

# Welding guns and torches

PRODUCT CATALOGUE



***FLEXLITE***

Guns and torches for efficient welding

2020





# Everyday welding comfort

Welding guns and torches must withstand extreme temperatures in a demanding environment, whilst allowing the creation of high quality welds.

Flexlite professional series are designed for reliable welding performance, focused around everyday welding comfort.

Flexlite products feature specific user values, including light weight, balance, and reduced wrist loading. They feature excellent technical performance and extended consumables life.

## EASY ACCESS TO INFORMATION

All Flexlite torches are equipped with a QR code to help you find the right parts and accessories. Scan the code, and it takes you directly to relevant ordering codes, consumables, product documents and Kemppi contacts.







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## FLEXLITE TX TORCHES FOR TIG WELDING

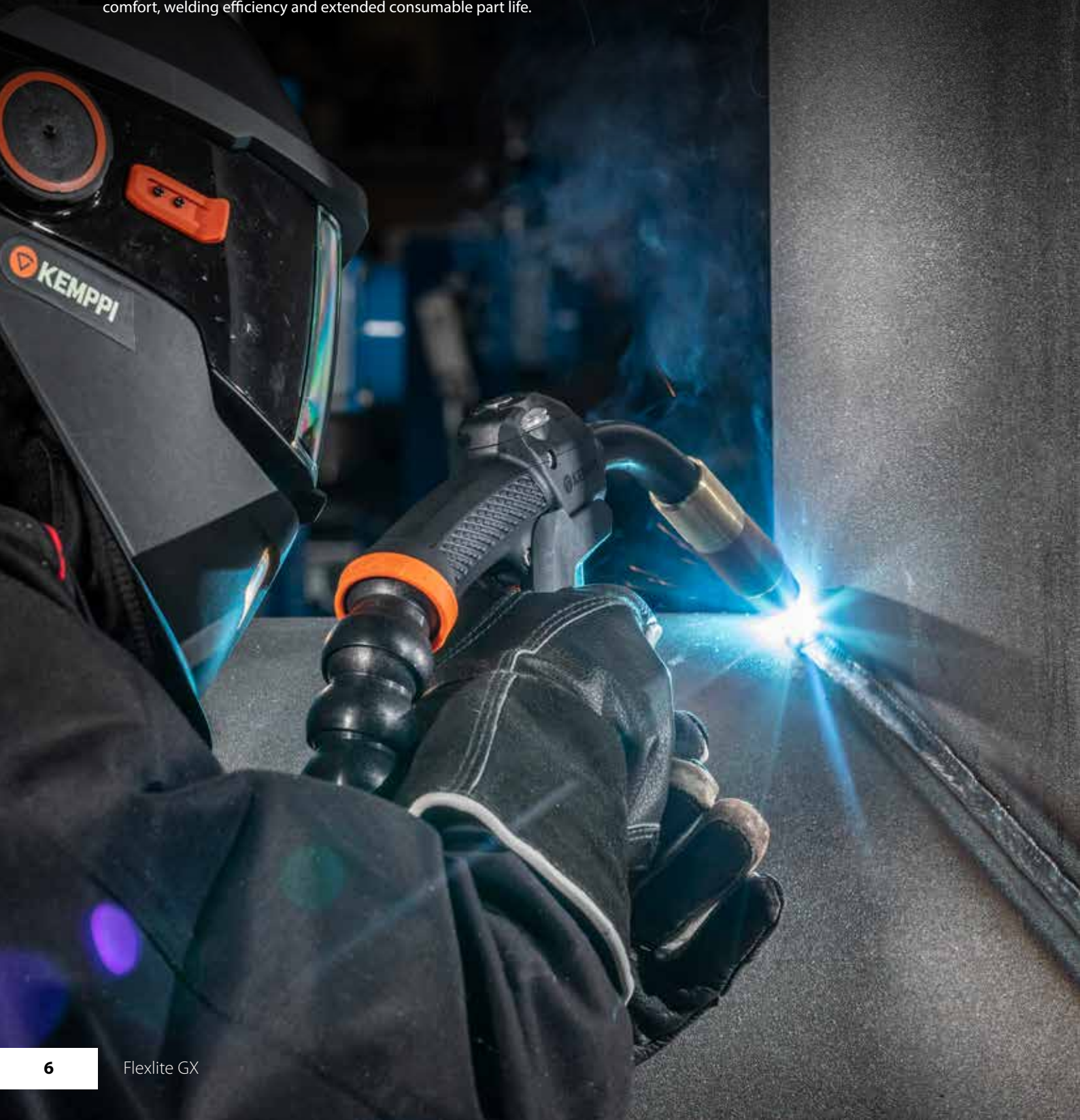
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# FLEXLITE GX

Natural extension to your hand

**Flexlite GX product series** contains welding guns to be used in MIG/MAG welding processes. There are Flexlite GX models available in three value levels: K3, K5 and K8. Each level is designed to serve specific welding needs. All Flexlite GX models enjoy the Flexlite features for user comfort, welding efficiency and extended consumable part life.





## Flexlite GX guns for MIG/MAG welding

Kemppi's Flexlite GX guns for MIG/MAG welding increase user comfort and welding productivity. Their innovative production methods, high quality materials and strict quality control guarantee that you can rely 100 % on your Flexlite GX welding gun.

The pistol grip handle, anatomically designed shape and excellent balance reduce wrist loading, allowing the welder to concentrate on challenging tasks to achieve the perfect weld. This has a good effect on both quality and productivity.

If you calculate the total cost of ownership for a Flexlite GX welding gun, you will see that it stands out for its long-life consumables, for its efficiency and good ergonomics, and that it clearly improves your overall welding productivity.

The Flexlite GX welding guns are available in alternative power classes and lengths, including different neck versions.



### **EXCELLENT ERGONOMICS**

Lower fatigue has a positive effect on welder's work and results in better quality and efficiency.



### **EFFICIENT WELDING**

High-performance torch uses the power source capacity efficiently and helps you create smooth and spatter-free welds.



### **LONG CONSUMABLE LIFE**

Reliable and durable  
Kemppi consumable parts support welding quality and productivity.



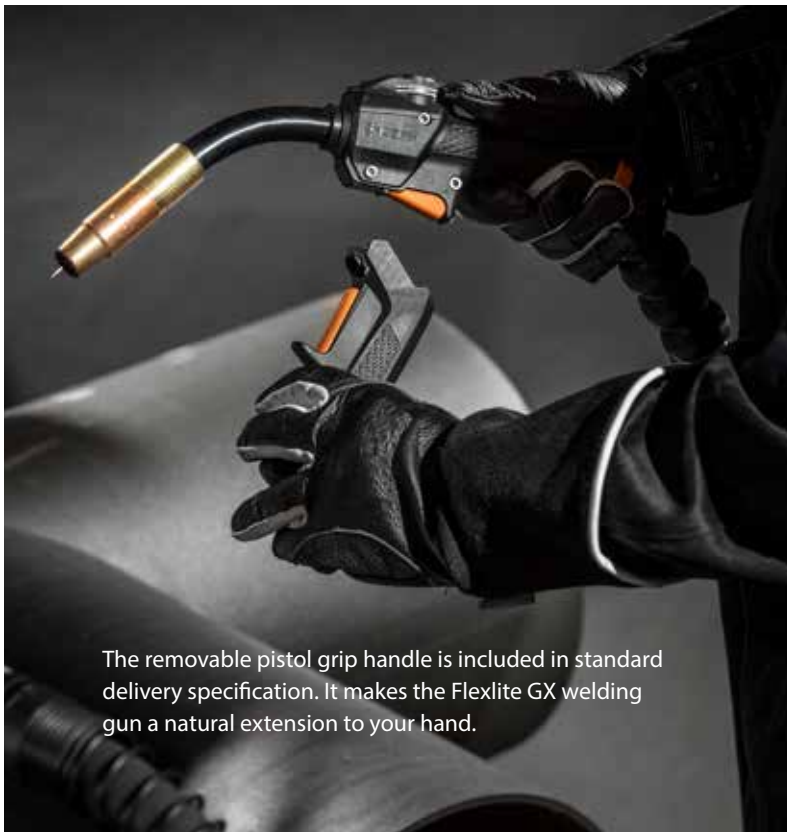


Manual welding is heavy physical work, which requires you to stay very alert for long periods of time. It helps if your tools have special features that reduce work fatigue – and the Flexlite GX welding guns match this description perfectly.



# When it comes to usability, you know Flexlite GX makes a great choice!


Flexlite GX welding guns feature impressive shape and balance. Flexible cable sets and ball-jointed cable protection reduce wrist loading, so that you can really feel the difference. This lowers the welder fatigue and leads to increased work quality and efficiency.



The removable pistol grip handle is included in standard delivery specification. It makes the Flexlite GX welding gun a natural extension to your hand.



The ball-jointed cable protection is very flexible, reducing wrist loading and allowing steady and reliable wire feed in all situations.



Every welder has a unique handwriting. It is of great significance, what kind of torch you are holding when filling the seam. Flexlite is the right instrument for every skilled welding professional. It helps you create a handwriting that stands out for its quality.



# Innovative design is reflected in weld quality and welding efficiency

Flexlite GX models feature lower gun neck and contact tip temperatures. This has been achieved with a new, innovative gun neck structure, where the cooling channels run closer to the main consumables, and they are separated from the shielding gas channels.

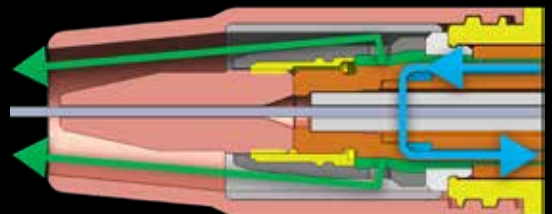
Together with high quality consumable parts, this feature elevates welding efficiency and improves the welding quality. It also extends the lifetime of consumable parts, leading to easier spare part management and savings in consumable costs.

**35 %** COOLER THAN OTHERS

According to tests made in Kemppi welding laboratory, the Flexlite GX welding guns showed up to **35 % temperature decrease** in contact tip, when compared to a corresponding non-Flexlite welding gun. This indicates that Flexlite's multi-channel cooling system plays an important role in significant lifetime improvement of consumables.



Shielding gas flow has a significant effect on weld quality. Normally shielding gas is invisible, but with Schlieren imaging technology it is possible to observe the real gas flow. This illustrates, how Flexlite GX welding gun design and consumable parts enable laminar gas flow and better shielding gas coverage.



Cooling liquid circulates close to main consumables, keeping them cooler and extending their lifetime. (Blue arrows)

Separate shielding gas channels in the gun neck enable cleaner welds, less spatters and smaller shielding gas consumption. (Green arrows)



Genuine Kemppe spare parts are made of high quality materials and under strict quality control and inspection. The Kemppe brand mark on the spare part is a guarantee of a long and reliable lifetime.



# Less consumables means lower inventory costs

Flexlite GX welding guns feature improved thermal efficiency, which enables cooler temperatures and extended consumable lifetime and leads to more than 50 % lower consumables usage. High-performance, precision-drilled contact tips with improved wear life suit wide-ranging applications and filler wire types.

## LESS PARTS, LOWER COSTS

The number of changeable parts has been reduced by improving cross-matching across corresponding models, and by combining the functions of some of the consumables. As a result, the total number of consumables has been reduced per individual gun models. This lowers inventory costs and makes Flexlite perfect for workshop cost management.



Original Kemppi contact tips are marked with a Kemppi brand mark. They are precision-drilled, high-performance contact tips that last longer and make the welding gun operation more reliable, bringing you direct cost savings.

For more information on Kemppi contact tips, see page 34.

*Easy contact tip size selection for different filler wire materials and applications with three clearance groups: C1, C2 and C3.*

# Better quality and

## GUN REMOTE CONTROL

Optional on-torch remote controls allow accurate and immediate welding current adjustment and memory channel selection at a distance. Available for K5 and K8 level welding guns.

## ERGONOMIC HANDLE DESIGN

Anatomically shaped handle with a firm grip. A modular trigger with a few parts and simple wiring. The handle cover, trigger and gun remote control are quick and easy to change.

## WORK LIGHTS

K8 level guns feature optional LED work lights to aid pre-weld positioning and post-weld visibility.

## IMPROVED NECK COOLING

Separate shielding gas channels and the cooling circulation that is running to the end of the gun neck keep the neck cooler and enable cleaner welds, less spatters and longer consumable life.

## LESS PARTS, LOWER COSTS

The number of changeable parts has been reduced by improving cross-matching across corresponding models, and by combining the functions of some of the consumables. This lowers inventory costs and makes Flexlite perfect for workshop cost management.

## PISTOL GRIP HANDLE

The pistol grip handle is included in standard delivery specification. It allows a natural wrist position, which makes the work easier and more effortless, especially when doing long welds. Quick to install without tools.





# improved productivity



## SMART CABLE DESIGN

Flexible cable sets and ball-jointed cable protection reduce wrist torque, which makes the work more easier and more effortless. The cable set features replaceable internal cables and hoses.

## EASY ACCESS TO INFORMATION

The QR code takes you directly to relevant ordering codes, consumables, product documents and Kemppi contacts.

## CABLE SPRING PROTECTION

Strong, spring-protected cable end prevents sudden bends and protects the hoses inside the cable.

## CONNECTION

K3 and K5 level gun models feature a universal Euro connection to the wire feeder, which enables their connectivity with most MIG/MAG welding equipment brands. K8 level welding gun models have a special Kemppi connector, allowing accurate data collection from the welding arc.

# Value levels – Best gun for each task

Kemppi's Flexlite GX guns for MIG/MAG welding are divided into three value levels: K3, K5 and K8. Each level is designed to serve specific welding needs. The higher the value level, the more features you get.

All value level models enjoy the Flexlite features for user comfort and extended consumable part life. Designed with superb balance, they reduce wrist loading and work fatigue. The same consumables can be used in all K-level models, which simplifies spare part management and makes it more cost-efficient.



**K8 level** models are a powerful combination of ergonomic and technical welding performance. A remote control device with a display can be bought separately. The LED work light provides better visibility in low light working conditions, aiding pre-weld positioning and post-weld visibility. The gas-cooled K8 level gun range features exchangeable swan necks. The Kemppi Gun Connector offers enhanced mechanical and electrical properties together with real-time arc voltage measurement.



**K5 level** models suit a variety of professional applications and include both gas- and water-cooled models. MN stands for Multi-Neck, a fast-change gun neck system, allowing one of three neck variants to be selected and fitted to the gun handle in seconds. All K5 level models accept the optional remote control device, which provides real-time selection of welding power or memory channels during welding. Euro connector guarantees connectivity with most MIG/MAG welding equipment brands.



