



MB Series Air-Cooled MIG Torch



MB15AK, MB24KD, MB36KD Catalog

Technology for the Welder's World.



www.abicorusa.com

Semi-Automatic Welding – with Abicor Binzel®

The MB Series of Abicor Binzel® standard models of handheld semi-automatic air-cooled MIG-Guns offer exceptional performance. High-quality materials and precise machining tolerances ensure superior welds, few repairs and lower operational costs than competitive models, especially when used with long lasting Abicor Binzel consumables. Available 180 to 340 amperes, MB series torches have proven their reliability for decades.

Backing the product is a team of experts – both in our USA manufacturing location in Frederick, Maryland with support from our German headquarters and our subsidiaries around the world – ready to offer custom-specific solutions. Along with installation, application and special training, our after-sales service includes the support of our optimized production facility. Quick spare parts supply and complete torch rebuilds are included as part of our personalized service.

Recognizing and co-creating innovative technological trends make Abicor Binzel® the torch leader in the welding industry.

Founded in 1945, Alexander Binzel Schweisstechnik GmBH & Co. KG specialize in the development and production of welding and cutting torches for the MIG, TIG, Robotics and Plasma processes.

Abicor Binzel® is represented in more than 50 countries with more than 1,000 employees, 30 production and sales companies, as well as over 20 exclusive partners.

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MB Series Air-Cooled MIG Guns

MB Series - Designed for Industrial Durability.

- The reliability and robustness of the MB Series of Abicor Binzel's semi-automatic air-cooled torches means trouble-free operation on every welding job suitable to those torches. MB torches offer exceptional performance at extremely competitive costs. High-quality materials and precise machining tolerances spell superior welds, few repairs and lower operational costs than competitive models, especially when used with long-lasting Abicor Binzel consumables. Available in 180 to 340 amperes, MB series torches have proven their reliability for decades on end.
- Optimal torch cooling - long service life consumables
- Unmatched reliability
- Time-saving torch exchange due to Abicor's Central Plug and Socket System (Euro connection). Also available in direct plug versions.
- Ergonomically designed for less welder fatigue

Available in:
Easygrip Handle
Ergonomic Handle (shown)
Easygrip with Extended Trigger

Comfort design handle utilizes rubber over-molding and curved spine for precise and fatigue-free work

Quality consumables for longer parts life

Easygrip with Extended Trigger Handle



Easygrip Handle



Ergonomic Handle



Lightweight and durable

Customized torches available

MB Series Air-Cooled MIG Guns



Type: **MB15AK**

Rating: 180 Amp Co2
150 Amp Mixed
60% Duty Cycle

Wire Sizes: .024"-.035" (0.6mm-0.9mm)

Weight: 34.2 oz.

Rated using power source with VDE standard volt/amp characteristic $[V=(Ax0.05) + 14]$
When pulse welding, reduce rating by 35%



Type: **MB24KD**

Rating: 250 Amp Co2
220 Amp Mixed
60% Duty Cycle

Wire Sizes: .030"-.045" (0.8mm-1.2mm)

Weight: 44.25 oz.

Rated using power source with VDE standard volt/amp characteristic $[V=(Ax0.05) + 14]$
When pulse welding, reduce rating by 35%



Type: **MB36KD**

Rating: 340 Amp Co2
320 Amp Mixed
60% Duty Cycle

Wire Sizes: .035"-.062" (0.9mm-1.6mm)

Weight: 53.5 oz.

Rated using power source with VDE standard volt/amp characteristic $[V=(Ax0.05) + 14]$
When pulse welding, reduce rating by 35%

MB Series Cable Assembly/Rear Ends

Unlike most other MIG gun manufacturers, Abicor Binzel makes our own power cable to exacting standards of quality and longevity.

All Abicor MB Series MIG guns use Abicor's signature BIKOX® power cable with these features:

- Polyimide inner wire conduit provides consistent gas coverage.
- Braided copper power cable with incorporated trigger wires for multi-directional flexibility.
- Hydraulically compressed Bikox® fittings for durability and a permanent gas seal.

The MB Series features two cable assembly rear end configurations: the Universal Connector for direct plugs or EURO Quick Connection (E).



Universal Connector rear end for direct plugs.
From top: Miller, Hobart/Tweco, Lincoln, Lincoln 10



