Soldering and Welding Equipment

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Application Table

Product listing according to application areas

			Soft soldering up to 450 °C	Brazing, etc. 450 °C-1100 °C	Mapp	Propane	Maxigas	Multigas	Supergas
CARTRIDGE SOLDERING UNITS									
	SUPER FIRE 3	176	Basic	Hot	●	●			
	POWER FIRE	180	Basic	Hot	●	●			
	POWER FIRE COMPACT	180	Basic	Hot	●	●			
	ROFIRE PIEZO 1.950 °C / ROFIRE 1.800 °C / EASYFIRE (only basic) with Maxigas	181	Basic	Hot			●	●	
	ROFLAME PIEZO 1.800 °C	181	Basic						●

Disposable gas cartridges 176 - 177

			Soft soldering up to 450 °C	Brazing, etc. 450 °C-1100 °C	Acetylene	Propane/Butane
ACETYLENE AND PROPANE TORCHES						
	AIRAC®	199	Basic	Hot	●	
	ROCOLT HANDY PIEZO	184, 185	Basic	Hot		●
	AIRPROP	186	Basic	Hot		●
	TURBOPROP	187	Basic	Hot		●
	Titanium Torch / Roofing Set	185/190	Basic	Hot		●
	Gas-fired Soldering Irons	188	Basic			●
	Multi 300	189	Basic			●

Light steel cylinders 200

The bottle colours shown are without obligation!

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Systemised Soldering, Brazing and Welding Equipment

			Soft soldering up to 450 °C	Brazing 450 °C-1100 °C	Gas welding > 1100 °C	
GAS-WELDING EQUIPMENT						
	ROFLASH	198	Basic	Hot	Max	Acetylene-Oxygen
	RE 17	196,197	Basic	Hot	Max	Acetylene-Oxygen
	Allgas 2000	193 - 195	Basic	Hot	Max	Propane-Oxygen
	ROXY KIT	195	Basic	Hot	Max	Maxi 400 Oxygen
ELECTRIC SOFT SOLDERING UNIT						
	ROTHERM 2000	204, 205	Basic			

Light steel cylinders 200

Disposable gas cartridges 182, 183

Soldered Joints

Material	Required Hard Solder	Melting Range	Working Temperature	Standard
Copper-Copper	S 34 Cu / S 34 Cu U S 94 / S 94 XN / S1 S 2 / S 5 S 15 S 30 / S 30 U S 45 / S 45 U	630 °C - 730 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 800 °C 600 °C - 690 °C 595 °C - 630 °C	710 °C 730 °C 710 °C 710 °C 680 °C 610 °C	DIN EN 1044
Copper-Carbon Steel	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U S 30 / S 30 U S 45 / S 45 U	630 °C - 730 °C 640 °C - 680 °C 600 °C - 690 °C 595 °C - 630 °C	710 °C 670 °C 680 °C 610 °C	DIN EN 1044
Copper-Brass	S 94 / S 94 XN / S1 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 1044
Brass-Carbon Steel	S 30 / S 30 U S 45 / S 45 U S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	600 °C - 690 °C 595 °C - 630 °C 630 °C - 730 °C 640 °C - 680 °C	680 °C 610 °C 710 °C 670 °C	DIN EN 1044
Brass-Brass	S 94 / S 94 XN S 1 (not standardised) S 2 / S 5 S 15	710 °C - 880 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 730 °C 710 °C 710 °C	DIN EN 1044
Carbon Steel-Carbon Steel	S 30 / S 30 U S 45 / S 45 U S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	600 °C - 690 °C 595 °C - 630 °C 630 °C - 730 °C 640 °C - 680 °C	680 °C 610 °C 710 °C 670 °C	DIN EN 1044

The bottle colours shown are without obligation!

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SUPER FIRE 3

Ergonomic HEAVY-DUTY brazing unit up to Ø 28 mm

For soft soldering, brazing and other applications such as loosening of colour or shrinking of hoses

Product Profile

KEY FEATURES

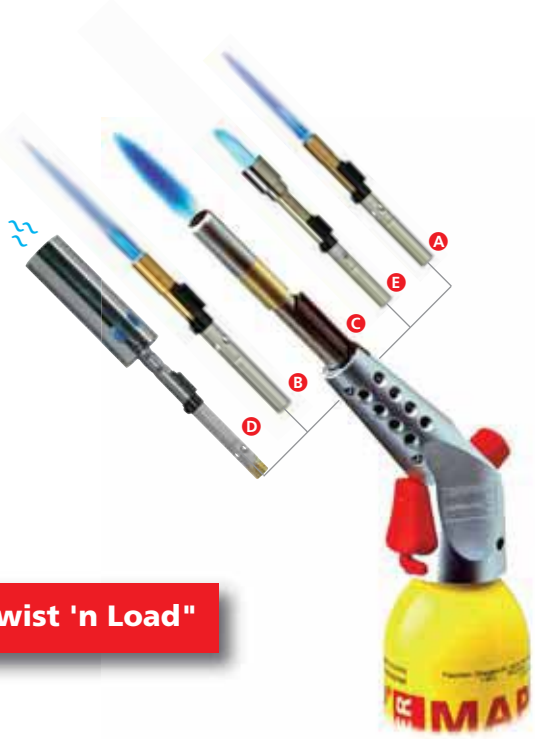
- Versatile - for use in all positions (360°)
- 1 Extremely high flame temperature
- 2 Long service life
- 3 "Twist 'n Load" system (5 different nozzles available)
- 4 Precise flame adjustment
- 5 Up to 2.5 hours of hard soldering with one cartridge
- 6 Even more comfortable for longer jobs
- 7 Reliable Piezo ignition (up to 30,000 ignitions)
- 8 Doubles the safety

TECHNICAL DATA

Brazing:	up to Ø 28 mm
Soft soldering:	up to Ø 35 mm
Coupling:	7/16" EU
Handle:	Aluminium, bolted
Burner:	Brass / stainless steel
"Twist 'N Load":	5 different nozzles for different uses

SUPER FIRE 3 Nozzles

Quick exchange with the "Twist 'N Load" system



"Twist 'n Load"

Pin-point Nozzle:

Ⓐ

For fine soldering; precise and stable flame

Standard Nozzle:

Ⓑ

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

Cyclone Nozzle:

Ⓒ

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

Hot air Nozzle:

Ⓓ

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

Shrinking Nozzle:

Ⓔ

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

Soft soldering in heating installation

High flame temperature through cyclone swirl

Hard soldering in gas installation

Hard soldering in refrigeration and climate control

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IDEAL FOR up to 28 m BRAZING

IDEAL FOR up to 35 mm SOFT SOLDERING

lock | Piezo | Fine | 360° | Off On | Hot

"Twist 'N Load"

1 Nozzle with swirl flame

Extremely high flame temperature

2 Elaborately manufactured brass / stainless steel design

Long service life

3 Fast "Twist 'n Load" system

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

4 Fine regulating valve

Precise flame adjustment

Ergonomically designed handle made of high-quality aluminium

Robust and optimum handling

8 Only ignites if torch has been securely locked

Dual safety

7 High Performance Piezo

Reliable (up to 30,000 ignitions)

6 Locking button

Continual use

Can be used in any position (360°)

5 ROTHENBERGER MAPP® Gas

Up to 2.5 hours of brazing with one cartridge

Fig. Hot Box (No. 3.5490/No. 3.5490U)

Loosening of paint

Shrinking of hoses (optimal with propane gas)

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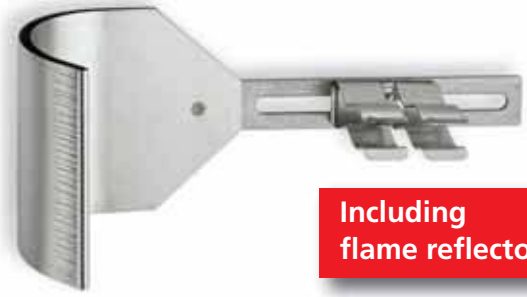
Fig. SUPER FIRE 3 HOT BOX

SUPER FIRE 3 HOT BOX

Hot

KEY FEATURES

- The ideal service kit



Including flame reflector

5 part set (No. 3.5490) includes: handle (No. 3.5445), cyclone nozzle (No. 3.5457), pin-point nozzle (No. 3.5455), flame reflector (No. 3.1043), universal torch support (No. 3.5461), 2 x MAPP® gas cartridges (No. 3.5551-A), carrying case

Model			No.
SUPER FIRE 3 HOT BOX	1	4	3.5490
SUPER FIRE 3 HOT BOX US, without MAPP® gas	1	4	3.5490U

6

No. 3.5436/No. 3.5431

No. 3.5432

No. 3.5437

SUPER FIRE 3 Basic Set

Hot

Set (No. 3.5436/No. 3.5431) includes:
handle (No. 3.5445), cyclone nozzle (No. 3.5457)

SUPER FIRE 3 MAPP®-Set

Hot

Set (No. 3.5432) includes:
handle (No. 3.5445), cyclone nozzle (No. 3.5457), MAPP® gas cartridge (No. 3.5551-A)

SUPER FIRE 3 All-In-One-Set

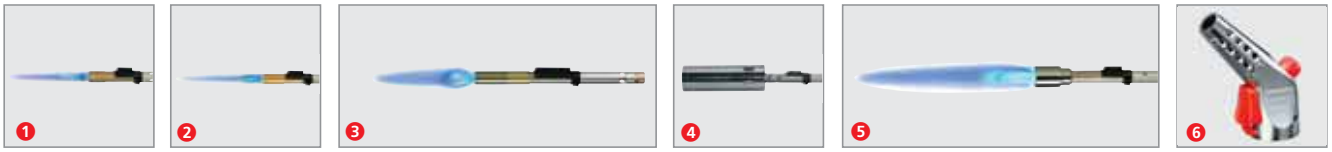
Hot

Set (No. 3.5437) includes: handle (No. 3.5445), cyclone nozzle (No. 3.5457), pin-point nozzle (No. 3.5455), universal torch support (No. 3.5461), MAPP® gas cartridge (No. 3.5551-A)

When placing your order, remember to order the universal torch support (No. 3.5461) for stationary soldering, too!

Model			No.
SUPER FIRE 3 Basic Set	1	4	3.5436
SUPER FIRE 3 Basic Set US	1	4	3.5431
SUPER FIRE 3 MAPP® Set	1	10	3.5432
SUPER FIRE 3 All-in-One-Set	1	5	3.5437

ACCESSORIES



Description			No.	Description			No.
Pin-point nozzle 15 mm	1	176	3.5455	Hot air nozzle 38 mm	4	176	3.5458
Standard nozzle 16 mm	2	176	3.5456	Shrinking nozzle 24 mm	5	176	3.5459
Cyclone nozzle	3	176	3.5457	Handle, EU coupling	6		3.5445
O-Ring set (2 pieces)			83.0806	Flame reflector		191	
Universal torch support MAPP® Gas			3.5461	MAPP® Gas		182	

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SUPER FIRE 3 MAPP® Mixed Displays

Hot

Display 1.9167-A contains:

2 x SUPER FIRE 3 MAPP® Set (No. 3.5432)
2 x SUPER FIRE 3 All-in-One-Set (No. 3.5437)
4 x SUPER FIRE 3 HOT BOX (No. 3.5490)
24 x MAPP® Gas cartridge (No. 3.5551-A)

Display 1.9169-A contains:

3 x SUPER FIRE 3 MAPP® Set (No. 3.5432)
2 x SUPER FIRE 3 All-in-One-Set (No. 3.5437)
4 x SUPER FIRE 3 HOT BOX (No. 3.5490)
1 x Hot air nozzle 38 mm (No. 3.5458)
1 x Pin-point nozzle 15 mm (No. 3.5455)
1 x Cyclone nozzle 16 mm (No. 3.5457)
24 x MAPP® Gas cartridge (No. 3.5551-A)

No. 1.9167-A

No. 1.9169-A

Model		No.
SUPER FIRE 3 MAPP® Mixed Display	1	1.9167-A

Model		No.
SUPER FIRE 3 MAPP® Mixed Display	1	1.9169-A

ACCESSORIES

Description		Description	
Flame reflector	191	Solders	206 - 211
ROVLIES®	203	Welding blanket	203
External brushes for copper pipe	203	Fittings flux	207
Internal brushes for copper pipe	203	Disposable gas cartridge	182, 183

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POWER FIRE

**PROFESSIONAL brazing- Ø 22 mm
and soft soldering-unit up to Ø 35 mm**

lock | Piezo | Fine | 360° | Off On | Hot

Product Profile

KEY FEATURES

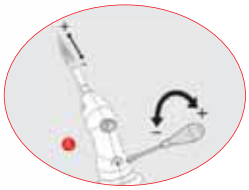
1. Ideal for brazing up to Ø 22 mm
2. Precise adjustment of the flame
3. Adjustable for all gases (adjustable access valve)
4. Continual use with locking button
5. Immediate flame ignition, up to 30,000 ignitions

TECHNICAL DATA

Brazing:	up to Ø 22 mm
Soft soldering:	up to Ø 35 mm
Coupling:	7/16" EU
Handle:	Fibreglass reinforced plastic
Burner:	Stainless steel

**7/16" EU-thread
Applicable with every
ROTHENBERGER Gas**

Fig. POWER FIRE Set



Model			No.
POWER FIRE MAPP® Set (including MAPP® Gas)	1	8	3.5427

Model			No.
POWER FIRE handle, EU	1	10	3.0812
POWER FIRE handle, US	1	10	3.0811

POWER FIRE Compact

**PROFESSIONAL brazing- Ø 22 mm
and soft soldering-unit up to Ø 35 mm**

ROTHENBERGER Plus TECHNOLOGY

lock | Piezo | Fine | 360° | Hot

45% lighter!

