (HW-27B only) – HW-27B BACK (32 pitch), rack length 11-11/16 in.	



## 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