BIKOX® Power Cable



Euro Quick Connector rear end

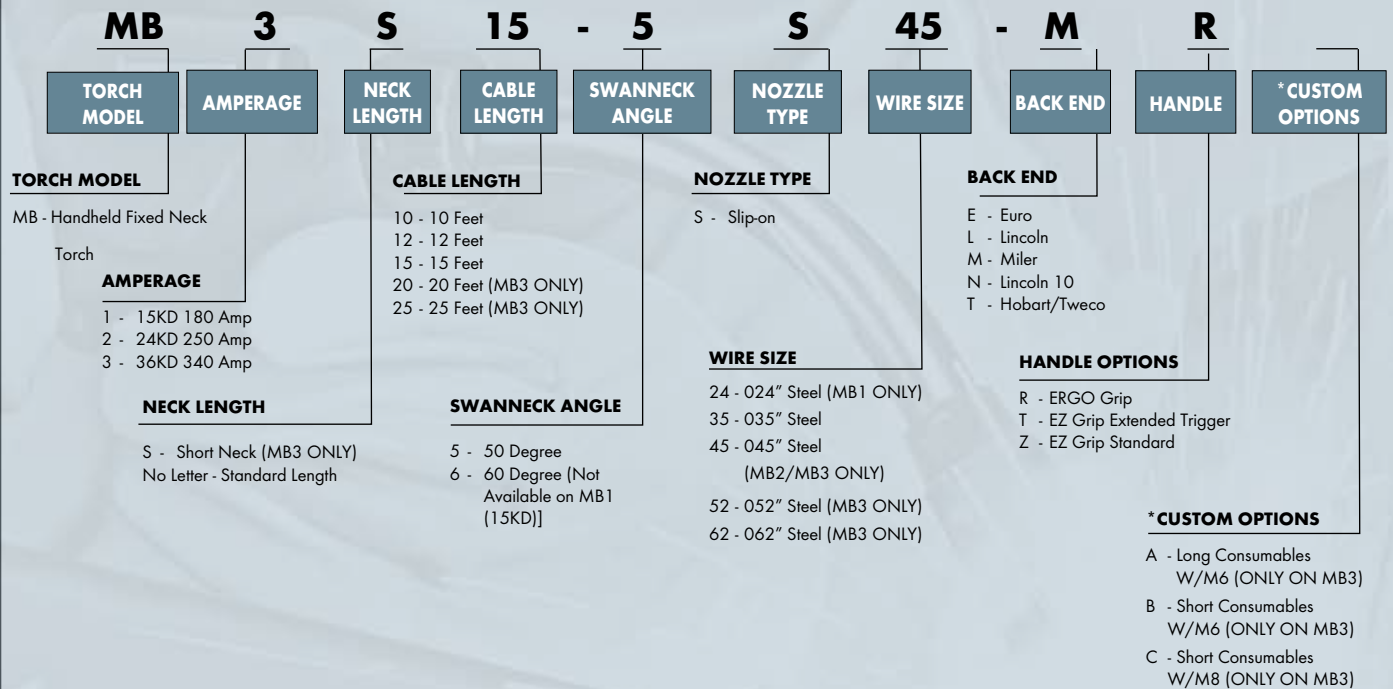
MB Series Air-Cooled MIG Torches

Ordering Information

MB Series MIG-Guns are available in 180, 250, and 340 amperes with various configurations based on neck length and bend, wire size, cable length and rear end connection. Refer to the detailed instruction below to determine the part number that best suits your requirements. If you have any questions, please contact Customer Service at 1.800.542.4867.

ORDERING INSTRUCTIONS FOR COMPLETE MB AIR-COOLED TORCHES

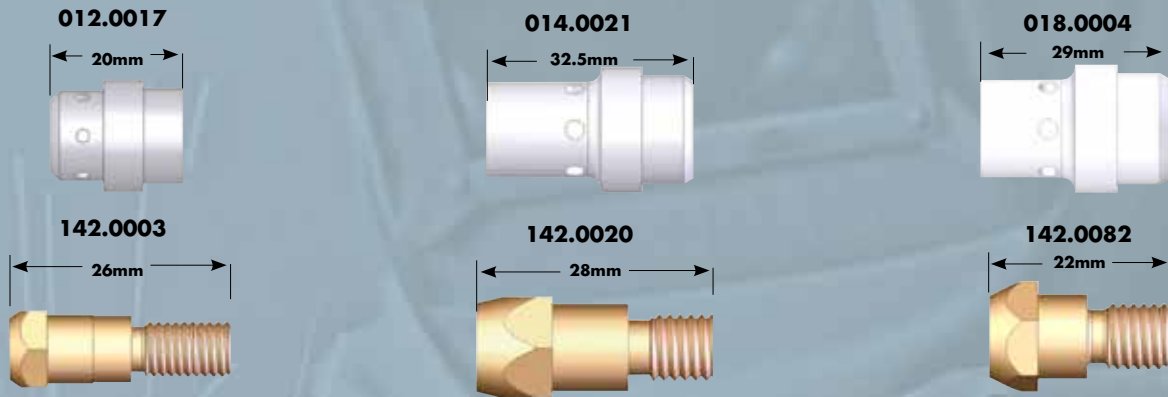
example: MB3S15-5S45-MR



* **NOTE:** Standard consumable set-up for MB3 is M8 / long consumables.

