



Soldering and Welding Equipment

Application Table	174 – 175
"Mobile Energy"	176 – 181
Disposable Gas Cartridges and Accessories	182 – 183
Propane High-Performance Torches	184 – 187
Universal Soft-Soldering Torches	188 – 189
Warming-up Torch	190
Propane Accessories	191 – 192
Mobile Gas-Welding Equipment	193
Mobile Brazing Equipment	194 – 195
Gas-Welding Equipment	196 – 198
Acetylene Brazing Equipment	199
Accessories for Gas-Welding	200
Accessories for Soldering, Brazing and Welding Technology	201 – 203
Electric Soft Soldering Unit	204 – 205
Soft Solders & Accessories	206 – 207
Hard Solders	208 – 211

6











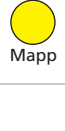
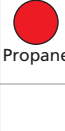















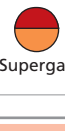












































ROTHENBERGER®
























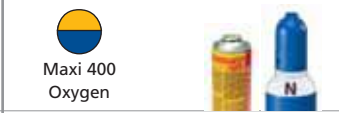



Systemised Soldering, Brazing and Welding Equipment


Application Table


Product listing according to application areas

CARTRIDGE SOLDERING UNITS					Soft soldering up to 450 °C	Brazing, etc. 450 °C-1100 °C	Gas Cartridge				
	SUPER FIRE 3		176								
	POWER FIRE		180								
	POWER FIRE COMPACT		180								
	ROFIRE PIEZO 1.950 °C / ROFIRE 1.800 °C / EASYFIRE (only basic) with Maxigas		181								
	ROFLAME PIEZO 1.800 °C		181								
					Disposable gas cartridges  176 - 177						
ACETYLENE AND PROPANE TORCHES											
	AIRAC®		199								
	ROCOLT HANDY PIEZO		184, 185								
	AIRPROP		186								
	TURBOPROP		187								
	Titanium Torch / Roofing Set		185/190								
	Gas-fired Soldering Irons		188								
	Multi 300		189								
					Light steel cylinders  200						

Systemised Soldering, Brazing and Welding Equipment







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

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!

"Mobile Energy"

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

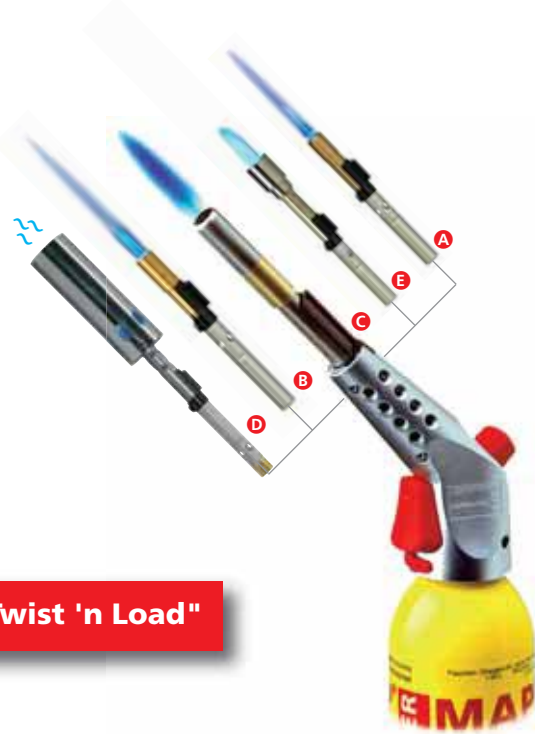
- Versatile - for use in all positions (360°)
- ❶ Extremely high flame temperature
- ❷ Long service life
- ❸ "Twist 'n Load" system (5 different nozzles available)
- ❹ Precise flame adjustment
- ❺ Up to 2.5 hours of hard soldering with one cartridge
- ❻ Even more comfortable for longer jobs
- ❼ Reliable Piezo ignition (up to 30,000 ignitions)
- ❽ 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



Pin-point Nozzle:



For fine soldering; precise and stable flame

Standard Nozzle:



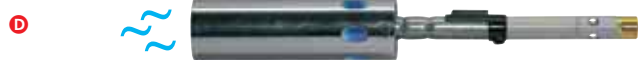
For soft soldering and other jobs with lower heat application; precise, powerful and stable flame