KEY FEATURES

Characteristics

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

TECHNICAL DATA

Coupling:	7/16" EU
Brazing:	up to Ø 22 mm
Soft soldering:	up to Ø 35 mm

Model	No.
POWER FIRE Compact Set (including MAPP® Gas)	3.0813

Disposable gas cartridges can be found on pages 182/183

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ROFIRE 1800 °C

Fine | Basic

ECONOMY soft soldering unit up to Ø 22 mm

KEY FEATURES

- Burner with integrated support bracket
- Precise adjustment of the flame with the fine adjustment valve

TECHNICAL DATA

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

Model	g	No.
ROFIRE 1800 °C Set, contains: Burner (No. 3.5506), Multigas 300 (3.5510)	760	3.5428

ROFIRE PIEZO 1950 °C

Piezo | Fine | Basic | Hot

ECONOMY soldering unit Ø 28 mm

Powerful soldering unit for CU-brazing joints up to Ø 15 mm and soft soldering up to Ø 28 mm

KEY FEATURES

- Piezo Ignition
- Precise adjustment of the flame
- Burner head with integrated support bracket

TECHNICAL DATA

Coupling: 7/16" EU
Brazing: up to Ø 15 mm
Soft soldering: up to Ø 28 mm

IDEAL FOR up to 28 mm SOFT SOLDERING

Model	g	No.
ROFIRE PIEZO 1950 °C Set, contains: Burner (No. 3.5556), including Multigas 300 (No. 3.5510)	760	3.5429

6

ROFLAME PIEZO 1800 °C

CLASSIC soft soldering unit Ø 22 mm

High performance torch with Piezo ignition

KEY FEATURES

- Piezo Ignition
- Precise adjustment of the flame

TECHNICAL DATA

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

Piezo | Fine | Basic

TÜV SÜD GS

Model	g	No.
ROFLAME PIEZO 1800 °C (without gas cartridge)	750	3.5931

EASY FIRE

ECONOMY soft soldering up to Ø 22 mm

High performance torch with Piezo ignition

Piezo | Fine | Basic

KEY FEATURES

- Piezo Ignition
- Precise adjustment of the burner flame
- Suitable for Multigas 300

TECHNICAL DATA

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

Model	g	No.
EASY FIRE, contains: Burner, Multigas 300 (No. 3.5510)	730	3.5553

Disposable gas cartridges can be found on pages 182/183

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Disposable Gas Cartridges

MAPP® Gas EU / US

Special gas mix for high-performance soldering work

Flame temperatures up to 2400 °C + 35 % faster than propane

Basic Hot

Product Profile

KEY FEATURES

1. Extremely high flame temperature, utmost burning performance and guaranteed short working times
2. Guaranteed constant top burner performance
3. Poses no health risks (contains no BUTADIENE)

KEY FEATURES

4. Easy to use
5. Increased user safety
6. Longer periods of use

Coupling thread

7/16"

EU 7/16"

US 1"

3 **Contains no BUTADIENE**

Poses no health risks

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

Easy to use

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

Guaranteed constant top burner performance

MAPP® monoblock aluminium cylinder

1 **Special gas mixture with outstanding flame characteristics**

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

5 **TÜV tested gas cartridge (drawn from solid material)**

Increased safety for the user

MAPP® Gas

Special gas mixture researched by ROTHENBERGER

6 **Burns approx. 1/3 longer than propane**

Longer period of use

Fig. MAPP® Gas EU

Fig. MAPP® Gas US

Model	Contents		No.
MAPP® gas cartridge	750 ml	12 / 360	3.5551-A
Languages: D, GB, F, E, I, P			
MAPP® gas cartridge	750 ml	12 / 360	3.5551-B
Languages: DK, NL, SE, FI, FR, RU			
MAPP® gas cartridge	750 ml	12 / 360	3.5551-C
Languages: CZ, PL, HU, BG, TR, GR			
Adaptor for US and EU standards			3.5648X

You can find burners starting on 176

Packaging Profile

Description	MAPP® Gas EU / US
No.	3.5551-A / 3.5698
EAN Code	4004625355510
Product size (mm) (W x H)	80 x 285
Contents (ml)	750
Weight (g)	670
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 1200 x 1000
Carton size (mm) (L x W x H)	320 x 295 x 250

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Maxigas 400

Hot

High-performance welding, cutting and brazing gas. for flame temperatures up to 2200 °C
Gas cartridge with 7/16" EU coupling thread

Description	Maxigas 400
No.	3.5570
EAN Code	4004625355701
Product size (mm) (W x H)	65 x 260
Contents (ml)	600
Weight (g)	338
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 1200 x 1000
Carton size (mm) (L x W x H)	405 x 272 x 264

Multigas 300

Hot

Propane / butane gas mixture for flame temperatures up to 1900 °C.
Gas cartridge with 7/16" EU coupling thread
.

Description	Multigas 300
No.	3.5510
EAN Code	4004625355107
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 1200 x 1000
Carton size (mm) (L x W x H)	405 x 272 x 264

Propane Gas EU / US

Basic

Gas cartridges for flame temperatures up to 1900 °C. With EU coupling 7/16" / US coupling 1"

EU Version

US Version

Description	Propangas EU / US
No.	3.5546-A / 3.5547
EAN Code	4004625355466
Product size (mm) (W x H)	80 x 285
Contents (ml)	750
Weight (g)	550
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)	198
Palette size (mm) (L x W x H)	800 x 1200 x 1000
Carton size (mm) (L x W x H)	320 x 295 x 250

C 200 Supergas

Basic

Pierceable butane cartridge with propane contents, also for working at low temperatures. Manufactured according to EN 417

Description	C 200 Supergas
No.	3.5900
EAN Code	4004625359006
Product size (mm) (W x H)	90 x 95
Contents (ml)	190
Weight (g)	290
Unit per PU	36
PU per layer / palette	9
Layer per palette	3
Units per palette	972
Number of palettes per truckload	60
Units per truckload	58.320
Palette weight (kg)	251
Palette size (mm) (L x W x H)	800 x 1200 x 1000
Carton size (mm) (L x W x H)	405 x 272 x 264

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Propane High-Performance Torches

ROCOLT HANDY PIEZO Set

Professional brazing system with Quick-change burner

Three burner tips for different applications

Product Profile

KEY FEATURES

- Three burner tips for different applications
- Tool-free burner exchange with the fast "Twist 'n Load" system
- 1 Reliable Piezo ignition for up to 30,000 ignitions
- 2 Increased safety with the hose failure protection
- 3 No twisting of the hose, work in any position

TECHNICAL DATA

Brazing:	up to Ø 28 mm
Soft soldering:	up to Ø 32 mm
Warming-up:	up to Ø 60 mm
Coupling:	3/8" left
Handle:	Plastic, with screws
Burner:	Brass / stainless steel

IDEAL FOR up to 28 m BRAZING

Standard burner Ø 19 mm

Soft Soldering
up to Ø 32 mm

"Twist 'n Load"

3 Rotatable hose coupling on the handle

No twisting of the hose, work in any position with standard burner
Ø 19 mm soft soldering up to Ø 32 mm

1 Piezo ignition

Up to 30.000 ignitions

2 Propane gas regulator with hose failure protection

Increased safety

Fig. ROCOLT HANDY PIEZO Set

8-part set (No. 3.5390) includes: ROCOLT handle (No. 3.5395), standard burner 19 mm (No. 3.5378), cyclone burner (No. 3.5398), pressure reducer including rotatable hose failure protection (No. 3.5356), propane hose 3 m (No. 3.5383), flame reflector 65 mm (No. 3.1043), ROVLIES® (No. 4.5268), plastic carrying case (No. 3.5355)

Model	kg	No.
ROCOLT HANDY PIEZO Set	1.5	3.5390
ROCOLT HANDY Handle	0.1	3.5395

Piezo ignition

Application with flame reflector

Brazing

Soft soldering

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Titanium
High-performance Warming-up Torch

Lighter professional high-performance torch with Ø 60 mm head

ROTHENBERGER Plus TECHNOLOGY

"Twist 'n Load" system

Fast burner exchange without tools

TITANIUM

Only 430 g

Can only be used with the ROCOLT PIEZO handle!

Product Profile

APPLICATION AREA

For bonding of bitumen sheeting, large-area burning of weeds, defrosting, insulate and drying

KEY FEATURES

- Especially recommended by longer use with the ergonomic light design (430 g)
- Fast burner exchange with the "Twist 'n Load" system
- Built-in Piezo ignition in handle
- Closed, brand reinforced burner head is stable and not sensitive to wind

TECHNICAL DATA

Flame type:	Standard
Burner head Ø:	60 mm
Burner length:	600 mm
Gas usage:	8000 g/h at 4 bar
Performance at 4 bar:	102 kW
Weight:	430 g

Model	kg	No.
Titanium High-performance Warming-up Torch	0.4	3.5396
ROCOLT Piezo Handle	0.1	3.5395

ROCOLT HANDY PIEZO
Standard Burner

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

Model	Ø mm		g	No.
Piezo Standard Burner	14	1	160	3.5377
Piezo Standard Burner	19	2	150	3.5378
Piezo Standard Burner	25	3	160	3.5379

ROCOLT HANDY PIEZO
Cyclone Burner

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

Model	Ø mm		g	No.
Piezo Standard Burner	14	4	180	3.5397
Piezo Standard Burner	19	5	150	3.5398
Piezo Standard Burner	25	6	180	3.5399

ACCESSORIES

Description		Description	
Welding blanket	203	External brush for copper pipe	203
Internal brush for copper pipe	203	ROVLIES®	203
Solder	206 - 211	Fittings flux	207

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Propane High-Performance Torches

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 2000 °C without oxygen, as well as warming up, shrinking and flame cleaning

