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7





Soldering & Welding

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Soldering & Welding

System Overview

Cartridge Brazing

	SUPER FIRE 3	SUPER FIRE 4	POWER FIRE Compact	ROFIRE Swivel PRO Cyclone (Piezo)	ROFIRE Swivel PRO Twin
					
Soft Soldering: 	up to Ø 35 mm	up to Ø 35 mm	up to Ø 28 mm	up to Ø 42 mm	up to Ø 64 mm
Brazing: 	up to Ø 28 mm	up to Ø 28 mm	up to Ø 22 mm	up to Ø 18 mm	up to Ø 28 mm
Special application:	Shrinking, Removal of paint	Shrinking, Removal of paint	—	—	—
For use with:	MAPP® ¹⁾ -Gas, Maxigas 400, Multigas 300	MAPP® ¹⁾ -Gas, Maxigas 400, Multigas 300	MAPP® ¹⁾ -Gas, Maxigas 400, Multigas 300	MAPP® ¹⁾ -Gas ²⁾ , Maxigas 400 ²⁾ , Multigas 300 ²⁾	MAPP® ¹⁾ -Gas ²⁾ , Maxigas 400 ²⁾ , Multigas 300 ²⁾
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Cartridge Soft Soldering

Roofing & Sheet Metal Works

	ROFLAME PIEZO	ROFIRE (PIEZO), EASY FIRE	MULTI MOBILE	MULTI 300 Propane Soft Soldering kit	ROOFING-SET
					
Soft Soldering: 	up to Ø 22 mm	up to Ø 22 mm	✓	✓	✓
Brazing: 	–	up to Ø 15 mm	–	–	–
Special application:	–	–	Sheet metal working	Sheet metal working	Bonding of bituminous sheeting
For use with:	Supergas C200	Multigas 300	Multigas 110	Propane, Butane	Propane, Butane
Page	156	157	165	166	167








Cartridges

	MAPP® ¹⁾ -Gas	Maxigas 400	Multigas 300	C 200 Supergas	Multigas 110
					
Flame temperature:	up to 2.700 °C	up to 2.200 °C	up to 1.900 °C	up to 1.800 °C	up to 1.900 °C
Application:	Soft sodering & Brazing	Soft sodering & Brazing	Soft Soldering	Soft Soldering	Soft Sodering
Valve:	EU 7/16"	EU 7/16"	EU 7/16"	Piercable cartridge	EU 7/16"
Content:	750 ml / 415 g	600 ml / 352 g	600 ml / 338 g	314 ml / 190 g	110 ml / 60 g
Page	158	159	159	159	159

Brazing & Soft Soldering devices




	ROFLASH	RE 17	ALLGAS 2000 PS 0,5/2 Compact	ALLGAS MOBILE Pro	ROXY 400 L
					
Soft Soldering: 	✓	✓	✓	✓	✓
Brazing: 	✓	✓	✓	✓	✓
Welding: 	0,2 - 14 mm	0,5 - 14 mm	0,2 - 5 mm	0,2 - 5 mm	0,5 - 2 mm
Cutting:	3-75 mm	12-100 mm	–	–	–
For use with:	Acetylene & Oxygen	Acetylene & Oxygen, Maxigas 400	Propane & Oxygen	MAPP® ¹⁾ -Gas & Oxygen	Maxigas 400 & Oxygen
Page	175	176	172	173	174

Cylinder Brazing & Soft Soldering

	AIRAC®	ROCOLT Handy Piezo	AIRPROP	TURBOPROP	ROTHERM 2000
					
Soft Soldering: 	up to Ø 54 mm	up to Ø 70 mm	up to Ø 54 mm	up to Ø 54 mm	up to Ø 54 mm
Brazing: 	up to Ø 35 mm	up to Ø 32 mm	up to Ø 22 mm	up to Ø 28 mm	–
Special application:	–	–	–	–	Soft soldering without flame
For use with:	Acetylene	Propane, Butane	Propane, Butane	Propane, Butane	230 V
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Cartridges & Cylinders

	Acetylene	Oxygen
		
Application:	Brazing, Welding, Cutting	Brazing, Welding, Cutting
Valve:	DIN 477-1	M 10x1 (One-way) / G 3/4" RH
Pressure:	19 bar	100 bar (One-way) / 200 bar
Content:	5 l, 10 l	930 ml (One-way) / 2 l, 5 l, 10 l
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-  Soft Soldering up to 450°C
-  Brazing 450°C - 1100°C
-  Gas Welding > 1100°C

¹⁾ MAPP® is a registered trademark of the MESSER Group GmbH, Bad Soden

Bonding

Cartridge Brazing

SUPER FIRE 3

Ergonomic HEAVY-DUTY brazing unit up to Ø 28 mm

For soft soldering, brazing and other applications such as removal of paint or shrinking of hoses



Product Profile

APPLICATION AREA

Brazing: up to Ø 28 mm (with flame reflector in a wind protected environment)
Soft soldering: up to Ø 35 mm

KEY FEATURES

- Rapid heat-up, less consumption!
- Long service life
- "Twist 'N' Load" system (5 different nozzles available)
- Precise flame adjustment
- Up to 2.5 hours of brazing with one cartridge

KEY FEATURES

- Even more comfortable for longer jobs
- Reliable Piezo ignition (up to 30,000 ignitions)
- Double the safety because there is no gas leakage without locked nozzle (Piezo ignition)

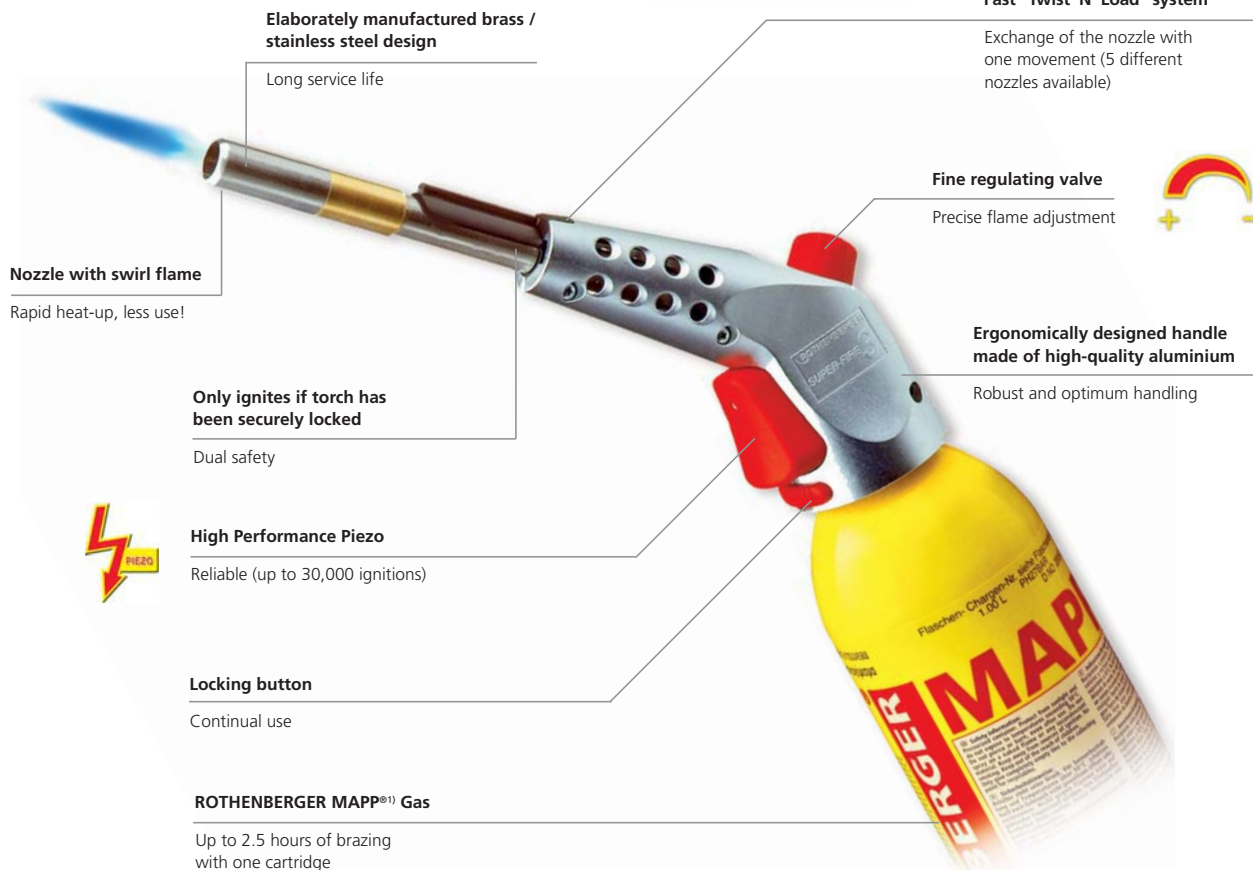
TECHNICAL DATA

Coupling: 7/16" EU
Handle: Aluminium, bolted
Burner: Brass / stainless steel

SUPER FIRE 3 Nozzles

Quick exchange with the "Twist 'N' Load" system

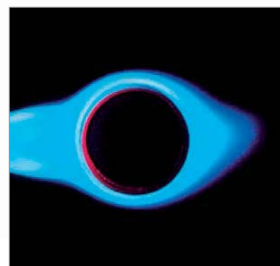
"Twist 'N' Load"



Brazing in gas installation



High flame temperature through cyclone swirl



Brazing in aircon and refrigeration



Pin-point Nozzle (460 °C):



For fine soldering; precise and stable flame

Standard Nozzle (700 °C):



For soft soldering and other jobs with lower heat application; precise, powerful and stable flame

Cyclone Nozzle (950 °C):



For hand and soft soldering with an efficient swirl flame (allows pipe to heat up evenly)

Hot air Nozzle (400 °C):



For the removal of paint and for shrinking work up to approx. 80 mm diameter; wind-stable, powerful current of hot air

Shrinking Nozzle (720 °C):



For shrinking up to ø 300 mm and for heating; powerful, wind-stable soft flame

SUPER FIRE 3 HOT BOX

KEY FEATURES

- The ideal service kit
- For repairs, heating installations and refrigeration / air-conditioning technology



5 part set (No. 35490) includes: handle (No. 35445), cyclone nozzle (No. 35457), pin-point nozzle (No. 35455), flame reflector (No. 31043), universal torch support (No. 35461), 2 x MAPP® gas cartridges (No. 035551-A), carrying case (No. 30898)

Model			No.
SUPER FIRE 3 HOT BOX	1	4	35490

SUPER FIRE 3 Basic Set

Set (No. 35436) includes:
handle (No. 35445), cyclone nozzle (No. 35457)

SUPER FIRE 3 MAPP®¹⁾ Set

Set (No. 35432) includes:
handle (No. 35445), cyclone nozzle (No. 35457),
MAPP® gas cartridge (No. 035551-A)



No. 035648X

When placing your order, remember to order the universal torch support (No. 35461) for stationary soldering, too!

Model			No.
SUPER FIRE 3 Basic Set	1	4	35436
SUPER FIRE 3 MAPP® Set	1	10	35432
SUPER FIRE safety adaptor 7/16" to 1"	1	1	035648X



No. 35436



No. 35432

ACCESSORIES



Model		Model	
Welding blanket	181	External brush for copper pipe	181
Internal brush for copper pipe	181	ROVLIES®	181
Solder	183 - 187	Soft-soldering paste ROSOL	183

1) MAPP® is a registered trademark of the MESSER Group GmbH, Bad Soden

Bonding

Cartridge Brazing

SUPER FIRE 4

Ergonomic Brazing Unit

For brazing up to Ø 28 mm and soft soldering up to Ø 35 mm as well as other applications such as removal of paint or shrinking of hoses



Product Profile

APPLICATION AREA

- Brazing:** up to Ø 28 mm (with flame reflector in a wind protected environment)
- Soft soldering:** up to Ø 35 mm

KEY FEATURES

- Rapid heat-up, less consumption!
- "Twist 'N' Load" system (5 different nozzles available) – exchange of the nozzle with only one movement
- Precise flame adjustment
- Improved Fine regulation mechanism for one-handed-operation

KEY FEATURES

- Reliable Piezo ignition (up to 30,000 ignitions)
- Double the safety because there is no gas leakage without locked nozzle (Piezo ignition)
- Longer handle for an even more stable positioning of the Cartridge

TECHNICAL DATA

- Coupling:** 7/16" EU
- Handle:** Aluminium, rubberized
- Burner:** Brass / Stainless steel

Nozzle with swirl flame

Rapid heat-up, less use!