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



"Mobile Energy"



"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

5 ROTHENBERGER MAPP® Gas
Up to 2.5 hours of brazing with one cartridge

6 Locking button
Continual use

7 High Performance Piezo
Reliable (up to 30,000 ignitions)

8 Only ignites if torch has been securely locked
Dual safety

Ergonomically designed handle made of high-quality aluminium
Robust and optimum handling

Can be used in any position (360°)



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



Loosening of paint



Shrinking of hoses (optimal with propane gas)

"Mobile Energy"



Fig. SUPER FIRE 3 HOT BOX

SUPER FIRE 3 HOT BOX



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



No. 3.5436/No. 3.5431



No. 3.5432



No. 3.5437

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

SUPER FIRE 3 Basic Set



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

SUPER FIRE 3 MAPP®-Set



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



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)

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	Hot air nozzle 38 mm	4	176 3.5458
Standard nozzle 16 mm	2	176	Shrinking nozzle 24 mm	5	176 3.5459
Cyclone nozzle	3	176	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



SUPER FIRE 3 MAPP® Mixed Displays

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



"Mobile Energy"

POWER FIRE

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



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



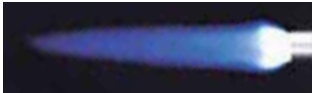
Fig. POWER FIRE Set



1 Nozzle with swirl flame

Extremely high
flame temperature

Sideways flame



Frontal flame



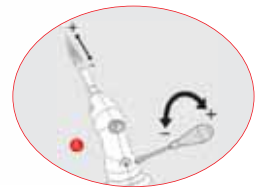
2 Fine regulating valve

Precise flame adjustment



3 Adjustable access valve

Adjustable for all gases



5 Piezo ignition

Immediate flame ignition
up to 30,000 ignitions

4 Locking button

Continual use

No. 3.0812

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

45% lighter!



POWER FIRE Compact

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



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

ROFIRE 1800 °C



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

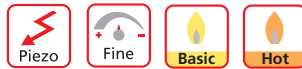
TECHNICAL DATA

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



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



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

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



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



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

MAPP® Gas EU / US

Special gas mix for high-performance soldering work

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



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

3 Contains no BUTADIENE
Poses no health risks

2 ROTHENBERGER MAPP® Gas is produced in ultra-modern filling plants and processor-controlled batching systems
Guaranteed constant top burner performance

1 Special gas mixture with outstanding flame characteristics
Extreme flame temperatures, utmost burner performance and guaranteed short working times

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

5 TÜV tested gas cartridge (drawn from solid material)
Increased safety for the user

6 Burns approx. 1/3 longer than propane
Longer period of use

Coupling thread 7/16"

EU 7/16" **US 1"**

MAPP® monoblock aluminium cylinder

MAPP® Gas
Special gas mixture researched by ROTHENBERGER



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

Disposable Gas Cartridges

Maxigas 400

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

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

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

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



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
- ❶ Reliable Piezo ignition for up to 30,000 ignitions
- ❷ Increased safety with the hose failure protection
- ❸ 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



"Twist 'n Load"



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



Propane High-Performance Torches

Titanium High-performance Warming-up Torch

Lighter professional high-performance torch with Ø 60 mm head



"Twist 'n Load" system

Fast burner exchange without tools

TITANIUM

Only 430 g

L = 600 mm

Ø 60 mm

Can only be used with the ROCOLT PIEZO handle!

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

Product Profile	
APPLICATION AREA	
For bonding of bitumen sheeting, large-area burning of weeds, defrosting, insulate and drying	
KEY FEATURES	
<ul style="list-style-type: none"> 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

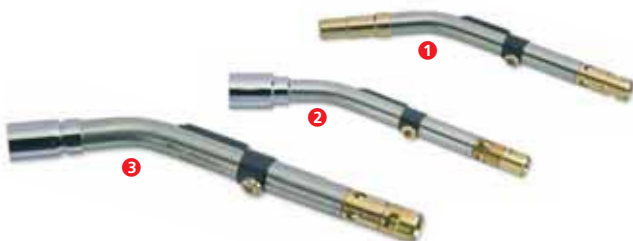
ROCOLT HANDY PIEZO Standard Burner

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



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.	Model	Ø mm	g	No.
Piezo Standard Burner	14	1	160 3.5377	Piezo Standard Burner	14	4	180 3.5397
Piezo Standard Burner	19	2	150 3.5378	Piezo Standard Burner	19	5	150 3.5398
Piezo Standard Burner	25	3	160 3.5379	Piezo Standard Burner	25	6	180 3.5399

