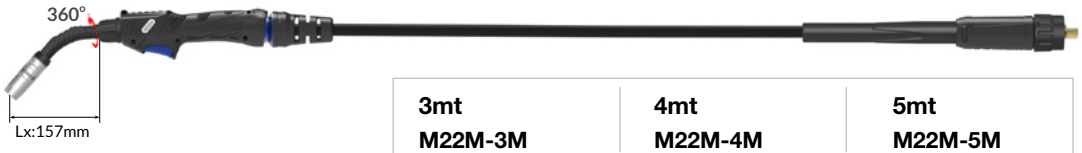
M22M Air-Cooled Mig Welding Torch - Multijust

Ratings:	250A CO_2, 220A mixed gas M21, 120A pulse. EN60974-7 @ 60% duty cycle. 0.8mm-1.2mm wires

A great all-round Industrial torch for high duty 200 Amp solid wires and low duty Pulse Mig Aluminium applications.
Fitted with a longer neck with 360º rotation, perfect for multiple positions in difficult to reach areas.

ARC M INDUSTRIAL MIG TORCH PACKAGES - MULTIJUST

M22M Multijust Torches are supplied with a Euro termination as standard and are supplied 'ready to weld' with all wear parts fitted.



3mt	4mt	5mt
M22M-3M	**M22M-4M**	**M22M-5M**

Wear Parts

A Nozzles

Part Number	Description	Bore	Wall	Material
•AM22CN	Conical Nozzle Assembly	16mm	1.75mm	Copper
AM22CNHD	Conical Nozzle HD Assembly	16mm	2.00mm	Copper
AM22TN	Tapered Nozzle Assembly	14mm	1.75mm	Copper

B Contact Tips

Part Number	Description	Size (mm)	Wire Size (mm-inch)	Material
AM2CT08	Contact Tip	M8*29.5	0.8 - 0.030	Copper
AM2CT09	Contact Tip	M8*29.5	0.9 - 0.035	Copper
•AM2CT10	Contact Tip	M8*29.5	1.0 - 0.040	Copper
AM2CT12	Contact Tip	M8*29.5	1.2 - 0.045	Copper
AM2CT08A	Contact Tip	M8*29.5	0.8 - 0.030	Copper
AM2CT10A	Contact Tip	M8*29.5	1.0 - 0.040	Copper
AM2CT12A	Contact Tip	M8*29.5	1.2 - 0.045	Copper