Fast "Twist 'N' Load" system

Exchange of the nozzle with one movement (5 different nozzles available)

Optimized fine regulating valve

Precise flame adjustment, faster opening and closing

Elaborately manufactured brass / stainless steel design

Long service life

Dual safety

Only ignites if torch has been securely locked

High Performance Piezo

Reliable (up to 30,000 ignitions)

Locking button

Continual use with only one hand

Ergonomically designed handle

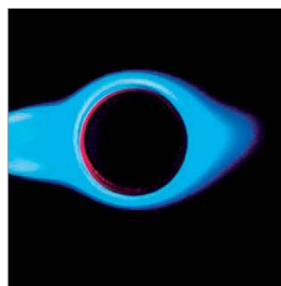
Robust, light and slipfree through rubberized surface

- ✓ Safe
- ✓ Fast
- ✓ Reliable

Brazing in aircon and refrigeration



High flame temperature through cyclone swirl



Brazing in aircon and refrigeration



Pin-point Nozzle (460 °C):



For fine soldering; precise and stable flame

Standard Nozzle (700 °C):



For soft soldering and other jobs with lower heat application; precise, powerful and stable flame

Cyclone Nozzle (950 °C):



For hand and soft soldering with an efficient swirl flame (allows pipe to heat up evenly)

Hot air Nozzle (400 °C):



For the removal of paint and for shrinking work up to approx. 80 mm diameter; wind-stable, powerful current of hot air

Shrinking Nozzle (720 °C):



For shrinking up to ø 300 mm and for heating; powerful, wind-stable soft flame

SUPER FIRE 4 HOT BOX

KEY FEATURES

- The ideal service kit
- For repairs, heating installations and refrigeration / air-conditioning technology



5 part Set (No. 1000001264) includes: handle (No. 1500001354), cyclone nozzle (No. 35457), pin-point nozzle (No. 35455), flame reflector (No. 31043), universal torch support (No. 35461), 2 x MAPP® gas cartridges (No. 035551-A), Carrying case (No. 1500001493), Inlay (No. 1500001491)

Model			No.
SUPER FIRE 4 HOT BOX	1	4	1000001264

SUPER FIRE 4 Basic Set

Set (No. 1500001355) includes:
handle (No. 1500001354), cyclone nozzle (No. 35457)

SUPER FIRE 4 MAPP® Set

Set (No. 1000001263) includes:
handle (No. 1500001354), cyclone nozzle (No. 35457),
MAPP® gas cartridge (No. 035551-A)



No. 035648X

When placing your order, remember to order the universal torch support (No. 35461) for stationary soldering, too!

Model			No.
SUPER FIRE 4 Basic Set	1	4	1500001355
SUPER FIRE 4 MAPP® Set	1	10	1000001263
SUPER FIRE Safety adaptor 7/16" on 1"	1	1	035648X



No. 1500001355



No. 1000001263

ACCESSORIES



Model		Model	
Welding blanket	181	External brush for copper pipe	181
Internal brush for copper pipe	181	ROVLIES®	181
Solder	183 - 187	Soft-soldering paste ROSOL	183

Bonding

Cartridge Brazing / Soft Soldering

POWER FIRE Compact

PROFESSIONAL brazing- Ø 22 mm
and soft soldering unit up to Ø 28 mm

APPLICATION AREA

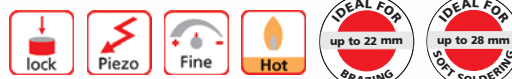
Coupling: 7/16" EU
Brazing: up to Ø 22 mm
Soft soldering: up to Ø 28 mm

KEY FEATURES

Characteristics

- With Piezo ignition button
- For use in all positions (MAPP®¹⁾ Gas)
- Compact and 45% lighter (compared to POWER FIRE)

Model	No.
POWER FIRE Compact set (torch, MAPP® ¹⁾ Gas)	35424
POWER FIRE Compact, EU-handle	30813



No. 35424



7

ROFIRE Swivel PRO Piezo Cyclone

Cyclone burner with Piezo ignition

Coupling: 1" US
Brazing: up to Ø 18 mm
Soft soldering: up to Ø 42 mm



Model	No.
-------	-----

ROFIRE SWIVEL PRO Cyclone Piezo US 35016

ROFIRE Swivel PRO Cyclone

Cyclone burner

Coupling: 1" US
Brazing: up to Ø 18 mm
Soft soldering: up to Ø 42 mm



Model	No.
-------	-----

ROFIRE SWIVEL PRO Cyclone US 35014

ROFIRE Swivel PRO Twin

Twin cyclone burner

Coupling: 1" US
Brazing: up to Ø 28 mm
Soft soldering: up to Ø 64 mm



Model	No.
-------	-----

ROFIRE SWIVEL PRO Twin US 35012

ROFLAME PIEZO

CLASSIC soft soldering unit Ø 22 mm

APPLICATION AREA

Coupling: Pluggable cartridge
Soft soldering: up to Ø 22 mm

KEY FEATURES

- High-performance torch with stable, ergonomic handle, including Piezo ignition and fine flame adjustment
- Comfortable one-handed use and secure storage surface
- Piezo Ignition
- Precise adjustment of the flame
- Exchangeable torch nozzles in case of repair is needed



Model	No.
-------	-----

ROFLAME PIEZO 1800 °C (w/o gas cartridge C 200) 750 35419

1) MAPP® is a registered trademark of the MESSER Group GmbH, Bad Soden

ROFIRE®

ECONOMY soft soldering unit up to Ø 22 mm

APPLICATION AREA

Coupling: 7/16" EU
Brazing: up to Ø 15 mm
Soft soldering: up to Ø 22 mm



KEY FEATURES

- Torch with integrated support bracket
- Precise adjustment of the flame with the fine adjustment valve
- Exchangeable torch nozzles in case of repair is needed

Model	g	No.
ROFIRE® 1800 °C set (torch, Multigas 300)	760	35428
ROFIRE® 1800 °C handle	240	35506



ROFIRE® PIEZO

CLASSIC soft soldering unit Ø 22 mm

Powerful soldering unit for CU-brazing joints up to Ø 15 mm and soft soldering up to Ø 22 mm

APPLICATION AREA

Coupling: 7/16" EU
Brazing: up to Ø 15 mm
Soft soldering: up to Ø 22 mm



KEY FEATURES

- Piezo Ignition
- Precise adjustment of the flame
- Torch head with integrated support bracket
- Exchangeable torch nozzles in case of repair is needed

Model	g	No.
ROFIRE® PIEZO set (torch, Multigas 300)	760	35429
ROFIRE® PIEZO handle	250	35556



EASY FIRE

ECONOMY soft soldering up to Ø 22 mm

High performance torch with Piezo ignition

APPLICATION AREA

Coupling: 7/16" EU
Brazing: up to Ø 15 mm
Soft soldering: up to Ø 22 mm



KEY FEATURES

- Piezo ignition
- Precise adjustment of the torch flame
- Suitable for Multigas 300

Model	g	No.
EASY FIRE set (torch, Multigas 300)	730	35553
EASY FIRE torch without gas	260	35552



Bonding

Cartridge Brazing

MAPP®¹⁾ Gas

Special gas mix for high-performance soldering work

Flame temperatures up to 2,700 °C and 35 % faster than propane



Product Profile	
KEY FEATURES <ul style="list-style-type: none"> Extremely high flame temperature, utmost burning performance and guaranteed short working times Guaranteed constant top torch performance 	KEY FEATURES <ul style="list-style-type: none"> Easy to use Increased user safety through the sandwich valves and aluminium mono-block cylinder Longer periods of use

7

Contains no BUTADIEN

Poses no health risks

ROTHENBERGER MAPP®¹⁾ Gas is produced in ultra-modern filling plants and processor-controlled batching systems

Guaranteed constant top torch performance

Special gas mixture with outstanding flame characteristics

Extreme flame temperatures, utmost torch performance and guaranteed short working times

7/16" Sandwich valve

Increased safety



Less weight compared to conventional steel cylinders (228g empty)

Easy to use

MAPP®¹⁾ monoblock aluminium cylinder

TÜV tested gas cartridge (drawn from solid material)

Increased safety for the user

Burns approx. 1/3 longer than propane

Up to 2.5 hours of use



Fig. MAPP®¹⁾ Gas

Model	Contents		No.
MAPP® ¹⁾ gas cartridge	750 ml	12 / 360	035551-A
Languages: DE, GB, FR, ES, IT, PT			
MAPP® ¹⁾ gas cartridge	750 ml	12 / 360	035551-B
Languages: DK, NL, SE, FI, FR, RUS			
MAPP® ¹⁾ gas cartridge	750 ml	12 / 360	035551-C
Languages: CZ, PL, HU, BG, TR, RO			
Burners can be found starting on 152			

1) MAPP® is a registered trademark of the MESSER Group GmbH, Bad Soden

Packaging Profile


Model	MAPP® ¹⁾ Gas
No.	035551-A
EAN Code	4004625355510 (A)
Product size (mm) (W x H)	80 x 285
Contents (ml)	750
Weight (g)	415
Unit per PU	12
PU per layer / palette	8
Layer per palette	3
Units per palette	288
Number of palettes per truckload	60
Units per truckload	17,280
Palette weight (kg)	241
Palette size (mm) (L x W x H)	800 x 1.200 x 1.000
Carton size (mm) (L x W x H)	320 x 295 x 250

Cartridge Brazing / Soft Soldering

Maxigas 400

High-performance welding, cutting and brazing gas for flame temperatures up to 2,200 °C. Gas cartridge with 7/16" EU coupling thread




Model	Maxigas 400
No.	035570-A/-B
EAN Code	4004625355701 (A)
Product size (mm) (W x H)	65 x 260
Contents (ml)	600
Weight (g)	352
Unit per PU 	24
PU per layer / palette	9
Layer per palette	3
Units per palette	648
Number of palettes per truckload	60
Units per truckload	38,880
Palette weight (kg)	195
Palette size (mm) (L x W x H)	800 x 1.200 x 1.000
Carton size (mm) (L x W x H)	405 x 272 x 264

Multigas 300

Propane / butane gas mixture for flame temperatures up to 1,900 °C. Gas cartridge with 7/16" EU coupling thread




Model	Multigas 300
No.	035510-A/-B
EAN Code	4004625355107 (A)
Product size (mm) (W x H)	65 x 260
Contents (ml)	600
Weight (g)	332
Unit per PU 	24
PU per layer / palette	9
Layer per palette	3
Units per palette	648
Number of palettes per truckload	60
Units per truckload	38,880
Palette weight (kg)	191
Palette size (mm) (L x W x H)	800 x 1.200 x 1.000
Carton size (mm) (L x W x H)	405 x 272 x 264

Multigas 110

Gas cartridges for flame temperatures up to 2.100 °C, suitable for MULTI MOBILE soft soldering unit. The special construction allows 360°-overhead operation. With EU-coupling 7/16"




Model	Multigas 110
No.	1500000459
EAN Code	4004625378977
Product size (mm) (W x H)	45 x 150
Contents (ml)	110
Weight (g)	60
Unit per PU 	12
VPE prer layer / palette	30
Layer per palette	5
Units per palette	1.800
Number of palettes per truckload	60
Units per truckload	108.000
Palette weight (kg)	198
Palette size (mm) (L x W x H)	800 x 1.200 x 1.000
Carton size (mm) (L x W x H)	185 x 140 x 160

Supergas C 200 TSS

Pierceable butane cartridge with propane contents, also for working at low temperatures. Manufactured according to new EN 417:2012, with integrated Top Safe System (TSS). This system prevents uncontrolled gas leakage when accidentally disconnecting it from the device.



Model	C 200 TSS
No.	035901-A/-B
EAN Code	4004625390627 (A)
Product size (mm) (W x H)	90 x 95
Contents (ml)	330
Weight (g)	190
Unit per PU 	36
VPE pro Lage / Palette	9
Layer per palette	3
Units per palette	972
Number of palettes per truckload	60
Units per truckload	58.320
Palette weight (kg)	350
Palette size (mm) (L x W x H)	800 x 1.200 x 1.180
Carton size (mm) (L x W x H)	360 x 275 x 280

Bonding

Cylinder Brazing

ROCOLT HANDY PIEZO Set

Professional brazing system with quick-change torch

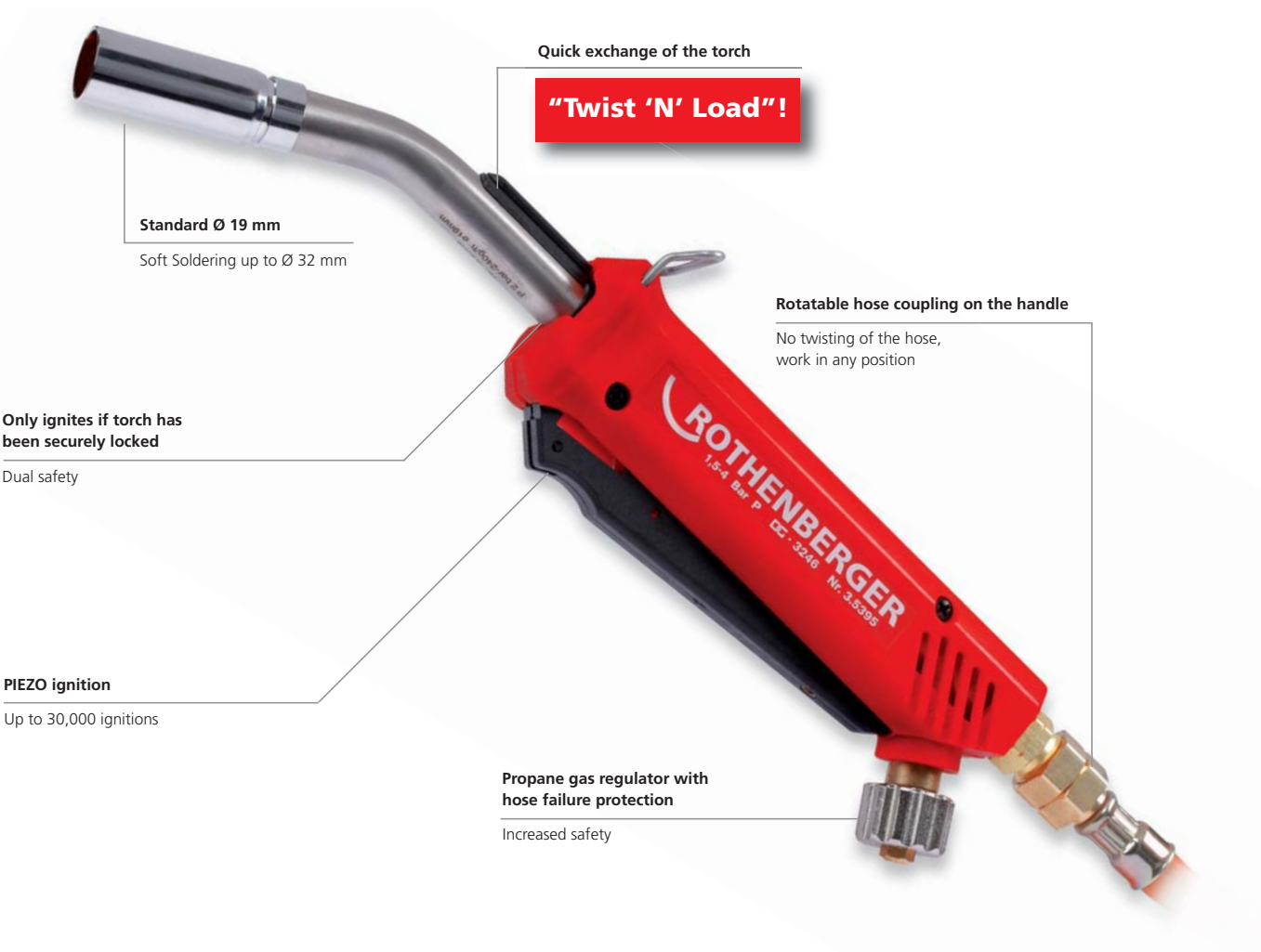
Three torch nozzles for different applications