ACCESSORIES



Description	No.	Description	No.
Welding blanket	203	External brush for copper pipe	203
Internal brush for copper pipe	203	ROVLIES®	203
Solder	206 - 211	Fittings flux	207



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

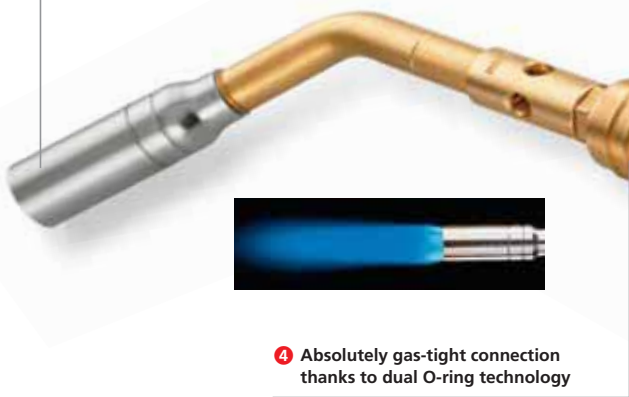
Burner: Surface treated, chromed brass

Hose coupling: 3/8" L



1 Built-in gas turbine in brazing torch

Bundled, concentrated and hot flame



2 Optimised valve technology

Absolutely gas tight

Shut-off valve

Prevents uncontrolled gas escape

3 Smooth-turning economy valve

Gas-saving operation

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

Fast burner exchange without tools



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



Threaded coupling

Push-in nipple

AIRPROP Brazing Burner with threaded coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
14 mm	140	125	1.60 – 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