Product Profile

KEY FEATURES

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

TECHNICAL DATA

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

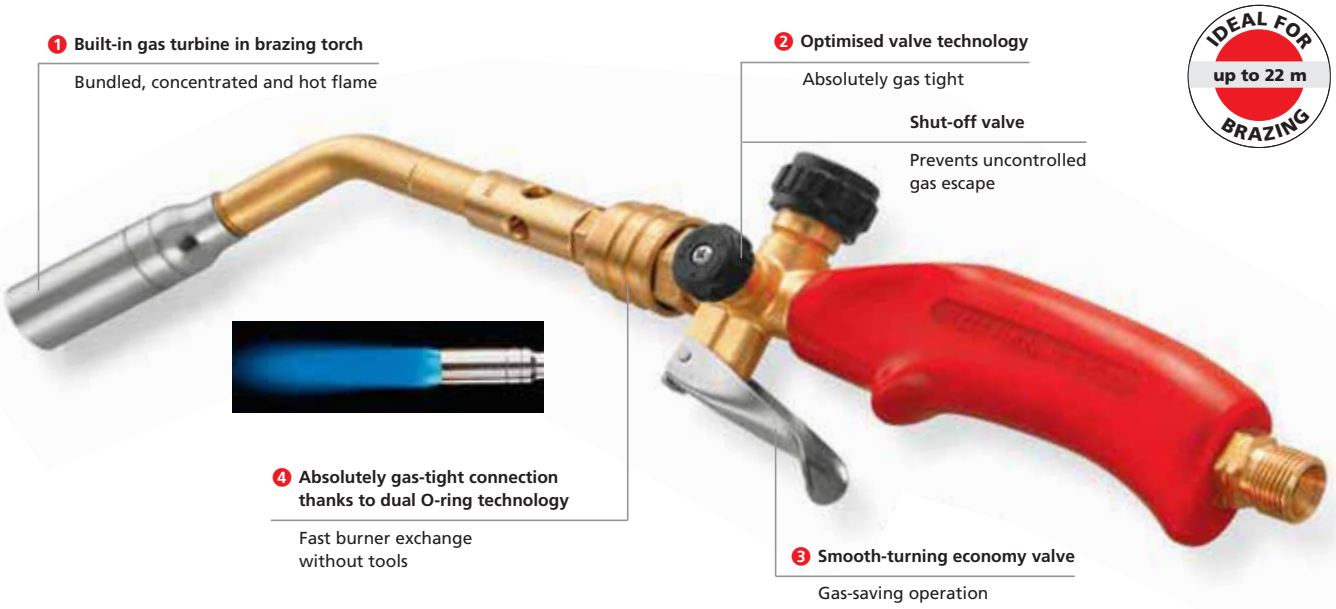

Abb. AIRPROP Set

Sets include: Safety handle with push-in coupling (No. 3.1009), brazing burner with push-in nipple Ø 14 mm (No. 3.1013) / Ø 16 mm (No. 3.1014) / Ø 19 mm (No. 3.1015), 2.5 m propane hose with 3/8" L coupling (No. 3.2201), safety igniter (No. 3.2077), replacement flints (No. 3.2088), open-ended spanner (No. 3.2073), steel case (No. 3.1005)

Model	kg	No.
AIRPROP Brazing Set without propane regulator	2.8	3.1092
AIRPROP Brazing Set with propane regulator (as in set (No. 3.1092) but with regulator (No. 3.2081) (W 21.8 L – R3/8 L))	3.1	3.1091

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 – 1375 – 5465	95	3.0913
16 mm	145	180	2.30 – 3300 – 7885	100	3.0914
19 mm	170	300	3.84 – 3300 – 13115	130	3.0915
22 mm	171	400	5.12 – 4400 – 26195	145	3.0916

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 – 1375 – 5465	95	3.1013
16 mm	145	180	2.30 – 3300 – 7885	100	3.1014
19 mm	170	300	3.84 – 3300 – 13115	130	3.1015
22 mm	171	400	5.12 – 4400 – 26195	145	3.1016

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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 2000 °C without oxygen, as well as for warming up, shrinking and flame cleaning

Product Profile

KEY FEATURES

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

TECHNICAL DATA

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

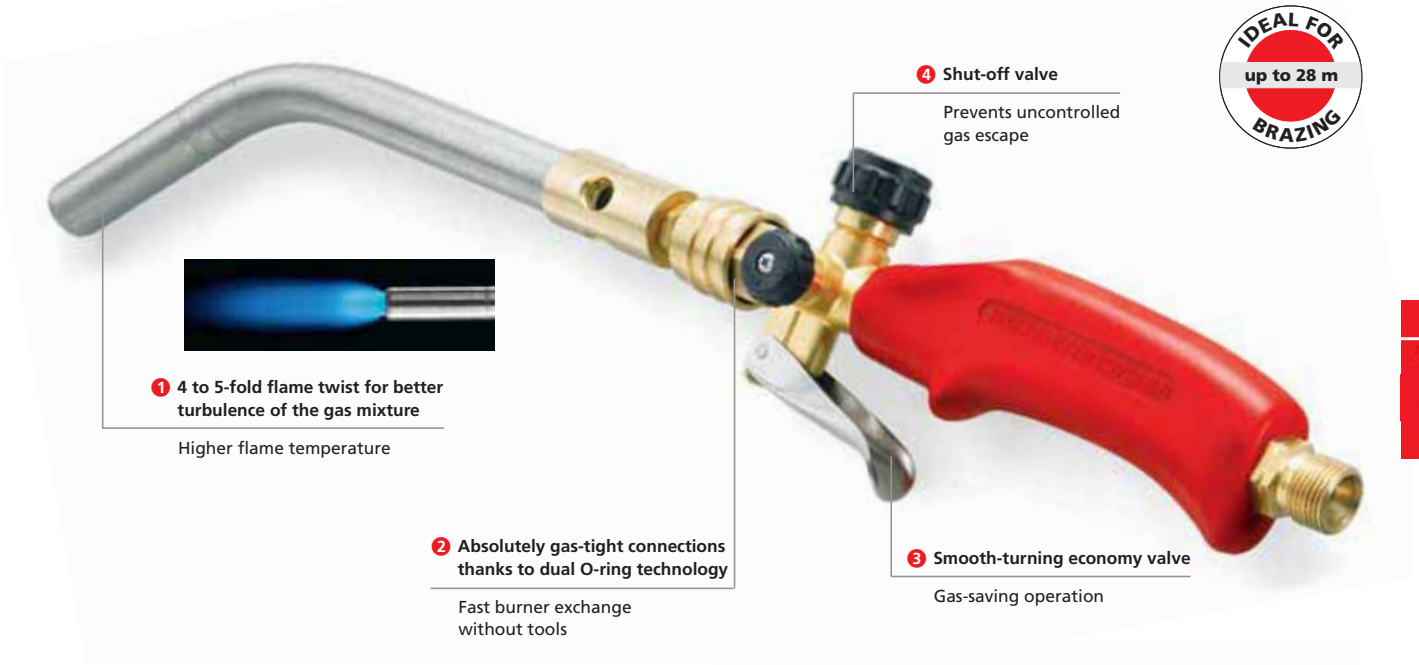

Fig. TURBOPROP torch with push-in nipple

Fig. TURBOPROP Set

Sets include: Safety handle with push-in coupling (No. 3.1009), brazing burner with push-in nipple Ø 14 mm (No. 3.1013) / Ø 16 mm (No. 3.1014) / Ø 19 mm (No. 3.1015), 2.5 m propane hose with 3/8" L coupling (No. 3.2201), safety igniter (No. 3.2077), replacement flints (No. 3.2088), open-ended spanner (No. 3.2073), steel case (No. 3.1005)

Model	g	No.
TURBOPROP-Set without propane regulator	2870	3.1090
TURBOPROP-Set with propane regulator (as in set (No. 3.1090) but with regulator (No. 3.2081E) (W 21.8 L – R 3/8 L))	3120	3.1094
TURBOPROP-Set with propane regulator (as in set (No. 3.1090) but with regulator (No. 3.2083) (POL 7/8 L – R 3/8 L))	3120	3.1037
TURBOPROP-Set with propane regulator (as in set (No. 3.1090) but with regulator (No. 3.2084) (W 20 x 14 L – R 3/8 L))	3120	3.1036

TURBOPROP Brazing Burner with push-in nipple

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
10 mm	165	70	1.89 – 770 – 3050	70	3.1031
12 mm	175	110	1.41 – 1210 – 4815	90	3.1032
15 mm	195	180	2.30 – 1980 – 7855	110	3.1033
18 mm	230	240	3.07 – 2640 – 10485	160	3.1034
24 mm	270	450	5.75 – 4950 – 19640	230	3.1035

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Universal Soft Soldering Torches

GAS-FIRED Soldering Irons

Professional soldering iron for the highest demands

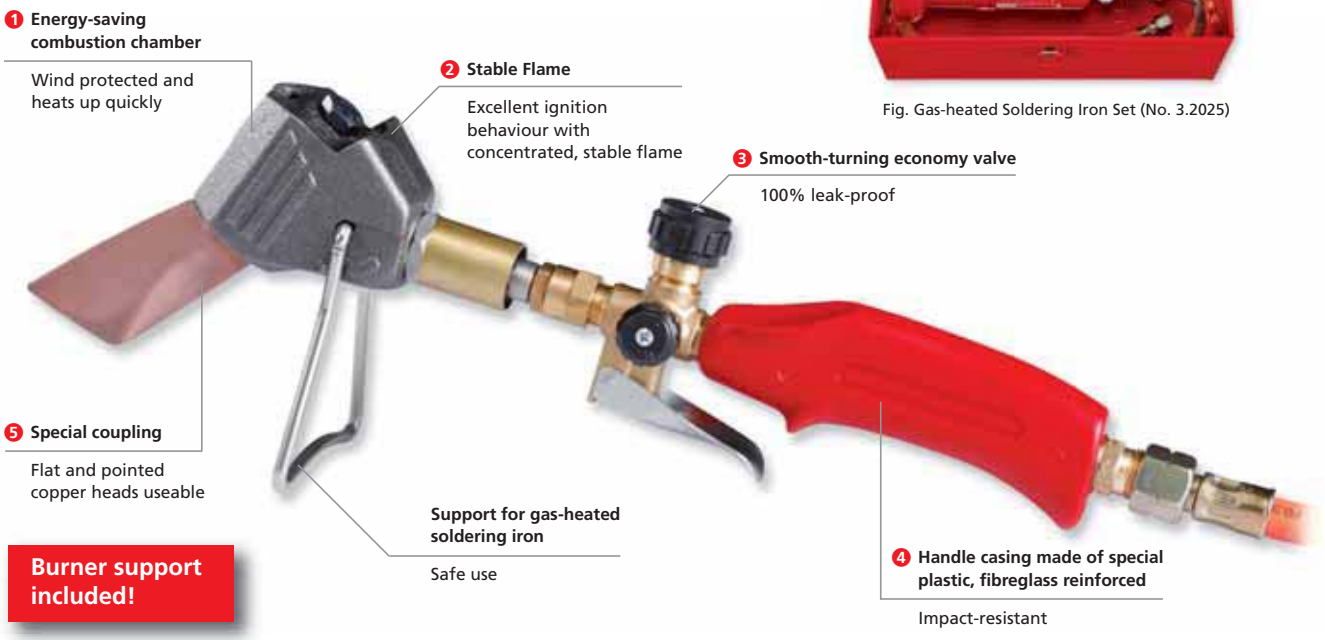
Ideal for soft soldering in corners, edges, joints and channels

Product Profile

KEY FEATURES

1. Wind protected and heats up quickly
2. Excellent ignition behaviour with concentrated, stable flame
3. 100% leak-proof with the shut-off valve
4. Impact-resistant, extremely robust and durable, with small dimensions
5. Flat and pointed copper heads useable

Fig. Gas-heated Soldering Iron Set (No. 3.2025)



Burner support included!

Model	kg	No.
Gas-heated Soldering Irons	0.7	**3.2040**
Gas-heated Soldering Irons (No. 3.2048), Copper head, flat 350 g (No. 3.2042)		
Gas-heated Soldering Irons - Set	1.0	**3.2030**
Safety handle with M 14 x 1 coupling (No. 3.1989),Gas-heated Soldering Irons (No. 3.2048), Copper head, flat 350 g (No. 3.2042)		
Gas-heated Soldering Irons - Set	1.3	**3.2029**
Safety handle with M 14 x 1 coupling (No. 3.1989), Gas-heated Soldering Irons (No. 3.2048), Copper head, flat 350 g (No. 3.2042), 2.5 m Propane hose (No. 3.2201)		

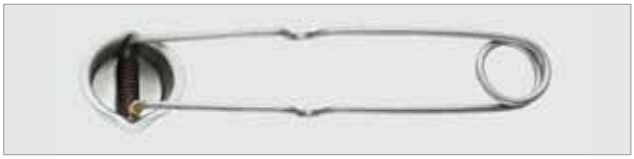
Model	kg	No.
Gas-heated Soldering Irons - Set in case	5.7	**3.2025**
Safety handle with M 14 x 1 coupling (No. 3.1989), Gas-heated Soldering Irons (No. 3.2048), copper head, flat 350 g (No. 3.2042), 2.5 m propane hose (No. 3.2201), open-ended spanner (No. 3.2073), safety igniter (No. 3.2077), replacement flints (No. 3.2079), propane regulator (No. 3.2082), refilling adaptor (No. 3.2207), small propane cylinder 0.5 kg (No. 3.3079), burner spanner (No. 3.5530), steel case (No. 3.5487)		

No. 3.2043 No. 3.2042 No. 3.2041 No. 3.2044

Special Copper Heads

Made of cathode copper for gas-fired soldering irons

Model	g	No.
Copper Head 250 g flat	250	**3.2041**
Copper Head 350 g flat	350	**3.2042**
Copper Head 450 g flat	450	**3.2043**
Copper Head 350 g pointed	350	**3.2044**



ACCESSORIES

Description			No.
Safety lighter	1	201	**3.2077**

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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.)