**K3 level** models are suitable for use across a wide range of materials and tasks. They are available in both gas- and water-cooled models from 3 to 5 meters in length. Euro connector guarantees connectivity with most MIG/MAG equipment brands. No option for remote control.

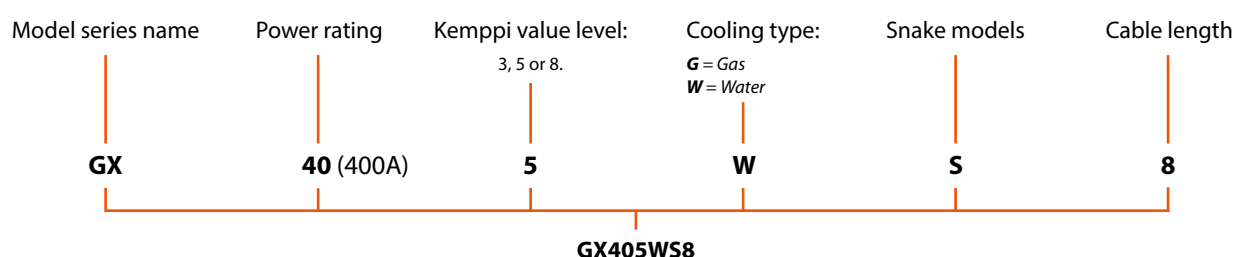




K3 level	page	K5 level	page	K8 level	page
<b>Flexlite GX 253G</b> Load capacity: 250A/35% Cooling: gas Length: 3.5 m / 5 m	20	<b>Flexlite GX 255G</b> Load capacity: 250A/35% Cooling: gas Length: 3.5 m / 5 m	20	<b>Flexlite GX 208G</b> Neck: Multi-neck Load capacity: 200A/60% Cooling: gas Length: 3.5 m / 5 m	26
<b>Flexlite GX 203G</b> Load capacity: 200A/35% Cooling: gas Length: 3.5 m / 5 m	21	<b>Flexlite GX 205G</b> Load capacity: 200A/35% Cooling: gas Length: 3.5 m / 5 m	21	<b>Flexlite GX 308G</b> Neck: Multi-neck Load capacity: 300A/60% Cooling: gas Length: 3.5 m / 5 m	26
<b>Flexlite GX 303G</b> Load capacity: 300A/35% Cooling: gas Length: 3.5 m / 5 m	22	<b>Flexlite GX 305G</b> Load capacity: 300A/35% Cooling: gas Length: 3.5 m / 5 m / 6 m / 8 m	22	<b>Flexlite GX 408G</b> Neck: Multi-neck Load capacity: 400A/60% Cooling: gas Length: 3.5 m / 5 m	27
<b>Flexlite GX 403G</b> Load capacity: 400A/35% Cooling: gas Length: 3.5 m / 5 m	23	<b>Flexlite GX 305GMN</b> Neck: Multi-neck Load capacity: 350A/35% Cooling: gas Length: 3.5 m / 5 m	25	<b>Flexlite GX 428W</b> Neck: normal or N250 Load capacity: 420A/100% Cooling: water Length: 3.5 m / 5 m / 8 m*	28, 31
<b>Flexlite GX 303W</b> Load capacity: 300A/100% Cooling: water Length: 3.5 m / 5 m	21	<b>Flexlite GX 405G</b> Load capacity: 400A/35% Cooling: gas Length: 3.5 m / 5 m	23	<b>Flexlite GX 528W</b> Neck: normal or N250 Load capacity: 520A/100% Cooling: water Length: 3.5 m / 5 m	29
<b>Flexlite GX 403W</b> Load capacity: 400A/100% Cooling: water Length: 3.5 m / 5 m	22	<b>Flexlite GX 305W</b> Load capacity: 300A/100% Cooling: water Length: 3.5 m / 5 m / 6 m**	21	<b>Flexlite GX 608W</b> Load capacity: 600A/40% Cooling: water Length: 5 m	30
<b>Flexlite GX 503W</b> Load capacity: 500A/100% Cooling: water Length: 3.5 m / 5 m	23	<b>Flexlite GX 405W</b> Load capacity: 400A/100% Cooling: water Length: 3.5 m / 5 m / 6 m* / 8 m*	22		
		<b>Flexlite GX 505W</b> Load capacity: 500A/100% Cooling: water Length: 3.5 m / 5 m	23		
		<b>Flexlite GX 605W</b> Load capacity: 600A/40% Cooling: water Length: 5 m	24		

\* Load capacity 300A/100%  
 \*\* Load capacity 250A/100%

### The name of a Flexlite welding gun tells its properties and use



## ACCESSORIES



Flexlite GX accessories provide greater comfort and usability to your welding. The on-torch remote controls reduce the need to leave the workplace to adjust parameters, and the pistol grip handle reduces the wrist loading in certain welding jobs. This makes the welder's work easier and more efficient.

# Improve the ergonomics and usability with Flexlite accessories



Pistol grip handle is a standard accessory included in all Flexlite GX welding gun packages. It allows a natural wrist position, which makes the work easier and more effortless, especially when doing long welds. Quick to install and remove without tools.



GXR10 Gun Remote is an on-torch remote control device for K5 level Flexlite GX welding guns. When used with a compatible welding system, it allows accurate and immediate welding current adjustment and memory channel selection conveniently from the welding gun.

Fast and easy to install, GXR10 Gun Remote can be purchased as an optional accessory for any K5 level Flexlite GX welding gun.

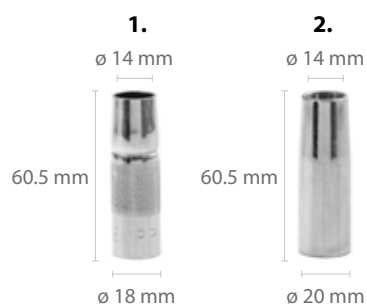
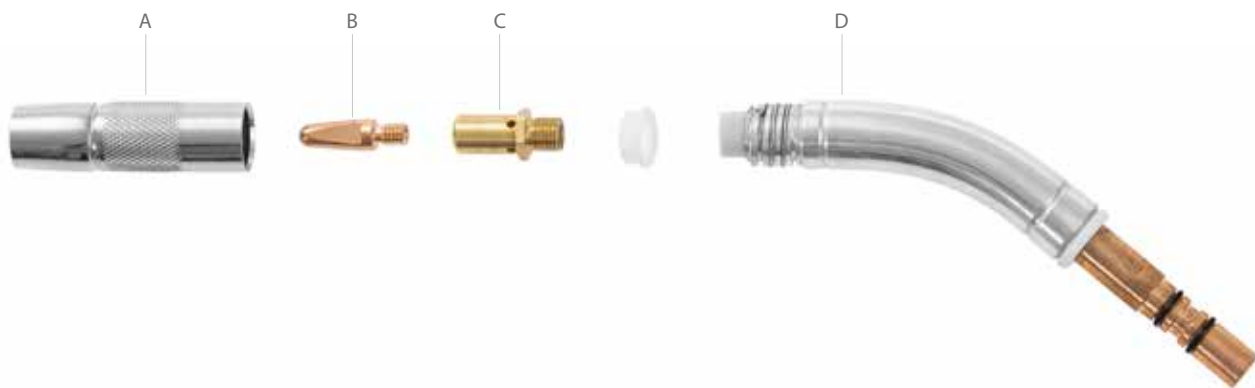


K8 level Flexlite GX welding guns can be equipped with a sophisticated gun remote control device GXR80 Gun Remote With Display. It has a bright and clear LED display that provides a crisp view to manage the welding parameters, memory channels and WPSs.



CONSUMABLES

GX253G35, GX253G5, GX255G35, GX255G5



A. Gas nozzle		
1.	9580101	MT18, 25, 26
2.	9580101E	MT25, thick wall
3.	958010101	MT18-25-26 with insulating bush



B. Contact tip		
CT10C1SD003	1.0 C1 STD M6	



C. Contact tip adapter		
9580173	MT18, 25	



D. Gun neck		
SP014695	180G	



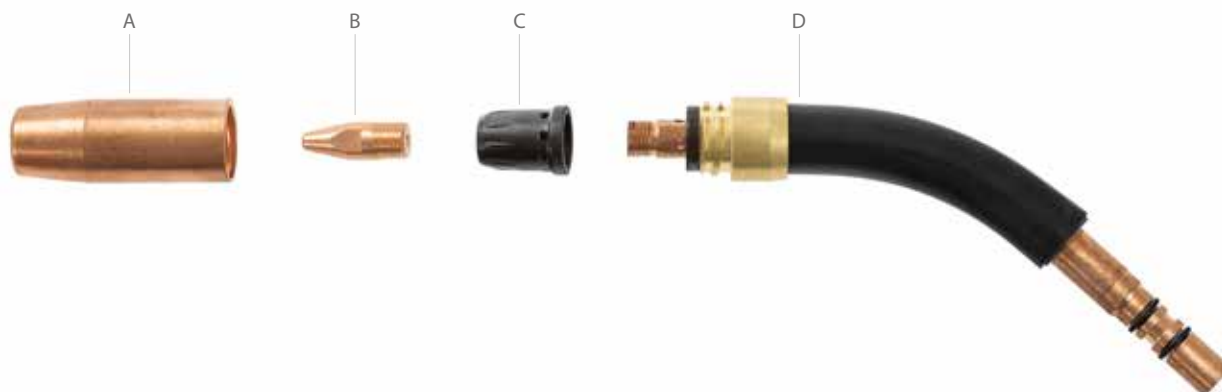
Wire liners		
W013628	0.9-1.2 Fe/3.5 m Ø 4.6 steel	
W013632	0.9-1.2 Fe/5.0 m Ø 4.6 steel	



Wire guide tube		
SP016214	End cap 4.9 mm, sealed, G	

## CONSUMABLES

GX203G35, GX203G5, GX303W35, GX303W5, GX205G35, GX205G5, GX305W35, GX305W5, GX305WS6\*



A. Gas nozzle		
1.	W014452	Thread, L57 / OD22 / D14
2.	W015858	Thread, L60 / OD22 / D15



D. Gun neck		
SP014682		200G
SP014957		300W



B. Contact tip		
CT10C1SD001		1.0 C1 STD M10



Wire liners		
W013628		0.9-1.2 Fe/3.5 m Ø 4.6 steel
W013632		0.9-1.2 Fe/5.0 m Ø 4.6 steel
W016311		1.0-1.2 Ss, (Fe)/6.0 m Ø 5.9 DL-CHILI



C. Contact tip adapter		
W013203		M10, insulated
W011483		M10

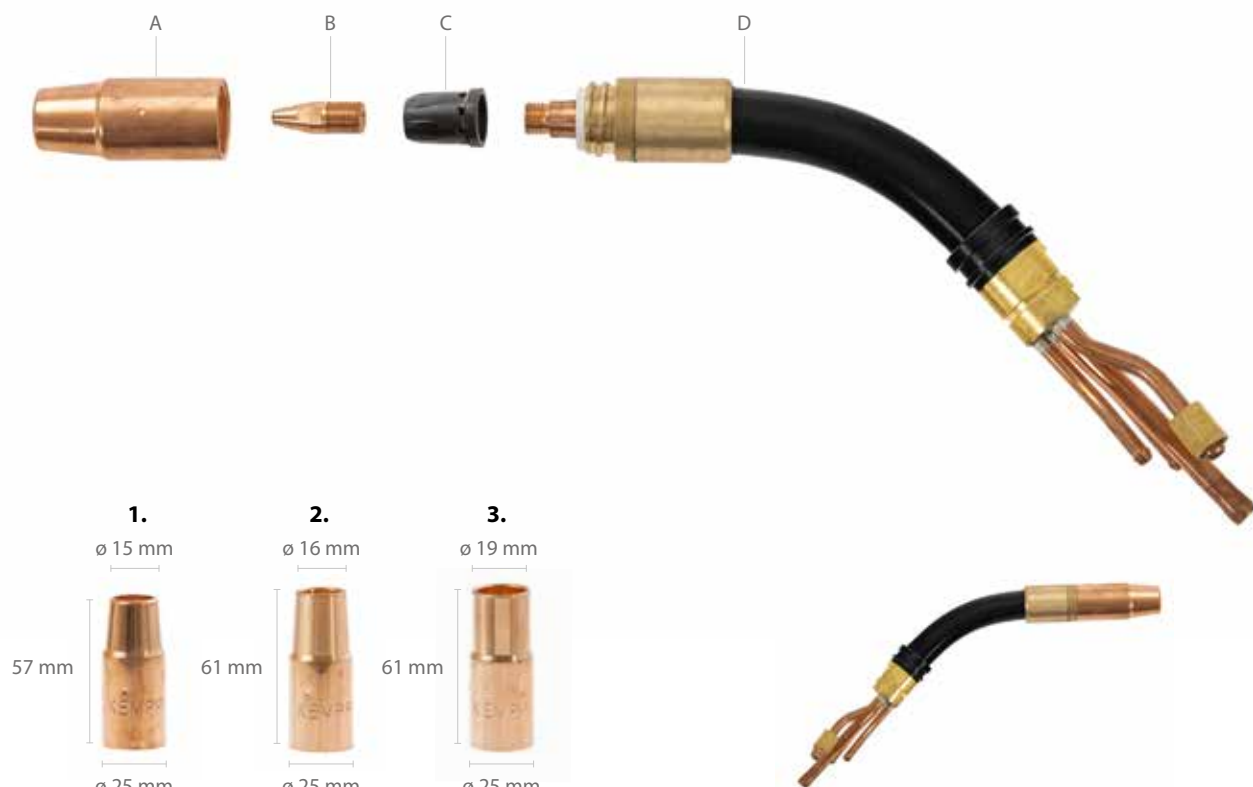


Wire guide tube		
SP016214		End cap 4.9 mm, sealed, G
SP014606		End cap 4.9 mm, W
SP015160		End cap 6.3 mm

\* Model delivered without a wire liner. For ordering codes, see page 36.

