BZ TORCH CONSUMABLES

Description

BZ TORCH CONSUMABLES

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
- 0.8mm
- 0.9mm
- 1.0mm
- 1.2mm

M6 : BZ25 + BZ36 TORCH

- 0.8mm
- 0.9mm
- 1.0mm
- 1.2mm
- 1.4mm
- 1.6mm

M8 : BZ36 + BZ40 + BZ501 TORCH

- 0.8mm
- 0.9mm
- 1.0mm
- 1.2mm
- 1.4mm
- 1.6mm
- 1.8mm
- 2.0mm

M10 : BZ61 TORCH

- 1.2mm
- 1.4mm
- 1.6mm
- 2.0mm
- 2.4mm
- 2.8mm
- 3.2mm

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

BZ25 TORCH

(RIGHT HAND & LEFT HAND)

BZ36 TORCH

(M6 & M8)

BZ40 TORCH

BZ501 TORCH

BZ61 TORCH

BZ GAS DIFFUSERS

Taurus gas diffusers provide gas flow to the weld pool.

BZ36 TORCH

BZ40 TORCH

BZ501 TORCH

BZ61 TORCH

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

BZ25 TORCH

BZ36 TORCH

BZ40 TORCH

BZ501 TORCH

BZ61 TORCH

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

CODE	LINER TYPE	LENGTH	WIRE SIZE	WIRE TYPE	BZ15	BZ25	BZ36	BZ40	BZ501	BZ61
02.04.B4	STEEL	5.4m	0.6 – 0.9	STEEL WIRES	?	?	?	?	?	?
02.04.R4	STEEL	4.4m	1.0 – 1.2	STEEL WIRES	?	?	?	?	?	?
02.04.R5	STEEL	5.4m	1.0 – 1.2	STEEL WIRES	?	?	?	?	?	?
02.04.P4	STEEL	4.4m	1.2 – 1.6	STEEL WIRES	?	?	?	?	?	?
02.04.P6	STEEL	5.4m	1.2 – 1.6	STEEL WIRES	?	?	?	?	?	?
02.04.501N4	STEEL	4m	1.2 – 1.6	STEEL WIRES	?	?	?	?	?	?
02.04.501N5	STEEL	5m	1.2 – 1.6	STEEL WIRES	?	?	?	?	?	?
02.04.61N4	STEEL	4m	2.4	STEEL WIRES	?	?	?	?	?	?
02.04.ALU-4.4M-0.9	TEFLON	4.4m	0.8 – 0.9	SOFT WIRES	?	?	?	?	?	?
02.04.ALU-4.4M-1.2	TEFLON	4.4m	1.0 – 1.2	SOFT WIRES	?	?	?	?	?	?

02.04.ALU-4.4M-1.6	**TEFLON**	**4.4m**	**1.2 – 1.6**	**SOFT WIRES**	?	?	?	?	?	?
02.04.ALU-5.4M-0.9	**TEFLON**	**5.4m**	**0.8 – 0.9**	**SOFT WIRES**	?	?	?	?	?	?
02.04.ALU-5.4M-1.2	**TEFLON**	**5.4m**	**1.0 – 1.2**	**SOFT WIRES**	?	?	?	?	?	?
02.04.ALU-5.4M-1.6	**TEFLON**	**5.4m**	**1.2– 1.6**	**SOFT WIRES**	?	?	?	?	?	?
02.04.SS-4.4M-0.9	**CARBON TEFLON**	**4.4m**	**0.8 – 0.9**	**SOFT STEEL WIRES**	?	?	?	?	?	?
02.04.SS-4.4M-1.2	**CARBON TEFLON**	**4.4m**	**1.0 – 1.2**	**SOFT STEEL WIRES**	?	?	?	?	?	?
02.04.SS-4.4M-1.6	**CARBON TEFLON**	**4.4m**	**1.2 – 1.6**	**SOFT STEEL WIRES**	?	?	?	?	?	?
02.04.SS-5.4M-0.9	**CARBON TEFLON**	**5.4m**	**0.8 – 0.9**	**SOFT STEEL WIRES**	?	?	?	?	?	?
02.04.SS-5.4M-1.2	**CARBON TEFLON**	**5.4m**	**1.0 – 1.2**	**SOFT STEEL WIRES**	?	?	?	?	?	?
02.04.SS-5.4M-1.6	**CARBON TEFLON**	**5.4m**	**1.2 – 1.6**	**SOFT STEEL WIRES**	?	?	?	?	?	?

02.04.SS-10M-1.6	**CARBON TEFLON**	**10m**	**1.2 – 1.6**	**SOFT STEEL WIRES**	?	?	?	?	?	?

Product Category

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

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