Product Profile	
APPLICATION AREA	
Brazing:	up to Ø 18 mm
Soft soldering:	up to Ø 32 mm
Warming-up:	up to Ø 60 mm
KEY FEATURES	
<ul style="list-style-type: none">Three torch nozzles for different applicationsReliable PIEZO ignition for up to 30,000 ignitionsIncreased safety with the hose failure protection	

KEY FEATURES	
<ul style="list-style-type: none">No twisting of the hose, work in any positionTool-free nozzle exchange with the fast "Twist 'N' Load" system	
TECHNICAL DATA	
Coupling:	G 3/8" LH
Handle:	Plastic, with screws
Burner:	Brass / stainless steel

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PIEZO ignition



Application with flame reflector



Brazing



Soft soldering



ROCOLT HANDY PIEZO Set

8-part set (No. 35390) includes: Rocolt handle (No. 35395), standard torch 19 mm (No. 35378), cyclone torch 19 mm (No. 35398), pressure reducer including rotatable hose failure protection (No. 35356), propane hose 3 m (No. 35383), flame reflector 65 mm (No. 31043), ROVLIES® (No. 45268), plastic carrying case (No. 30898)



With flame reflector!



Model	kg	No.
ROCOLT HANDY PIEZO Set	1.5	35390
ROCOLT HANDY Handle	0.3	35395

ROCOLT HANDY PIEZO Standard Torch

Standard torch with extremely short, bundled flame for low consumption. Ideal burner for brazing, soft soldering, warming up, annealing, hardening, etc.



Soft soldering Ø 32 mm
(No. 35378)



ROCOLT HANDY PIEZO Cyclone Torch

Cyclone torch with optimum enveloping flame aspect when soldering pipes and fittings. Ideal burner for brazing, soft soldering, warming up, annealing, hardening, etc.



Soft soldering Ø 28 mm
Brazing Ø 15 mm
(No. 35397)

Soft soldering Ø 32 mm
Brazing Ø 18 mm
(No. 35398)

Soft soldering Ø 70 mm
Brazing Ø 32 mm
(No. 35399)



Model	Torch Ø mm	g	No.	Model	Torch Ø mm	g	No.
PIEZO Standard Torch	19	150	35378	PIEZO Cyclone Torch	14	180	35397
				PIEZO Cyclone Torch	19	150	35398
				PIEZO Cyclone Torch	25	180	35399

ACCESSORIES



Model		Model	
Welding blanket	181	External brush for copper pipe	181
Internal brush for copper pipe	181	ROVLIES®	181
Solder	183 - 187	Soft-soldering paste ROSOL	183

Bonding

Cylinder Brazing

AIRPROP®

Propane high-performance torches for brazing up to Ø 22 mm and soft soldering up to Ø 54 mm

For brazing and soft soldering of copper and steel pipes up to 2,000 °C without oxygen, as well as warming up, shrinking and flame cleaning



Product Profile

KEY FEATURES

- Bundled, concentrated and hot flame with the built-in gas turbine in brazing torch
- Absolutely gas-tight with the optimised valve technology
- Gas-saving operation with the smooth-running economy valve
- Fast burner exchange without tools

TECHNICAL DATA

Self-induced air:	Turbine and combustion chamber
Torch:	Surface treated, chromed brass
Hose coupling:	G 3/8" LH

Built-in gas turbine in brazing torch

Bundled, concentrated and hot flame

Smooth-turning economy valve

Gas-saving operation

Optimised valve technology

Absolutely gas tight

Shut-off valve

Prevents uncontrolled gas escape

Absolutely gas-tight connection thanks to dual O-ring technology

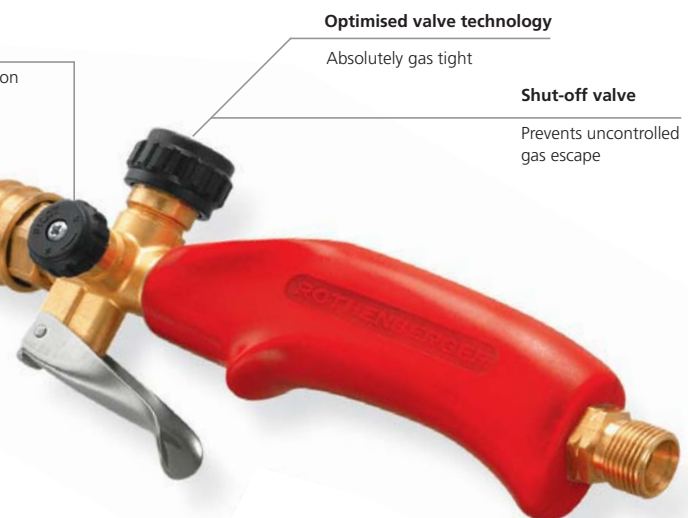
Fast burner exchange without tools



No. 31092

Sets include: Safety handle with push-in coupling (No. 211121116), brazing torch with push-in nipple Ø 14 mm (No. 221131416) / Ø 16 mm (No. 221131616) / Ø 19 mm (No. 221131916), 2.5 m propane hose with 3/8" LH coupling (No. 32201), safety igniter (No. 32077), replacement flints (No. 32088), open-ended spanner (No. 32073), steel case (No. 31005)

Model	kg	No.
AIRPROP® Brazing set without propane regulator	2.8	31092
AIRPROP® Brazing set with propane regulator (as in set (No. 31092) but with regulator (No. 32081) (W 21.8 L – G 3/8 LH))	3.1	31091
Flame cleaning torch 20/50 mm	0.2	30922



Threaded coupling
M14 x 1



Push-in nipple

AIRPROP® brazing burner with threaded coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
14 mm	140	125	1.60 – 1,375 – 5,465	95	30913
16 mm	145	180	2.30 – 3,300 – 7,885	100	30914
19 mm	170	300	3.84 – 3,300 – 13,115	130	30915
22 mm	171	400	5.12 – 4,400 – 26,195	145	30916

AIRPROP® brazing burner with push-in nipple coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
14 mm	140	125	1.60 – 1,375 – 5,465	95	221131416
16 mm	145	180	2.30 – 3,300 – 7,885	100	221131616
19 mm	170	300	3.84 – 3,300 – 13,115	130	221131916
22 mm	171	400	5.12 – 4,400 – 26,195	145	221132216

Bonding

Cylinder Brazing

TURBOPROP

Propane high-performance torch for brazing up to Ø 28 mm and soft soldering Ø 54 mm

For brazing and soft soldering of copper and steel pipes up to 2,200 °C without oxygen, as well as for warming up, shrinking and flame cleaning



Product Profile

KEY FEATURES

- High flame temperature due to turbine with increased oxygen self-induced air and 4- to 5-fold flame chamber
- Fast burner exchange without tools
- Gas-saving operation with the smooth-running economy valve
- Shut-off valve prevents uncontrolled gas escape

TECHNICAL DATA

Self-induced air:	Turbine and combustion chamber
Torch:	Surface treated, chromed brass
Hose coupling:	G 3/8" LH

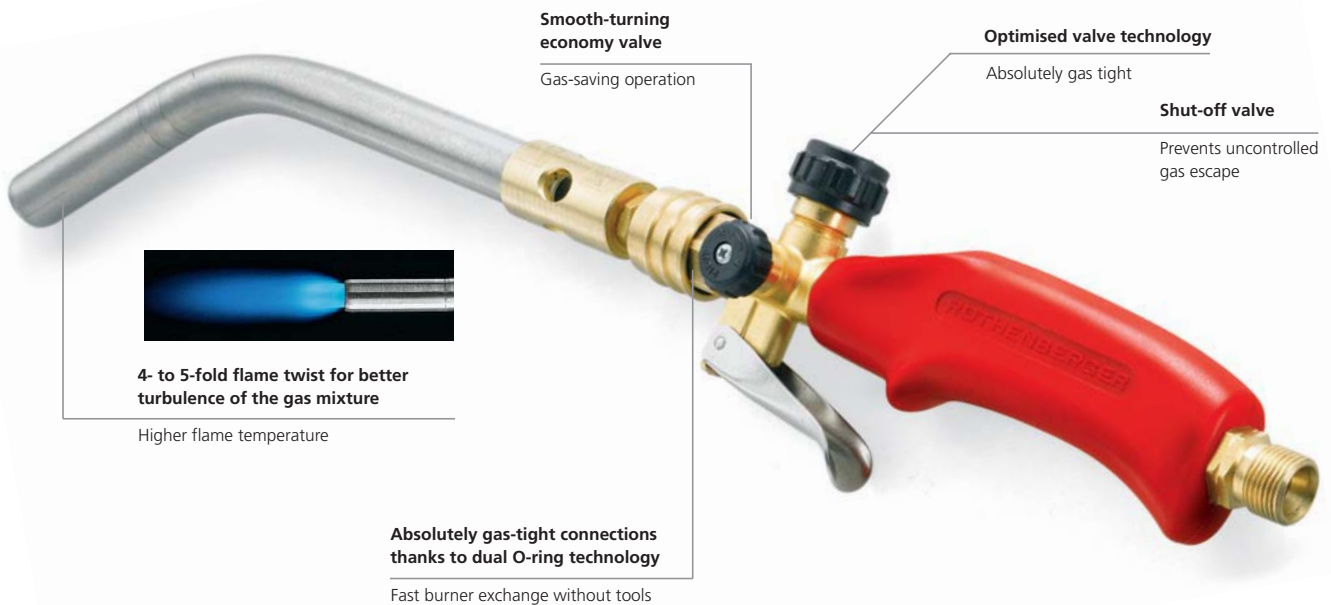


Fig. TURBOPROP torch with push-in nipple

Sets include: Safety handle with push-in coupling (No. 211121116), brazing torch with push-in nipple Ø 12 mm (No. 31032) / Ø 15 mm (No. 221031500) / Ø 18 mm (No. 221031800), 2.5 m propane hose with 3/8" LH coupling (No. 32201), safety igniter (No. 32077), replacement flints (No. 32088), open-ended spanner (No. 32073), steel case (No. 31005)

Model	kg	No.
TURBOPROP set without propane regulator	2.8	31090
TURBOPROP set with propane regulator	3.1	31094
(as in set (No. 31090) but with regulator (No. 3.2081E) (W 21.8 LH – G 3/8 LH))		
TURBOPROP set with propane regulator	3.1	31037
(as in set (No. 31090) but with regulator (No. 3.2083) (POL 7/8 LH – G 3/8 LH))		
TURBOPROP set with propane regulator	3.1	31036
(as in set (No. 31090) but with regulator (No. 32084) (W 20 x 14 LH – G 3/8 LH))		



No. 31090

TURBOPROP brazing torch with push-in nipple coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
10 mm	165	70	1.89 – 770 – 3,050	70	31031
12 mm	175	110	1.41 – 1,210 – 4,815	90	31032
15 mm	195	180	2.30 – 1,980 – 7,855	110	221031500
18 mm	230	240	3.07 – 2,640 – 10,485	160	221031800

Bonding

Cylinder Brazing

AIRAC® Set

Acetylene brazing torch up to Ø 35 mm with 2,350 °C

Ideal brazing unit - efficient, weight-saving and fast compared to gas welding units (no additional oxygen cylinders needed)



Product Profile

KEY FEATURES

- Oxygen from the surrounding air and acetylene are fed without pressure into the burner and with the special construction of the burner produce a flame temperature of 2,350° C with a concentrated, pointed flame for precise and fast work
- Ideal for refrigeration installation

KEY FEATURES

- Scale build-up on the treated surface is prevented by the nitrogen that is introduced into the air flow (shielding gas effect)
- Light weight makes transporting easy (one-cylinder system)
- Maximal performance with the turbine and combustion chamber effect
- Shut-off valve prevents uncontrolled gas leaks
- Gas-saving use with the smooth-running economy valve

High-performance injections burner only for acetylene 2,350 °C

Powerful operation

Turbine and combustion chamber effect, self-induced air

Maximum performance



Smooth running economy valve

Gas-saving operation

Shut-off valve

Prevents uncontrolled gas leaks



10-piece set (No. 31093) includes: Safety handle (No. 211541116), brazing torch size 2 (No. 35022) / size 3 (No. 35023) / size 4 (No. 35024), 2.5 m acetylene hose (No. 35203), bend with nut 150 mm (No. 35110), torch spanner 14 x 19 mm (No. 32073), safety igniter (No. 32077), replacement flints (No. 32079), steel case (No. 35005)

Model	kg	No.
AIRAC® brazing set in steel case	2.9	31093
Further accessories can be found on 178		



AIRAC® Safety Handle

Safety handle with economy, regulating and shut-off valve, threaded coupling M 16 x 1, hose coupling G 3/8" LH

Model	g	No.
Safety handle	290	211541116
Repair kit for regulating valve, complete	10	30102
Repair kit for economy valve, complete	10	30103



AIRAC® Brazing Torch

Made of surface-handled brass, stable and concentrated flame

Model	Pipe Ø	kg	No.
Bend with nut (150 mm)		80	35110
Size 2	12 - 15	40	35022
Size 3	18 - 22	50	35023
Size 4	28 - 35	70	35024

MULTI MOBILE Set

A mobile soft-soldering cartridge tool for professional applications in sheet metal work and for soldering tin and lead

Professional soft soldering with maximum mobility and safety!