## CONSUMABLES

GX303G35, GX303G5, GX403W35, GX403W5, GX305G35, GX305G5, GX305GS6\*, GX305GS8\*, GX405W35, GX405W5, GX405WS6\*, GX405WS8\*



### A. Gas nozzle

1.	W011478	Thread, L57 / OD25 / D15
2.	W013930	Thread, L61 / OD25 / D16
3.	W012143	Thread, L61 / OD25 / D19



### B. Contact tip

CT10C1SD001	1.0 C1 STD M10
CT12C1SD001	1.2 C1 STD M10



### C. Contact tip adapter

W013203	M10, insulated
W011483	M10

### D. Gun neck

SP013786	300G
SP012594	420W
SP013770	420W, L=250



### Wire liners

W013628	0.9-1.2 Fe/3.5 m Ø 4.6 steel
W013632	0.9-1.2 Fe/5.0 m Ø 4.6 steel
W016311	1.0-1.2 Ss, (Fe)/6.0 m Ø 5.9 DL-CHILI
W016312	1.0-1.2 Ss, (Fe)/8.0 m Ø 5.9 DL-CHILI



### Wire guide tube

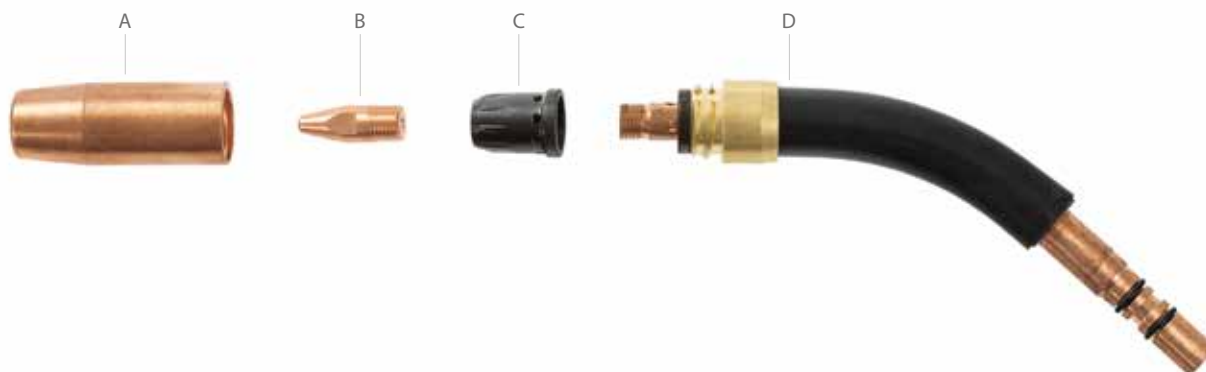
SP016214	End cap 4.9 mm, sealed, G
SP014606	End cap 4.9 mm, W
SP015160	End cap 6.3 mm

\* Model delivered without a wire liner. For ordering codes, see page 36.



## CONSUMABLES

GX403G35, GX403G5, GX503W35, GX503W5, GX405G35, GX405G5, GX505W35, GX505W5



A. Gas nozzle		
1.	W011472	Thread, L60 / OD28 / D15
2.	W013931	Thread, L64 / OD28 / D17
3.	W012146	Thread, L64 / OD28 / D21



B. Contact tip		
CT12C1SD001	1.2 C1 STD M10	



C. Contact tip adapter		
W013203	M10, insulated	
W011483	M10	



D. Gun neck		
SP014666	400G	
SP012561	520W	
SP013778	520W, L=250	



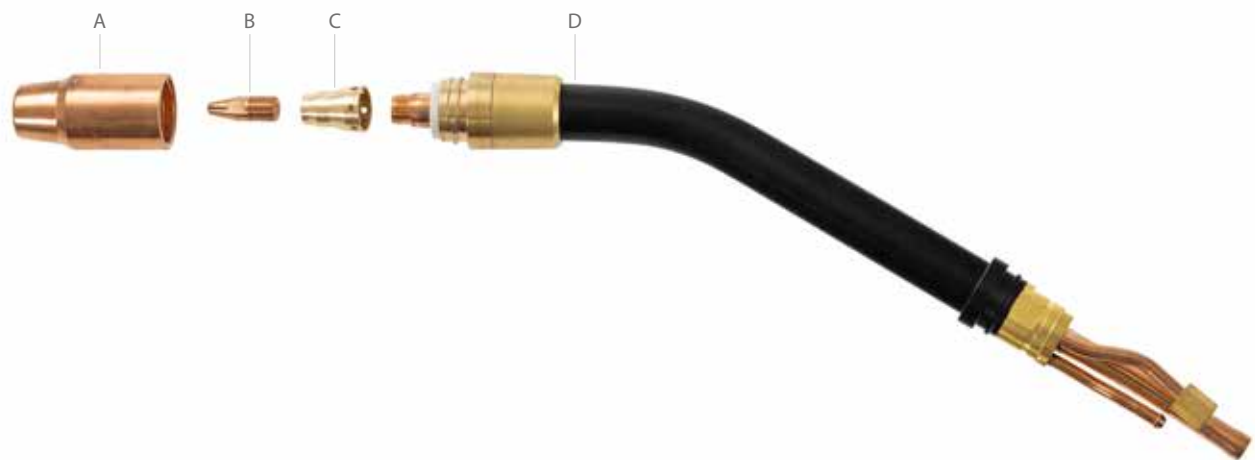
Wire liners		
W013628	0.9-1.2 Fe/3.5 m Ø 4.6 steel	
W013632	0.9-1.2 Fe/5.0 m Ø 4.6 steel	



Wire guide tube		
SP016214	End cap 4.9 mm, sealed, G	
SP014606	End cap 4.9 mm, W	

CONSUMABLES

GX605W5



**A. Gas nozzle**

W012793	Thread, L64 / OD30 / D17
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**D. Gun neck**

SP012776	600W
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**B. Contact tip**

CT12C1SD001	1.2 C1 STD M10
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**Wire liners**

W012614	1.2-1.6 Fe/5M YE steel
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**C. Contact tip adapter**

W012810	M10, 600W
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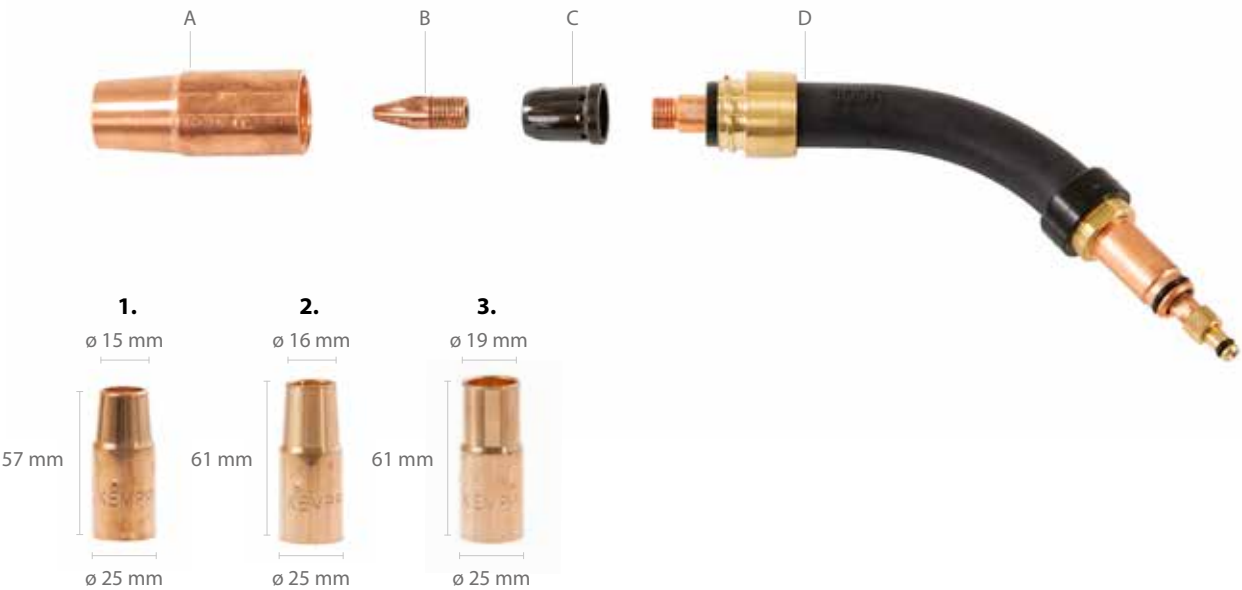


**Wire guide tube**

SP015160	End cap 6.3 mm
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CONSUMABLES

GX305GMN35, GX305GMN5



A. Gas nozzle		
1.	W011478	Thread, L57 / OD25 / D15
2.	W013930	Thread, L61 / OD25 / D16
3.	W012143	Thread, L61 / OD25 / D19
4.	W011958	Thread, L51 / OD25 / D12 (Root)



B. Contact tip		
CT10C1SD001		1.0 C1 STD M10



C. Contact tip adapter		
W013203		M10, insulated
W011483		M10



D. Gun neck		
SP012416		300G MN



Neck wire liner		
SP012201		NECK LINER MN 300G 1.5/4.0 L191
SP012202		NECK LINER MN 300G 2.0/4.0 L191
SP012200		NECK LINER MN 300G 2.5/4.0 L191



Wire liners		
W012361		MN 0.9-1.2 Fe/3.5 m RD steel
W012362		MN 0.9-1.2 Fe/5.0 m RD steel



Wire guide tube		
SP015160		End cap 6.3 mm



CONSUMABLES

GX208GMN35, GX208GMN5, GX308GMN35, GX308GMN5

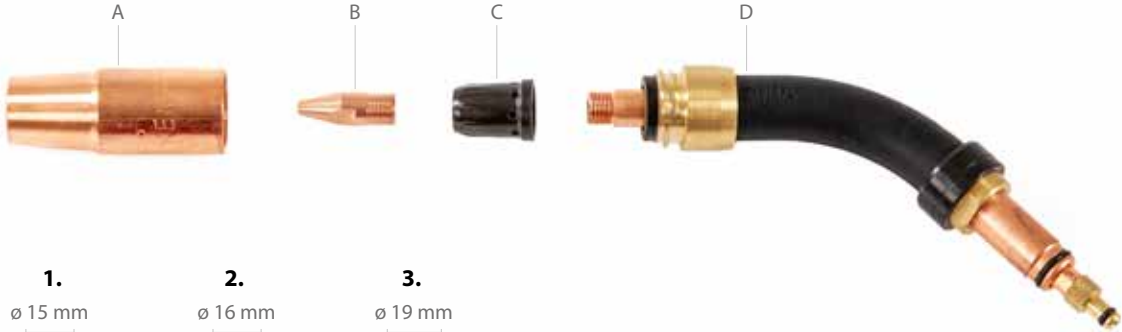


Diagram showing the assembly of consumable components A, B, C, and D. Component A is a gas nozzle, B is a contact tip, C is a contact tip adapter, and D is the gun neck assembly.

**1.**

ø 15 mm

57 mm

ø 25 mm

**2.**

ø 16 mm

61 mm

ø 25 mm


**3.**

ø 19 mm


61 mm

ø 25 mm

A. Gas nozzle		
1.	W011478	Thread, L57 / OD25 / D15
2.	W013930	Thread, L61 / OD25 / D16
3.	W012143	Thread, L61 / OD25 / D19
4.	W011958	Thread, L51 / OD25 / D12 (Root)




B. Contact tip	
CT10C1SD001	1.0 C1 STD M10




C. Contact tip adapter	
W013203	M10, insulated
W011483	M10 brass




D. Gun neck	
SP012415	200G MN
SP012416	300G MN



Neck wire liner	
SP012238	MN 200G 1.5/4.0 L171
SP012239	MN 200G 2.0/4.0 L171
SP012240	MN 200G 2.5/4.0 L171
SP012201	MN 300G 1.5/4.0 L191
SP012202	MN 300G 2.0/4.0 L191
SP012200	MN 300G 2.5/4.0 L191



Wire liners	
W012361	MN 0.9-1.2 Fe/3.5 m RD steel
W012362	MN 0.9-1.2 Fe/5.0 m RD steel



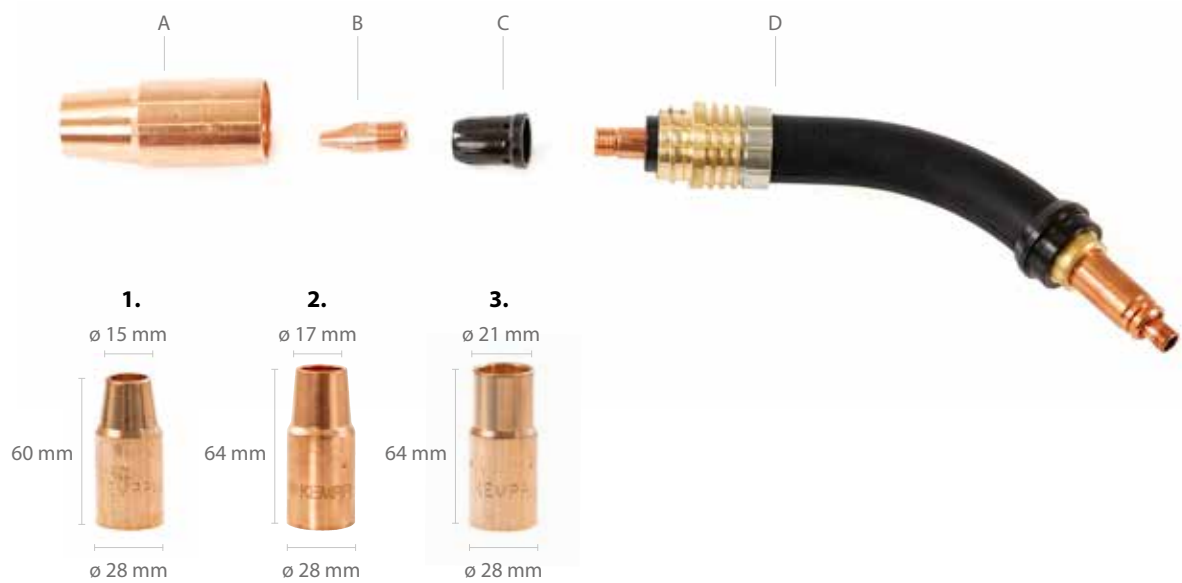
Wire guide tube	
SP011868	Guide tube out 1.0 RD plastic

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Flexlite GX

CONSUMABLES

GX408GMN35, GX408GMN5



A. Gas nozzle		
1.	W011472	Thread, L60 / OD28 / D15
2.	W013931	Thread, L64 / OD28 / D17
3.	W012146	Thread, L64 / OD28 / D21



B. Contact tip	
CT12C1SD001	1.2 C1 STD M10



C. Contact tip adapter	
W013203	M10, insulated
W011483	M10



D. Gun neck	
SP012417	400G MN



Neck wire liner	
SP012235	MN 400G 1.5/4.0 L216
SP012236	MN 400G 2.0/4.0 L216
SP012237	MN 400G 2.5/4.0 L216