C Tip Adaptors

Part Number	Description	Material
•AM22TA	Tip Adaptor	Brass

•Denotes torch package standard wear part set-up

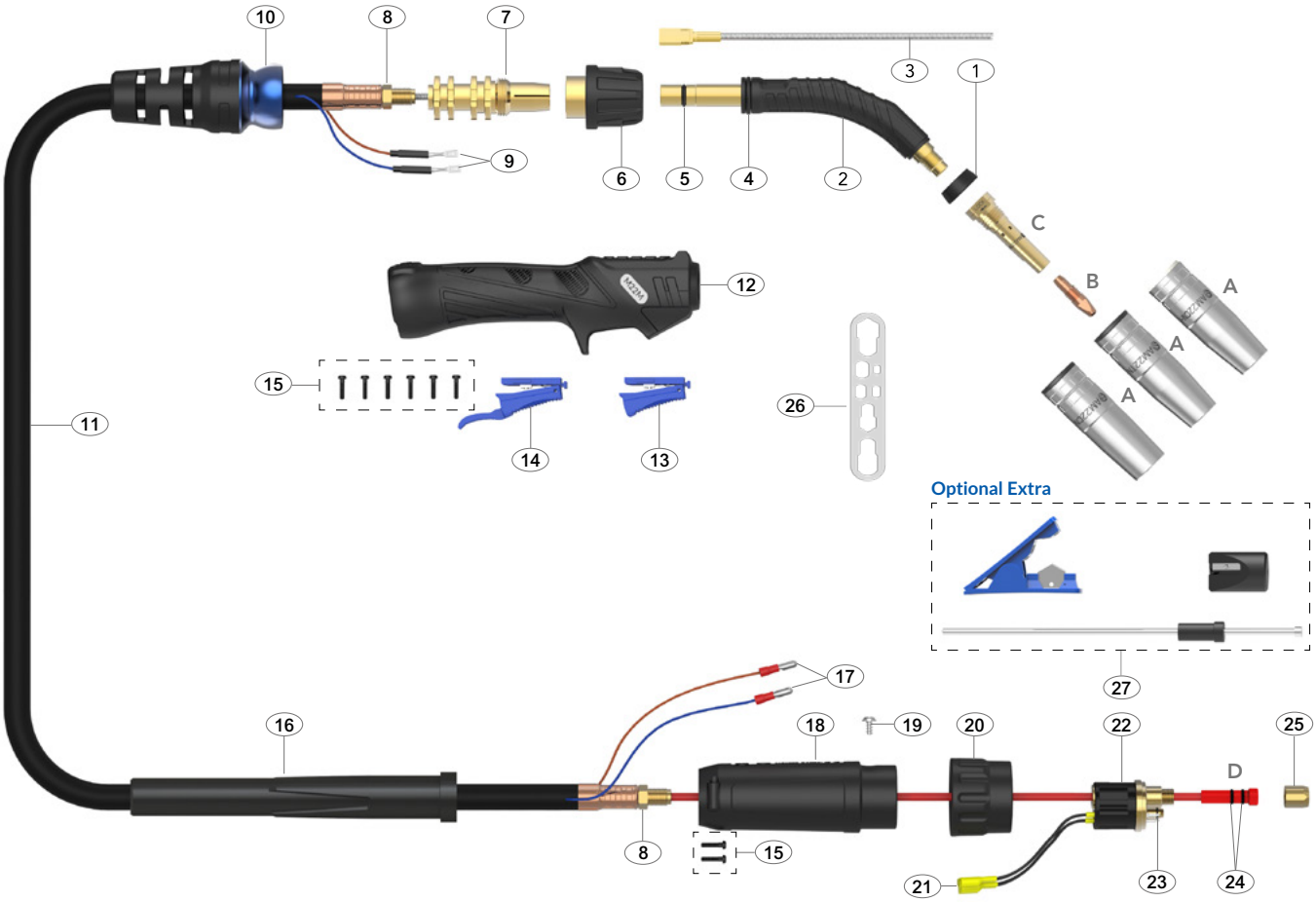
D Liners

Part Number	Description	Wire Size
•AM2524-30	Steel Liner x 3mt	1.0-1.2mm
•AM2524-40	Steel Liner x 4mt	1.0-1.2mm
•AM2524-50	Steel Liner x 5mt	1.0-1.2mm

For alternate liner options please refer to page 30

Arc Conical HD Nozzle
Recommended for High Amperage and Pulse Welding

INDUSTRIAL SERIES - MULTIJUST



Spare Parts

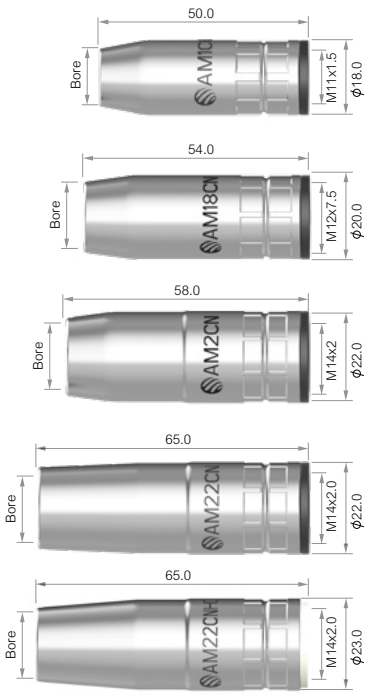
	Part Number	Description
1	AM2AP	Neck Insulator
2	AM22001M	Swan Neck Assembly - Multijust
3	AM22MJL	Neck Jump Liner 0.8-1.2mm - Hard Wire
4	AM-MJ1509	Neck 'O' Ring(Ø14xØ2.5)
5	AM-MJ1508	Neck 'O' Ring(Ø8.5xØ1.5)
6	AM1516M	Neck Nut - Multijust
7	AM1515M	Socket Connection
8	AM1505	Lock Nut
9	AM1521	Cable Terminal
10	AM1514	Handle Cable Support c/w Ball Joint
11	AM2603-30	Ultraflex Cable Assembly x 3mt
	AM2603-40	Ultraflex Cable Assembly x 4mt
	AM2603-50	Ultraflex Cable Assembly x 5mt
12	AM2514	Handle Kit
13	AM2516	Microswitch Standard Trigger
14	AM2516L	Microswitch Extended Trigger
15	AMSP1-1	Screw Pack
16	AMPA3541	Cable Support
17	AM1522	Cable Terminal Male
18	AM2578/L	Gun Plug Housing
19	AML1541	Gun Plug Screw
20	AMC1519/S	Gun Plug Nut
21	AM1523	Gun Plug Terminal Female