Product Profile

KEY FEATURES

- Ideal for mobile construction sites and service calls
- Titanium combustion chamber and light aluminium hand grip
- No flare-up effect thanks to special Multigas 110 gas cartridge
- Usable in any position (360°) with a constantly stable flame
- Special wind stability due to the combustion chamber's protective design
- Piezo ignition and exact adjustment with a fine regulator valve
- For sheet metal work such as roof gutters, panels and roof edges, ventilation shafts, etc.
- Robust metal case for safe transport


TECHNICAL DATA


Copper piece temperature:	600 °C
Heat effect:	945 W
Ignition:	Piezo
Consumption:	75 g/h at 2 bar
Handle diameter:	50 mm
Weight incl. copper piece and cartridge:	890 g



Fig. MULTI MOBILE Set

Set (No. 1000000390) includes: MULTI MOBILE soft-soldering cartridge tool incl. hammer shaped copper piece 250g (No. 1000000514), 2 Multigas 110 gas cartridge (No. 1500000459), 2 Düsen (No. 1500000461), steel case (No. 1500000460)

Model	 g	No.
Copper piece, hammer shape	250	1000000514
Copper piece, pointed shape	245	1000000512

Model		No.
MULTI MOBILE Set		1000000390
Multigas 110 gas cartridge	12	1500000459

Bonding

Cylinder Soft Soldering

MULTI 300 Propane Soft Soldering Kit

For soft soldering of copper pipes, for tin and lead soldering, for tinning, warming up, flame cleaning, etc.



Product Profile

KEY FEATURES

- For all types of fine soldering in the areas of electronics and telecommunications
- For working with lead (gutters, laminations and roof edging, ventilation shafts, etc.)
- Propane handle with heat insulated wooden grip
- Rotatable air / rotary valve for the adjustment of an especially fine flame
- Rotatable hose coupling M10 x 1 LH

TECHNICAL DATA

- With longer ball spindle and dual spring control
- Favourable working pressure with 1.5 bar



No. 35486

Fig. Similar

Model	kg	No.
MULTI 300 / Kit A without propane regulator	4.1	35486
MULTI 300 / Kit A with propane regulator (No. 242206000)	4.3	35489
MULTI 300 / Kit B	9	35488



Fig. Similar

3-part set (No. 35486) includes: Soft soldering iron copper head with 350 g flat (No. 520849), 2 m propane hose (No. 30927), small propane cylinder 0.5 kg with hook (No. 33079)

13-part set (No. 35488) includes: Soft soldering iron with copper head 350 g flat (No. 520849), soft soldering torch Ø 17 mm (No. 520856) / Ø 20 mm (No. 520857), wide torch 45 mm (No. 520845), propane regulator 0-6 bar (No. 242206000), 2 m propane hose (No. 30927), small propane cylinder 0.5 kg with hook (No. 33079), refilling adaptor (No. 32207), torch spanner (No. 35530), open-ended spanner (No. 32073), safety igniter (No. 32077), replacement flints (No. 32088), steel case (No. 35487)

ACCESSORIES



No. 520849



Fig. Similar



No. 520865



No. 520866



No. 520867



No. 32099



No. 32098 / 32075



No. 520856



No. 520857



No. 30927

Description	g	No.	Description	g	No.
Soft soldering iron with handle, iron torch,	940	520849	Copper Head 250 g pointed	270	32099
Iron Holder, wind protector, copper head			Copper Head 350 g flat	370	32075
Soft soldering iron with handle, iron burner,	570	520840	Soft soldering torch size 5, Ø 17 mm, M 15 x 1	70	520856
Iron Holder, wind protector, without copper head			Soft soldering burner size 7, Ø 20 mm, M 15 x 1	120	520857
Handle with hose coupling M 10 x 1 L	300	520850	Steel case	3390	35487
Iron Burner with coupling M 15 x 1	70	520865	Torch spanner	60	35530
Iron Holder with foot	100	520866	Safety igniter with rolling file	60	32077
Wind protector	100	520867	Replacement flints, tin with 5 pieces	15	32088
Copper Head 250 g flat	270	32098			

ROOFING-Set

Propane surface-heating torch with Ø 63 mm high-performance torch nozzle



Product Profile

APPLICATION AREA

Ideal for roofing and asphalt work and for bonding of bituminous sheeting, large-scale burning of weeds, defrosting, insulation, shrinking, drying and warming up.

KEY FEATURES

- Large working range with 5 m propane hose
- Efficient use even in adverse weather conditions with the flame stabiliser
- High-performance burner with flame stabiliser chrome plated with a reinforced edge
- Burner support

TECHNICAL DATA

600 mm burner tube
Burner support



Ø 63 mm

L = 600 mm

Burner support included!

5 m Propane hose

Large working range

Ideal for roofing and asphalt work



600 mm burner tube with support and 5.0 m propane hose



5-part set (No. 30954) includes: Propane handle (No. 21511216), 63 mm high-performance torch (No. 223216300), 600 mm torch pipe (No. 236010000), 5.0 m propane hose (No. 32203), torch support (No. 252010000)

Model	g	No.
ROOFING-Set	1,920	30954
ROOFING-Set	1,960	030955X
(as 30954, with Piezo ignition)		
ROOFING-Set	2,300	30957
(as 30954, with pressure regulator 30925)		
Burner support	60	252010000

Extensions

Special tube, chrome plated, angled 40°, inlet M 14 x 1, outlet M 20 x 1



L mm	g	No.	L mm	g	No.
100	90	231010000	350	190	233510000
200	120	232010000	600	290	236010000

Surface-Heating Torch Heads

High-efficiency torch heads with flame stabilisers, made of special chrome plated steel, reinforced edge. For warming up, shrinking, insulating, hardening, general repair work, etc.
Threaded M 20 x 1 coupling




mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
45	102	2500	32.00 – 27,500 – 109,280	240	32045
51	112	3800	48.60 – 41,800 – 165,970	270	32051
63	138	6700	85.70 – 73,700 – 292,670	440	32063
closed					
45	102	2500	32.00 – 27,500 – 109,280	240	223214500
51	112	3800	48.60 – 41,800 – 165,970	270	223215100
57	126	5500	70.35 – 60,500 – 240,257	350	223215700
63	138	6700	85.70 – 73,700 – 292,670	440	223216300

Bonding

Accessories Cylinder Brazing / Soft Soldering

Safety Propane Handles

With economy, regulating and shut-off valves, hose coupling G 3/8" LH

Model			No.
Safety Propane handle with push-in coupling	350	211121116	
Safety Propane handle with M 14x1 coupling	290	211111116	
Repair kit with shut-off valve, complete	10	30101	
Repair kit with regulating valve, complete	10	30102	




No. 211121116



No. 211111116

Propane Regulators

Brass, for 0.5 kg, 5 kg and 11 kg cylinders

Inlet	Outlet	Working pressure Bar	Performance kg/h		No.
W 21,8x1/14" LH	G 3/8" LH	0,5 - 4,0	8	240	32081
G 3/8" LH	G 3/8" LH	0 - 6	8	200	242206000
W 21,8x1/14" LH	G 3/8" LH	4	8	230	30925



No. 32081




No. 242206000



No. 30925

Propane Hoses

Top quality, DIN / DVGW tested, with strong inlay, durable and flexible, mounted with sleeves and nuts, up to 20 bar pressure (2 MPa)

L m	Inlet	Outlet	Pressure class	Interior-Ø mm Wall thickness		No.
2	G 3/8" LH	M 10 x 1 LH	ISO 3821	4,0 x 3,5	310	30927
2,5	G 3/8" LH	G 3/8" LH	ISO 3821	4,0 x 3,5	350	32201
5	G 3/8" LH	G 3/8" LH	ISO 3821	4,0 x 3,5	730	33310
10	G 3/8" LH	G 3/8" LH	EN 1327	5,0 x 3,5	1.650	32223



No. 30927




No. 32223

Propane Hose Failure Protection

Nominal pressure 1.5 - 4 bar, brass, DIN / DVGW tested.

Automatic interruption of gas supply if hose is damaged or loosened, push-button for resetting after interruption

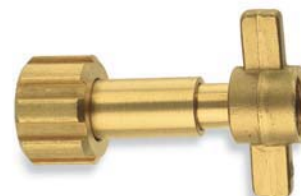
Inlet	Outlet	Performance kg/h	Push button		No.
G 3/8" LH	G 3/8" LH	10	blue	130	35925



Refilling Adaptor


For refilling 0.5 propane cylinders from 3.5 or 11 kg propane cylinders, brass with guide pin

Inlet	Outlet		No.
W 21.8 x 1/14" L	G 3/8" LH	160	32207



Propane Lightweight Steel Cylinder

With cylinder valve, TÜV tested, according to TRG

Model	Outlet	Contents		No.
Small cylinder, 0.5 kg with foot	G 3/8" LH	empty	2.75	33079
Protective collar for 33079				35636
Cylinder 5 kg, with foot and cap		filled	12.60	31081
W 21.8 x 1/14" LH				



No. 33079

With 0.5 kg cylinder protective collar included in delivery



No. 31081

ROTHERM 2000

Electric soft soldering unit up to Ø 54 mm / 2.1/8"



Product Profile

APPLICATION AREA

For simple, safe and time-saving soft soldering without a flame. Particularly suitable for repair and modification work in surroundings or rooms with a fire hazard, as well as in building refurbishment

Soft soldering of Copper pipes up to:
Ø 6 - 54 mm, 1/4 - 2.1/8"

KEY FEATURES

- Soldering without open flame
- Large working radius, also when working under ceilings
- Comfortable transport and convenient use
- High performance, short soldering times
- Thermal overload protection turns device off automatically

KEY FEATURES

- Handle shell will not overheat
- No purchasing on handling of gas cylinders necessary
- Equivalent with transport terms
- Problem-free connection on every 230 V outlet, 2 m connection cable
- Fast return on investment
- Power control lamp (red) and operating control lamp (green), equipment fuse accessible from outside

TECHNICAL DATA

Power:	2000 Watt
Soldergun cable:	4 m
Dimensions (L x W x H):	260 x 190 x 200 mm
Weight:	10.5 kg

Soldering without open flame!

