

BZ TORCH CONSUMABLES

Description

BZ CONTACT TIPS

Taurus BZ contact tips are manufactured from a hard and highly-conductive copper alloy. The higher copper alloy quality requires less frequent replacements which in turn saves on welder’s downtime and consumable costs. Contact tips are one of the consumables needing frequent replacement on a MIG torch. They are responsible for guiding the welding wire and transferring the current from the swan neck (conductor tube) through the MIG wire to the work piece. It is important to choose a correct size contact tip for the welding application to ensure the best welding performance. Using an incorrect tip size that is too big or too small can create problems such as micro-arcing, overheating, friction and wire jamming, all of which can lead to wire burn-back. Copper is naturally soft and when combined with heat and wire friction can lead to contact tip deformation. This in turn can lead to arc-start issues, burn-back and poor welds such as a lack of penetration. Contact tips need to be changed on a regular basis.

THREAD SIZE	HOLE DIAMETER

M6 : BZ15 TORCH



- 0.6mm [BZ15-0.6]
- 0.8mm [BZ15-0.8]
- 0.9mm [BZ15-0.9]
- 1.0mm [BZ15-1.0]
- 1.2mm [BZ15-1.2]

M6 : BZ25 + BZ36 TORCH



- 0.8mm [M6-0.8]
- 0.9mm [M6-0.9]
- 1.0mm [M6-1.00]
- 1.2mm [M6-1.20]
- 1.4mm [M6-1.40]
- 1.6mm [M6-1.60]

M8 : BZ36 + BZ40 + BZ501 TORCH



- 0.8mm [M8-0.8]
- 0.9mm [M8-0.9]
- 1.0mm [M8-1.00]
- 1.2mm [M8-1.20]
- 1.4mm [M8-1.40]
- 1.6mm [M8-1.60]
- 1.8mm [M8-1.8]
- 2.0mm [M8-2.00]

M10 : BZ61 TORCH



- 1.2mm [M8-1.20]
- 1.4mm [M8-1.40]
- 1.6mm [M8-1.60]
- 2.0mm [M8-2.00]
- 2.4mm [M8-2.40]
- 2.8mm [M8-2.80]
- 3.2mm [M8-3.20]

BZ TIP ADAPTORS

Taurus BZ36, BZ40, BZ501 and BZ61 tip adaptors holds the contact tip and gas diffuser in place. Taurus BZ15 and BZ25 have combined contact tip and gas diffuser units.

BZ15 TORCH



M6 [02.05.15]

BZ25 TORCH



M6 [02.03.25M6]

M8 [02.03.25M8]

BZ36 TORCH



M6 [02.03.36M6]

M8 [02.03.36M8]

BZ40 TORCH



M8 [02.03.40]

BZ501 TORCH



M8 [02.05.501C]

BZ61 TORCH



M10 [02.03.61]

BZ GAS DIFFUSERS

Taurus gas diffusers provide gas flow to the weld pool.

BZ36 TORCH



[02.05.36]

BZ40 TORCH



[02.05.40]

BZ501 TORCH



[02.05.501]

BZ61 TORCH



[02.05.61]

BZ NOZZLES

Taurus BZ MIG nozzles are precision engineered with a thicker wall offering superior performance and longevity. The nozzle (also known as a shroud) keeps the gas at the weld puddle. When nozzle spatter builds up or when the nozzle is damaged due to misuse, wear and tear, or overheating, it can result in an uncontrolled shielding process which, in turn, may result in poor welding results, lack of penetration or increased spatter. Spatter build-up between the contact tip and the nozzle can result in shorting. The removal of spatter can be facilitated by using silicon anti-spatter spray. Spatter build-up can also be removed by using a wire brush after removal of the nozzle from the torch.