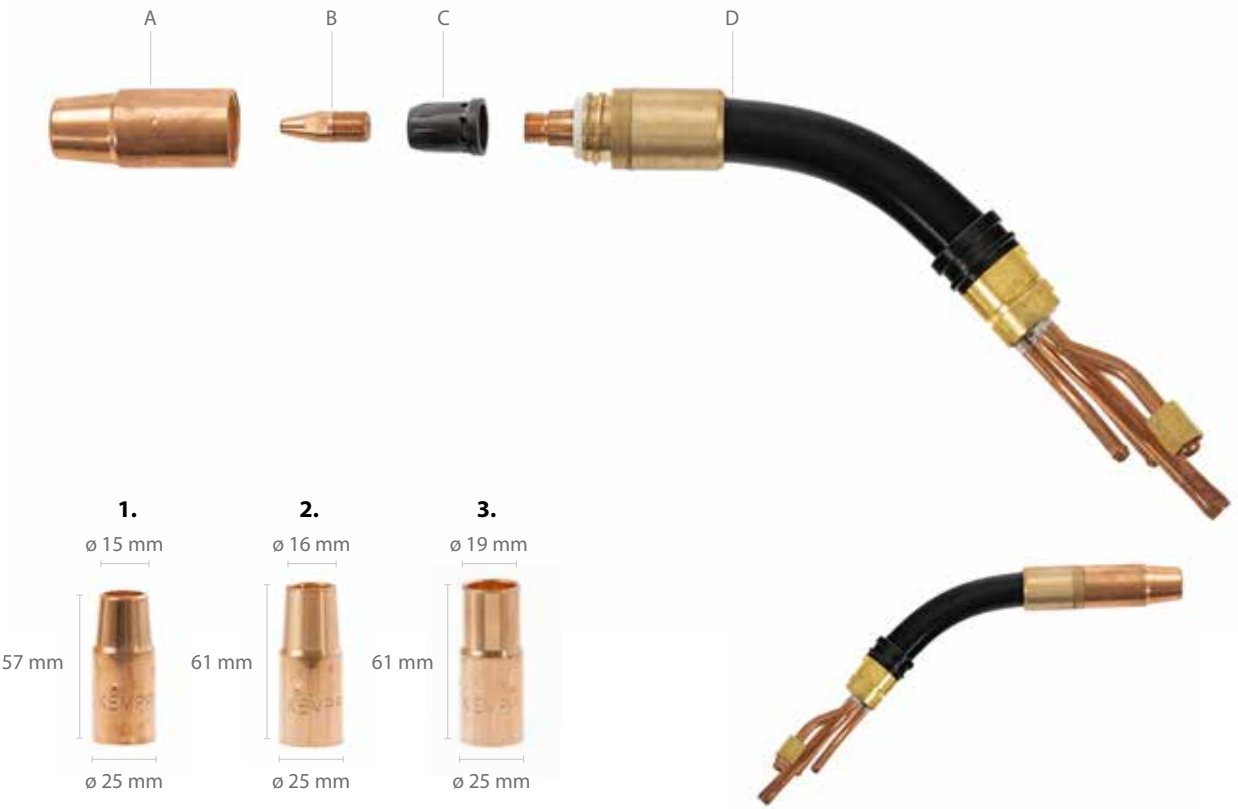
Wire liners	
W012361	MN 0.9-1.2 Fe/3.5 m RD steel
W012362	MN 0.9-1.2 Fe/5.0 m RD steel



Wire guide tube	
SP011869	Guide tube out 1.2 OG plastic

CONSUMABLES

GX428W35, GX428W5, GX428W35N250, GX428W5N250



A. Gas nozzle		
1.	W011478	Thread, L57 / OD25 / D15
2.	W013930	Thread, L61 / OD25 / D16
3.	W012143	Thread, L61 / OD25 / D19



B. Contact tip		
CT10C1SD001	1.0 C1 STD M10	



C. Contact tip adapter		
W013203	M10, insulated	
W011483	M10	

D. Gun neck		
SP012594	420W	
SP013770	420W, L=250	



Wire liners		
W013628	0.9-1.2 Fe/3.5 m Ø 4.6 steel	
W013632	0.9-1.2 Fe/5.0 m Ø 4.6 steel	

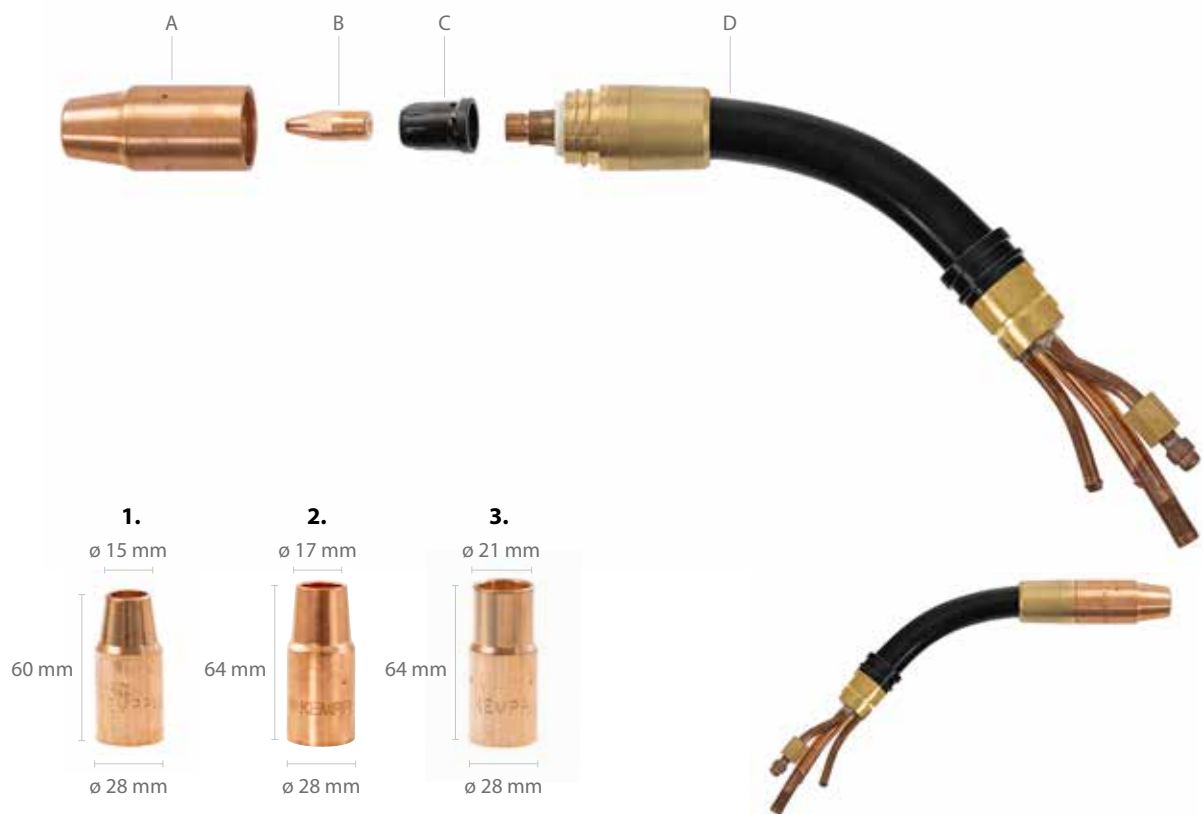


Wire guide tube		
SP013597	1.0 / 4.9 RD plastic	



CONSUMABLES

GX528W35, GX528W5, GX528W35N250, GX528W5N250



A. Gas nozzle		
1.	W011472	Thread, L60 / OD28 / D15
2.	W013931	Thread, L64 / OD28 / D17
3.	W012146	Thread, L64 / OD28 / D21



B. Contact tip	
CT12C1SD001	1.2 C1 STD M10



C. Contact tip adapter	
W013203	M10, insulated
W011483	M10

D. Gun neck	
SP012561	520W
SP013778	520W, L=250



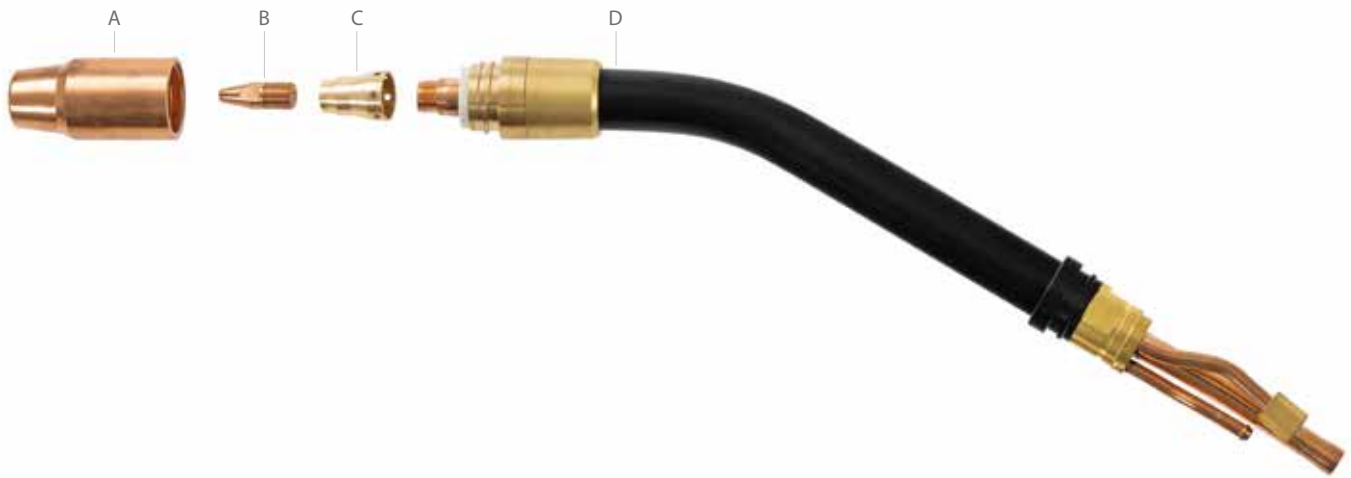
Wire liners	
W013632	0.9-1.2 Fe/5.0 m $\varnothing$ 4.6 steel



Wire guide tube	
SP013598	1.2 / 4.9 OG plastic

CONSUMABLES

GX608W5



A. Gas nozzle	
W012793	Thread, L64 / OD30 / D17



D. Gun neck	
SP012776	600W



B. Contact tip	
CT12C1SD001	1.2 C1 STD M10



Wire liners	
W012614	1.2-1.6 Fe/5 m YE steel



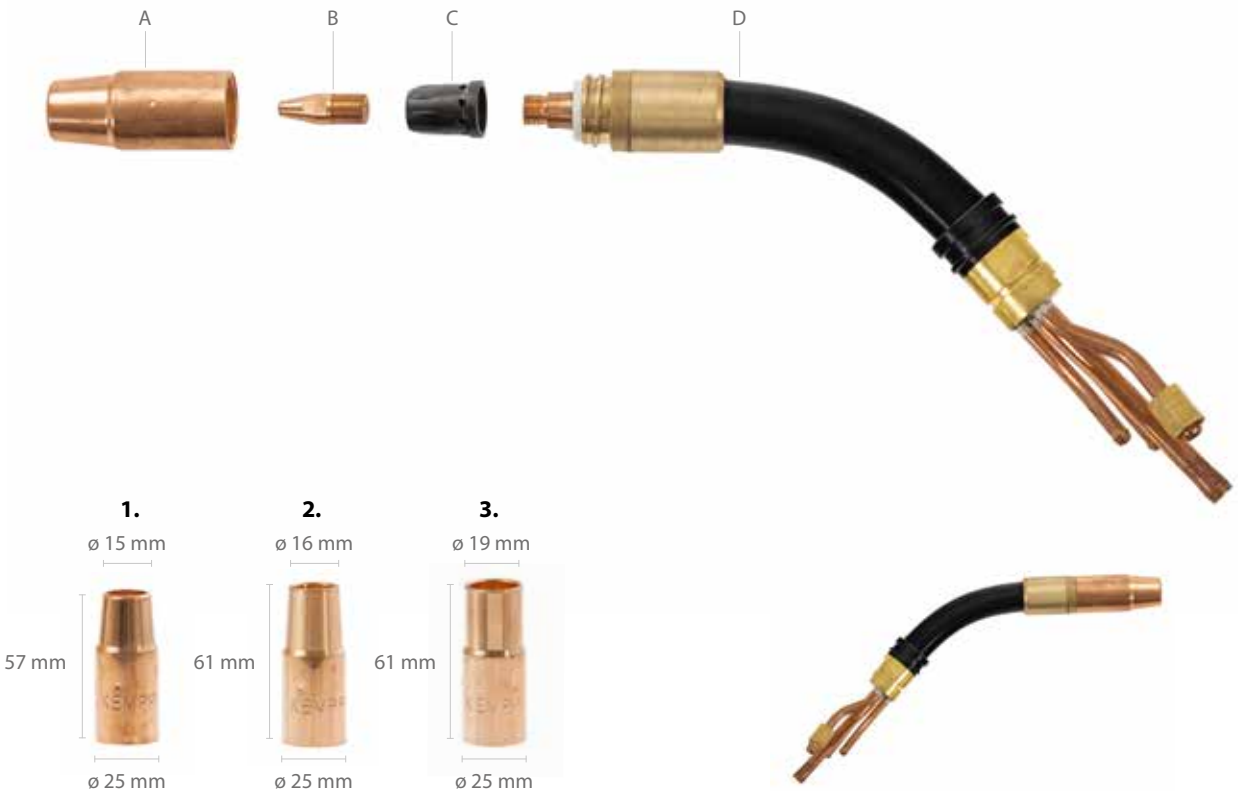
C. Contact tip adapter	
W012810	M10, 600W



Wire guide tube	
SP011869	1.2 OG plastic

CONSUMABLES

GX428WS8\*



A. Gas nozzle		
1.	W011478	Thread, L57 / OD25 / D15
2.	W013930	Thread, L61 / OD25 / D16
3.	W012143	Thread, L61 / OD25 / D19



B. Contact tip	
CT12C1SD001	1.2 C1 STD M10



C. Contact tip adapter	
W013203	M10, insulated

D. Gun neck	
SP012594	420W
SP013770	420W, L=250



Wire liners	
W016312	1.0-1.2 Ss, (Fe)/8.0 m Ø 5.9 DL-Chili



Wire guide tube	
SP011869	1.2 OG plastic

\* Model delivered without a wire liner. For ordering codes, see page 36.