Generously dimensioned stainless steel cooling ribs on both shanks of the tongs

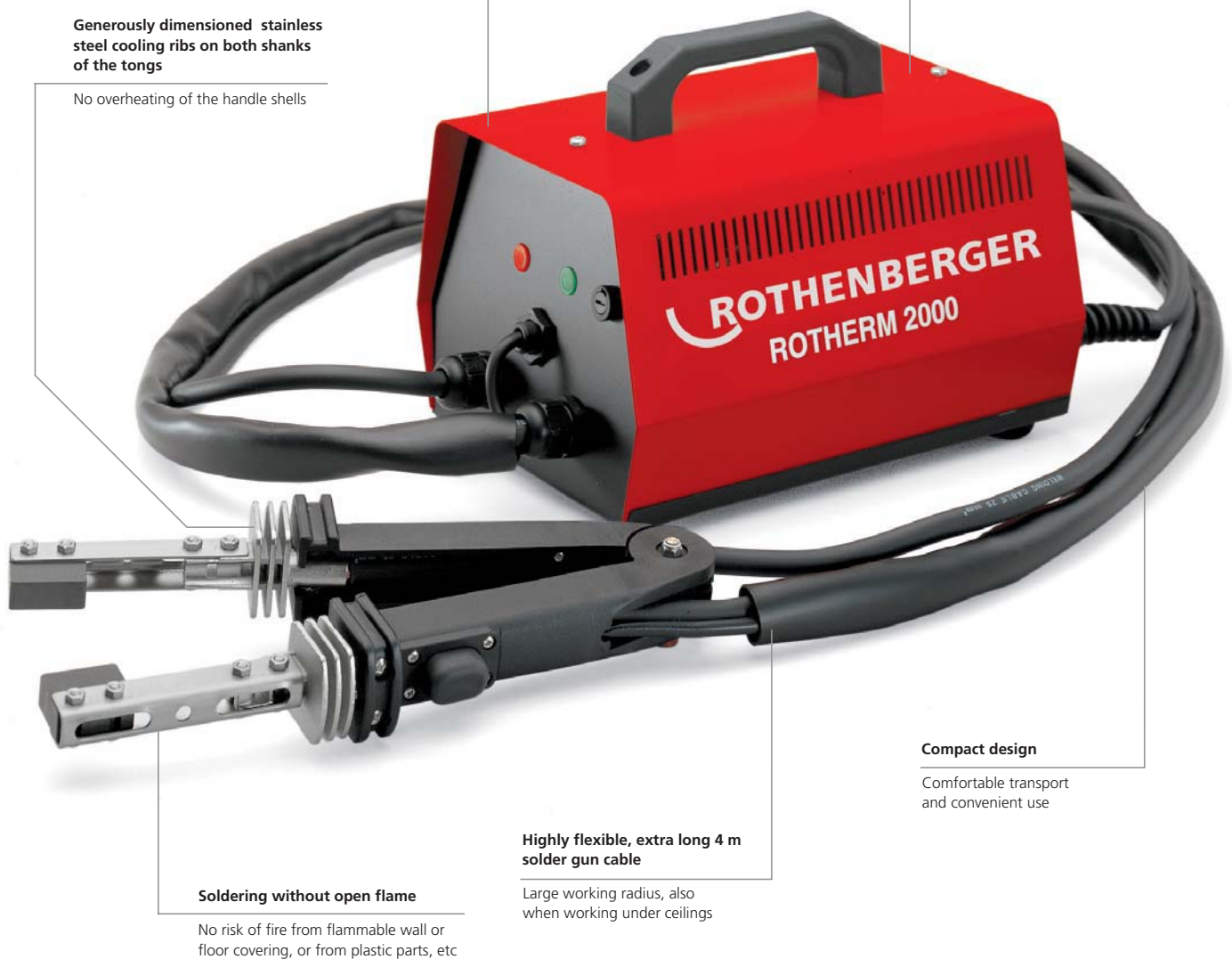
No overheating of the handle shells

Thermal overload protection

Automatic device shut-off

2000 W

High performance, short soldering times



Soldering without open flame

No risk of fire from flammable wall or floor covering, or from plastic parts, etc

Highly flexible, extra long 4 m solder gun cable

Large working radius, also when working under ceilings

Compact design

Comfortable transport and convenient use

Bonding

Electric Soft Soldering

ROTHERM 2000 Soft Soldering Set

Electric soft soldering unit up to Ø 54 mm / 2.1/8"

Set (No. 36702 / No. 036704V) includes: ROTHERM 2000 soft soldering unit 230 V (No. 36700), Rosol 3 fittings soldering paste No. 45225), fitting solder 3 (No. 45255), ROVLIES® (No. 45268), Cu. Internal brushes 10 mm (No. 854180) / 12 mm (No. 854181) / 15 mm (No. 854183) / 18 mm (No. 854185) / 22 mm (No. 854186), steel case (No. 36715)

Particularly suitable for repair and modification work in surroundings or rooms with a fire hazard, as well as in building refurbishment!



7

Warming up of the soldering point without open flame



Rod electrodes for working near to the wall or between parallel running pipes with narrow gaps (can be ordered separately)



Flat electrode



Simple replacement of electrodes and electrode holders



ACCESSORIES



Model	No.	Model	
Flat electrode (pair)	36721	ROVLIES®	181
Flat electrode with holder (pair)	36711	External brush for copper pipe	181
Rod electrodes (pair)	36720	Soft soldering flux	183
Rod electrodes with holder (pair)	36710	Solders	183
		Internal brush for copper pipe	181

ALLGAS 2000 Set

Mobile soldering and welding torch

Ideal mobile soldering and welding torch for plumbers, HVAC fitters, refrigeration technicians, automotive workshops and tinsmiths



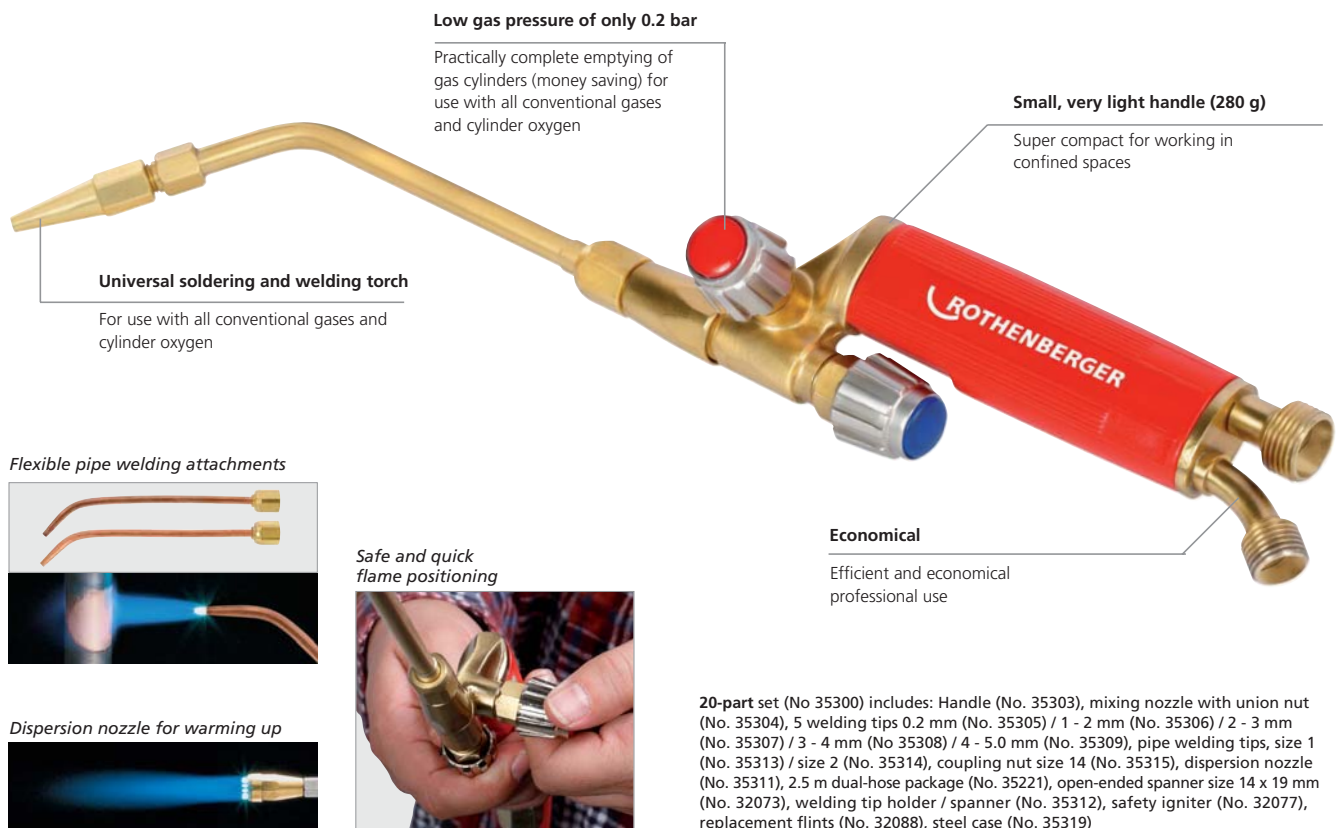
Product Profile

APPLICATION AREA

Soldering range:	up to 2.5 mm material thickness
Welding range:	0.2 - 5 mm
Suitable for use with:	Oxy-Acetylene Propane and oxygen CNG and oxygen Town gas and oxygen

KEY FEATURES

- For use with all conventional gases and cylinder oxygen
- Practically complete emptying of gas cylinders (money-saving)
- Super compact for working in confined spaces
- Efficient and economical professional use



20-part set (No. 35300) includes: Handle (No. 35303), mixing nozzle with union nut (No. 35304), 5 welding tips 0.2 mm (No. 35305) / 1 - 2 mm (No. 35306) / 2 - 3 mm (No. 35307) / 3 - 4 mm (No. 35308) / 4 - 5.0 mm (No. 35309), pipe welding tips, size 1 (No. 35313) / size 2 (No. 35314), coupling nut size 14 (No. 35315), dispersion nozzle (No. 35311), 2.5 m dual-hose package (No. 35221), open-ended spanner size 14 x 19 mm (No. 32073), welding tip holder / spanner (No. 35312), safety igniter (No. 32077), replacement flints (No. 32088), steel case (No. 35319)

Model	Coupling oxygen	Coupling fuel gas	g	No.
ALLGAS 2000 Set (acetylene)			3.100	35300
Handle ALLGAS 2000	G 1/4" RH	G 3/8" LH	280	35303
Mixing nozzle with union nut			40	35304

Welding tips, Welding attachments

Size	Welding range mm	g	No.
Welding tip size 1	0.2 - 1.0	10	35305
Welding tip size 2	1.0 - 2.0	10	35306
Welding tip size 3	2.0 - 3.0	10	35307
Welding tip size 4	3.0 - 4.0	10	35308
Welding tip size 5	4.0 - 5.0	10	35309
Dispersion nozzle for warming up		20	35311
Welding tip holder, can be used as a spanner		20	35312
Flexible welding tip size 1	2.0 - 3.0	40	35313
Flexible welding tip size 2	4.0 - 5.0	40	35314
Coupling / union nut, size 14		10	35315

Further accessories can be found on 178



Fig. ALLGAS 2000 Set

Bonding

Gas-Welding

ALLGAS 2000 PS 0.5 / 2 Compact

Portable fitter's brazing equipment with carrying frame

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



Product Profile

KEY FEATURES

- Secure transport in closed supporting frame
- Portable, light fitter's brazing equipment
- Ideal for mobile building-site and repair use
- Small propane cylinders can be refilled

TECHNICAL DATA

Gas:	Propane with oxygen
Flame temperature:	2,850 °C
Working temperature:	1,150 °C

**With safety devices
to prevent flashbacks**

24-part set (No. 35655) includes: Handle Allgas 2000 (No. 35303), 2.5 m propane hose (No. 32201), 2.5 m oxygen hose (No. 35210), propane regulator adjustable 0 - 6 bar (No. 242206000), oxygen pressure reducer 10 bar (No. 35634), mixing nozzle with union nut (No. 35304), welding tips 0.2-1 mm (No. 35305) / 1 - 2 mm (No. 35306) / 2 - 3 mm (No. 35307) / 3 - 4 mm (No. 35308) / 4-5 mm (No. 35309), flexible welding tip size 1 (No. 35313) / size 2 (No. 35314), dispersion nozzle (No. 35311), welding tip holder / spanner (No. 35312), multi-size spanner (No. 35738), safety igniter (No. 32077), replacement flints (No. 32088), nylon safety goggles (No. 540620), small propane cylinder 0.5 kg, empty (No. 33079), steel oxygen cylinder 2.0 l, full (No. 35635), oxygen safety device (No. 1000000633), fuel gas safety device (No. 1000000631), carrying frame (No. 35629)

Model	kg	No.
ALLGAS 2000 PS 0.5 / 2 Set	21.4	35655
Carrying frame without accessories	10.3	35629
Further accessories can be found on 178		

Carrying comfort



ALLGAS 2000 Welding Tips

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



Welding Tips, Nozzle thread M8 X 1



Size	Welding range mm	g	No.
Welding tip size 1	0.2 - 1.0	10	35305
Welding tip size 2	1.0 - 2.0	10	35306
Welding tip size 3	2.0 - 3.0	10	35307
Welding tip size 4	3.0 - 4.0	10	35308
Welding tip size 5	4.0 - 5.0	10	35309
Dispersion nozzle for warming up		20	35311
Welding tip holder, can be used as a spanner		20	35312



No. 35311



No. 35312

Flexible Pipe Welding Attachments

Size	Welding range mm	g	No.
Flexible welding tip size 1	2.0 - 3.0	40	35313
Flexible welding tip size 2	4.0 - 5.0	40	35314
Coupling / union nut, size 14		10	35315



ALLGAS Mobile Pro

Mobile brazing equipment with safety devices

For brazing of iron, steel, sheet steel, pipes and non-ferrous metals



Product Profile

KEY FEATURES

- Mobile brazing set with a total weight lower than 6 kg incl. cartridges
- High quality safety devices for both gas hoses to prevent flashbacks
- MAPP®-gas pressure regulator with an adjustable range of 0 - 2 bar for a constant, low consumption and an efficient flame adjustment

TECHNICAL DATA

Gas:	MAPP®-gas with oxygen (disposable)
Flame temperature:	over 3,100 °C
Working temperature:	1,300 °C

Accessories included in the set



MAPP®¹⁾ and oxygen

Flame temperature
above 3,100 °C

Welding and brazing torch

Including 5 interchangeable
nozzles and a bendable welding
attachment for a material
thickness up to 5 mm

High quality safety devices

Reliable prevention of
gas returns and flashbacks

Pressure reducer 0 - 2 bar

Constant, low consumption
and efficient flame adjustment

Total weight < 6 kg

High mobility on
construction site

High quality rubber hoses

20 bar, DIN EN ISO 3821
certified, length: 2,5 m

Model	kg	No.
ALLGAS Mobile Pro 1" US, w/o cartridges	3.86	1000000529
ALLGAS Mobile Pro 1" US, incl. cartridges	5.95	1000000743
ALLGAS Mobile Pro 7/16" EU, w/o cartridges	3.86	1000000642
ALLGAS Mobile Pro 7/16" EU, incl. cartridges	5.70	1000000558
MAPP® ¹⁾ Gas 1" US, 750 ml	0.67	35698
MAPP® ¹⁾ Gas, 7/16" EU, 750 ml	0.67	035551-A
Oxygen, 110 L	1.20	35750

1) MAPP® is a registered trademark of the MESSER Group GmbH, Bad Soden

Bonding

Gas-Welding

ALLGAS 2000 PS 0.5 / 2 Basic

Portable fitter's brazing equipment

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



KEY FEATURES

- Compact and handy construction for mobile building-site and repair use
- Job compatible combination, assembled and ready to use

Space saving storage in service vehicles!