	Part Number	Description
22	AM1528	Hybrid Gun Plug Body c/w Spring Pins
23	AM1524	Gun Plug 'O' Ring
24	AMLOR	Liner 'O' Ring
25	AM1826	Liner Retaining Nut
26	AMWS	Wear Parts Spanner
	Optional Extra	
27	AMCLST-KITS	Combi-Liner Set-up kit

Welding with Soft Wires

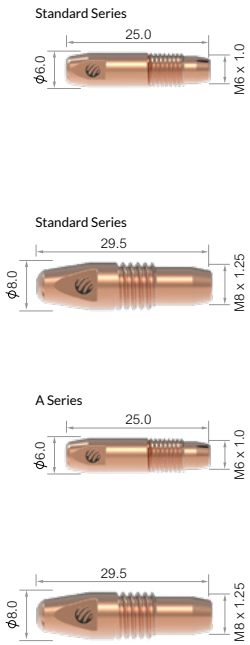
For welding with Aluminum wires use a Combi-liner (page 30).
Optimum installation is achieved when using the Combi-liner set-up kit.

Nozzles



Part No.	Description	Bore	Wall	Material	M1	M18	M2	M22	M2M	M22M
AM1CN	Conical Nozzle Assembly	12mm	1.0mm	Copper	●	○	○	○	○	○
AM1TN	Tapered Nozzle Assembly	10.6mm	1.0mm	Copper	◐	○	○	○	○	○
AM18CN	Conical Nozzle Assembly	14mm	1.5mm	Copper	○	●	○	○	○	○
AM18TN	Tapered Nozzle Assembly	12mm	1.5mm	Copper	○	◐	○	○	○	○
AM2CN	Conical Nozzle Assembly	15mm	1.9mm	Copper	○	○	●	○	●	○
AM2TN	Tapered Nozzle Assembly	12mm	1.9mm	Copper	○	○	◐	○	◐	○
AM22CN	Conical Nozzle Assembly	16mm	1.75mm	Copper	○	○	○	●	○	●
AM22TN	Tapered Nozzle Assembly	14mm	1.75mm	Copper	○	○	○	◐	○	◐
Recommended for High Amperage and Pulse Welding										
AM22CNHD	Conical Nozzle HD Assembly	16mm	2.00mm	Copper	○	○	○	◐	○	◐

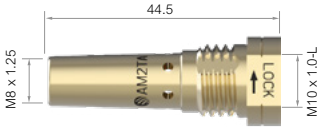
Contact Tips



Part No.	Description	Size mm	Wire Size mm-Inch	Material	M1	M18	M2	M22	M2M	M22M
Standard Series - Recommended for Fe, Fe-MC/FC Set-up										
AM1CT06	Contact Tip	M6*25.0	0.6-0.023	Copper	◐	◐	○	○	○	○
AM1CT08	Contact Tip	M6*25.0	0.8-0.030	Copper	●	●	○	○	○	○
AM1CT09	Contact Tip	M6*25.0	0.9-0.035	Copper	◐	◐	○	○	○	○
AM1CT10	Contact Tip	M6*25.0	1.0-0.040	Copper	◐	◐	○	○	○	○
AM1CT12	Contact Tip	M6*25.0	1.2-0.045	Copper	◐	◐	○	○	○	○
Standard Series - Recommended for Fe, Fe-MC/FC Set-up										
AM2CT08	Contact Tip	M8*29.5	0.8-0.030	Copper	○	○	◐	◐	◐	◐
AM2CT09	Contact Tip	M8*29.5	0.9-0.035	Copper	○	○	◐	◐	◐	◐
AM2CT10	Contact Tip	M8*29.5	1.0-0.040	Copper	○	○	●	●	●	●
AM2CT12	Contact Tip	M8*29.5	1.2-0.045	Copper	○	○	◐	◐	◐	◐
A Series - Recommended for Aluminium and SS Set-up										
AM1CT08A	Contact Tip	M6*25.0	0.8-0.030	Copper	◐	◐	○	○	○	○
AM1CT10A	Contact Tip	M6*25.0	1.0-0.040	Copper	◐	◐	○	○	○	○
AM1CT12A	Contact Tip	M6*25.0	1.2-0.045	Copper	◐	◐	○	○	○	○
A Series - Recommended for Aluminium and SS Set-up										
AM2CT08A	Contact Tip	M8*29.5	0.8-0.030	Copper	○	○	◐	◐	◐	◐
AM2CT10A	Contact Tip	M8*29.5	1.0-0.040	Copper	○	○	◐	◐	◐	◐
AM2CT12A	Contact Tip	M8*29.5	1.2-0.045	Copper	○	○	◐	◐	◐	◐