# Factory-installed consumables

## GAS-COOLED FLEXLITE GX WELDING GUNS

	CT10C1SD001	CONTACT TIP 1.0 C1 STD M10	CT12C1SD001	CONTACT TIP 1.2 C1 STD M10	CT10C1SD003	CONTACT TIP 1.0 C1 STD M6	9580173	CONTACT TIP ADAPTER MT18, 25	W013203	CONTACT TIP ADAPTER, INSULATED	9591079	INSULATING RING NECK, PMT25	9580101	GAS NOZZLE, PMT25	W014452	GAS NOZZLE, THREAD, L57 / OD22 / D14	W011478	GAS NOZZLE, THREAD, L57 / OD25 / D15	W011472	GAS NOZZLE, THREAD, L60 / OD28 / D15	W013628	WIRE LINER 0.9-1.2 FE / 3.5 M Ø 4.6 STEEL	W013632	WIRE LINER 0.9-1.2 FE / 5.0 M Ø 4.6 STEEL	W012361	WIRE LINER MN 0.9-1.2 FE / 3.5 M RD STEEL	W012362	WIRE LINER MN 0.9-1.2 FE / 5.0 M RD STEEL	SP012239	NECK LINER MN 200G 2.0/4.0 L=171	SP012202	NECK LINER MN 300G 2.0/4.0 L=191	SP012236	NECK LINER MN 400G 2.0/4.0 L=216	SP016214	END CAP 4.9 MM SEALED	SP015160	END CAP 6.3 MM, GX	SP011868	GUIDE TUBE GUN 1.0 RD PLASTIC	SP011869	GUIDE TUBE GUN 1.2 OG PLASTIC			
GX203G35	●								●						●							●																							
GX203G5	●								●						●								●																						
GX205G35	●								●						●							●																							
GX205G5	●								●						●								●																						
GX208GMN35	●								●								●										●																●		
GX208GMN5	●								●								●																										●		
GX253G35					●	●					●		●									●																		●					
GX253G5					●	●					●		●										●																	●					
GX255G35					●	●					●		●									●																		●					
GX255G5					●	●					●		●										●																	●					
GX303G35	●								●								●					●																			●				
GX303G5	●								●								●						●																		●				
GX305G35	●								●								●					●																			●				
GX305G5	●								●								●						●																		●				
GX305GMN35	●								●								●										●														●				
GX305GMN5	●								●								●																								●				
GX305GS6			●						●								●																								●				
GX305GS8			●						●								●																								●				
GX308GMN35	●								●								●										●																●		
GX308GMN5	●								●								●																										●		
GX403G35			●						●										●		●																				●				
GX403G5			●						●										●			●																			●				
GX405G35			●						●										●		●																				●				
GX405G5			●						●										●			●																			●				
GX408GMN35			●						●										●								●																	●	
GX408GMN5			●						●										●																								●		



## WATER-COOLED FLEXLITE GX WELDING GUNS

	CONTACT TIP 1.0 C1 STD M10		CONTACT TIP 1.2 C1 STD M10		CONTACT TIP ADAPTER, INSULATED		CONTACT TIP ADAPTER, 600W		GAS NOZZLE, THREAD, L57 / OD22 / D14				GAS NOZZLE, THREAD, L57 / OD25 / D15				GAS NOZZLE, THREAD, L61 / OD25 / D16				GAS NOZZLE, THREAD, L60 / OD28 / D15				GAS NOZZLE, THREAD, L64 / OD28 / D17				GAS NOZZLE, THREAD, L64 / OD30 / D17				WIRE LINER 0.9-1.2 FE / 3.5 M Ø 4.6 STEEL				WIRE LINER 0.9-1.2 FE / 5.0 M Ø 4.6 STEEL				WIRE LINER 1.2-1.6 FE / 5.0 M YE STEEL				END CAP 4.9 MM				END CAP 6.3 MM, GX				GUIDE TUBE GUN 1.0 / 4.9 RD PLASTIC				GUIDE TUBE GUN 1.2 / 4.9 OG PLASTIC				GUIDE TUBE GUN 1.2 OG PLASTIC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
	CT10C1SD001	CT12C1SD001	W013203	W012810	W014452	W011478	W013930	W011472	W013931	W012793	W013628	W013632	W012614	SP014606	SP015160	SP013597	SP013598	SP011869																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																

# Contact tips

All Kemppi's original M10 contact tips are precision-drilled, high quality consumables. The high-speed drilling produces a much smoother borehole surface, which enables smooth and reliable wire feed and extends contact tip lifetime.

## RECOMMENDED FIRST CHOICE

Filler wire Ø	Ferrous wires	Stainless wires	Aluminum wires	Fluxed wires
0.8	C1 (small)	C2 (medium)	C3 (large)	
0.9	C1 (small)	C2 (medium)	C3 (large)	C1 (small)
1	C1 (small)	C2 (medium)	C3 (large)	C1 (small)
1.2	C1 (small)	C2 (medium)	C3 (large)	C1 (small)
1.4	C1 (small)		C3 (large)	C1 (small)
1.6	C1 (small)	C2 (medium)	C3 (large)	C1 (small)
2	C3 (large)		C3 (large)	
2.4	C3 (large)		C3 (large)	

### Note

Each filler wire diameter includes three clearance classes:

C1 = Small --> Fe  
C2 = Medium --> Ss  
C3 = Large --> Al

Large class is the best choice for spray arc welding (high power).

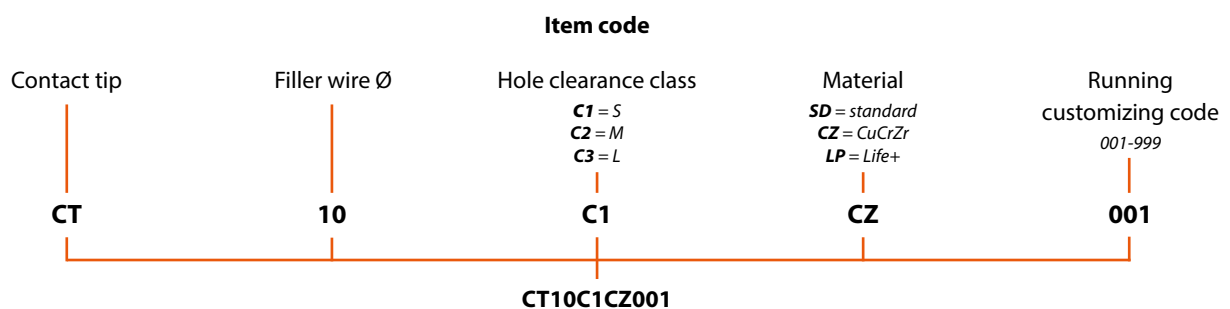
Small class is better for short arc welding (low power). Small class offers also accuracy for precise arc ignition.

LIFE+ contact tips last up to 5 times longer than ordinary copper tips, reducing overall costs and increasing welding time.

Each filler wire diameter includes three clearance classes: C1, C2, C3. Just select the class that is the most suitable for your application.

If you experience trouble in high-power welding, you might try selecting a bigger clearance class. A smaller clearance class may have a positive effect on ignition.

Please notice that these are recommendations only.



## Contact tips, STD



## Contact tips, CRZR



## Contact tips, LIFE+



## Contact tips, other

Ordering code	Wire Ø, mm	Clearance	Material	Thread
CT08C1SD001	0.8	C1	STD	M10
CT09C1SD001	0.9	C1	STD	M10
CT10C1SD001	1.0	C1	STD	M10
CT12C1SD001	1.2	C1	STD	M10
CT14C1SD001	1.4	C1	STD	M10
CT16C1SD001	1.6	C1	STD	M10
CT08C2SD001	0.8	C2	STD	M10
CT09C2SD001	0.9	C2	STD	M10
CT10C2SD001	1.0	C2	STD	M10
CT12C2SD001	1.2	C2	STD	M10
CT14C2SD001	1.4	C2	STD	M10
CT16C2SD001	1.6	C2	STD	M10
CT08C3SD001	0.8	C3	STD	M10
CT09C3SD001	0.9	C3	STD	M10
CT10C3SD001	1.0	C3	STD	M10
CT12C3SD001	1.2	C3	STD	M10
CT14C3SD001	1.4	C3	STD	M10
CT16C3SD001	1.6	C3	STD	M10
CT20C3SD001	2.0	C3	STD	M10
CT24C3SD001	2.4	C3	STD	M10
CT06C1SD003	0.6	C1	STD	M6
CT08C1SD003	0.8	C1	STD	M6
CT09C1SD003	0.9	C1	STD	M6
CT10C1SD003	1.0	C1	STD	M6
CT12C1SD003	1.2	C1	STD	M6
CT16C1SD003	1.6	C1	STD	M6
CT08C1CZ001	0.8	C1	CRZR	M10
CT09C1CZ001	0.9	C1	CRZR	M10
CT10C1CZ001	1.0	C1	CRZR	M10
CT12C1CZ001	1.2	C1	CRZR	M10
CT16C1CZ001	1.6	C1	CRZR	M10
CT10C2CZ001	1.0	C2	CRZR	M10
CT12C2CZ001	1.2	C2	CRZR	M10
CT16C2CZ001	1.6	C2	CRZR	M10
CT08C1CZ003	0.8	C1	CRZR	M6
CT08C1LP002	0.8	C1	LIFE+	M10
CT10C1LP002	1.0	C1	LIFE+	M10
CT12C1LP002	1.2	C1	LIFE+	M10
CT14C1LP002	1.4	C1	LIFE+	M10
CT16C1LP002	1.6	C1	LIFE+	M10
CT08C2LP002	0.8	C2	LIFE+	M10
CT10C2LP002	1.0	C2	LIFE+	M10
CT12C2LP002	1.2	C2	LIFE+	M10
CT14C2LP002	1.4	C2	LIFE+	M10
CT16C2LP002	1.6	C2	LIFE+	M10
CT10C3LP002	1.0	C3	LIFE+	M10
CT12C3LP002	1.2	C3	LIFE+	M10
CT14C3LP002	1.4	C3	LIFE+	M10
CT16C3LP002	1.6	C3	LIFE+	M10
CT10C1SD004 *	1.0	C1	STD	M10
CT12C1SD004 *	1.2	C1	STD	M10

\* Narrow gap welding



## Wire liners

Kemppi wire liners are strong, durable and efficient. Designed to suit specific filler wire materials and applications, Kemppi liners support the filler wire and ensure reliable delivery to the welding arc. The liner selection tables describe gun type, filler material, liner color, ordering code and gun length. Steel spiral liners are suitable for welding solid and cored filler wires of corresponding wire diameter.

Kemppi 'DL Chili' teflon liners are the best solution for reliable feeding of aluminum, stainless steel, acid-resistant and solid steel filler wires. Kemppi's patented technology, two layer DL Chili liner material significantly reduces friction losses between the filler wire material and liner wall, ensuring reliable and worry-free feeding for listed wire types, even in welding guns up to 8 meters in length. Please refer to the following tables to ensure accurate selection of liners for your chosen welding gun and application.

### WIRE LINERS FOR S MODELS (SNAKE)

Ordering code	Liner	Length, m	Wire Ø, mm	Material	Cooling	Note
W016311	DL Chili	6	1.0-1.2	Ss (Fe)	G / W	Best suited for Ss, works also for Fe.
W016312	DL Chili	8	1.0-1.2	Ss (Fe)	G / W	Best suited for Ss, works also for Fe.
W016301	DL Chili	6	1.0-1.2	Al (Ss)	G / W	Best suited for Al (1.2 mm).
W014061	DL Chili	8	1.0-1.2	Al (Ss)	G / W	Best suited for Al (1.2 mm).
W016408	DL Chili	6	1.4-1.6	Al (Ss, Fe)	G / W	Best suited for Al (1.4-1.6 mm), works also for Ss and Fe (up to 1.6 mm).
W014060	DL Chili	8	1.4-1.6	Al (Ss, Fe)	G / W	Best suited for Al (1.4-1.6 mm), works also for Ss and Fe (up to 1.6 mm).



## WIRE LINERS FOR FLEXLITE GX (K3, K5 AND K8 LEVEL MODELS)

Ordering code	Liner type	Length, m	Wire Ø, mm	Material	Cooling	Note
4307650	Steel	3		Fe	G / W	MMG
4307660	DL Chili	3	0.6-1.0	Fe	G / W	MMG
W013621	Steel	3.5	0.8	Fe	G / W	
W013628	Steel	3.5	0.9-1.2	Fe	G / W	
W013629	Steel	3.5	1.4	Fe	G / W	
W013630	Steel	3.5	1.6	Fe	G / W	
W013631	Steel	5	0.8	Fe	G / W	
W013632	Steel	5	0.9-1.2	Fe	G / W	
W013633	Steel	5	1.4	Fe	G / W	
W013634	Steel	5	1.6	Fe	G / W	
W013609	DL Chili	3.5	0.8	Al, Ss, Fe	W	
W013610	DL Chili	3.5	0.9-1.0	Ss, Fe	W	
W013611	DL Chili	3.5	1.2	Ss, Fe	W	
W013612	DL Chili	3.5	1.4-1.6	Al, Ss, Fe	W	
W013613	DL Chili	5	0.8	Al, Ss, Fe	W	
W013614	DL Chili	5	0.9-1.0	Ss, Fe	W	
W013615	DL Chili	5	1.2	Ss, Fe	W	
W013616	DL Chili	5	1.4-1.6	Al, Ss, Fe	W	
W013637	DL Chili	3.5	0.9-1.0	Al	W	
W013638	DL Chili	3.5	1.2	Al	W	
W013641	DL Chili	5	0.9-1.0	Al	W	
W013642	DL Chili	5	1.2	Al	W	
W007675	DL Chili	3.5	0.6-1.0	Al, Ss, Fe	G	
W007677	DL Chili	3.5	1.0-1.2	Al, Ss, Fe	G	
W007681	DL Chili	3.5	1.2-1.6	Al, Ss, Fe	G	
W007676	DL Chili	5	0.6-1.0	Al, Ss, Fe	G	
W007680	DL Chili	5	1.0-1.2	Al, Ss, Fe	G	
W007683	DL Chili	5	1.2-1.6	Al, Ss, Fe	G	
W014831	DL Chili	5	2.0-2.4	Al	W	600W Only
W012614	Steel	5	1.2-1.6	Fe	W	600W Only
W013652	Steel	5	2.0-2.4	Fe	W	600W Only

## WIRE LINERS FOR GX MULTINECK

Ordering code	Liner type	Length, m	Wire Ø, mm	Material	Cooling	Note
W012361	Steel	3.5	0.9-1.2	Fe	G	
W012363	Steel	3.5	1.2-1.6	Fe	G	
W012362	Steel	5	0.9-1.2	Fe	G	
W012364	Steel	5	1.2-1.6	Fe	G	
W012355	DL Chili	3.5	0.6-1.0	Al, Ss, Fe	G	
W012356	DL Chili	3.5	1.0-1.2	Al, Ss, Fe	G	
W012357	DL Chili	3.5	1.2-1.6	Al, Ss, Fe	G	
W012351	DL Chili	5	0.6-1.0	Al, Ss, Fe	G	
W012352	DL Chili	5	1.0-1.2	Al, Ss, Fe	G	
W012353	DL Chili	5	1.2-1.6	Al, Ss, Fe	G	



## Wire guide tubes

Kempfi wire guide tubes facilitate installation and tightening of the wire liner into its correct position. The end cap for gas-cooled models includes sealing to prevent gas leakage and improve shielding gas coverage.