TECHNICAL DATA

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

Fig. Multi 300 PROPAN Soft Soldering Kit

No. 3.5489

3-part set (No. 3.5489) includes: Soft soldering iron copper head with 350 g flat (No. 52.0849), 2 m propane hose (No. 3.0927), small propane cylinder 0.5 kg with hook (No. 3.3079)

13-part set (No. 3.5488) includes: Soft soldering iron with copper head 350 g flat (No. 52.0849), soft soldering burner Ø 17 mm (No. 52.0856) / Ø 20 mm (No. 52.0857), wide burner 45 mm (No. 52.0845), propane regulator 0-6 bar (No. 3.2082), 2 m propane hose (No. 3.0927), small propane cylinder 0.5 kg with hook (No. 3.3079), refilling adaptor (No. 3.2207), burner spanner (No. 3.5530), open-ended spanner (No. 3.2073), safety igniter (No. 3.2077), replacement flints (No. 3.2088), steel case (No. 3.5487)

Model	kg	No.
MULTI 300 / Kit A without propane regulator	4.1	3.5486
MULTI 300 / Kit A with propane regulator (No. 3.2082)	4.3	3.5489
MULTI 300 / Kit B	9.0	3.5488

ACCESSORIES

No. 52.0849

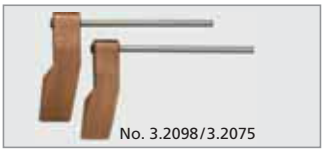
No. 52.0850

No. 52.0865

No. 52.0866

No. 52.0867

No. 3.2099/3.2076


No. 3.2098/3.2075

No. 52.0855

No. 52.0857

No. 52.0845

No. 3.0927

Description	g	No.
Soft Soldering iron with handle, iron burner, Iron Holder, wind protector, copper head 350 g	940	52.0849
Soft Soldering iron with handle, iron burner, Iron Holder, wind protector, without copper head	570	52.0840
Handle with hose coupling M 10 x 1 L 300	300	52.0850
Iron Burner with coupling M 15 x 1	70	52.0865
Iron Holder with foot	100	52.0866
Wind protector	100	52.0867
Copper Head 250 g pointed	270	3.2099
Copper Head 350 g pointed	370	3.2076

Description	g	No.
Copper Head 250 g flat	270	3.2098
Copper Head 350 g flat	270	3.2075
Soft soldering burner size 3 Ø 12 mm, M 15 x 1	370	52.0855
Soft soldering burner size 5, Ø 17 mm, M 15 x 1	70	52.0856
Soft soldering burner size 7, Ø 20 mm, M 15 x 1	120	52.0857
Wide burner Ø 45 mm, M 15 x 1	120	52.0845
Steel case	3390	3.5487
Burner spanner	60	3.5530
Safety igniter with rolling file	60	3.2077
Replacement flints, tin with 5 pieces	15	3.2088

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Propane Warming-Up Torch

ROOFING-SET

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

Product Profile

APPLICATION AREA

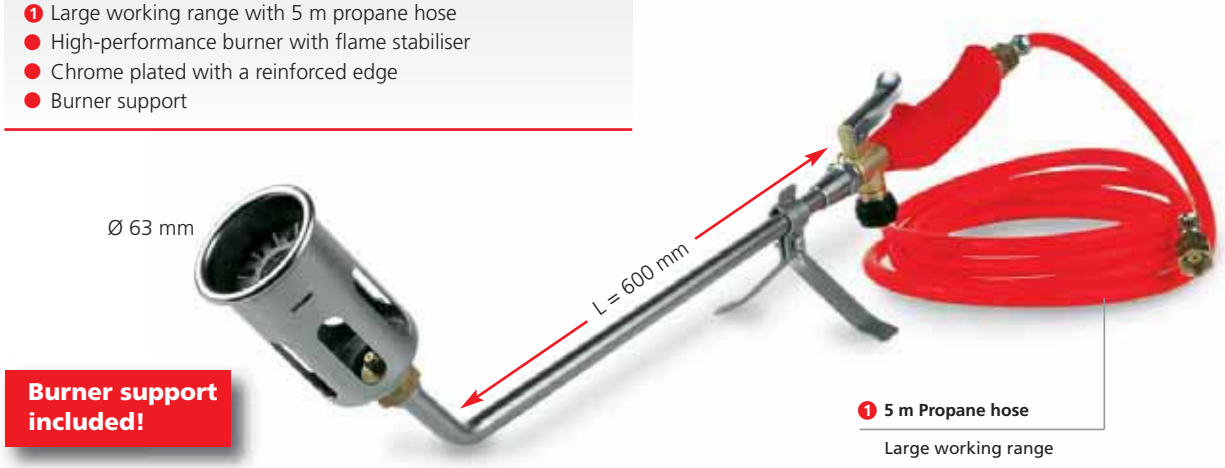
Ideal for roofing and asphalt work and for bonding of bituminous sheeting, large-scale burning of weeds, defrosting, insulation, shrinking, drying and warming up.

KEY FEATURES

- 1 Large working range with 5 m propane hose
- High-performance burner with flame stabiliser
- Chrome plated with a reinforced edge
- Burner support

TECHNICAL DATA

600 mm burner tube
Burner support



Burner support included!

5-part set (No. 3.0954E) includes: Propane handle (No. 3.0910D), 63 mm high-performance burner (No. 3.2163), 600 mm burner tube (No. 3.2160), 5.0 m propane hose (No. 3.2203), burner support (No. 3.2213)

Model	g	No.
Roofing-Set	1920	3.0954E
Burner support	60	3.2213

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.
60	80	3.2105	350	190	3.2135
100	90	3.2110	600	290	3.2160
200	120	3.2120	750	470	3.2175

Surface-heating Burner Heads

High-efficiency burner 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 – 27500 – 109280	240	3.2045
51	112	3800	48.60 – 41800 – 165970	270	3.2051
57	Surface-heating burner heads, closed				see page 187
63	138	6700	85.70 – 73700 – 292670	440	3.2063

Ideal for roofing and asphalt work

600 mm burner tube with support and 5.0 m propane hose

Improved ergonomics for fatigue-free work

High-performance burner with flame stabiliser

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Closed Warming-up Burner Heads

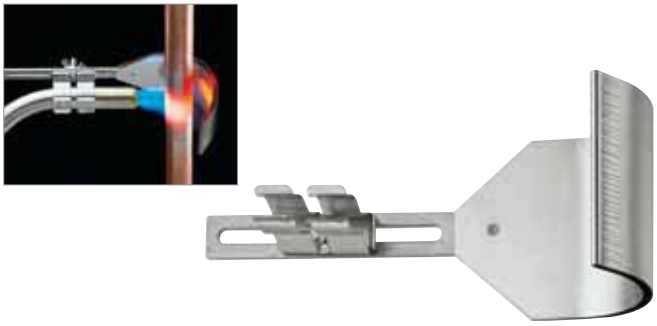
High-efficiency burner heads with flame stabilisers, closed and not sensitive to wind. Made of special chrome plated steel, with reinforced edge. For warming up, shrinking, insulating, hardening general repair work, etc. Threaded M 20 x 1 coupling

mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
45	102	2500	32.00 – 27500 – 109280	240	3.2111
51	112	3800	48.60 – 41800 – 165970	270	3.2112
57	126	5500	70.35 – 60500 – 240257	350	3.2113
63	138	6700	85.70 – 73700 – 292670	440	3.2114

Flame Reflectors

- Made of high-quality stainless steel
- Protects surrounding materials
- For pipe soldering, to mount onto burner
- Better heat utilisation, saves time and energy
- Even warming of the pipe

Model	Width mm	Coupling Ø mm	g	No.
65 / 15	65	8 – 15	100	3.1042
65 / 22	65	15 – 22	100	3.1043



Safety Propane Handles

With economy, regulating and shut-off valves, hose coupling R 3/8" L

Model	g	No.
Safety handle with push-in coupling	350	3.1009
Safety handle with M 14x1 coupling	290	3.1989
Repair kit with shut-off valve, complete	10	3.0101
Repair kit with regulating valve, complete	10	3.0102
Repair kit for economy valve, complete	10	3.0103

No. 3.1009

No. 3.1989

Propane Regulators

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

Inlet	Outlet	Working pressure Bar	Consumption kg/h	g	No.
W 21.8 x 1/14" L	R 3/8" L	0,5 - 4.0	8	240	3.2081E
R 3/8" L	R 3/8" L	0.5 - 4.0	8	200	3.2082
W 21.8 x 1/14" L	R 3/8" L		10	270	3.2100
W 21.8 x 1/14" L	R 3/8" L		8	230	3.0925

No. 3.2081

No. 3.2082

No. 3.0925

No. 3.2100 with pressure gauge

Propane Hoses

Top quality, DIN / DVGW tested, with strong inlay, durable and flexible, mounted with sleeves and nuts in middle (DK 6) or high-pressure (DK 30) versions

m	Inlet	Outlet	Pressure-class	Inner-Ø mm wall thickness	g	No.
2	R 3/8" L	M 10 x 1 L	DK 6	4.0 x 3.5	310	3.0927
2.5	R 3/8" L	R 3/8" L	DK 6	4.0 x 3.5	350	3.2201
5	R 3/8" L	R 3/8" L	DK 30	4.0 x 4.0	730	3.3310
10	R 3/8" L	R 3/8" L	DK 30	6.3 x 5.0	1650	3.2223

No. 3.0927

No. 3.2223

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Propane Accessories

No. 3.2207

Refilling Adaptor

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

Inlet	Outlet	g	No.
W 21.8 x 1/14" L	R 3/8" L	160	3.2207

No. 3.5925

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	Consumption kg/h	Pressure - class	g	No.
R 3/8" L	R 3/8" L	10	blue	130	3.5925

No. 3.0925

Propane Constant Regulator

Adjusted to 4.0 bar, for connecting to 5 and 11 kg cylinders

Inlet	Outlet	Consumption kg/h	g	No.
W 21.8 x 1/14" L	R 3/8" L	8	230	3.0925

No. 3.2100

Propane Regulator with Pressure Gauge

Adjustable from 0.5 - 4 bar, for connection to 5 and 11 kg cylinders

Inlet	Outlet	Consumption kg/h	g	No.
W 21.8 x 1/14" L	R 3/8" L	10	270	3.2100

No. 3.3079

With 0.5 kg cylinder
Protective collar included in delivery

No. 3.1081

Propane Lightweight Steel Cylinder

With cylinder valve, TÜV tested, according to TRG

Model	Outlet	Contents	kg	No.
Small cylinder, 0.5 kg with foot	R 3/8"	empty	2.75	3.3079
Cylinder 5 kg, with foot and cap		filled	12.60	3.1081
W 21.8 x 1/14" L				
Collar				3.5636