◐ Standard wear part range ● Torch package standard wear part set-up

Tip Adaptors



Part No.	Description	Material	M1	M18	M2	M22	M2M	M22M
AM1TA	Tip Adaptor	Brass	●					
AM18TA	Tip Adaptor	Brass		●				
AM2TA	Tip Adaptor	Brass			●		●	
AM22TA	Tip Adaptor	Brass				●		●

Liners

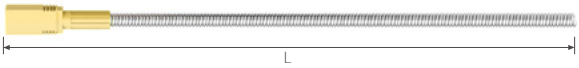
Filler Metal

Steel Liner
Recommended for: Fe, Fe-MC/FC. Light and medium duty applications

Part No.	Description	Nipple	Wire Size mm	M1	M18	M2	M22	M2M	M22M
AM1535-30	Steel Liner x 3mt	Moulded Nipple	0.6-0.9	●	●	●	●	●	●
AM1535-40	Steel Liner x 4mt	Moulded Nipple	0.6-0.9	●	●	●	●	●	●
AM1535-50	Steel Liner x 5mt	Moulded Nipple	0.6-0.9	●	●	●	●	●	●

AM2524-30	Steel Liner x 3mt	Moulded Nipple	1.0-1.2	●	●	●	●	●	●
AM2524-40	Steel Liner x 4mt	Moulded Nipple	1.0-1.2	●	●	●	●	●	●
AM2524-50	Steel Liner x 5mt	Moulded Nipple	1.0-1.2	●	●	●	●	●	●

AM2MJL	Neck Jump Liner - Hard Wire(L:170mm)	Brass Nipple	0.8-1.2	○	○	○	○	●	○
AM22MJL	Neck Jump Liner - Hard Wire(L:186.5mm)	Brass Nipple	0.8-1.2	○	○	○	○	○	●



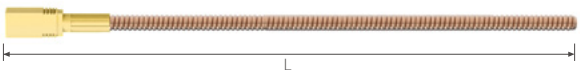
Al - Combi Liner
Recommended for: Air-cooled torches with AlMg. Can be used for SS-MC/FC wires

AM1564-30	Combi-Liner x 3mt	Brass Nipple	0.8-1.2	●	●	●	●	○	○
AM1564-40	Combi-Liner x 4mt	Brass Nipple	0.8-1.2	●	●	●	●	○	○
AM1564-50	Combi-Liner x 5mt	Brass Nipple	0.8-1.2	●	●	●	●	○	○

Al - Soft Wire Liner
Recommended for: Air-cooled torches with AlMg. Can be used for SS-MC/FC wires

AM1564A-30	Soft Wire Liner x 3mt	Brass Nipple	0.8-1.2	○	○	○	○	●	●
AM1564A-40	Soft Wire Liner x 4mt	Brass Nipple	0.8-1.2	○	○	○	○	●	●
AM1564A-50	Soft Wire Liner x 5mt	Brass Nipple	0.8-1.2	○	○	○	○	●	●

AM2MJL-B	Neck Jump Liner - Soft Wire(L:170mm)	Brass Nipple	0.8-1.2	○	○	○	○	●	○
AM22MJL-B	Neck Jump Liner - Soft Wire(L:186.5mm)	Brass Nipple	0.8-1.2	○	○	○	○	○	●



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● Standard wear part range ● Torch package standard wear part set-up