### WIRE GUIDE TUBES GX (K3 AND K5 LEVEL MODELS)

Ordering code	Tube type	Wire Ø, mm	Material	Cooling	Note
SP016214	Brass	-	Al, Ss, Fe	G	End cap with sealing
SP014606	Brass	-	Al, Ss, Fe	G / W	
SP015160	Brass	-	Al, Ss, Fe	G / W	600W, MN, S

### WIRE GUIDE TUBES GX (K8 LEVEL MODELS)

Ordering code	Tube type	Wire Ø, mm	Material	Cooling	Note
SP013595	Plastic	0.6	Al, Ss		
SP013596	Plastic	0.8-0.9	Al, Ss	W	
SP013597	Plastic	1.0	Al, Ss	W	
SP013598	Plastic	1.2	Al, Ss	W	
SP013599	Plastic	1.4	Al, Ss	W	
SP013600	Plastic	1.6	Al, Ss	W	
SP013751	Metal	0.8-0.9	Fe	W	
SP013752	Metal	1.0	Fe	W	
SP013753	Metal	1.2	Fe	W	
SP013754	Metal	1.4	Fe	W	
SP013755	Metal	1.4-1.6	Fe	W	
SP009276	Plastic	0.6	Al, Ss	G	
SP011867	Plastic	0.8-0.9	Al, Ss	G	
SP011868	Plastic	1.0	Al, Ss	G	
SP011869	Plastic	1.2	Al, Ss	G	420-W-8m
SP011870	Plastic	1.4	Al, Ss	G	420-W-8m
SP011871	Plastic	1.6	Al, Ss	G	420-W-8m
SP011872	Plastic	2.0	Al, Ss	G	
SP011873	Plastic	2.4	Al, Ss	G	
SP011886	Metal	0.6	Fe	G	
SP011887	Metal	0.8-0.9	Fe	G	
SP011888	Metal	1.0	Fe	G	
SP011889	Metal	1.2	Fe	G	
SP011890	Metal	1.4	Fe	G	
SP011891	Metal	1.4-1.6	Fe	G	
SP011892	Metal	2.0	Fe	G	600-W
SP011893	Metal	2.4	Fe	G	600-W



# Technical data and ordering codes

## K3 MODELS

Flexlite GX		253G	203G	303G	403G	303W	403W	503W
Welding process		MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG
Contact tip		M6	M10	M10	M10	M10	M10	M10
Type of cooling		Gas	Gas	Gas	Gas	Water	Water	Water
Type of connection		Euro	Euro	Euro	Euro	Euro	Euro	Euro
Wire diameters (mm)		0.6–1.2	0.8–1.2	0.8–1.2	0.8–1.6	0.8–1.6	0.8–1.6	0.8–1.6
Load capacity (IEC 60974-7)								
35% / Ar + 18% CO <sub>2</sub>		250 A	200 A	300 A	400 A			
60% / Ar + 18% CO <sub>2</sub>								
100% / Ar + 18% CO <sub>2</sub>						300 A	400 A	500 A
Pistol grip handle		Yes	Yes	Yes	Yes	Yes	Yes	Yes
Remote control option		No	No	No	No	No	No	No
LED option		No	No	No	No	No	No	No
Rotating neck		Yes	Yes	Yes	Yes	No	No	No
Changeable neck		No	No	No	No	No	No	No
Ordering codes	3.5 m	GX253G35	GX203G35	GX303G35	GX403G35	GX303W35	GX403W35	GX503W35
	5 m	GX253G5	GX203G5	GX303G5	GX403G5	GX303W5	GX403W5	GX503W5

## K5 MODELS

Flexlite GX		255G	205G	305G	405G	305W	405W	505W
Welding process		MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG
Contact tip		M6	M10	M10	M10	M10	M10	M10
Type of cooling		Gas	Gas	Gas	Gas	Water	Water	Water
Type of connection		Euro	Euro	Euro	Euro	Euro	Euro	Euro
Wire diameters (mm)		0.6–1.2	0.8–1.2	0.8–1.2	0.8–1.6	0.8–1.6	0.8–1.6	0.8–1.6
Load capacity (IEC 60974-7)								
35% / Ar + 18% CO <sub>2</sub>		250 A	200 A	300 A	400 A			
60% / Ar + 18% CO <sub>2</sub>								
100% / Ar + 18% CO <sub>2</sub>						300 A	400 A	500 A
Pistol grip handle		Yes	Yes	Yes	Yes	Yes	Yes	Yes
GXR10 Gun Remote (ordering code: GXR10)		Yes	Yes	Yes	Yes	Yes	Yes	Yes
LED option		No	No	No	No	No	No	No
Rotating neck		Yes	Yes	Yes	Yes	No	No	No
Changeable neck		No	No	No	No	No	No	No
Ordering codes	3.5 m	GX255G35	GX205G35	GX305G35	GX405G35	GX305W35	GX405W35	GX505W35
	5 m	GX255G5	GX205G5	GX305G5	GX405G5	GX305W5	GX405W5	GX505W5



## K5 MODELS

Flexlite GX		605W	305GMN	305GS	305WS	405WS
Welding process		MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG
Contact tip		M10	M10	M10	M10	M10
Type of cooling		Water	Gas	Gas	Water	Water
Type of connection		Euro	Euro	Euro	Euro	Euro
Wire diameters (mm)		1.2–2.4	0.8–1.2	1.0–1.2	1.0–1.6	1.0–1.6
Load capacity (IEC 60974-7)						
35% / Ar + 18% CO <sub>2</sub>		600 A (40%)	350 A	300 A		
60% / Ar + 18% CO <sub>2</sub>						
100% / Ar + 18% CO <sub>2</sub>					250 A	300 A
Pistol grip handle		Yes	Yes	Yes	Yes	Yes
GXR10 Gun Remote (ordering code: GXR10)		Yes	Yes	Yes	Yes	Yes
LED option		No	No	No	No	No
Rotating neck		No	Yes	Yes	No	No
Changeable neck		No	Yes	No	No	No
Ordering codes	3.5 m	GX605W35	GX305GMN35			
	5 m	GX605W5	GX305GMN5			
	6 m			GX305GS6	GX305WS6	GX405WS6
	8 m			GX305GS8		GX405WS8

## K8 MODELS

Flexlite GX		208GMN	308GMN	408GMN	428W	528W	608W	428WS
Welding process		MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG
Contact tip		M10	M10	M10	M10	M10	M10	M10
Type of cooling		Gas	Gas	Gas	Water	Water	Water	Water
Type of connection		Kemppi	Kemppi	Kemppi	Kemppi	Kemppi	Kemppi	Kemppi
Wire diameters (mm)		0.8–1.2	0.8–1.2	0.8–1.6	0.8–1.6	0.8–1.6	1.2–2.4	1.2–1.6
Load capacity (IEC 60974-7)								
35% / Ar + 18% CO <sub>2</sub>							600 A (40%)	
60% / Ar + 18% CO <sub>2</sub>		200 A	300 A	400 A				
100% / Ar + 18% CO <sub>2</sub>					420 A	520 A		300 A
Pistol grip handle		Yes	Yes	Yes	Yes	Yes	Yes	Yes
Remote control option		Yes*	Yes*	Yes*	Yes*	Yes*	Yes*	Yes*
LED option		Yes	Yes	Yes	Yes	Yes	Yes	Yes
Rotating neck		Yes	Yes	Yes	No	No	No	No
Changeable neck		Yes	Yes	Yes	No	No	No	No
Ordering codes	3.5 m	GX208GMN35	GX308GMN35	GX408GMN35	GX428W35	GX528W35	GX608W35	
	5 m	GX208GMN5	GX308GMN5	GX408GMN5	GX428W5	GX528W5	GX608W5	
	8 m							GX428WS8

\* GXR80 Gun Remote With Display (ordering code: GXR80)

NOTE: Extra long S models are delivered without a wire liner. For wire liner ordering codes, see page 36.



# FLEXLITE TX

Ignite your passion for welding

**Flexlite TX product series** contains welding torches to be used in TIG welding process. There are Flexlite TX models available in two value levels: K3 and K5. Each level is designed to serve specific welding needs. All Flexlite TX models enjoy the Flexlite features for user comfort, welding efficiency and extended consumable part life.



## Flexlite TX torches for TIG welding

Flexlite TX welding torches for TIG welding increase user comfort and lower welder fatigue. Silicone rubber material gives a firm grip, and the innovative design reduces wrist loading, allowing you to concentrate on challenging tasks to achieve the perfect weld.

Flexlite TX torches are available in alternative power classes and lengths, including different neck versions: fixed, flexible and S-shaped.



### **EXCELLENT ERGONOMICS**

Flexlite TX torches feature unique and innovative handle flexibility, moving the moment of load away from the welder's wrist, reducing apparent weight and lowering fatigue.



### **USABILITY MEANS EFFICIENCY**

Compact neck designs include rigid, flexible and S-shaped rotating neck designs, offering superb cooling performance and good access to challenging joint designs.



### **QUALITY IS MORE THAN MEETS THE EYE**

Kemppi consumables and accessories support both welding quality and productivity.





# Materials selection elevates usability

The Flexlite TX silicone rubber handles are shaped to the hand. They consider both right and left-handed welders and alternative holding positions. Combined with cables set flexibility and leather sheathing protection, Flexlite TX materials selection elevates usability to maximize welding comfort and practical durability.

Fixed neck, flexible neck and S-shaped rotating neck. Flexlite TX torches are designed to provide best welding ergonomics in all welding positions.





## QUALITY IS MORE THAN MEETS THE EYE!

Shielding gas flow has a significant effect on weld quality. Normally shielding gas flow is invisible, but this simulation demonstrates how torch design and consumable parts affect gas turbulence and effective shielding gas coverage.

Kemppi gas lenses include many high-quality gas diffuser mesh layers. This structure provides the best performance by improving the laminar flow compared to other conventional designs.

# Kemppi consumables support welding quality and productivity

Consumables represent only a small portion of the total costs in TIG welding, but from the quality point of view they play an important role.

Kemppi offers all consumables for your TIG welding applications. Manufactured using the best processes and materials, Kemppi consumables help you create top quality TIG welds. Kemppi consumables and accessories are designed especially to suit your Flexlite torches. To get the best quality and cost-effectiveness for your welding, equip your Flexlite torch with Kemppi consumables.



The picture on the right shows a highly turbulent flow, offering poor shielding and elevated gas consumption.

The picture on the left defines a torch fitted with a Kemppi gas lens kit, creating a smooth laminar gas flow, excellent weld pool shielding and economic gas usage.

# Welding comfort and

## KEMPPI CONSUMABLES

Manufactured using the best processes and materials, Kemppi consumables support your welding productivity and help you create top quality TIG welds.

## GOOD ACCESS

Neck designs include rigid, flexible and S-shaped rotating necks, offering superb cooling performance and good access to challenging joint designs.

## FIRM GRIP

Silicone rubber material gives a firm grip, and the innovative design reduces wrist loading, allowing you to concentrate on challenging tasks to achieve the perfect weld.

## EASY ACCESS TO INFORMATION

The QR code takes you directly to relevant ordering codes, consumables, product documents and Kemppi contacts.





# practical durability

## ● TRIGGER OPTIONS

Available with or without a trigger switch. An optional switch extension makes the trigger control more accurate when holding the torch close to the welding head.

## ● REMOTE CONTROLS

Flexlite TX torches offer alternative on-torch remote controls, which allow accurate and immediate welding current adjustment at distance. Remote controls are available for K5 level models only.

## ● SHAPED TO THE HAND

The Flexlite TX handles are shaped to the hand. They consider both right and left-handed welders and alternative holding positions.

## ● DURABILITY

The cable set flexibility and leather sheathing protection elevates usability to maximize welding comfort and practical durability.

# Flexlite TX models

## SELECT SUITABLE TORCH ACCORDING TO THE VALUE LEVEL

Kemppi's Flexlite TX welding torches are divided into two value levels: K3 and K5. The difference between them is the type of connectors in control cable and cooling water hoses as shown in the pictures below. The K3 level also includes models with DIX connector and a shielding gas valve in the torch body.



K3 level models have screw-in connectors in water hoses and a 4-pin control cable connector.



K5 level models have snap connectors in water hoses and a 7-pin control cable connector.

Welding capacity, physical size and reach are primary considerations when selecting the torch for your application. Thermal efficiency, consumables design and lifetime, are values that will improve your welding satisfaction and reduce overall costs.

Flexlite products offer a wide range of models, so you can be sure to select the capacity, size, and length, to match your application. Be it road vehicles or aerospace, Flexlite ignites your passion for welding.



TX135GF  
TX133GF

TX165GF  
TX163GF



TX165GS  
TX163GS



TX165G  
TX225G  
TX223G



TX225GS  
TX223GS



TX255WS  
TX253WS



TX305WF  
TX303WF



TX355W  
TX353W

Flexlite TX (all models)		135GF 133GF	165GF 163GF	165GS 163GS	165G	163GVD9	225G 223G	225GS 223GS	223GVD13	255WS 253WS	305WF 303WF	355W 353W
Type of cooling		Gas	Gas	Gas	Gas	Gas	Gas	Gas	Gas	Water	Water	Water
Coolant flow rate	l/min	-	-	-	-	-	-	-	-	1	1	1
Coolant pressure (min)	MPa	-	-	-	-	-	-	-	-	0.1	0.1	0.1
Coolant pressure (max)	MPa	-	-	-	-	-	-	-	-	0.5	0.5	0.5
Arc striking voltage	kV	10	10	10	10	10	10	10	10	10	10	10
Load capacity @ 40 % (Argon)	A	130	160	160	160	160	220	220	220	250	300	350
Load capacity @ 100 % (Argon)	A	-	-	-	-	-	-	-	-	200	200	250
Operating temperature range	°C	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40	-10...+40
Storage temperature range	°C	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60	-40...+60
Minimum cooling power at 1.0 l/min	kW	-	-	-	-	-	-	-	-	1.0 kW	1.0 kW	1.0 kW
Neck type		Flexible	Flexible	Rotating	70° angle	70° angle	70° angle	Rotating	70° angle	Rotating	Flexible	70° angle
Torch head type		Small	Large	Small	Large	Large	Large	Large	Large	Small	Small	Large

Flexlite TX (3-series models)		133GF	163GF	163GS		163GVD9	223G	223GS	223GVD13	253WS	303WF	353W
Type of connection	Current-gas	R1/4	R1/4	R1/4		DIX 9 mm	R1/4	R1/4	DIX 13 mm			
	Control	4-pin	4-pin	4-pin		-	4-pin	4-pin	-	4-pin	4-pin	4-pin
	Coolant	-	-	-		-	-	-	-	R1/4&R3/8	R1/4&R3/8	R1/4&R3/8
Electrode diameters	mm	1.0...2.4	1.0...4.0	1.0...2.4		1.0...4.0	1.0...4.0	1.0...4.0	1.0...4.0	1.0...4.0	1.0...2.4	1.0...4.0
Remote control		-	-	-		-	-	-	-	-	-	-

Flexlite TX (5-series models)		135GF	165GF	165GS	165G		225G	225GS		255WS	305WF	355W
Type of connection	Current-gas	R1/4	R1/4	R1/4	R1/4		R1/4	R1/4		R1/4	R1/4	R1/4
	Control	7-pin	7-pin	7-pin	7-pin		7-pin	7-pin		7-pin	7-pin	7-pin
	Coolant	-	-	-	-		-	-		Snap connector	Snap connector	Snap connector
Electrode diameters	mm	1.0...2.4	1.0...4.0	1.0...2.4	1.0...4.0		1.0...4.0	1.0...4.0		1.0...2.4	1.0...2.4	1.0...4.0
Remote control		Optional	Optional	Optional	Optional		Optional	Optional		Optional	Optional	Optional

These equipment comply with standard IEC 60974-7.