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ALLGAS 2000

Mobile soldering and welding torch

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

Product Profile

KEY FEATURES

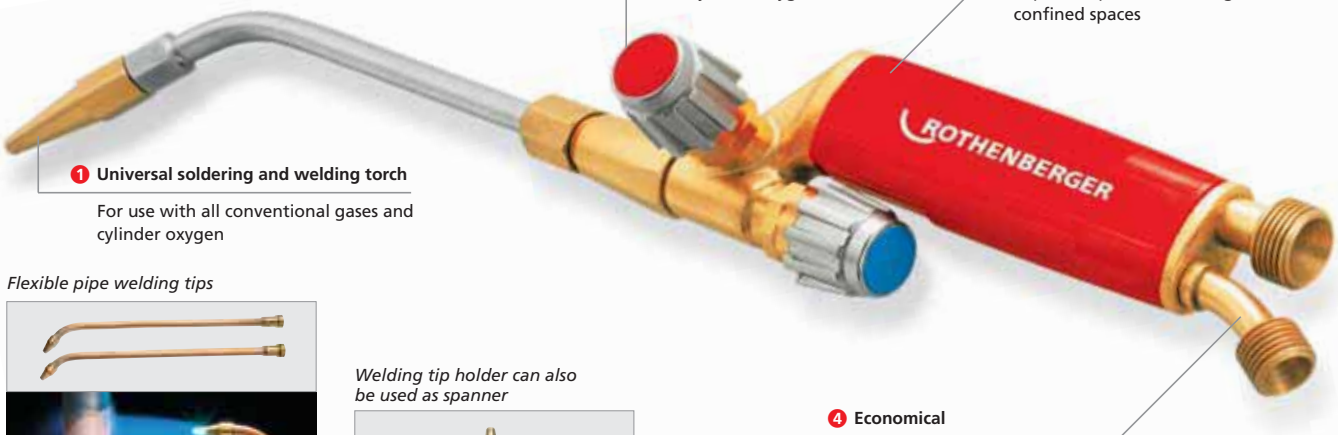
1. For use with all conventional gases and cylinder oxygen
2. Practically complete emptying of gas cylinders (money-saving)
3. Super compact for working in confined spaces
4. Efficient and economical professional use

TECHNICAL DATA

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

Suitable for use with the following gases:

- Oxy-Acetylene
- Propane with oxygen
- CNG and oxygen
- Town gas and oxygen



2 Low gas pressure of only 0.2 bar

Practically complete emptying of gas cylinders (money saving) for use with all conventional gases and cylinder oxygen

3 Small, very light handle (280 g)

Super compact for working in confined spaces

1 Universal soldering and welding torch

For use with all conventional gases and cylinder oxygen

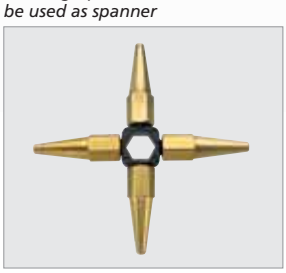
4 Economical

Efficient and economical professional use

Flexible pipe welding tips

Dispersion nozzle for warming up

Welding tip holder can also be used as spanner



Model	Coupling oxygen	Coupling fuel gas	g	No.
Allgas 2000 set			3100	3.5300
Handle ALLGAS 2000	R 1/4"	R 3/8" L	280	3.5303
Mixing nozzle with union nut			40	3.5304

Welding tips, Welding attachments

Size	Brazing range mm	g	No.
Size 1	0.2 - 1.0	10	3.5305
Size 2	1.0 - 2.0	10	3.5306
Size 3	2.0 - 3.0	10	3.5307
Size 4	3.0 - 4.0	10	3.5308
Size 5	4.0 - 5.0	10	3.5309
Dispersion nozzle for warming up	20		3.5311
Welding tip holder, can be used as a spanner		20	3.5312
Size 1	2.0 - 3.0	40	3.5313
Size 2	4.0 - 5.0	40	3.5314
Coupling / union nut, size 14	10		3.5315

You will find further accessories on 200

Fig. ALLGAS 2000 Set

20-part set (No 3.5300) includes: Handle (No. 3.5303), mixing nozzle with union nut (No. 3.5304), 5 welding tips Ø 0.2 mm (No. 3.5305) / Ø 1 - 2 mm (No. 3.5306) / Ø 2 - 3 mm (No. 3.5307) / Ø 3 - 4 mm (No. 3.5308) / Ø 4 - 5.0 mm (No. 3.5309), pipe welding tips, size 1 (No. 3.5313) / size 2 (No. 3.5314), coupling nut size 14 (No. 3.5315), dispersion nozzle (No. 3.5311), 2.5 m dual-hose package (No. 3.5221), open-ended spanner size 14 x 19 mm (No. 3.2073), welding tip holder / spanner (No. 3.5312), safety igniter (No. 3.2077), replacement flints (No. 3.2088), steel case (No. 3.5319)

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Mobile Brazing Equipment

ALLGAS 2000 PS 0.5 / 2 Compact

Portable fitter's brazing equipment

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

Product Profile

KEY FEATURES

- Portable, light fitter's brazing equipment
- Ideal for mobile building-site and repair use
- Small propane cylinders can be refilled

TECHNICAL DATA

Transport secure:	In compliance with DIN EN 962, BGV D34,
Gas:	Propane with oxygen
Flame temperature:	2850 °C
Working temperature:	1150 °C

Carrying comfort

22-part set (No. 3.5655) includes: Handle Allgas 2000 (No. 3.5303), 2.5 m propane hose (No. 3.2201), 2.5 m oxygen hose (No. 3.5210), propane regulator adjustable 0 - 6 bar (No. 3.2082), oxygen pressure reducer 10 bar (No. 3.5634), mixing nozzle with union nut (No. 3.5304), welding tips 0.2-1 mm (No. 3.5305) / 1 - 2 mm (No. 3.5306) / 2 - 3 mm (No. 3.5307) / 3 - 4 mm (No. 3.5308) / 4-5 mm (No. 3.5309), pipe-welding tips, flexible size 1 (No. 3.5313) / size 2 (No. 3.5314), dispersion nozzle (No. 3.5311), welding tip holder / spanner (No. 3.5312), multi-size spanner (No. 3.5738), safety igniter (No. 3.2077), replacement flints (No. 3.2088), nylon safety goggles (No. 54.0620), small propane cylinder 0.5 kg, empty (No. 3.3079), steel oxygen cylinder 2.0 l, full (No. 3.5635), carrying frame (No. 3.5629)

The bottle colours shown are without obligation!

Model	kg	No.
Allgas 2000 PS 0.5 / 2 Set	21.4	3.5655
Carrying frame without accessories	10.3	3.5629

You will find further accessories on 200

ALLGAS 2000 Welding Tips

No. 3.5304

No. 3.5312

No. 3.5311

Welding Tips

Size	Welding range mm	g	No.
Size 1	0.2 - 1.0	10	3.5305
Size 2	1.0 - 2.0	10	3.5306
Size 3	2.0 - 3.0	10	3.5307
Size 4	3.0 - 4.0	10	3.5308
Size 5	4.0 - 5.0	10	3.5309
Dispersion nozzle for warming up		20	3.5311
Welding tip holder can be used as spanner		20	3.5312

Pipe-welding Tips, flexible

Size	Welding range mm	g	No.
Size 1	2,0 - 3,0	40	3.5313
Size 2	4,0 - 5,0	40	3.5314
Coupling / union nut, size 14		10	3.5315

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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

The bottle colours shown are without obligation!

18-part set (No. 3.5651) includes: Handle Allgas 2000 (No. 3.5303), 2.5 m propane hose (No. 3.2201), 2.5 m oxygen hose (No. 3.5210), propane regulator adjustable 0 - 6 bar (No. 3.2082), oxygen pressure reducer 10 bar (No. 3.5634), mixing nozzle with union nut (No. 3.5304), welding tips 0.2 - 1 mm (No. 3.5305) / 1 - 2 mm (No. 3.5306) / 2 - 3 mm (No. 3.5307) / 3 - 4 mm (No. 3.5308) / 4 - 5 mm (No. 3.5309), welding tip holder / spanner (No. 3.5312) multi-size spanner (No. 3.5738), safety igniter (No. 3.2077), replacement flints (No. 3.2088), steel oxygen cylinder 2.0 l, filled (No. 3.5635) Allgas stand (No. 3.5628)

Model	kg	No.
Allgas 2000 PS 0.5 / 2 Set	14.4	3.5651
Allgas 2000 PS 0.5 / 2 Set	14.4	3.5652

You will find further accessories on 200

Set (No. 3.5652) includes: As in set (No. 3.5651), additionally oxygen pressure reducer (No. 3.5677), oxygen cylinder 2 l (No. 3.5770), welding tips 2 - 3 (No. 3.5313), welding tips 4 - 5 (No. 3.5314), dispersion nozzle (No. 3.5311), nylon safety goggles (No 54.0620), carrying frame Allgas (No. 3.5629) The following articles are not included in set: (No. 3.5635), (No. 3.5305), (No. 3.5628), (No. 3.5634), (No. 9.4044), (No. 9.1929), (No. 9.1930), (No. 9.2778)

ROXY 400 L

Standard gas-welding equipment for flame temperatures up to 3100 °C

The bottle colours shown are without obligation!

20-part set (No. 3.5780) includes: Handle with fine regulating valve (No. 3.5580), Maxigas 400 (No. 3.5570), oxygen cylinder 2.0 L (No. 3.5635), fine regulating valve (No. 3.5723), oxygen pressure reducer according to DIN 0-315 / 200 bar 0-16 / 10 bar (No. 3.5634), oxygen hose (No. 3.5410), propane hose (No. 3.5525), oxygen blowback protection (No. 3.5678), gas blowback protection (No. 3.5691), mixing nozzle with union nut (No. 3.5587), high-performance tips 1.5 mm (No. 3.5422) / 2.0 mm (No. 3.5423), micro-tips 0.3 mm (No. 3.5712) / 0.5 mm (No. 3.5696) / 0.7 mm (No. 3.5713), micro-tip adaptor (No. 3.5585), welding goggles A5 (No. 3.5621), safety igniter (No. 3.2077), multi-size spanner (No. 3.5738) carrying frame (No. 3.5727)

Model	kg	No.
Roxy 400 L Set	10.8	3.5780
Accessories		
Roxy welding handle Profi	0.01	3.5580
Roxy hose package (including handle and 1.5 m hose)	0.60	3.3301
Dual hose kit (3 m without handle)	0.95	3.5421E

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No. 3.5480

No. 3.5324

RE 17 UNIVERSAL Set

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

Set (No. 3.5479) includes: Handle with coupling nut (No. 3.5324), welding tips 2 - 4 mm (No. 3.5327) / 4 - 6 mm (No. 3.5328) / 6 - 9 mm (No. 3.5329), pipe-welding tips 2 - 4 mm (No. 3.5347) / 4 - 6 mm (No. 3.5348), wing-lever cutting attachment (No. 3.5338), Cutting tip 3 - 25 mm (No. 3.5341), Heating nozzle 3 - 100 mm (No. 3.5339), Nozzle cleaning set, 10 piece (No. 51.0105), burner spanner (No. 51.0106), safety igniter (No. 3.2077), replacement flints (No. 3.2088), steel case (No. 3.5800)

Nominal size	kg	No.
RE 17 Pipe-welding kit	4.3	3.5479
RE 17 Universal kit	4.8	3.5480
As in set (No. 3.5479), but also including with welding tips 0.5-1 mm (No. 3.5325) / 1-2 mm (No. 3.5326), cutting tip 25-50 mm (No. 3.5341) / 25-50 mm (No. 3.5344)		
Steel case RE 17 (empty)	1.70	3.5800
RE 17 handle with burner coupling nut	0.47	3.5324
Coupling: oxygen R 1/4", gas R 3/8" L		

RE 17 Welding Tips

Welding range mm	kg	No.
0.5 – 1	140	3.5325
1 – 2	150	3.5326
2 – 4	170	3.5327
6 – 9	220	3.5329
9 – 14	260	3.5334
14 – 20	280	3.5335

Pipe-welding tip - front piece

Pipe-welding tip - complete

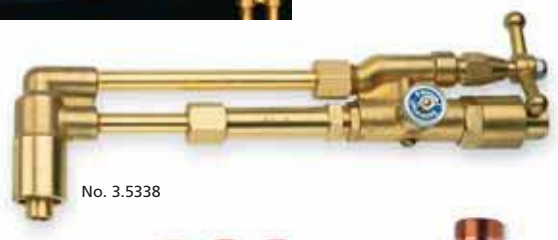
RE 17 Pipe-welding Tips, flexible

Pipe-welding tips

Welding range mm	g	No.
1 - 2	40	3.5346
2 - 4	40	3.5347
4 - 6	50	3.5348

Flexible copper tips

Welding range mm	g	No.
1 - 2	130	3.5475
2 - 4	140	3.5476
4 - 6	150	3.5477



No. 3.5338

No. 3.5341
No. 3.5344
No. 3.5345

No. 3.5339

RE 17 Wing-lever Cutting Attachment

Model	g	No.
Cutting Attachment without tips	820	3.5338

RE 17 Cutting Tips and Heating Nozzle

Model	Cutting range mm	g	No.
Cutting Tip	3 - 25	10	3.5341
Cutting Tip	25 - 50	20	3.5344
Cutting Tip	50 - 100	20	3.5345
Heating Nozzle	3 - 100	50	3.5339

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RE 17 UNIVERSAL THREE-GAS System AMS 5/5

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

27-part set (No. 3.5401) includes: Handle with coupling nut (No. 3.5324), welding tips 0.5 - 1 mm (No. 3.5325) / 1 - 2 mm (No. 3.5326) / 2 - 4 mm (No. 3.5327) / 4 - 6 mm (No. 3.5328) / 6 - 9 mm (No 3.5329) / 9 - 14 m (No. 3.5334), wing-lever cutting attachment (No. 3.5338), cutting tips 3-25 mm (No. 3.5341) / 25 - 50 mm (No. 3.5344), heating nozzle 3-100 mm (No. 3.5339), 5 m dual-hose package A / S (No. 3.5222), acetylene pressure reducer 1.5 bar (No. 3.5794), oxygen pressure reducer 10 bar (No. 3.5634), 2 each - protective rubber caps, red (No. 51.1428) / blue (No. 51.1427),10 piece nozzle cleaning set (No. 51.0105), burner spanner (No. 51.0106), safety igniter (No. 3.2077), replacement flints (No. 3.2088), acetylene cylinder 10 l (filled) (No. 3.5179), oxygen cylinder 10 l (filled) (No. 3.5189), Maxigas 400 (No. 3.5570), gas regulating valve Maxigas (No. 3.5723), hose adaptor Maxigas (No. 3.5491), steel case (No. 3.5800), dual-telescoping transport trolley (No. 3.5354)

Including gas cylinders and dual-telescoping transport trolley

The bottle colours shown are without obligation!