18-part set (No. 35651) includes: Handle Allgas 2000 (No. 35303), 2.5 m propane hose (No. 32201), 2.5 m oxygen hose (No. 35210), propane regulator adjustable 0 - 6 bar (No. 242206000), oxygen pressure reducer 10 bar (No. 35634), mixing nozzle with union nut (No. 35304), welding tips 0.2 - 1 mm (No. 35305) / 1 - 2 mm (No. 35306) / 2 - 3 mm (No. 35307) / 3 - 4 mm (No. 35308) / 4 - 5 mm (No. 35309), welding tip holder / spanner (No. 35312) multi-size spanner (No. 35738), safety igniter (No. 32077), replacement flints (No. 32088), steel oxygen cylinder 2.0 l, filled (No. 35635), propane cylinder 0.5 kg (empty) (No. 33079), Allgas stand (No. 35628)

Model	kg	No.
ALLGAS 2000 PS 0.5 / 2 Set	14.4	35651
Further accessories can be found on 178		

7



The bottle colours shown are without obligation!

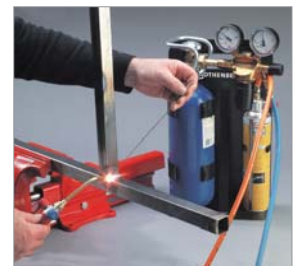
ROXY 400 L

Standard gas-welding equipment for flame temperatures up to 3,100 °C

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



Space saving storage in service vehicles!



20-part set (No. 035780X) includes: Handle with fine regulating valve (No. 35580), Maxigas 400 (No. 035570-A), oxygen cylinder 2.0 L (No. 35635), fine regulating valve (No. 263003700), oxygen pressure reducer according to DIN 0-315 / 200 bar 0-16 / 10 bar (No. 35634), hose set (3 m without handle) (No. 35785), oxygen blowback protection (No. 1000000633), gas blowback protection (No. 35691), mixing nozzle with union nut (No. 35587), high-performance tips 1.5 mm (No. 263005600) / 2.0 mm (No. 263005400), micro-tips 0.3 mm (No. 35712) / 0.5 mm (No. 35696) / 0.7 mm (No. 35713), micro-tip adaptor (No. 35585), welding goggles A5 (No. 35621), safety igniter (No. 32077), multi-size spanner (No. 35738) carrying frame (No. 35727)

Model	kg	No.
ROXY 400 L Set	10.80	035780X
ROXY welding handle Profi	0.01	35580
Hose Set (3 m without handle)	0.95	35785
ROXY micro-nozzle adaptor	0.01	35585
ROXY micro-nozzle for 1-1.2 sheet metal	0.04	263005700
ROXY micro-nozzle for 0.7-0.9 sheet metal	0.06	263005800
ROXY micro-torch 0.4 mm	0.01	35695
ROXY micro-torch 0.5 mm	0.02	35696
ROXY micro-torch 0.6 mm	0.02	35697
ROXY micro-torch 0.3 mm	0.01	35712
ROXY micro-torch 0.7 mm	0.01	35713



The bottle colours shown are without obligation!

ROFLASH Set

Welding and cutting kit

Welding range: 0.5 - 14 mm, Cutting range: 3 - 75 mm

22-part set (No. 513300) includes: Handle (No. 513010), welding attachments 0.2 - 0.5 (No. 513030), 0.5 - 1 (No. 513031), 1 - 2 (No. 513032), 2 - 4 (No. 513033), 4 - 6 (No. 513034), 6 - 9 (No. 513035), 9 - 14 (No. 513036), spring-lever cutting attachment (No. 513310), cutting tips 3 - 6 (No. 513330), 6 - 20 (No. 513331), 20 - 75 (No. 513332), cutting burner guiding wagon, burner spanner (No. 510106), nylon safety goggles (No. 540621), 10 piece nozzle cleaning set (No. 510105)

Model	kg	No.
ROFLASH Set	4.2	513300



Fig. Similar



Exchange of the welding tip

Can be used with all types of gas

Cutting oxygen valve with spring-lever

Enables one-handed use for spray-free cutting, etc.

ROFLASH Handle

Welding kit handle

KEY FEATURES

- The new monoblock valves enable the precise adjustment and accurate control of the flame
- Comfortable one-handed use with the v-formed valve arrangement

Model	g	No.
ROFLASH Handle	434	513010

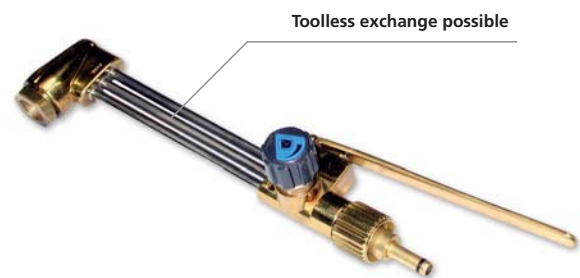


ROFLASH Spring-lever Cutting Attachment

KEY FEATURES

- The solid torch nozzle is made from forged brass and can withstand the highest thermal demands and also enables use under extreme conditions, maintenance-free monoblock valve

Model	g	No.
ROFLASH spring-lever cutting attachment	582	513310
ROFLASH cutting tips 3 - 6 mm	97	513330
ROFLASH cutting tips 6 - 20 mm	97	513331
ROFLASH cutting tips 20 - 75 mm	98	513332



Toolless exchange possible

ROFLASH Welding Attachments / Welding Tips



Model	g	No.
ROFLASH welding attachments 0.2 - 0.5 mm	96	513030
ROFLASH welding attachments 0.5 - 1.0 mm	96	513031
ROFLASH welding attachments 1.0 - 2.0 mm	104	513032
ROFLASH welding attachments 2.0 - 4.0 mm	117	513033
ROFLASH welding attachments 4.0 - 6.0 mm	128	513034
ROFLASH welding attachments 6.0 - 9.0 mm	148	513035
ROFLASH welding attachments 9.0 - 14.0 mm	171	513036



Model	g	No.
ROFLASH welding tips 0.2 - 0.5 mm	96	513040
ROFLASH welding tips 2.0 - 4.0 mm	126	513043
ROFLASH welding tips 4.0 - 6.0 mm	128	513044
ROFLASH welding tips 6.0 - 9.0 mm	147	513045
ROFLASH welding tips 9.0 - 14 mm	171	513046

Bonding

Three-Gas Welding

RE 17 Three-gas System AMS 5/5

Assembly, welding, cutting and brazing system
Welding range 0.5 - 14 mm, Cutting range 3.0 - 50 mm



The bottle colours shown are without obligation!

Including gas cylinders and dual-telescoping transport trolley!

27-piece set (No. 35400) includes: Handle with coupling nut (No. 35324), welding attachments 0.5 - 1 mm (No. 35325) / 1 - 2 mm (No. 35326) / 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329) / 9 - 14 mm (No. 35334), wing-lever cutting attachment (No. 35338), cutting tips 12 - 25 mm (No. 35341) / 25 - 50 mm (No. 35344), heating nozzle 12-100 mm (No. 35339), acetylene pressure reducer 1.5 bar (No. 35794), oxygen pressure reducer 10 bar (No. 35634), 2 each - protective rubber caps, red (No. 511428) / blue (No. 511427), 10 piece nozzle cleaning set (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), acetylene cylinder 5 l (filled) (No. 35178), oxygen cylinder 5 l (filled) (No. 35188), Maxigas 400 (No. 035570-A), gas regulating valve Maxigas (No. 263003700), hose adaptor Maxigas (No. 35491), steel case (No. 35800), dual-telescoping transport trolley (No. 35354), 5 m dual-hose package A / S (No. 35222), steel case (No. 35800)

Model	kg	No.
RE 17 Three-gas System AMS 5/5	50	35400

RE 17 Three-gas System AMS 5 and 10

Assembly, welding, cutting and brazing system
Welding range 0.5 - 14 mm, Cutting range 3.0 - 50 mm



7



Including dual-telescoping transport trolley!

25-part set (No. 35403) includes: Handle with coupling nut (No. 35324), welding attachments 0.5 - 1 mm (No. 35325) / 1 - 2 mm (No. 35326) / 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329) / 9 - 14 mm (No. 35334), wing-lever cutting attachment (No. 35338), cutting tips 12 - 25 mm (No. 35341) / 25 - 50 mm (No. 35344), heating nozzle 12-100 mm (No. 35339), 5 m dual-hose package A / S (No. 35222), acetylene pressure reducer 1.5 bar (No. 35794), oxygen pressure reducer 10 bar (No. 35634), 2 each - protective rubber caps, red (No. 511428) / blue (No. 511427), 10 piece nozzle cleaning set (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), Maxigas 400 (No. 035570-A), gas regulating valve Maxigas (No. 263003700), hose adaptor Maxigas (No. 35491), steel case (No. 35800), dual-telescoping transport trolley (No. 35354)

Model	kg	No.
RE 17 Three-gas System AMS 5 + 10	23	35403

RE 17 Three-gas System AMS 10/10

Assembly, welding, cutting and brazing system
Welding range 0.5 - 14 mm, Cutting range 3.0 - 50 mm



Including gas cylinders and dual-telescoping transport trolley!

27-part set (No. 35401) includes: Handle with coupling nut (No. 35324), welding attachments 0.5 - 1 mm (No. 35325) / 1 - 2 mm (No. 35326) / 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329) / 9 - 14 mm (No. 35334), wing-lever cutting attachment (No. 35338), cutting tips 12 - 25 mm (No. 35341) / 25 - 50 mm (No. 35344), heating nozzle 12 - 100 mm (No. 35339), 5 m dual-hose package A / S (No. 35222), acetylene pressure reducer 1.5 bar (No. 35794), oxygen pressure reducer 10 bar (No. 35634), 2 each - protective rubber caps, red (No. 511428) / blue (No. 511427), 10 piece nozzle cleaning set (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), acetylene cylinder 10 l (filled) (No. 35179), oxygen cylinder 10 l (filled) (No. 35189), Maxigas 400 (No. 035570-A), gas regulating valve Maxigas (No. 263003700), hose adaptor Maxigas (No. 35491), steel case (No. 35800), dual-telescoping transport trolley (No. 35354)

Model	kg	No.
RE 17 Three-gas System AMS 10/10	66	35401
RE 17 as in 35401, cutting range 3.0 - 25 mm	65	35798

The bottle colours shown are without obligation!

RE 17 UNIVERSAL Pipe Welding Set

For welding, cutting, brazing and warming up
Welding range: 0.5 - 14 mm, Cutting range: 3 - 100 mm



Set (No. 35479) includes: Handle with coupling nut (No. 35324), welding attachments 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329), flexible pipe-welding tips 2 - 4 mm (No. 35347) / 4 - 6 mm (No. 35348), wing-lever cutting attachment (No. 35338), Cutting tip 12 - 25 mm (No. 35341), Heating nozzle 12 - 100 mm (No. 35339), Nozzle cleaning set, 10 piece (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), steel case (No. 35800)

Nominal size	kg	No.
RE 17 Pipe welding set	4.3	35479
RE 17 Pipe welding set	4.8	35480
As in set (No. 35479), but also including with		
welding attachments 0.5-1 mm (No. 35325) / 1-2 mm (No. 35326), 9-14 mm (No. 35334) / cutting tip 12-25 mm (No. 35341), 25-50 mm (No. 35344), without flexible		
pipe-welding tips 2-4 mm (No. 35347) / 4-6 mm (No. 35348)		
Steel case RE 17 (empty)	1.70	35800
RE 17 handle with burner coupling nut	0.47	35324
Coupling: oxygen G 1/4" RH, gas G 3/8" LH		



No. 35480



No. 35324

RE 17 Welding Attachments

	Welding range mm	g	No.
Welding attachment	0.5 - 1.0	140	35325
Welding attachment	1.0 - 2.0	150	35326
Welding attachment	2.0 - 4.0	170	35327
Welding attachment	4.0 - 6.0	190	35328
Welding attachment	6.0 - 9.0	220	35329
Welding attachment	9.0 - 14.0	260	35334



7

RE 17 Pipe Welding Attachment, Flexible

Pipe welding attachment, Flexible copper tips complete

Welding range mm	g	No.	Welding range mm	g	No.
2.0 - 4.0	140	35347	1.0 - 2.0	40	35475
4.0 - 6.0	150	35348	2.0 - 4.0	40	35476
			4.0 - 6.0	50	35477