Flexlite TX models 163GVD9 and 223GVD13 are equipped with a DIX connector and a manual gas valve to regulate the shielding gas flow, ensuring basic TIG welding tasks are easily completed. Use with MMA power sources for scratch and TouchArc TIG ignition.

**Torch bodies compatibility table**

			TX135GF TX133GF	TX165GF TX163GF	TX165GS TX163GS	TX165G TX225G TX223G	TX225GS TX223GS	TX255WS TX253WS	TX305WF TX303WF	TX355W TX353W
SP013377	TX BODY FLEX G SMALL		●	○	○	○	○			
SP013386	TX BODY FLEX G LARGE		○	●	○	○	○			
SP013394 *	TX BODY S-NECK G		○	○	●	○	●			
SP801064 *	TX BODY S-NECK HEAD SMALL		○	○	●	○	○	●	○	○
SP013404 *	TX BODY S-NECK HEAD LARGE		○	○	○	○	●	○	○	○
SP013362	TX BODY RIGID G LARGE		○	○	○	●	○			
SP014575 *	TX BODY S-NECK W							●	○	○
SP014126	TX BODY FLEX W SMALL							○	●	○
SP013423	TX BODY RIGID W LARGE							○	○	●

\* SP014575 Requires always SP801064 or SP013404  
 SP013394 Requires always SP801064 or SP013404  
 SP801064 and SP013404 cannot be used separately

● = Standard delivery ○ = Accessory



Flexlite TX product range offers optional accessories for your torch to make it a perfect tool for your welding. Optimize your torch and make your TIG welding more efficient and convenient with accessories.

## Trigger switch options

Available with or without a trigger switch, Flexlite TX range also includes an optional switch extension to replace the regular switch. It makes the trigger control more accurate when holding the torch close to the welding head.



Regular switch



Switch extension



No switch

## Remote control options

Whatever your preference and machine type, Flexlite TX TIG torches offer an alternative on-torch remote control, which allows accurate and immediate welding current adjustment at a distance. Select either rocker or roller type of switch. Remote controls can be used only in K5 level Flexlite TX torches.



Torch remote control (rocker model)

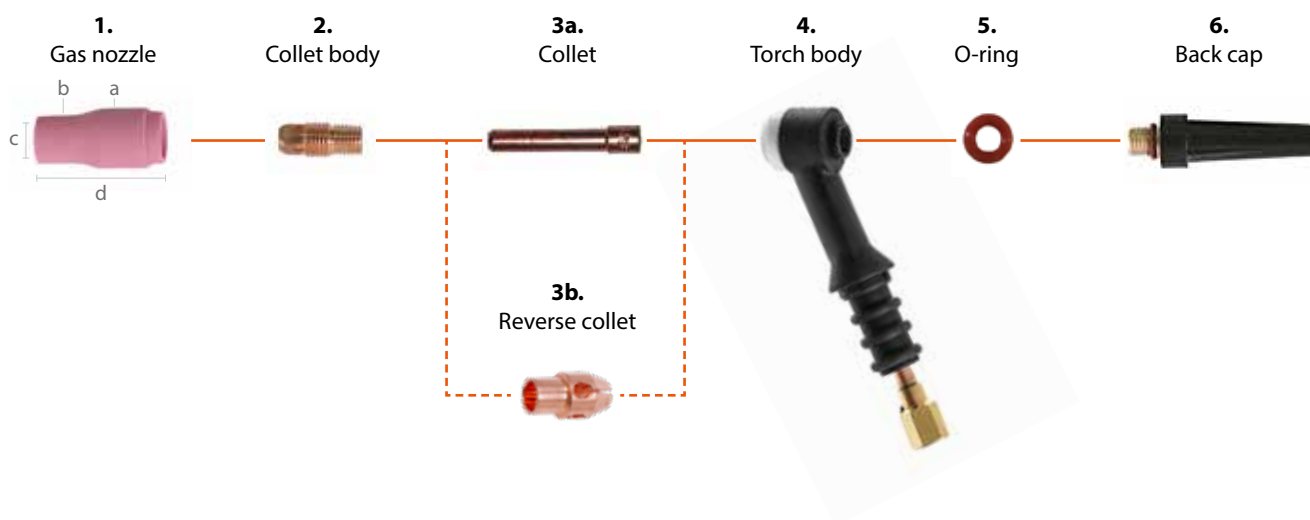


Torch remote control (roller model)



## CONSUMABLES

Small torch body, standard consumables



1. Gas nozzle		mm			
No.	Ordering code	a	b	c	d
4	7990760	14.5	10	6.5	30
5	7990761*	14.5	11	8	30
6	7990762	14.5	14.5	10	30
7	7990763	14.5	14.5	11	30

2. Collet body	
ø 1.0	7990660
ø 1.6	7990661
ø 2.4	7990662 *

3a. Collet	
ø 1.0	7990635
ø 1.6	7990636
ø 2.4	7990637 *

3b. Reverse collet	
ø 1.0	7990640
ø 1.6	7990641
ø 2.4	7990642

4. Torch body	
SP013377	TX BODY FLEX G SMALL
SP013394	TX BODY S-NECK G
SP801064	TX BODY S-NECK HEAD SMALL
SP014126	TX BODY FLEX W SMALL
<b>Note:</b> SP013394 requires SP801064	

See suitability from torch bodies compatibility table on page 51.

5. O-ring
SP7990790

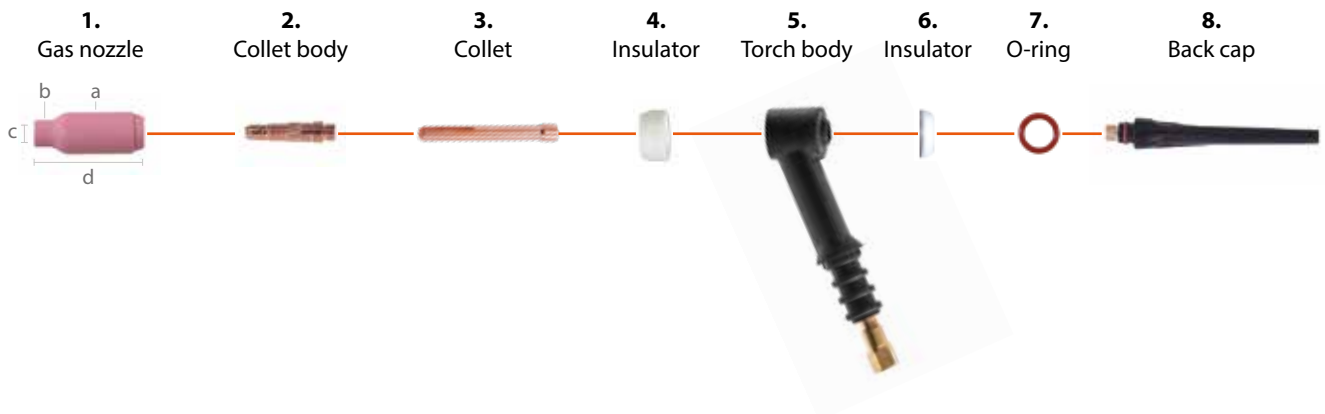
6. Back cap		Length (mm)
Small	7990730	18
Medium	7990734 *	48
Long	7990740	145

Electrode		
Grey	ø 1.0	9873531
	ø 1.6	9873532
	ø 2.4	9873533 *
White	ø 1.0	9873520
	ø 1.6	9873521
	ø 2.4	9873522
Length of all electrodes 175 mm		

\* Delivery equipment is for ø 2.4 mm electrode. Lens equipment is delivered as an accessory. The above mentioned dimensions are directive.

## CONSUMABLES

Large torch body, standard consumables



1. Gas nozzle		mm			
No.	Ordering code	a	b	c	d
4	7990766	18	11.5	6.5	47.5
5	7990770	18	12.5	8	47.5
6	7990771 *	18	14.5	9.5	47.5
7	7990772	18	16	11	47.5
8	7990773	18	18	12.5	47.5
10	7990775	21	21	16	47.5
12	7990776	24	24	19	47.5

2. Collet body	
ø 1.6	7990681
ø 2.4	7990682 *
ø 3.2	7990683
ø 4.0	7990684

3. Collet	
ø 1.6	9876867
ø 2.4	9876868 *
ø 3.2	9876869
ø 4.0	9876870

4. Insulator	
SP9580266	

5. Torch body	
SP013386	TX BODY FLEX G LARGE
SP013394	TX BODY S-NECK G
SP014575	TX BODY S-NECK W
SP013404	TX BODY S-NECK HEAD LARGE
SP013362	TX BODY RIGID G LARGE
SP013423	TX BODY RIGID W LARGE
<b>Note:</b> SP014575 requires SP013404	

See suitability from torch bodies compatibility table on page 51.

6. Insulator	
SP9580267	

7. O-ring	
SP7990791	

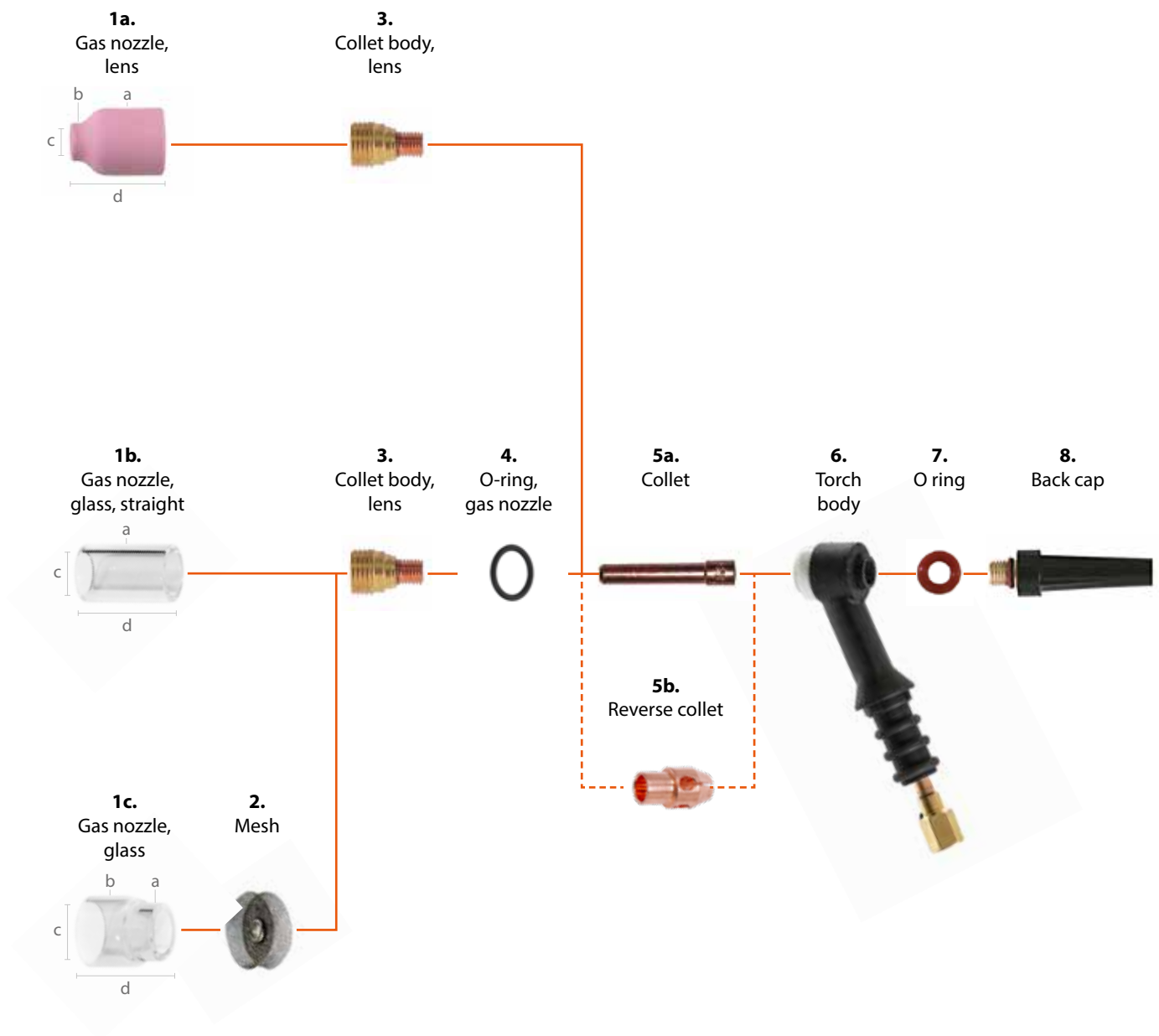
8. Back cap		Length (mm)
Small	7990731	26
Medium	7990735	58
Long	7990741 *	120

Electrode		
Grey	ø 1.6	9873532
	ø 2.4	9873533 *
	ø 3.2	9873534
	ø 4.0	9873535
White	ø 1.6	9873521
	ø 2.4	9873522
	ø 3.2	9873523
Green	ø 4.0	9873524
	ø 4.0	9873505
Length of all electrodes 175 mm		

\* Delivery equipment is for ø 2.4 mm electrode. Lens equipment is delivered as an accessory. The above mentioned dimensions are directive.

CONSUMABLES

Small torch body, lens consumables



1a. Gas nozzle, lens		mm			
No.	Ordering code	a	b	c	d
4	7990779	18.5	10.5	7	25.5
5	7990780	18.5	12	8	25.5
6	7990781	18.5	13.5	9.5	25.5
7	7990782	18.5	15	11	25.5
8	SP016562	18.5	16.5	12.5	25.5

1b. Gas nozzle, glass, straight		mm		
	Ordering code	a	c	d
Straight	SP015847	19.9	14.8	32.5

1c. Gas nozzle, glass		mm			
	Ordering code	a	b	c	d
15/20 mm	SP015848	20.2	25.3	21	28.3

2. Mesh	
	SP015851

3. Collet body, lens	
ø 1.0	7990700
ø 1.6	7990701
ø 2.4	7990702

4. O-ring, gas nozzle, glass	
	SP009746

5a. Collet	
ø 1.0	7990635
ø 1.6	7990636
ø 2.4	7990637

5b. Reverse collet	
ø 1.0	7990640
ø 1.6	7990641
ø 2.4	7990642

6. Torch body	
SP013377	TX BODY FLEX G SMALL
SP013394	TX BODY S-NECK G
SP801064	TX BODY S-NECK HEAD SMALL
SP014126	TX BODY FLEX W SMALL

**Note:** SP013394 requires SP801064

See suitability from torch bodies compatibility table on page 51.