Model	kg	No.
RE 17 Universal Three-gas System AMS 5/5	50	**3.5400**

RE 17 UNIVERSAL THREE-GAS System AMS 5 or 10

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

25-part set (No. 3.5403) includes: Handle with coupling nut (No. 3.5324), welding tips 0.5 - 1 mm (No. 3.5325) / 1 - 2 mm (No. 3.5326) / 2 - 4 mm (No. 3.5327) / 4 - 6 mm (No. 3.5328) / 6 - 9 mm (No 3.5329) / 9 - 14 m (No. 3.5334), wing-lever cutting attachment (No. 3.5338), cutting tips 3-25 mm (No. 3.5341) / 25 - 50 mm (No. 3.5344), heating nozzle 3-100 mm (No. 3.5339), 5 m dual-hose package A / S (No. 3.5222), acetylene pressure reducer 1.5 bar (No. 3.5794), oxygen pressure reducer 10 bar (No. 3.5634), 2 each - protective rubber caps, red (No. 51.1428) / blue (No. 51.1427),10 piece nozzle cleaning set (No. 51.0105), burner spanner (No. 51.0106), safety igniter (No. 3.2077), replacement flints (No. 3.2088), Maxigas 400 (No. 3.5570), gas regulating valve Maxigas (No. 3.5723), hose adaptor Maxigas (No. 3.5491), steel case (No. 3.5800), dual-telescoping transport trolley (No. 3.5354)

Including gas cylinders and dual-telescoping transport trolley

The bottle colours shown are without obligation!

Model	kg	No.
RE 17 Universal Three-gas System AMS 5 + 10	23	**3.5403**

RE 17 UNIVERSAL THREE-GAS System AMS 10/10

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

27-part set (No. 3.5401) includes: Handle with coupling nut (No. 3.5324), welding tips 0.5 - 1 mm (No. 3.5325) / 1 - 2 mm (No. 3.5326) / 2 - 4 mm (No. 3.5327) / 4 - 6 mm (No. 3.5328) / 6 - 9 mm (No 3.5329) / 9 - 14 m (No. 3.5334), wing-lever cutting attachment (No. 3.5338), cutting tips 3-25 mm (No. 3.5341) / 25 - 50 mm (No. 3.5344), heating nozzle 3 - 100 mm (No. 3.5339), 5 m dual-hose package A / S (No. 3.5222), acetylene pressure reducer 1.5 bar (No. 3.5794), oxygen pressure reducer 10 bar (No. 3.5634), 2 each - protective rubber caps, red (No. 51.1428) / blue (No. 51.1427),10 piece nozzle cleaning set (No. 51.0105), burner spanner (No. 51.0106), safety igniter (No. 3.2077), replacement flints (No. 3.2088), acetylene cylinder 10 l (filled) (No. 3.5179), oxygen cylinder 10 l (filled) (No. 3.5189), Maxigas 400 (No. 3.5570), gas regulating valve Maxigas (No. 3.5723), hose adaptor Maxigas (No. 3.5491), steel case (No. 3.5800), dual-telescoping transport trolley (No. 3.5354)

Including gas cylinders and dual-telescoping transport trolley

- No. 3.5798 as in 3.5401 for cutting range 3.0 - 25 mm
- No. 3.5799 like 3.5401 without cylinders

The bottle colours shown are without obligation!

Model	kg	No.
RE 17 Universal Three-gas System AMS 10 / 10	66	**3.5401**
RE 17 as in 3.5401, cutting range 3.0 - 25 mm	65	**3.5798**
RE 17 without cylinder	23	**3.5799**

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ROFLASH-Set

Welding and cutting kit
Welding range: 0.5 - 14 mm, Cutting range: 3 - 75 mm

22-part set (No. 51.3300) includes: Handle (No. 51.3010), welding tips 0.2 - 0.5 (No. 51.3030), 0.5 - 1 (No. 51.3031),1 - 2 (No. 51.3032), 2 - 4 (No. 51.3033), 4 - 6 (No. 51.3034), 6 - 9 (No. 51.3035), 9 - 14 (No. 51.3036), spring-lever cutting attachment (No. 51.3310), cutting tips 3 - 6 (No. 51.3330), 6 - 20 (No. 51.3331), 20 - 75 (No. 51.3332), cutting burner guiding wagon, burner spanner (No. 51.0106), nylon safety goggles (No. 54.0621), 10 piece nozzle cleaning set (No. 51.0105), hose nozzle R 1/4" 4 mm (No. 54.0221), hose nozzle R 3/8" 4 mm (No. 54.0222), hose nozzle R 3/8" 6 mm (No. 54.0223), coupling nut R 1/4" (No. 54.0210), coupling nut R 3/8" (No. 54.0215)

Model	kg	No.
ROFLASH Set	4.2	51.3300

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	51.3010

ROFLASH Spring-lever Cutting Attachment

KEY FEATURES

- Less repair costs through the kit system and maintenance-free monoblock valve
- The solid burner is made from forged brass and can withstand the highest thermal demands and also enables use under extreme conditions

Model	g	No.
ROFLASH Spring-lever Cutting Attachment	582	51.3310

ROFLASH Welding Tips

O2-Consumption	Material thickness (mm)	g	No.
approx. 40 l / h	0.2 - 0.5	96	51.3030
approx. 80 l / h	0.5 - 1.0	96	51.3031
approx. 160 l / h	1.0 - 2.0	104	51.3032
approx. 315 l / h	2.0 - 4.0	117	51.3033
approx. 500 l / h	4.0 - 6.0	128	51.3034
approx. 800 l / h	6.0 - 9.0	148	51.3035
approx. 1250 l / h	9.0 - 14.0	171	51.3036

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AIRAC®

Acetylene brazing torch up to Ø 60 mm with 2350 °C flame temperature

High-performance injection burner - only for acetylene - for brazing / warming up of copper and steel pipes up to Ø 60 mm.

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

KEY FEATURES

- Scale build-up on the treated surface is prevented by the nitrogen that is introduced into the air flow (shielding gas effect)
- 1 Maximal performance with the turbine and combustion chamber effect
- 2 Shut-off valve prevents uncontrolled gas leaks
- 3 Gas-saving use with the smooth-running economy valve

12-part set (No. 3.1093) includes: Safety handle (No. 3.4991), brazing burner size 2 (No. 3.5022) / size 3 (No. 3.5023) / size 4 (No. 3.5024), 2.5 m acetylene hose (No. 3.5203), bend with nut 150 mm (No. 3.5110), burner spanner 14 x 19 mm (No. 3.2073), safety igniter (No. 3.2077), replacement flints (No. 3.2079), steel case (No. 3.5005)

Model	kg	No.
AIRAC® Brazing Set in steel case	2,9	3.1093
You will find further accessories on 📖 **200**		

Fig. AIRAC® Set

AIRAC® Safety Handle

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

Model	g	No.
Safety Handle	290	3.4991
Repair kit for shut-off valve, complete	10	3.0101
Repair kit for regulating valve, complete	10	3.0102
Repair kit for economy valve, complete	10	3.0103

AIRAC® Brazing Torch

Made of surface-handled brass, stable and concentrated flame

Model	Pipe Ø	g	No.
Bend with nut (150 mm)		80	3.5110
Size 2	12 - 15	40	3.5022
Size 3	18 - 22	50	3.5023
Size 4	28 - 35	70	3.5024

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Accessories for Gas Welding

Oxy-Acetylene Hoses

Top quality in accordance with DIN 8541, with strong inlay, durable and flexible, rubber, mounted with sleeves and nuts

DIN -Norm

Oxygen Hoses

L m	Inlet	Outlet	Internal Ø x wall thickness mm	kg	No.
5	R 1/4"	R 1/4"	6.0 x 3.5	1.1	3.3311
10	R 1/4"	R 1/4"	6.0 x 3.5	1.9	3.3314

Acetylene Hoses

L m	Inlet	Outlet	Internal Ø x wall thickness mm	kg	No.
2.5	R 3/8"	R 3/8" L	6.0 x 3.5	0.5	3.5203
5	R 3/8"	R 3/8" L	6.0 x 3.5	1.1	3.3312
10	R 3/8"	R 3/8" L	6.0 x 3.5	1.9	3.3315

Dual Hoses A/S

L m	Coupling Oxygen	Coupling Outlet	Internal Ø x wall thickness Oxygen / Acetylene	kg	No.
2.5	R 1/4"	R 3/8" L	6.0 x 3.5	0.9	3.5221
5	R 1/4"	R 3/8" L	6.0 x 3.5	2.0	3.5222
10	R 1/4"	R 3/8" L	6.0 x 3.5	3.8	3.5223
40*	R 1/4"	R 3/8" L	6.0 x 3.5	9.1	3.5230

*40 m hose without sleeves and nuts

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	0.67 l	200	400	80	2.5	3.5736
Oxygen	2 l	200	420	110	4.6	3.5635
Oxygen	5 l	200	595	145	14.0	3.5188
Oxygen	10 l	200	980	145	17.0	3.5189
Acetylene	5 l	18	595	145	13.0	3.5178
Acetylene	10 l	18	980	145	23.0	3.5179

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	8.9	3.5354
5 / 10 l acetylene / oxygen cylinders		
Conversion kit for adaption of		3.5342
Propane 0.5 kg / oxygen 5 l and 10 l cylinders		
Propane 5 kg		3.5343

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Cylinder Pressure Reducer

Rugged pressed brass construction with large pressure gauge according to **DIN 8549** (Ø 63 mm), with shut-off and safety valves, one-stage design according to **DIN 8546** with test mark

DIN -Norm

Cylinder contents bar	Working pressure bar	Inlet	Abgang	kg	No.
Oxygen					
0 - 315 / 200	0 - 16 / 10	R 3/4"	R 1/4"	1.4	3.5634
Acetylene					
0 - 40	0 - 2,5/1,5	R 3/4"	R 3/8" L	1.6	3.5794

No. 3.5634

No. 3.5794

Blowback Prevention

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

Model	max. Operating pressure	Coupling thread	g	No.
Handle-mounted, oxygen	20 bar	R 1/4"	190	54.0320
Handle-mounted, acetylene	1.5 bar	R 3/8" L	190	54.0321
Reducer-mounted, oxygen	20 bar	R 1/4"	190	54.0360
Reducer-mounted, acetylene	1.5 bar	R 3/8" L	190	54.0365