Pipe welding attachment, front piece



Pipe welding attachment, complete

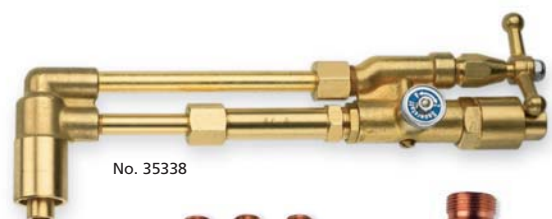


RE 17 Wing-lever Cutting Attachment

Model	g	No.
Cutting attachment without tips	820	35338

RE 17 Cutting Tips and Heating Nozzle

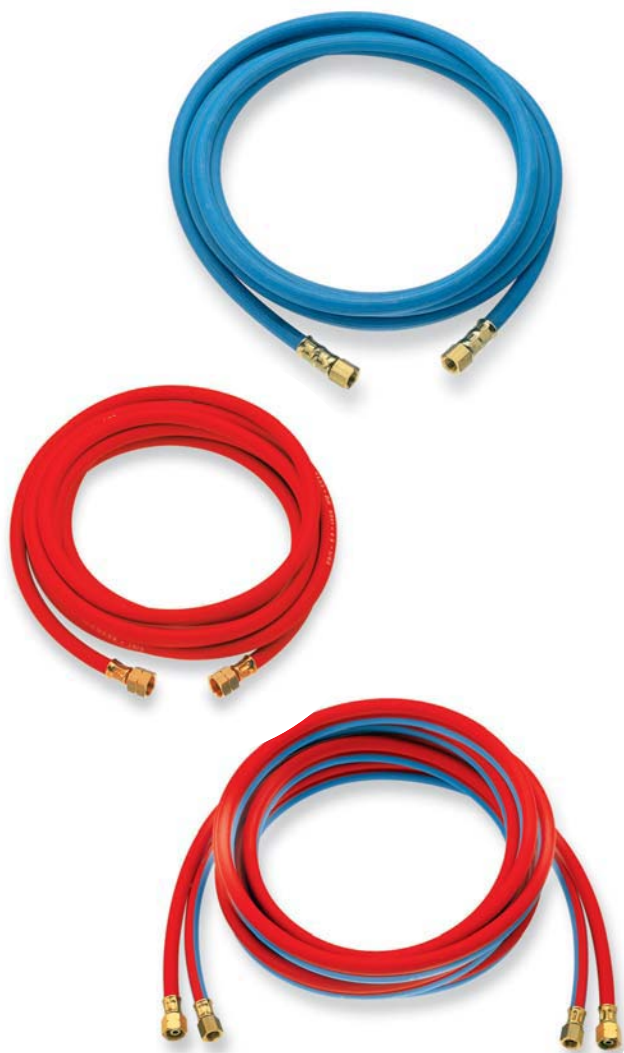
Model	Cutting range mm	g	No.
Cutting tip	12 - 25	10	35341
Cutting tip	25 - 50	20	35344
Cutting tip	50 - 100	20	35345
Heating nozzle	12 - 100	50	35339



No. 35338

No. 35341
No. 35344
No. 35345

No. 35339



Oxy-Acetylene Hoses

Top quality in accordance with **ISO 3821** (former EN 559), with strong inlay, durable and flexible, rubber, mounted with sleeves and nuts

Oxygen Hoses

L m	Inlet	Outlet	Internal Ø x wall thickness mm	kg	No.
2.5	G 1/4" RH	G 1/4" RH	6.3 x 3,5	0.5	35210
5.0	G 1/4" RH	G 1/4" RH	6.3 x 3.5	1.1	33311

Acetylene Hoses

L m	Inlet	Outlet	Internal Ø x wall thickness mm	kg	No.
2.5	G 3/8" LH	G 3/8" LH	6.3 x 3.5	0.5	35203
5.0	G 3/8" LH	G 3/8" LH	6.3 x 3.5	1.1	33312

Dual Hoses A/S

L m	Coupling Oxygen	Coupling Acetylene	Internal Ø x wall thickness mm	kg	No.
2.5	G 1/4" RH	G 3/8" LH	6.0 x 3.5	0.9	35221
5.0	G 1/4" RH	G 3/8" LH	6.0 x 3.5	2.0	35222
10	G 1/4" RH	G 3/8" LH	6.0 x 3.5	3.8	35223



Included in delivery for steel cylinders without cap, protective bracket



The bottle colours shown are without obligation!

Lightweight Steel Cylinders, filled

With cylinder valve, base and cap from 5 l, TÜV tested in accordance with TRGI

Model	Contents	Filling pressure bar	Height mm	Ø mm	kg	No.
Oxygen	2 l	200	420	110	4.6	35635
Oxygen	5 l	200	595	145	14.0	35188
Oxygen	10 l	200	980	145	17.0	35189
Acetylene	5 l	18	595	145	13.0	35178
Acetylene	10 l	18	980	145	23.0	35179




Cylinder Transport Trolley

Portable and mobile, for 5 and 10 l acetylene / oxygen cylinders, 5 kg and 12 kg propane cylinders can be used with conversion kit (special accessory). Coupling for disposable MAXIGAS 400 cartridges, dual-telescoping for different cylinder heights, brackets for ALLGAS and RE 17 steel cases

Model	kg	No.
Transport Trolley for 5 / 10 l acetylene / oxygen cylinders	8.9	35354

Cylinder Pressure Reducer


Rugged pressed brass construction with large pressure gauge according to ISO 5171, with shut-off and safety valves, cylinder pressure reducer with bow coupling according to DIN 477-1

Cylinder contents bar	Working pressure bar	Inlet	Outlet		No.
Oxygen					
0 - 200	0 - 10	G 3/4" RH	G 1/4" RH	1.4	35634
Acetylene					
0 - 40	0 - 1.5	clamp RH	G 3/8" LH	1.6	35794



Blowback Prevention


Torch-mounted safety devices (flashback arrestors), type-tested, with flame trap, flow lock, non-return valve and dirt filter

Model	max. Operating pressure	Coupling-thread		No.
Handle-mounted, oxygen	25.0 bar	G 1/4" RH	90	540320
Handle-mounted, acetylene	1.5 bar (Ace)	G 3/8" LH	110	540321
	5.0 bar (propane/CNG)			
Reducer-mounted, oxygen	20.0 bar	G 1/4" RH	150	540360
Reducer-mounted, acetylene	1.5 bar (Ace)	G 3/8" LH	160	540365
	4.0 bar (propane/CNG)			
Reducer-mounted, oxygen	20.0 bar	G 1/4" RH	120	1000000633
Reducer-mounted, fuel gas	1.5 bar (Ace)	G 3/8" LH	120	1000000631
	5.0 bar (propane/CNG)			
Handle-mounted, oxygen	20.0 bar	G 1/4" RH	100	1000000764
Handle-mounted, fuel gas	1.5 bar (Ace)	G 3/8" LH	100	1000000762
	4.0 bar (propane/CNG)			




Protective Guard for Pressure Reducer

Impact protection, rugged steel construction, mounts on connection coupling

Model	Colour		No.
For oxygen pressure reducer	blue	820	35146
For acetylene pressure reducer	yellow	820	35140

Protective Rubber Cap


With slot, open

Model	Farbe		No.
For oxygen pressure reducer	blue	50	511427
For acetylene pressure reducer	red	50	511428



Oxygen Refilling Bend


Suitable for all 0.67l, 2l, 3l, 5l, 10l, 20l and 50l bottles up to 200 bar

Model		No.
max. 200 bar, cylinder coupling G 3/4"	360	35199



Safety Igniters

Powerful spark, wear-free hard alloy friction surface

Model		No.
Safety Igniter with rolling file	60	32077
Replacement flints, tin with 5 pieces	15	32088



Bonding

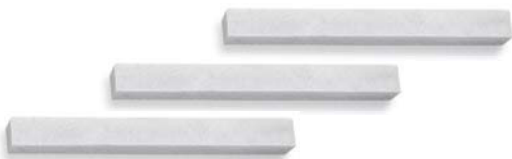
Accessories Soldering & Welding



No. 540850



No. 540855



No. 540620

No. 540622



No. 540640

Hand-held Welding Mirror

Model	g	No.
Steel wire handle with clamp / ball joint	280	540850
Spare steel mirror	50	540851

Magnet Welding Mirror

Model	g	No.
With flexible metal tube / ball joint	450	540855
Spare steel mirror	50	540851

Nozzle Cleaner

Model	g	No.
10 piece, in folding case	20	510105

Torch Spanner

Model	g	No.
With 11 SW	210	510106

Soldering Flux and Container for Hydrochloric Acid

Model	g	No.
With screw cap retaining band	40	530250

Salmiakstone

Model	L x W x H		g	No.
Pressed	65 x 45 x 40 mm	1	15	530310

Soapstone Marker

Model	L x W x H		g	No.
White, heat-resistant	100 x 10 x 10 mm	10	30	561550

Welding Goggles DIN EN 166

With thermal glasses as per DIN EN 169






Model	Glass	g	No.
Nylon safety goggles	A 4	60	540620
	A 5	60	540621
	clear, non-splintering	60	540622
Replacement glass (pair)	A 4	30	540625
	A 5	10	540626
	clear, non-splintering	30	540627
Screw-ring safety goggles	A 4	90	540640
	A 5	90	540641
Replacement glass (Ø 50 mm)	A 4	30	540675
	A 5	10	540676

ROVLIES® Cleaning Pads

Metal-free, for fast, score-free cleaning of copper pipe soldering surfaces

KEY FEATURES





- Reduced corrosion damage
- No metal abrasion, can be used wet or dry
- Removes oxide layers, corrosion, surface dirt, oil and grease residues
- Solvent-resistant and flexible

Model				No.
ROVLIES®	1(10)		80	45268
ROVLIES® counter display		36(10)	2,180	045268D



Internal Brushes for Copper Pipe





For fast cleaning of the soldering surface, rugged plastic handle

	mm		No.		mm		No.
	8	60	854179		16	120	854184
	10	70	854180		18	120	854185
	12	80	854181		22	140	854186
	14	90	854182		28	140	854187
	15	100	854183		35	160	854188




External Brushes for Copper Pipe

For fast cleaning of the soldering surface, tough housing

	mm		No.		mm		No.
	8	80	854189		18	140	854195
	12	100	854191		22	150	854196
	15	120	854193		28	160	854197
					35	170	854198



Hand Wire Brushes

Model	Numbers of rows		No.
Standard steel	3 rows	130	561351
Standard steel	4 rows	130	561352



Welding Blanket

Flame and heat resistant up to 700° C

- Permanent heat resistance up to 600° by direct flame contact and molten slag
- Good formability, long service life, asbestos-free and poses no health hazard
- Bonded edges

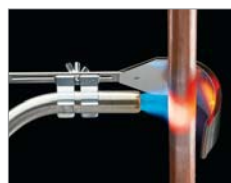
Thickness: 1.4 mm
Weight: 1,000 g/m²




Model	L x W x H		No.
Welding Blanket	330 x 500 mm	300	31050

Flame Reflectors

- Made of high-quality stainless steel
- Protects surrounding materials
- Better heat utilisation, saves time and energy



Model	Width mm	Adaptor Ø mm		No.
65 / 15	65	8 – 15	100	31042
65 / 22	65	15 – 22	100	31043


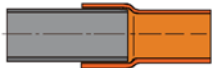
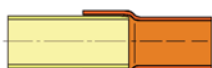



Fitting Soft Solder to DIN EN

Standard type according to DIN EN 29 453	Solder composition in weight %	Melting range °C	Suitable for soft soldering in the plumbing industry			Recommended heat source
			Pipe Material	Fittings material	Recommended Flux according to DIN EN 29454	
S -Sn97Cu3	Sn 97 %, Cu 3 %	230 - 250°	Copper	Copper, gunmetal, brass	Part 1 - 3.1.1, 3.1.2, 2.1.2 or ROSOL 3	Cartridge burner, heat resistant soldering unit, Propane / induced-air burner, Acetylene / induced-air burner, Larger pipe diameters above 28 mm with propane / oxygen burner with dispersion nozzle
S -Sn97Ag3	Sn 96.7 %, Ag 3.3 %	221 - 240°	Copper	Copper, gunmetal, brass	Part 1 - 3.1.1, 3.1.2, 2.1.2 or ROSOL 1 S	

Standard Solder according to DIN EN ISO

Standard type according to ISO 17672	Solder composition in weight %	Melting range °C	Working temperature °C	Suitable for installation technology brazing			Recommended Flux according to DIN EN 1045	Recommended heat source
				Pipe Material	Fittings material	Flux		
CuP 179	Cu 93,8 / P 6,2	710 - 880°	730°	Copper	Copper Gunmetal Brass	without flux with flux	FH 10 or LP 5	Cartridge torch with MAPP [®] Gas, Propane / induced-air torch, Acetylene / induced-air torch, Larger pipe diameters above 28 mm with propane / oxygen torch with dispersion nozzle
CuP 279	Ag 2 / Cu 91,7 / P 6,3	650 - 810°	710°	Copper	Copper Gunmetal Brass	without flux with flux	FH 10 or LP 5	
CuP 281	Ag 5 / Cu 89 / P 6	650 - 810°	710°	Copper	Copper Gunmetal Brass	without flux with flux	FH 10 or LP 5	
CuP 284	Ag 15 / Cu 80 / P 5	650 - 800°	710°	Copper	Copper Gunmetal Brass	without flux with flux	FH 10 or LP 5	
Ag 134	Ag 34 / Cu 36 / Zn 27,5 / Sn 2,5	630 - 730°	710°	Stahl Copper	Steel, Copper Gunmetal Brass	with flux (U = sheathed from 22 mm pipe-Ø)	FH 10 or LP 5	
Ag 145	Ag 45 / Cu 27 / Zn 25,5 / Sn 2,5	640 - 680°	670°	Stahl Copper	Steel, Copper Gunmetal Brass	with flux (U = sheathed from 22 mm pipe-Ø)	FH 10 or LP 5	