Propane High-Performance Torches

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



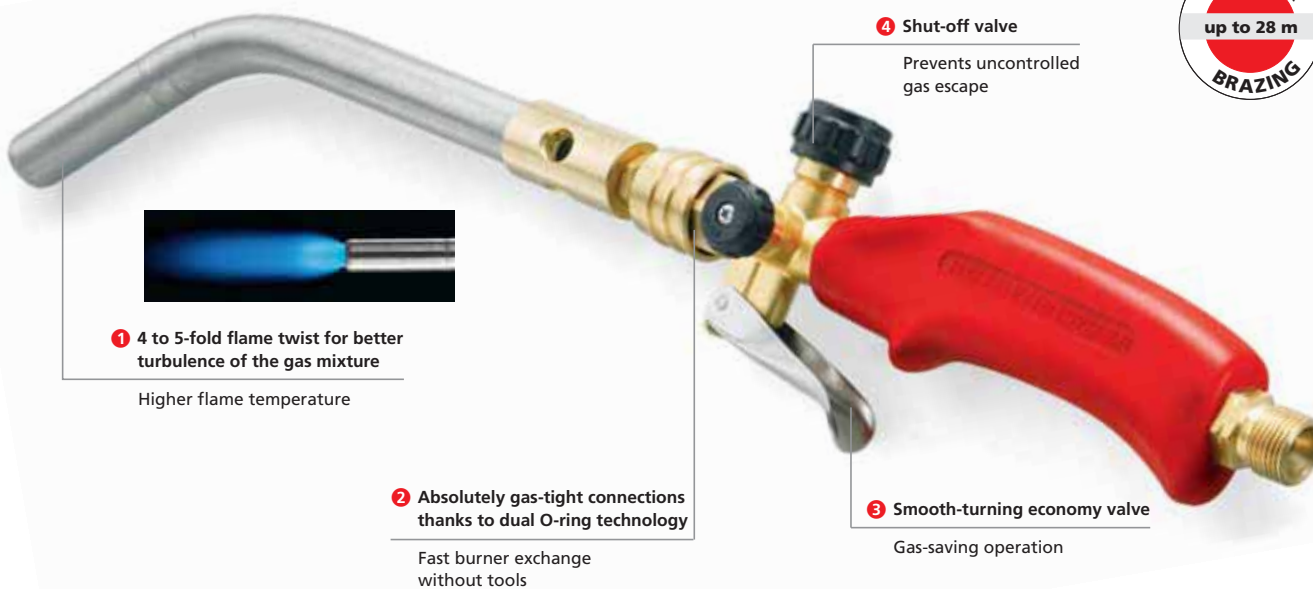
Product Profile

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



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



TURBOPROP Brazing Burner with push-in nipple

Ø mm		mm	g/h 2 bar	kWh – kcal – BTU		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	

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

1 Energy-saving combustion chamber

Wind protected and heats up quickly

2 Stable Flame

Excellent ignition behaviour with concentrated, stable flame

3 Smooth-turning economy valve

100% leak-proof

5 Special coupling

Flat and pointed copper heads useable

Support for gas-heated soldering iron

Safe use

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



4 Handle casing made of special plastic, fibreglass reinforced

Impact-resistant

6

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

Universal Soft Soldering Torches

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



Description	g	No.	Description	g	No.
Soft Soldering iron with handle, iron burner,	940	52.0849	Copper Head 250 g flat	270	3.2098
Iron Holder, wind protector, copper head 350 g			Copper Head 350 g flat	270	3.2075
Soft Soldering iron with handle, iron burner,	570	52.0840	Soft soldering burner size 3 Ø 12 mm, M 15 x 1	370	52.0855
Iron Holder, wind protector, without copper head			Soft soldering burner size 5, Ø 17 mm, M 15 x 1	70	52.0856
Handle with hose coupling M 10 x 1 L 300	300	52.0850	Soft soldering burner size 7, Ø 20 mm, M 15 x 1	120	52.0857
Iron Burner with coupling M 15 x 1	70	52.0865	Wide burner Ø 45 mm, M 15 x 1	120	52.0845
Iron Holder with foot	100	52.0866	Steel case	3390	3.5487
Wind protector	100	52.0867	Burner spanner	60	3.5530
Copper Head 250 g pointed	270	3.2099	Safety igniter with rolling file	60	3.2077
Copper Head 350 g pointed	370	3.2076	Replacement flints, tin with 5 pieces	15	3.2088

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
<ul style="list-style-type: none"> 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



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

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



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

mm	L mm	g/h	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



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

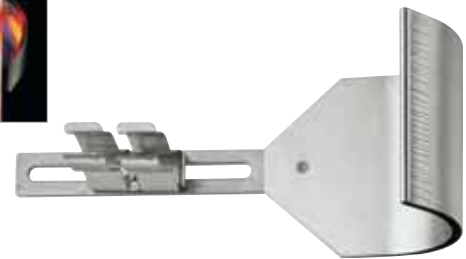
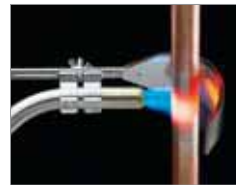
mm	mm	g/h 2 bar	kWh – kcal – BTU	g	No.
45	102	2500	32.00 – 27500 – 109280	240	3.2111
51	112	3800	48.60 – 41800 – 165970	270	3.2112
57	126	5500	70.35 – 60500 – 240257	350	3.2113
63	138	6700	85.70 – 73700 – 292670	440	3.2114



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. 3.2082

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



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	Consumption kg/h	Pressure - class	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

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

Flexible pipe welding tips



Welding tip holder can also be used as spanner



Dispersion nozzle for warming up



4 Economical

Efficient and economical professional use

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			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 mm 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)



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



The bottle colours shown are without obligation!

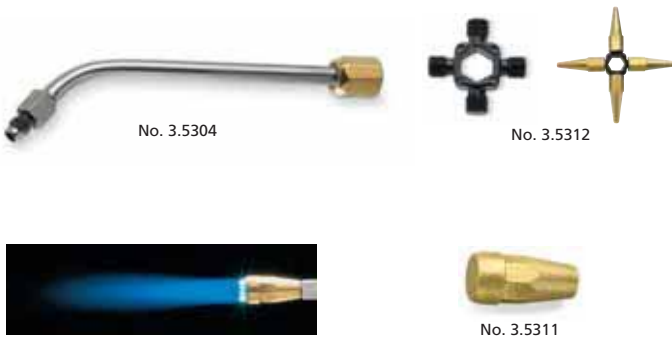
6

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)

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



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

Mobile Brazing Equipment

ALLGAS 2000 PS 0.5 / 2 Basic

Portable fitter's brazing equipment

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



KEY FEATURES

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



Space saving storage
in service vehicles

18-part set (No. 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



The bottle colours shown are without obligation!