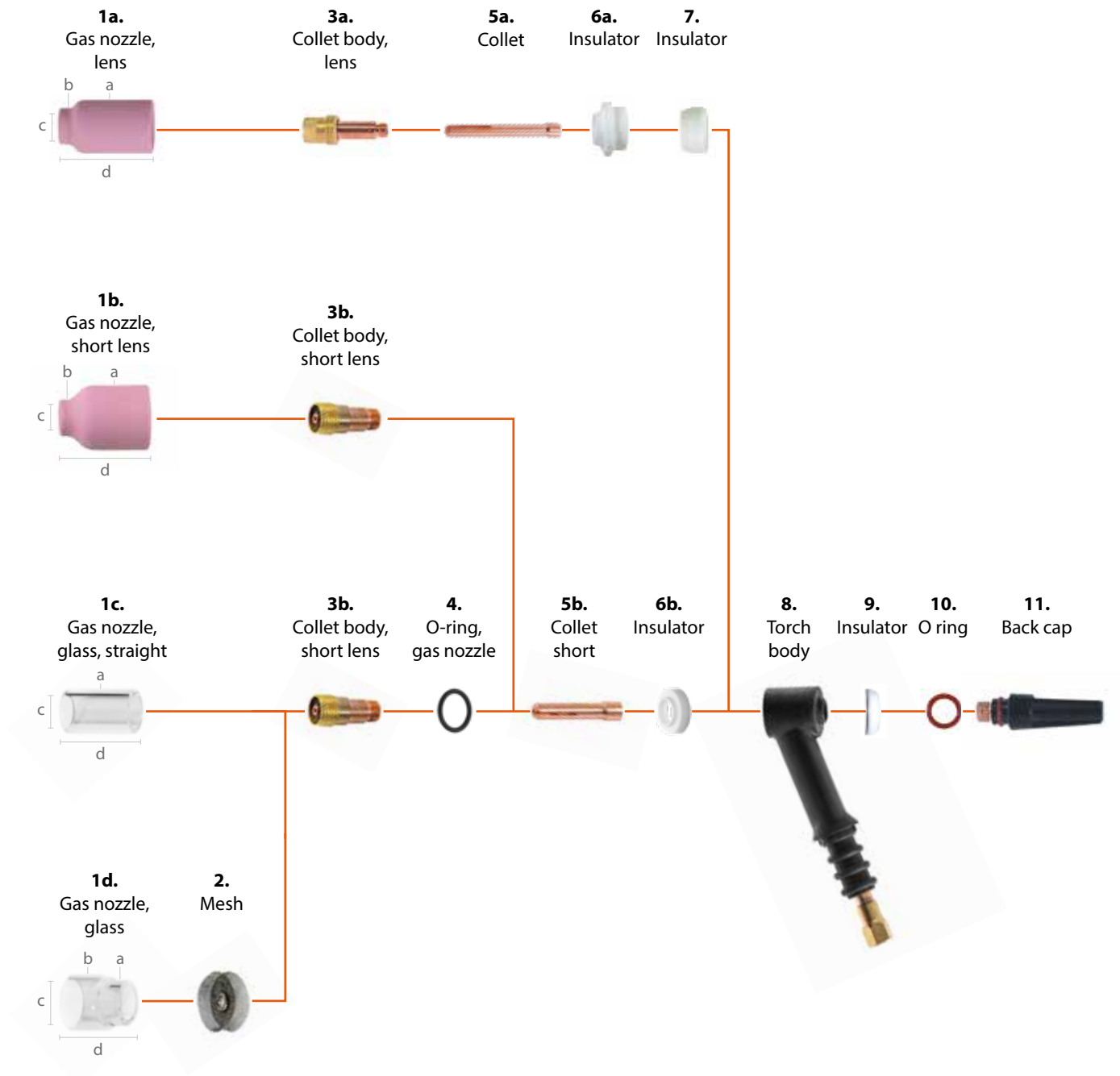
7. O-ring	
	SP7990790

8. Back cap		Length (mm)
Small	7990730	18
Medium	7990734	48
Long	7990740	145

Electrode		
Grey	ø 1.0	9873531
	ø 1.6	9873532
	ø 2.4	9873533
White	ø 1.0	9873520
	ø 1.6	9873521
	ø 2.4	9873522
Length of all electrodes 175 mm		

## CONSUMABLES

Large torch body, lens consumables





1a. Gas nozzle, lens		mm			
No.	Ordering code	a	b	c	d
5	7990783	25	12.5	7.5	42
6	7990784	25	14	9	42
7	7990785	25	15.5	11	42
8	7990786	25	16.5	12	42
11	7990787	25	22	17	42

1b. Gas nozzle, short lens		mm			
No.	Ordering code	a	b	c	d
4	7990779	18.5	10.5	7	25.5
5	7990780	18.5	12	8	25.5
6	7990781	18.5	13.5	9.5	25.5
7	7990782	18.5	15	11	25.5
8	SP016562	18.5	16.5	12.5	25.5

1c. Gas nozzle, glass		mm			
	Ordering code	a	c	d	
Straight	SP015847	19.9	14.8	32.5	

1d. Gas nozzle, glass		mm			
	Ordering code	a	b	c	d
15/20 mm	SP015848	20.2	25.3	21	28.3

2. Mesh	
SP015851	

3a. Collet body, lens	
ø 1.6	7990711
ø 2.4	7990712
ø 3.2	7990713
ø 4.0	7990714

3b. Collet body, short lens	
ø 1.6	SP015842
ø 2.4	SP015843
ø 3.2	SP015844

4. O-ring, gas nozzle, glass	
SP009746	

5a. Collet	
ø 1.6	9876867
ø 2.4	9876868
ø 3.2	9876869
ø 4.0	9876870

5b. Collet, short	
ø 1.6	7990655
ø 2.4	7990656
ø 3.2	7990657

6a. Insulator	
9876860	

6b. Insulator	
SP015849	

7. Insulator	
SP9580266	

8. Torch body	
SP013386	TX BODY FLEX G LARGE
SP013394	TX BODY S-NECK G
SP014575	TX BODY S-NECK W
SP013404	TX BODY S-NECK HEAD LARGE
SP013362	TX BODY RIGID G LARGE
SP013423	TX BODY RIGID W LARGE
<b>Note:</b> SP014575 requires SP013404	

See suitability from torch bodies compatibility table on page 51.

9. Insulator	
SP9580267	

10. O-ring	
SP7990791	

11. Back cap		Length (mm)
Small	7990731	26
Medium	7990735	58
Long	7990741	120

Electrode		
Grey	ø 1.6	9873532
	ø 2.4	9873533
	ø 3.2	9873534
	ø 4.0	9873535
White	ø 1.6	9873521
	ø 2.4	9873522
	ø 3.2	9873523
Green	ø 4.0	9873524
	ø 4.0	9873505
	Length of all electrodes 175 mm	

## CONSUMABLE KITS

Kemppi genuine PRO consumable starter kits include a complete set of consumables for your TIG welding applications. Kits provide all TIG torch accessories you need to start welding. They include multiple size nozzles, glass nozzles, lenses, collets and collet bodies ready to be used with small or large torch bodies.

The kits come complete with pre-labeled cartoon box for convenient storage and easy re-ordering. See more detailed content in the table below. PRO KIT 5/16-24 is for small torch bodies and PRO KIT 3/8-32 is for large torch bodies.

By selecting Kemppi TIG consumables you will receive the durability and performance that you need.



W016085	PRO KIT 5/16-24, including:	Amount
7990635	COLLET 1.0 S	3
7990636	COLLET 1.6 S	3
7990637	COLLET 2.4 S	3
SP9878013	INSULATOR S	2
7990730	BACK CAP SHORT S	1
7990734	BACK CAP MEDIUM S	1
7990740	BACK CAP LONG S	1
7990700	COLLET BODY LENS 1.0 S	1
7990701	COLLET BODY LENS 1.6 S	1
7990702	COLLET BODY LENS 2.4 S	1
7990779	GAS NOZZLE LENS 4 S	1
7990780	GAS NOZZLE LENS 5 S	1
7990781	GAS NOZZLE LENS 6 S	1
7990782	GAS NOZZLE LENS 7 S	1
SP015847	GAS NOZZLE GLASS STRAIGHT	2
SP015848	GAS NOZZLE GLASS 15/20MM	2
SP009746	O-RING GAS NOZZLE GLASS	4
SP015851	MESH GAS NOZZLE GLASS	2



W016086	PRO KIT 3/8-32, including:	Amount
7990780	GAS NOZZLE LENS 5 S	1
7990781	GAS NOZZLE LENS 6 S	1
7990782	GAS NOZZLE LENS 7 S	1
7990779	GAS NOZZLE LENS 4 S	1
7990655	COLLET SHORT 1.6 L	3
7990656	COLLET SHORT 2.4 L	3
7990657	COLLET SHORT 3.2 L	3
SP015842	COLLET BODY LENS SHORT 1.6 L	1
SP015843	COLLET BODY LENS SHORT 2.4 L	1
SP015844	COLLET BODY LENS SHORT 3.2 L	1
SP9580267	INSULATOR UP L	1
SP015849	INSULATOR SPECIAL L	2
7990731	BACK CAP SHORT L	1
7990735	BACK CAP MEDIUM L	1
7990741	BACK CAP LONG L	1
SP015847	GAS NOZZLE GLASS STRAIGHT	2
SP015848	GAS NOZZLE GLASS 15/20MM	2
SP009746	O-RING GAS NOZZLE GLASS	4
SP015851	MESH GAS NOZZLE GLASS	2

W017119	TIG 3.2 LENS KIT L, including:	Amount
7990731	BACK CAP SHORT L	1
7990786	GAS NOZZLE LENS 8 L	1
9876860	INSULATOR LENS L	1
9876869	COLLET 3.2 L	1
7990713	COLLET BODY LENS 3.2 L	1

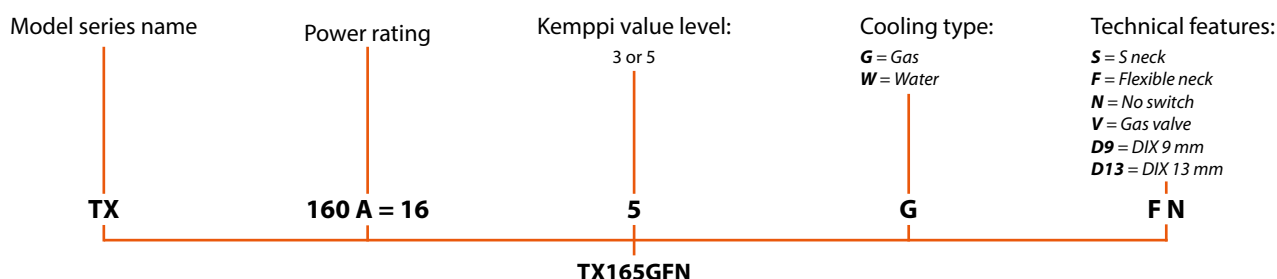
## ORDERING INFORMATION

FLEXLiTE TX			
Product	Ordering code		
	4 m:	8 m:	16 m:
FLEXLiTE TX 133GF	-	TX133GF8	-
FLEXLiTE TX 135GF	TX135GF4	TX135GF8	TX135GF16
FLEXLiTE TX 163GF	-	TX163GF8	-
FLEXLiTE TX 165GF	TX165GF4	TX165GF8	TX165GF16
FLEXLiTE TX 163GS	TX163GS4	TX163GS8	-
FLEXLiTE TX 165GS	TX165GS4	TX165GS8	TX165GS16
FLEXLiTE TX 165G	TX165G4	TX165G8	TX165G16
FLEXLiTE TX 223G	TX223G4	TX223G8	-
FLEXLiTE TX 225G	TX225G4	TX225G8	TX225G16
FLEXLiTE TX 223GS	-	TX223GS8	TX223GS16
FLEXLiTE TX 225GS	TX225GS4	TX225GS8	TX225GS16
FLEXLiTE TX 303WF	-	TX303WF8	-
FLEXLiTE TX 305WF	TX305WF4	TX305WF8	TX305WF16
FLEXLiTE TX 253WS	TX253WS4	TX253WS8	-
FLEXLiTE TX 255WS	TX255WS4	TX255WS8	TX255WS16
FLEXLiTE TX 353W	TX353W4	TX353W8	TX353W16
FLEXLiTE TX 355W	TX355W4	TX355W8	TX355W16
FLEXLiTE TX 135GFN	TX135GFN4	TX135GFN8	-
FLEXLiTE TX 163GVD9	TX163GVD94	-	-
FLEXLiTE TX 165GFN	TX165GFN4	TX165GFN8	-
FLEXLiTE TX 165GSN	-	TX165GSN8	-
FLEXLiTE TX 223 GVD13	TX223GVD134	-	-
FLEXLiTE TX 225GN	TX225GN4	TX225GN8	-
FLEXLiTE TX 255WSN	-	TX255WSN8	-
FLEXLiTE TX 305WFN	-	TX305WFN8	-
FLEXLiTE TX 355WN	-	TX355WN8	-

FLEXLiTE TX remotes (optional, available for K5 models only)		
Product	Ordering code	
	For water-cooled torch:	For gas-cooled torch:
FLEXLiTE TXR10 remote, roller switch	TXR10W	TXR10G
FLEXLiTE TXR20 remote, rocker switch	TXR20W	TXR20G

FLEXLiTE TX other accessories (optional)	
Product	Ordering code
FLEXLiTE TX trigger extension	SP801091
Adapter R1/4 to DIX 9mm	SP016758
Adapter R1/4 to DIX 13mm	SP016759

### The name of a Flexlite torch tells its properties and use



[illegible]

[illegible]



[illegible]

[illegible]

[illegible]



**Kemppi** is the pioneering company within the welding industry. It is our role to develop solutions that make you win business. Headquartered in Lahti, Finland, Kemppi employs over 800 welding industry experts in 17 countries and has a revenue of more than 150 MEUR. Our offering includes welding solutions - intelligent equipment, welding management software and expert services - for both demanding industrial applications and ready-to-weld needs. Local expertise is available via our global partner network covering over 60 countries.

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