No. 54.0360

No. 54.0365

No. 54.0320

No. 54.0321

Protective Guard for Pressure Reducer

Impact protection, rugged steel construction, mounts on connection coupling

Model	Colour	g	No.
For oxygen pressure reducer	blue	820	3.5146
For acetylene pressure reducer	yellow	820	3.5140

No. 3.5146

Protective Rubber Cap

With slot, open

Model	Colour	g	No.
For oxygen pressure reducer	blue	50	51.1427
For acetylene pressure reducer	red	50	51.1428

No. 51.1428

No. 51.1427

No. 3.5140

Oxygen Refilling Bend

Model	g	No.
max. 200 bar, cylinder coupling R 3/4"	360	3.5199

Safety Igniters

Powerful spark, wear-free hard alloy friction surface

Model	g	No.
Safety Igniter with rolling file	60	3.2077
Replacement flints, tin with 5 pieces	15	3.2088

No. 3.2077

No. 3.2088

Stirrup Lighter

Description	g	No.
Stirrup Lighter, with friction roller and flint stone	50	54.0800
Replacement flints 3 x 20 mm	10	54.0801

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Accessories for Gas Welding

No. 54.0850

No. 54.0855

Hand-held Welding Mirror

Model	g	No.
Steel wire handle with clamp / ball joint	280	54.0850
Spare steel mirror	50	54.0851

Magnet Welding Mirror

Model	g	No.
With flexible metal tube / ball joint	450	54.0855
Spare steel mirror	50	54.0851

Nozzle Cleaner

Model	g	No.
10 piece, in folding case	20	51.0105

Burner Spanner

Model	g	No.
With 11 SW	210	51.0106

Soldering Flux and Container for Hydrochloric Acid

Model	g	No.
With screw cap retaining band	40	53.0250

Salmiakstone

Model	L x W x H		g	No.
Pressed	65 x 45 x 40 mm	1	15	53.0310

Soapstone Marker

Model	L x W x H		g	No.
White, heat-resistant	100 x 10 x 10 mm	10	30	56.1550

No. 54.0622

No. 54.0620

No. 54.0640

Welding Goggles

With thermal glasses **as per DIN**

DIN -Norm

Model	Glass	g	No.
Nylon safety goggles	A 4	60	54.0620
	A 5	60	54.0621
	clear, non-splintering	60	54.0622
Replacement glass (pair)	A 4	30	54.0625
	A 5	10	54.0626
	clear, non-splintering	30	54.0627
Screw-ring safety goggles	A 4	90	54.0640
	A 5	90	54.0641
Replacement glass (Ø 50 mm)	A 4	30	54.0675
	A 5	10	54.0676

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ROVLIES® Cleaning Pads

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

KEY FEATURES

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

Model			g	No.
ROVLIES®	1(10)		80	**4.5268**
ROVLIES® counter display		36(10)	2180	**4.5268D**

Internal Brushes for Copper Pipe

For fast cleaning of the soldering surface, rugged plastic handle

mm	g	No.	mm	g	No.
8	60	**85.4179**	16	120	**85.4184**
10	70	**85.4180**	18	120	**85.4185**
12	80	**85.4181**	22	140	**85.4186**
14	90	**85.4182**	28	140	**85.4187**
15	100	**85.4183**	35	160	**85.4188**

External Brushes for Copper Pipe

For fast cleaning of the soldering surface, tough housing

mm	g	No.	mm	g	No.
8	80	**85.4189**	16	130	**85.4194**
10	90	**85.4190**	18	140	**85.4195**
12	100	**85.4191**	22	150	**85.4196**
14	110	**85.4192**	28	160	**85.4197**
15	120	**85.4193**	35	170	**85.4198**

Hand Wire Brushes

Model	Number of rows	g	No.
Standard steel	3 rows	130	**56.1351**
Standard steel	4 rows	130	**56.1352**

Welding Blanket

Offers protection up to 1000 °C from welding flames and heat. Melting point of 840 °C under direct flame contact. Reduced fire hazard, also in case of long working times, protect wall coverings, cables, carpets and other flammable materials. Highly flexible, good formability enables it to be used everywhere, long service life, asbestos-free, no health risk. Packed in plastic cover.

Model	L x W x H	g	No.
Welding Blanket	330 x 500 mm	300	**3.1050**

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Electric Soft-Soldering Unit

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

KEY FEATURES

1. Soldering without open flame
2. Large working radius, also when working under ceilings
3. Comfortable transport and convenient use
4. High performance, short soldering times
5. Thermal overload protection turns device off automatically
6. Handle shell will not overheat

- Problem-free connection on every 230 V outlet, 2 m connection cable
- Fast return on investment

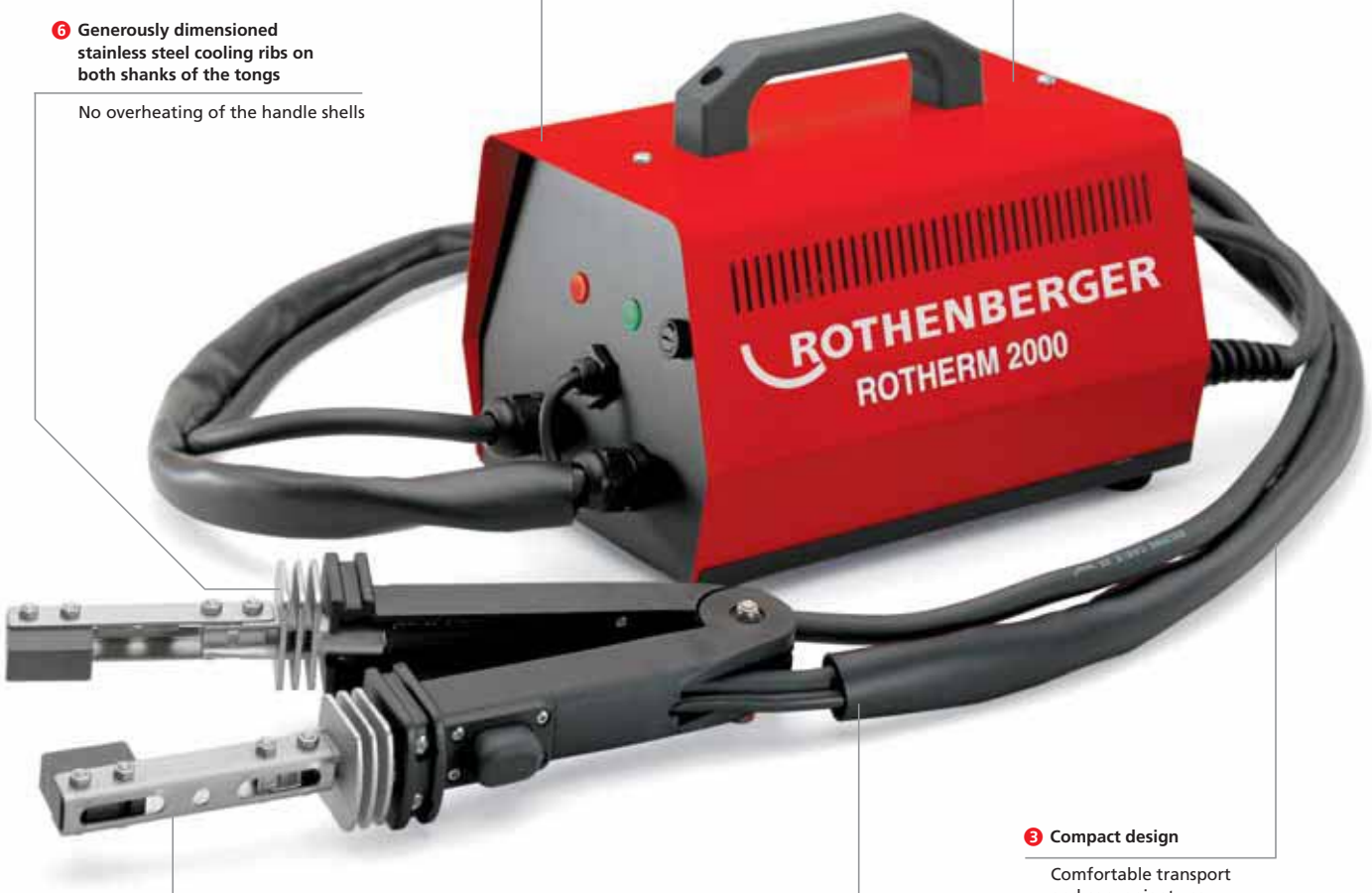
KEY FEATURES

- No purchasing or handling of gas cylinders necessary
- Complies with all accident prevention / safety regulations and is therefore in accordance with the Device Safety Act

TECHNICAL DATA

Soft soldering of	
Copper pipes up to:	Ø 6 - 54 mm, 1/4 - 2.1/8"
Power:	2000 Watt
Solder gun cable:	4 m
Dimensions (L x W x H):	260 x 190 x 200 mm
Weight:	10.5 kg

Power control lamp (red) and operating control lamp (green), Equipment fuse accessible from the outside



5 Thermal overload protection

Automatic device shut-off

4 2000 W

High performance, short soldering times

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

No overheating of the handle shells

3 Compact design

Comfortable transport and convenient use

2 Highly flexible, extra long 4 m solder gun cable

Large working radius, also when working under ceilings

1 Soldering without open flame

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

Soldering without open flame!

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ROTHERM 2000 Soft-Soldering Unit

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

Set (No. 3.6702 / No. 3.6704V) includes: ROTHERM 2000 soft soldering unit 230 V (No. 3.6700), Rosol 3 fittings soldering paste No. 4.5225), fitting solder 3 (No. 4.5255), ROVLIES® (No. 4.5268), Cu. Internal brushes 10 mm (No. 85.4180) / 12 mm (No. 85.4181) / 15 mm (No. 85.4183) / 18 mm (No. 85.4185) / 22 mm (No. 85.4186), steel case (No. 3.6715)

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

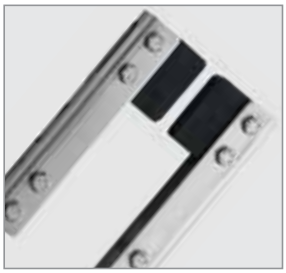
Fig. ROTHERM 2000 Set

Warming up of the soldering point without open flame

Model	kg	230 V 50/60 Hz	110 V 50/60 Hz
Rotherm 2000 Soft-soldering Set	17.8	3.6702	3.6704 V
Rotherm 2000 soft-soldering Unit	13.6	3.6700	3.6701 V
Steel case	3.5	3.6715	3.6715

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

Description	No.	Description	
Flat electrode (pair)	3.6721	ROVLIES®	203
Flat electrode with holder (pair)	3.6711	External brush for copper pipe	203
Rod electrodes (pair)	3.6720	Soft soldering flux	207
Rod electrodes with holder (pair)	3.6710	Solders	206, 211
		Internal brush for copper pipe	203

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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

Standard type according to DIN EN 1044	Solder composition in weight %	Melting range °C	Working temperature °C	Suitable for soft soldering in the plumbing industry			Recommended Flux according to DIN EN 29454	Recommended heat source
				Pipe Material	Fittings material	Flux		
CP 203	P 5.9 - 6.5 / Cu Rest	710 - 880°	730°	Copper	Copper gunmetal brass	without flux with flux	F-SH 1 or LP 5	Cartridge burner with MAPP® Gas, Propane / induced-air burner, Acetylene / induced-air burner, Larger pipe diameters above 28 mm with propane / oxygen burner with dispersion nozzle
CP 105	Ag 1.5 - 2.5 / P 5.9 - 6.5 / Cu Rest	650 - 810°	710°	Copper	Copper gunmetal brass	without flux with flux	F-SH 1 or LP 5	
CP 104	Ag 4.0 - 6.0 / P 5.7 - 6.3 / Cu Rest	650 - 810°	710°	Copper	Copper gunmetal brass	without flux with flux	F-SH 1 or LP 5	
CP 102	Ag 14.0 - 16.0 / P 4.7 - 5.3 / Cu Rest	650 - 800°	710°	Copper	Copper gunmetal brass	without flux with flux	F-SH 1 or LP 5	
AG 306	Ag 29 - 31 / Cd 19 - 23 Cu 27 - 29 / Zn Rest	600 - 690°	680°	Steel copper	Steel, copper gunmetal brass	with flux (U = sheathed from 22 mm pipe-Ø)	F-SH 1 or LP 5	
AG 106	Ag 33 - 35 / Cu 35 - 37 Sn 1.5 - 2.5 / Zn Rest	630 - 730°	710°	Steel copper	Steel, copper gunmetal brass	with flux (U = sheathed from 22 mm pipe-Ø)	F-SH 1 or LP 5	
AG 304	Ag 39 - 41 / Cd 18 - 22 Cu 18 - 20 / Zn Rest	595 - 630°	610°	Steel copper	Steel, copper gunmetal brass	with flux (U = sheathed from 22 mm pipe-Ø)	F-SH 1 or LP 5	
AG 104	Ag 44 - 46 / Cu 26 - 28 Sn 2.5 - 3.5 / Zn Rest	640 - 680°	670°	Steel copper	Steel, copper gunmetal brass	with flux (U = sheathed from 22 mm pipe-Ø)	F-SH 1 or LP 5	

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Application: For general soldering work on tinplate, copper, brass and for tinning - not suitable for drinking water installations and electronics.