BZ15 TORCH



[02.02.15CO]

BZ25 TORCH



[02.02.25CO]

BZ36 TORCH



[02.02.36CO]

BZ40 TORCH



[02.02.40CO]

BZ501 TORCH



[02.02.501.16]

BZ61 TORCH



[02.02.61CO]

BZ LINERS



The Taurus BZ liner is the guide for the welding wire through the MIG torch to the contact tip. The correct liner is required to ensure smooth, consistent wire feed and high-quality welding. Several criteria such as wire thickness, torch length and type of wire material should be considered when selecting the correct liner. When the internal diameter of the liner is too small for the wire being used, wire feed will be affected. When the internal diameter of the liner is too large for the wire being used, the wire could fold back. When thinner wire is used, erratic feeding or even blockages can occur. Liners need to be cut to to the correct length when installed. Wire feeding problems can result from liners cut too short. Liners should fit tightly against the contact tip. The correct liner should be selected for the type of welding wire used – steel liners for mild steel wires. Aluminium alloy wires require smoother teflon liners and for stainless steel wires harder carbon-teflon liners are required. Regular cleaning of liners is necessary to prevent clogging. Due to friction, liners do wear out and should be replaced periodically.

BZ LINER CHART

Y – Recommended for the MIG torch :: **o** – Compatible with the MIG torch

STEEL TYPE – STEEL WIRES (MILD STEEL)

CODE	LENGTH	WIRE SIZE	BZ15	BZ25	BZ36	BZ40	BZ501	BZ61
[02.04.B4]	5.4m	0.6 – 0.9	Y	Y	o	o	o	o
[02.04.R4]	4.4m	1.0 – 1.2	Y	Y	Y	o	o	o
[02.04.R5]	5.4m	1.0 – 1.2	Y	Y	Y	o	o	o
[02.04.P4]	4.4m	1.2 – 1.6	o	o	o	Y	o	o
[02.04.P6]	5.4m	1.2 – 1.6	o	o	o	Y	o	o
[02.04.501N4]	4m	1.2 – 1.6	o	o	o	o	Y	o
[02.04.501N5]	5m	1.2 – 1.6	o	o	o	o	Y	o
[02.04.61N4]	4m	2.4	o	o	o	o	o	Y

TEFLON TYPE – SOFT WIRES (ALUMINIUM)

CODE	LENGTH	WIRE SIZE	BZ15	BZ25	BZ36	BZ40	BZ501	BZ61
[02.04.ALU-4.4M-0.9]	4.4m	0.8 – 0.9	Y	Y	o	o	o	o
[02.04.ALU-4.4M-1.2]	4.4m	1.0 – 1.2	Y	Y	Y	o	o	o
[02.04.ALU-4.4M-1.6]	4.4m	1.2 – 1.6	o	o	o	Y	Y	Y
[02.04.ALU-5.4M-0.9]	5.4m	0.8 – 0.9	Y	Y	o	o	o	o
[02.04.ALU-5.4M-1.2]	5.4m	1.0 – 1.2	Y	Y	Y	o	o	o

[02.04.ALU-5.4M-1.6]	5.4m	1.2– 1.6	o	o	o	Y	Y	Y

CARBON TEFLON TYPE – SOFT WIRES (STAINLESS STEEL)

CODE	LENGTH	WIRE SIZE	BZ15	BZ25	BZ36	BZ40	BZ501	BZ61
[02.04.SS-4.4M-0.9]	4.4m	0.8 – 0.9	Y	Y	o	o	o	o
[02.04.SS-4.4M-1.2]	4.4m	1.0 – 1.2	Y	Y	Y	o	o	o
[02.04.SS-4.4M-1.6]	4.4m	1.2 – 1.6	o	o	o	Y	Y	Y
[02.04.SS-5.4M-0.9]	5.4m	0.8 – 0.9	Y	Y	o	o	o	o
[02.04.SS-5.4M-1.2]	5.4m	1.0 – 1.2	Y	Y	Y	o	o	o
[02.04.SS-5.4M-1.6]	5.4m	1.2 – 1.6	o	o	o	Y	Y	Y
[02.04.SS-10M-1.6]	10m	1.2 – 1.6	o	o	o	Y	Y	Y

Product Category

1. Mig Torches and Accessories
2. BZ Torches
3. Consumables

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