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)

6



ROXY 400 L

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



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



The bottle colours shown are without obligation!

Gas-Welding Equipment



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		

6



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			Flexible copper tips		
Welding range mm	g	No.	Welding range mm	g	No.
1 - 2	40	3.5346	1 - 2	130	3.5475
2 - 4	40	3.5347	2 - 4	140	3.5476
4 - 6	50	3.5348	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

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 mm (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 mm (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 mm (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

Gas-Welding Equipment



Exchange of the welding tip
Can be used with all types of gas

Cutting oxygen valve with spring-lever
Enables one-handed use for spray-free cutting, etc.

ROFLASH-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



Tool-less exchange possible

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

Acetylene Brazing Equipment

AIRAC®

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

High-performance injection burner - only for acetylene - for brazing /



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

warming up of copper and steel pipes up to Ø 60 mm.

KEY FEATURES

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



❶ High-performance injection burner only for acetylene 2350 °C
Powerful operation

❶ Turbine and combustion chamber effect, self-induced air
Maximum performance

❷ Shut-off valve
Prevents uncontrolled gas leaks

❸ Smooth running economy valve
Gas-saving operation

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



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



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



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

Cylinder contents	Working pressure bar	Inlet	Abgang		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		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		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		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		No.
max. 200 bar, cylinder coupling R 3/4"	360	3.5199



Safety Igniters

Powerful spark, wear-free hard alloy friction surface

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



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	15	53.0310



Soapstone Marker

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



No. 54.0622



No. 54.0620



No. 54.0640

Welding Goggles

With thermal glasses as per DIN






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

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				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

		No.			No.
mm	g		mm	g	
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

		No.			No.
mm	g		mm	g	
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		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		No.
Welding Blanket	330 x 500 mm	300	3.1050