Soldered Joints

Material	Required Hard Solder	Melting Range	Working Temperature	Standard
Copper-Copper 	S 34 Cu / S 34 Cu U S 94 S 2 / S 5 S 15	630 °C - 730 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 800 °C	710 °C 730 °C 710 °C 710 °C	DIN EN ISO 17672 (former DIN EN 1044)
Copper-Carbon Steel 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	630 °C - 730 °C 640 °C - 680 °C	710 °C 670 °C	DIN EN ISO 17672 (former DIN EN 1044)
Copper-Brass 	S 94 S 2 S 5 S 15	710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 730 °C 710 °C 710 °C	DIN EN ISO 17672 (former DIN EN 1044)
Brass-Carbon Steel 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	600 °C - 690 °C 595 °C - 630 °C	680 °C 610 °C	DIN EN ISO 17672 (former DIN EN 1044)
Brass-Brass 	S 94 S 2 / S 5 S 15	710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 710 °C 710 °C	DIN EN ISO 17672 (former DIN EN 1044)
Carbon Steel-Carbon Steel 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	630 °C - 730 °C 640 °C - 680 °C	710 °C 670 °C	DIN EN ISO 17672 (former DIN EN 1044)

1) MAPP[®] is a registered trademark of the MESSER Group GmbH, Bad Soden


Fittings Solders

Quality soft solders according to **DIN EN 29453** for joining copper pipes to copper, gunmetal and brass fittings for hot and cold-water plumbing in accordance with DVGW worksheet GW 2 without flux, for use with corresponding ROSOL fittings solder paste

DIN
-Norm

Fitting Solder 1 S

Quality soft solder **S-Sn97Ag3**, melting range 221 °C – 240 °C, for use with ROSOL 1 S fittings solder paste


Solder wire Ø	Description	 g	No.
2 mm	250 g coil	270	45252
3 mm	250 g coil	270	45250



No. 45252

Fitting Solder 3

Quality soft solder, **S-Sn97Cu3**, melting range 230 °C - 250 °C, for use with ROSOL 3 fittings solder paste

Solder wire Ø	Description	 g	No.
2 mm	250 g coil	270	45257
3 mm	250 g coil	270	45255



No. 45257

DIN
-Norm

ROSOL Soldering Paste


Quality soft soldering flux according to **DIN EN ISO 9453** and **DIN EN 29454-1, 3.1.1.C**, with DVGW test mark Reg.-No. **DV-0101AT2247**, for joining copper pipes to copper, gunmetal and brass fittings for hot and cold-water plumbing in accordance with DVGW worksheet GW 7, metal content 60% by weight, flux residues are 100% water soluble

DIN
-Norm

ROSOL 1 S

Fittings solder paste

Quality soft soldering flux, metal content: **S-Sn97Ag3**, only for use with fitting solder 1 S

Model	 g	No.
ROSOL 1 S in plastic bottle 250 g	270	45220



No. 45220




No. 45225

ROSOL 3

Fittings solder paste


Quality soft soldering flux, metal content: **S-Sn97Cu3**, only for use with fittings solder 3

Model	 g	No.
ROSOL 3 in plastic bottle 250 g	270	45225

Fittings Soft Solder Flux

According to **DIN EN 29454-1 3.1.1.C**, flux residues are 100 % water soluble, for joining copper pipes to copper, gunmetal, and brass fittings for hot and cold-water plumbing in accordance with DVGW worksheet GW 2 + GW 7, also suitable for general-purpose soldering work.

DIN
-Norm

Model	 g	No.
Fittings Soft Solder Flux in plastic jar 35 ml	35	45266





Hard Solder Rings S 2

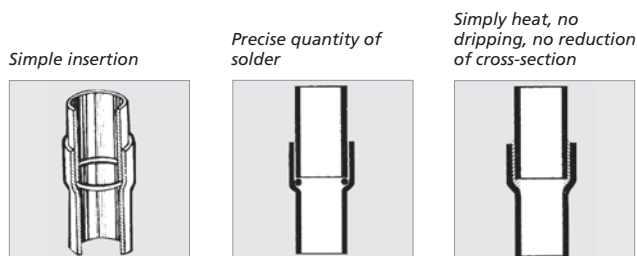
High-quality safety solder material with silver-phosphorus content, guaranteed according to DIN EN ISO 17672, CuP 279

KEY FEATURES

- Ideal for capillary soldering with copper pipe installation in sanitary and heating systems
- Matched precisely to the inner pipe diameters of expanded sockets and fittings according to **EN 1254**
- Complete wetting of soldering gaps
- Particularly efficient working through precise solder quantity
- No preparatory or re-work of the soldered joint

TECHNICAL DATA

Alloy (weight %):	Ag 1.5 - 2,5 / P 5.9 - 6.5 / Cu rest
Melting range:	650 °C - 810 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Use of flux with:	Gunmetal, brass, bronze with hard solder paste LP 5
Package size:	250 g plastic bag



Outside Ø mm	approx. Content rings	g	No.
Hard solder rings S 2, Ø 12 mm	395	260	40512
Hard solder rings S 2, Ø 14 mm	268	260	40514
Hard solder rings S 2, Ø 15 mm	244	260	40515
Hard solder rings S 2, Ø 16 mm	228	260	40516
Hard solder rings S 2, Ø 18 mm	186	260	40518
Hard solder rings S 2, Ø 22 mm	106	260	40522
Hard solder rings S 2, Ø 28 mm	79	260	40528



Hard Solder Paste LP 5

Flux for hand soldering at working temperatures above 600 °C, according to DIN EN 1045, Type FH 10, DVGW tested Reg.-No. DV-0101-AT2245, for gas and water installations with copper pipes, recommended by DVGW in accordance with Worksheets GW 2 and GW 7, hard solders with silver content and usable with any basic materials of steel, copper and copper alloys, brass and gunmetal, working temperature range 550 °C – 800 °C, flux residues must be removed carefully

Description	Type	g	No.
LP 5 in plastic bottle 160 g	160 g	180	40500



Hard Solder Powder HKM

Flux for hard soldering at working temperatures above 800 °C, according DIN EN 1045 - FH 21, working temperature 800 °C – 1,100 °C, for copper and copper alloys, brass, gunmetal, nickel silver, bronze, steel and galvanised steel, grey iron and malleable cast iron, for welding copper and brass in dry conditions, can be mixed with clean water to form a paste, flux residues must be removed carefully. Free of boric acid.

Description	g	No.
HKM in plastic bottle 50 g	65	35611



Flux Brush

Description	Width mm	Length mm	g	No.
Flux Brush	13	140	20	530261

Hard Solders

For copper pipe installation

ROTHENBERGER ROLOT® special hard solders are particularly suited for copper pipe installations in cold and hot water systems, for open and closed heating systems, for gas installations in accordance with DVGW Worksheet GW 2 (liquid, natural and town gas), as well as for HVAC and refrigeration applications, and oil pipes. ROTHENBERGER ROLOT® is especially suited for capillary soldering of copper pipes without fittings. Copper / phosphorus / silver solders are highly formable, and are therefore recommended for joints that are subjected to high thermal and mechanical alternating loads.

KEY FEATURES

- Non-foaming. Heat-resistant up to 200 °C
- No flux required with copper / copper joints
- Flux LP 5 is to be used when joining brass, gunmetal, copper, tin and copper / tin alloys
- Not to be used with materials containing sulphur, with iron / nickel alloys or with copper alloys containing nickel
- Manufactured with new, environmentally compatible technology, corrosion neutral, scale-free, improved flow properties



ROLOT® S 94 CuP 179

Quality hard solder **guaranteed according to DIN EN ISO 17672**, due to low phosphorus content, the solder has a wide melting range, and gives soldered joints with increased strength. Standard solder for normally-stressed copper pipe installation, especially for capillary soldering with copper pipe installation without fittings

TECHNICAL DATA

Alloy (weight %):	Cu 93,8 / P 6,2
Melting range:	710 °C – 880 °C
Working temperature:	730 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with LP 5



Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1,025	40094
400 g blister	2 x 2	500	420	1000000133

ROLOT® S 94 XN CuP 179

Quality brazing solder, **guaranteed according to DIN EN ISO 17672**, due to the special manufacturing method it has excellent flow characteristics, uniform melting for perfect soldered joints, capillary and air-tight active, ideal for capillary gap soldering in sanitary, heating and gas installation

TECHNICAL DATA

Alloy (weight %):	Cu 93,8 / P 6,2
Melting range:	710 °C – 880 °C
Working temperature:	730 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with LP 5



Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1,025	040097X

ROLOT® S 1

Special quality brazing solder, not standardised, **similar to DIN EN ISO 17672**, for normally-stressed copper pipes systems, also for gap soldering for copper pipe installations without fittings

TECHNICAL DATA

Melting range:	710 °C – 880 °C
Working temperature:	730 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Brass, gunmetal, bronze LP 5




Contents	mm	Length mm	g	No.
1 kg carton	2	500	1,025	40102

Bonding

Accessories Soldering & Welding



Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	40202
400 g blister	2 x 2	500	420	1000000135


ROLOT® S 2

Special quality hard solder, not standardised, **similar to DIN EN ISO 17672**, with low silver content, matched to normally-stressed copper pipe system, ideal for capillary gap soldering

TECHNICAL DATA

Melting range:	710 °C – 820 °C
Working temperature:	720 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with hard solder paste LP 5



Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	40212
1 kg carton	3 x 3	500	1,025	40213
400 g blister	2 x 2	500	420	1000000134

ROLOT® S 2


CuP 279

Silver / phosphorus safety hard solder, **guaranteed according to DIN EN ISO 17672**, for higher-stressed copper pipe systems, ideal for capillary soldering in sanitary, heating and gas installations

TECHNICAL DATA

Alloy (weight %):	Ag 2 / Cu 91.7 / P 6.3
Melting range:	650 °C – 810 °C
Working temperature:	710 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with hard solder paste LP5



Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	40502
400 g blister	2 x 2	500	420	1000000137


ROLOT® S 5

Particularly high quality hard solder, not standardised, **similar to DIN EN ISO 17672**, with low silver content, ideal for capillary and joint soldering in sanitary, heating and gas installations

TECHNICAL DATA

Melting range:	710 °C – 820 °C
Working temperature:	720 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with hard solder paste LP5



Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	40005
400 g blister	2 x 2	500	420	1000000136

ROLOT® S 5

CuP 281

High-quality silver/phosphorus safety hard solder, **guaranteed according to DIN EN ISO 17672**, for higher-stressed copper pipe systems, ideal for capillary and joint soldering in sanitary, heating and gas installations

TECHNICAL DATA

Alloy (weight %):	Ag 5 / Cu 89 / P 6
Melting range:	650 °C – 810 °C
Working temperature:	710 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with hard solder paste LP5


ROLOT® S 15 CuP 284

Particularly high quality silver hard solder, **guaranteed according to DIN EN ISO 17672**, especially for capillary-gap soldering subject to high thermal and mechanical alternating loads in HVAC systems, as well as demanding sanitary and gas installations



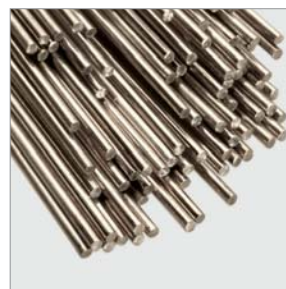
TECHNICAL DATA

Alloy (weight %):	Ag 15 / CU 80 / P 5
Melting range:	650 °C – 800 °C
Working temperature:	710 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Flux required with:	Gunmetal, brass, bronze with hard solder paste LP5

Contents	Square mm	Length mm	 g	No.
1 kg carton	2 x 2	500	1,025	40015



Silver Hard Solders Ag 134 S 34 Cu / S 34 Cu U flux-covered

Free of cadmium, quality silver hard solder **guaranteed according to DIN EN ISO 17672**, plain (S 34 Cu) or flux-covered **according to DIN EN1045 FH 10** (S 34 Cu U), universal application areas for gap soldering, also for drinking water installations, heat-resistant up to 200 °C



TECHNICAL DATA

Alloy (weight %):	Ag 34 / Cu 36 / Zn 27.5 / Sn 2.5
Melting range:	630 °C – 730 °C
Working temperature:	710 °C
Joinable materials:	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys
Flux required:	for S 34 Cu generally with hard solder paste LP 5

Contents	 mm	 g	S 34 No.	S 34 U No.
100 g plastic bag	2	110	44910	44915
250 g plastic bag	2	260	44911	44916
1000 g plastic bag	2	1,010	44912	44917



Silver Hard Solders Ag 145 S 45 Cu / S 45 Cu U flux-covered

Free of cadmium, quality silver hard solder, **guaranteed according to DIN EN ISO 17672**, plain (S 45 Cu) or flux-covered according to **DIN EN 1045, Type FH 10** (S 45 Cu U), universal application areas for gap soldering, excluding drinking water installations, heat-resistant up to 200 °C



TECHNICAL DATA

Alloy (weight %):	Ag 45 / Cu 27 / Zn 25.5 – 3.5 / Sn 2.5
Melting range:	640 °C – 680 °C
Working temperature:	670 °C
Joinable materials:	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys, stainless steel
Flux required:	for S 45 generally with hard solder paste LP 5

Contents	 mm	 g	S 45 No.	S 45 U No.
100 g plastic bag	2	110	45050	45055
250 g plastic bag	2	260	45051	45056
1000 g plastic bag	2	1,010	45052	45057