DIN -Norm

Standard Solder

Universal soft solder according to DIN EN 29 453 and flux **according to DIN EN 29 454-1 2.1.1., S-Pb60Sn40**, melting range 183 °C–236 °C

Solder wire Ø	Description	g	No.
2 mm	100 g coil	110	4.5271
2 mm	250 g coil	270	4.5270

Application: For all soldering work in electro-technology and communications - not suitable for drinking water installations.

DIN -Norm

Radio Solder

Quality soft solder **according to DIN EN 29 453** and flux **according to DIN EN 29 454-1 1.1.2, S-Pb60Sn40**, melting range 183 °C – 236 °C

Solder wire Ø	Description	g	No.
2 mm	100 g coil	110	4.5261E
2 mm	250 g coil	270	4.5260

Application: For soldering work in electro-technology electronics, miniature technology, printed circuits - not suitable for drinking water installations

DIN -Norm

Electronic Solder

Quality soft solder according to DIN EN 29 453 and flux according to DIN EN 29 454-1 1.1.3, S-Su60, melting range 183 °C – 190 °C, activated without halogens, non-corrosive, all flux residues can remain on soldered joint without risk of corrosion

Solder wire Ø	Description	g	No.
1.5 mm	100 g coil	110	4.5281
1.5 mm	250 g coil	270	4.5280

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Fittings Solders

DIN -Norm

Quality soft solders in accordance with **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

Fitting Solder 1 S

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

Solder wire Ø	Description	g	No.
2 mm	250 coil	270	**4.5252**
3 mm	100 coil	110	**4.5251**
3 mm	250 coil	270	**4.5250**

Fitting Solder 3

DIN -Norm

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

Solder wire Ø	Description	g	No.
2 mm	250 coil	270	**4.5257**
3 mm	100 coil	110	**4.5256**
3 mm	250 coil	270	**4.5255**

ROSOL Soldering Paste

DIN -Norm

Quality soft solders according to **DIN EN 29453**, with flux core **DIN EN 29454-1 3.1.1.C, with test mark DVGW 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.

No. 4.5220 No. 4.5225

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	**4.5220**

ROSOL 3

Fittings solder paste

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

Model	g	No.
ROSOL 1 S in plastic bottle 250 g	270	**4.5225**

Fittings Soft Solder Flux

DIN -Norm

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.

Model	g	No.
Fittings Soft Solder Flux in plastic tube 35 ml	45	**4.5266**

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Hard Solder Rings S 5

High-quality safety solder material with silver-phosphorus content, guaranteed according to DIN EN 1044, CP 105

KEY FEATURES

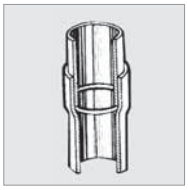
- Ideal for capillary soldering with copper pipe installation in sanitary and heating systems
- No lost material through dripping
- Matched precisely to the inner pipe diameters of brushed pipes and fittings according to **EN 1254**
- Complete wetting of brushes
- Particularly efficient working through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

TECHNICAL DATA

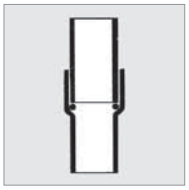
Alloy (weight %):	Ag 1.5 - 2.5 / P 5.9 - 6.5 / Cu rest
Melting range:	650 °C - 810 °C
Joinable materials:	Copper, gunmetal, brass, bronze
Use of flux with:	Gunmetal, brass, bronze with hard solder paste LP 5
Package size:	250 g plastic bag

Outside Ø mm	approx. Content rings	g	No.
12	395 pieces	260	**4.0512**
14	268 pieces	260	**4.0514**
15	244 pieces	260	**4.0515**
16	228 pieces	260	**4.0516**
18	186 pieces	260	**4.0518**
22	106 pieces	260	**4.0522**
28	79 pieces	260	**4.0528**

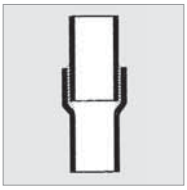
Simple insertion



Precise quantity of solder



Simply heat, no dripping, no reduction of cross-section



Hard Solder Paste LP 5

Flux for hand soldering at working temperatures above 600 °C according to DIN EN 29454, Type F-SH 1, 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 gun-metal, working temperature range 550 °C – 800 °C, flux residues must be removed carefully

Description	g	No.
LP 5 in plastic bottle 160 g	180	**4.0500**

Hard Solder Powder HKM

Flux for hard soldering at working temperatures above 800 °C, according DIN EN 29454, Type F-SH 2, working temperature 750 - 1100 °C, for copper and copper alloys, brass, gunmetal 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

Description		g	No.
HKM in plastic bottle	160 g	180	**3.5611**

Flux Brush

Description	Width mm	Length mm	g	No.
Flux Brush	13	140	20	**53.0261**

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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 CP 203

Quality hard solder **guaranteed according to DIN EN 1044**, 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 %)	P 5.9 - 6.5 Cu rest
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

Guaranteed according to DIN EN 1044

Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1025	4.0094
1 kg carton	3 x 3	500	1025	4.0095
5 kg-plastic bag	2 x 2	500	5025	4.0094A

ROLOT® S 94 XN CP 203

Quality hard solder guaranteed according to DIN EN 1044, 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 %):	P 5,9 - 6,5 Cu rest
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

Guaranteed according to DIN EN 1044

Contents	Squared section mm	Length mm	g	No.
1 kg-carton	2 x 2	500	1025	4.0097X

ROLOT® S 1 CP 203

Special quality hard solder, not standardised, similar to **DIN EN 1044**, CP 203, for normally-stressed copper pipes systems, also for capillary 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	1025	4.0102

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Hard Solders

Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1025	4.0202
1 kg carton	3 x 3	500	1025	4.0203

ROLOT® S 2 CP 105

Special quality hard solder, not standardised, **similar to DIN EN 1044**, with low silver content, matched to normally-stressed copper pipe system, ideal for capillary 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

Guaranteed according to DIN EN 1044

Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1025	4.0212
1 kg carton	3 x 3	500	1025	4.0213

ROLOT® S 2 CP 105

Silver / phosphorus safety hard solder, **guaranteed according to DIN EN 1044**, for higher-stressed copper pipe systems, ideal for capillary soldering in sanitary, heating and gas installations

TECHNICAL DATA

Alloy (weight %):	Ag 1.5 – 2.5 / P 5.9 – 6.5 / Cu rest
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

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Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1025	4.0502

ROLOT® S 5 CP 104

Particularly high quality hard solder, not standardised, **similar to DIN EN 1044**, with low silver content, ideal for capillary 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

Guaranteed according to DIN EN 1044

Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1025	4.0005

ROLOT® S 5 CP 104

High-quality silver/phosphorus safety hard solder, **guaranteed according DIN EN 1044**, for higher-stressed copper pipe systems, ideal for capillary soldering in sanitary, heating and gas installations

TECHNICAL DATA

Alloy (weight %):	Ag 4 – 6 / P 5.7 – 6.3 / Cu rest
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 LP 5

Guaranteed according to DIN EN 1044

Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1025	4.0015

ROLOT® S 15 CP 102

Particularly high quality silver hard solder, **guaranteed according to DIN EN 1044**, especially for capillary 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 14.0 – 16.0/P 4.7 – 5.3 / Cu rest
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 LP 5

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Important note:
The hard solder Series S 30, S 30 U, S 45, S 45 U contain cadmium and are therefore only permitted outside of drinking water installations for hygienic reasons. Accident Prevention Regulations (e.g. VBG 15) require that adequate workplace ventilation must be ensured when working with cadmium-containing solders. Harmful vapours can arise due to over-heating. In the case of continuous soldering operations, extraction devices are recommended

Silver Hard Solders Ag 306
S 30 / S 30 U flux-covered

Contains cadmium, quality silver hard solder, **guaranteed according DIN EN 1044**, plain (S 30) or flux-covered according to **DIN 8511 F-SH 1 (S 30 U)** universal application areas for gap soldering, excluding drinking water installations, heat-resistant up to 200 °C

Guaranteed according to DIN EN 1044

TECHNICAL DATA

Alloy (weight %):	Ag 29.0 – 31.0 / Cd 19.0 – 23.0 Cu 27.0 – 29.0 / Zn rest
Melting range:	600 °C – 690 °C
Working temperature:	680 °C
Joinable materials:	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys
Flux required:	for S30 generally with hard solder paste LP 5

Contents	mm	g	S 30 No.	S 30 U No.
100 g plastic bag	2	110	**4.4901**	**4.4921**
250 g plastic bag	2	260	**4.4902**	**4.4922**
1000 g plastic bag	2	1010	**4.4900**	**4.4930**

Silver Hard Solders Ag 106
S 34 Cu / S 34 Cu U flux-covered

Free of cadmium, quality silver hard solder **guaranteed according to DIN EN 1044**, plain (S 34 Cu) or flux-covered according to DIN EN 29454 F-SH 1(S 34 Cu U), universal application areas for gap soldering, also for drinking water installations, heat-resistant up to 200 °C

Guaranteed according to DIN EN 1044

TECHNICAL DATA

Alloy (weight %):	Ag 33.0 – 35.0 / Cu 35.0 – 37.0 Sn 1.5 – 2.5 / Zn rest
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 plastic bag	2	110	**4.4910**	**4.4915**
250 plastic bag	2	260	**4.4911**	**4.4916**
1000 plastic bag	2	1010	**4.4912**	**4.4917**

Silver Hard Solders Ag 304
S 45 / S 45 U flux-covered

Contains cadmium, quality silver hard solder, **guaranteed according to DIN EN 1044**, plain (S 45) or flux-covered according to **DIN EN 29454 F-SH 1 (S 45 U)**, universal application areas for gap soldering, excluding drinking water installation, heat-resistant up to 200 °C

Guaranteed according to DIN EN 1044

TECHNICAL DATA

Alloy (weight %):	Ag 39,0 – 41,0 / Cd 18,0 – 22,0 Cu 18,0 – 20,0 / Zn Rest
Melting range:	595 °C – 630 °C
Working temperature:	610 °C
Joinable materials:	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys
Flux required:	for S 45 generally with hard solder paste LP 5

Contents	mm	g	S 45 No.	S 45 U No.
100 plastic bag	2	110	**4.5002**	**4.5102**
250 plastic bag	2	260	**4.5007**	**4.5104**
1000 plastic bag	2	1010	**4.5004**	**4.5103**

Silver Hard Solders Ag 104
S 45 Cu / S 45 Cu U flux-covered

Free of cadmium, quality silver hard solder, **guaranteed according to DIN EN 1044**, plain (S 45 Cu) or flux-covered according to **DIN EN 29454 F-SH 1** (S 45 Cu U), universal application areas for gap soldering, excluding drinking water installations, heat-resistant up to 200 °C

Guaranteed according to DIN EN 1044

TECHNICAL DATA

Alloy (weight %):	Ag 44.0 – 46.0 / Cu 26.0 – 28.0 Sn 2.5 – 3.5 / Zn rest
Melting range:	640 °C – 680 °C
Working temperature:	670 °C
Joinable materials:	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys
Flux required:	for S 45 generally with hard solder paste LP 5

Contents	mm	g	S 45 No.	S 45 U No.
100 plastic bag	2	110	**4.5050**	**4.5055**
250 plastic bag	2	260	**4.5051**	**4.5056**
1000 plastic bag	2	1010	**4.5052**	**4.5057**

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