Electric Soft-Soldering Unit

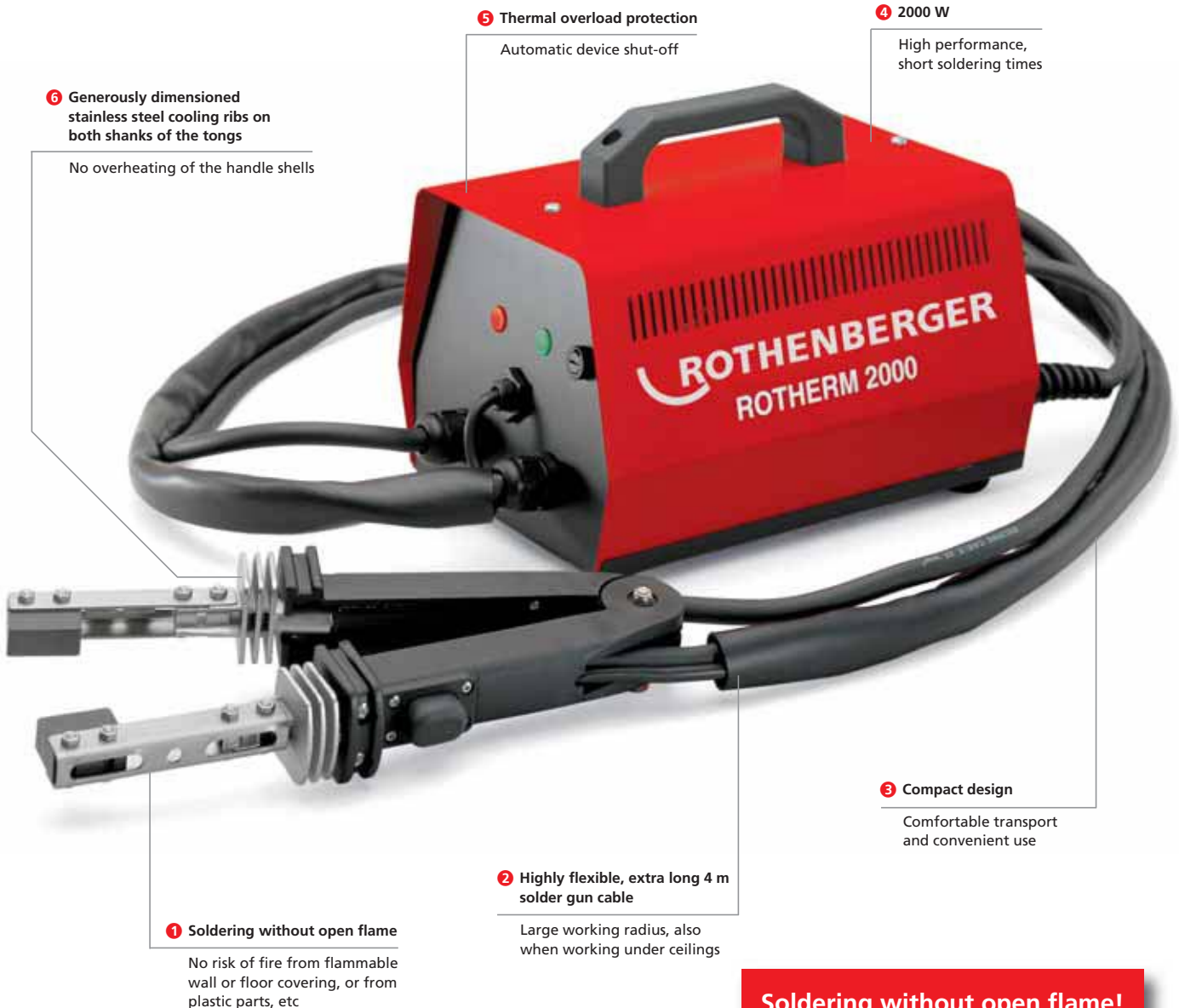
ROThERM 2000

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 <ol style="list-style-type: none"> 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 <ul style="list-style-type: none"> ● Problem-free connection on every 230 V outlet, 2 m connection cable ● Fast return on investment

KEY FEATURES
<ul style="list-style-type: none"> ● 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



Soldering without open flame!

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



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



Soft Solders and Accessories

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	



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



Fittings Solders

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

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

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

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



Hard Solders



Hard Solder Rings S 5

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

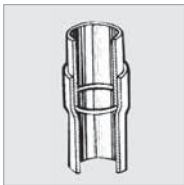
KEY FEATURES

- 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

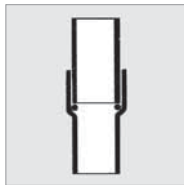
TECHNICAL DATA

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

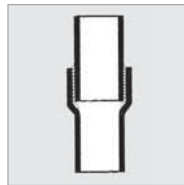
Simple insertion



Precise quantity of solder



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



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

6

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 gunmetal, 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 to DIN EN 29454, Type F-SH 2, working temperature 750 - 1100 °C, for copper and copper alloys, brass, gunmetal, nickel silver, bronze, steel and galvanised steel, grey iron and malleable cast iron, for welding copper and brass in dry conditions, can be mixed with clean water to form a paste, flux residues must be removed carefully

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



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




Hard Solders



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

Guaranteed according to DIN EN 1044



Contents	Squared section mm	Length mm		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

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

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


6



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

Guaranteed according to DIN EN 1044



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

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

ROLOT® S 5 CP 104


High-quality 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 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		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

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 to 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

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

**Guaranteed according to DIN EN 1044**

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

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

**Guaranteed according to DIN EN 1044**

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

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

**Guaranteed according to DIN EN 1044**

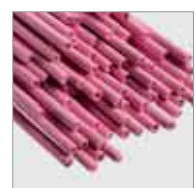
Contents	mm	g	S 45 No.	S 45 U No.
100 plastic bag	2	110	4.5002	4.5102
250 plastic bag	2	260	4.5007	4.5104
1000 plastic bag	2	1010	4.5004	4.5103

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

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

**Guaranteed according to DIN EN 1044**

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