MB Air-Cooled MIG Torches

Consumables: Diffusers/Tip Holders/Contact Tips



DIFFUSERS/TIP HOLDERS (packaged 10 per bag)

| DESCRIPTION | MB 15 | MB 24 | MB 36 LONG STANDARD | | * MB 36 SHORT | |
|-------------------------------|-------|----------|---------------------|-------------|---------------|-------------|
| | | | M6 TIPS | M8 STANDARD | M6 OPTIONAL | M8 OPTIONAL |
| Diffuser | — | 012.0017 | 014.0216 | 014.0261 | 018.0116 | 018.0116 |
| Diffuser Hi-Temp | — | — | 014.0026 | 014.0026 | — | — |
| Tip Holder Spray Arc (Recess) | — | 142.0003 | 142.0020 | 142.0005 | 142.0082 | 142.0007 |
| Tip Holder Short Arc (Flush) | — | 142.0010 | 142.0024 | 142.0011 | 142.0026 | 142.0012 |

*Use with Short Nozzles - See Page 7

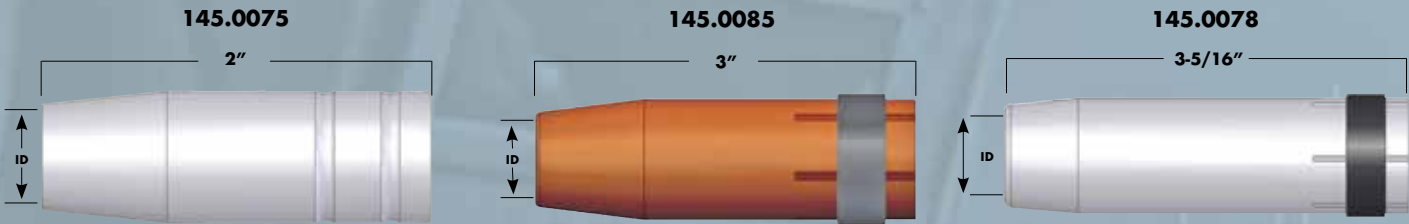


CONTACT TIPS (packaged 25 per bag)

| DESCRIPTION | MB 15 | MB 24 | M8 | MB 36 | M6 |
|--------------------------|----------|----------|----------|-------|----------|
| | M6 TIPS | M6 TIPS | STANDARD | | OPTIONAL |
| .024 CU Standard Copper | 140.0008 | 140.0008 | — | — | — |
| .030 CU Standard Copper | 140.0059 | 140.0059 | 140.0114 | — | 140.0051 |
| .035 CU Standard Copper | 140.0177 | 140.0177 | 140.0214 | — | 140.0169 |
| .040 CU Standard Copper | — | 140.0253 | 140.0313 | — | 140.0242 |
| .045 CU Standard Copper | — | 140.0387 | 140.0442 | — | 140.0379 |
| .052 CU Standard Copper | — | — | 140.0533 | — | 140.0516 |
| .062 CU Standard Copper | — | — | 140.0587 | — | 140.0555 |
| .024 CZ Long Life Copper | 140.0855 | — | — | — | — |
| .030 CZ Long Life Copper | 140.0062 | 140.0062 | 140.0117 | — | 140.0054 |
| .035 CZ Long Life Copper | 140.0180 | 140.0180 | 140.0217 | — | 140.0172 |
| .040 CZ Long Life Copper | — | — | 140.0316 | — | 140.0245 |
| .045 CZ Long Life Copper | — | 140.0390 | 140.0445 | — | 140.0382 |
| .052 CZ Long Life Copper | — | — | 140.0536 | — | 140.0519 |
| .062 CZ Long Life Copper | — | — | 140.0590 | — | 140.0558 |

MB Series MIG Torches

Consumables: Nozzles, Swannecks



NOZZLES (packaged 5 per bag)

| DESCRIPTION | MB 15 | | MB 24 | | MB 36 | | | |
|-----------------------------|---------|------------|---------|----------------|---------|--------------------------|---------|------------------|
| | BORE ID | NOZZLES 2" | BORE ID | NOZZLES 2-1/2" | BORE ID | STANDARD NOZZLES 3-5/16" | BORE ID | SHORT NOZZLES 3" |
| NOZZLES | | | | | | | | |
| Cylindrical | 5/8" | 145.0041 | 11/16" | 145.0047 | 3/4" | 145.0045 | 3/4" | 145.0051 |
| Cylindrical with Extra-Ins. | 5/8" | 145.0067 | — | — | — | — | — | — |
| Cylindrical HD | 9/16" | 145.0072 | 11/16" | 145.0062 | — | — | — | — |
| Conical (Standard) | 1/2" | 145.0075 | 1/2" | 145.0080 | 5/8" | 145.0078 | 5/8" | 145.0085 |
| Conical HD | — | — | 1/2" | 145.0101 | — | — | 5/8" | 145.0086 |
| Conical with Extra-Ins. | 1/2" | 145.0107 | — | — | — | — | — | — |
| Conical Small | 3/8" | 145.0123 | 3/8" | 145.0128 | 1/2" | 145.0126 | 9/16" | 145.0132 |
| Bottleform | 1/2" | 145.0143 | — | — | 5/8" | 145.0147 | 5/8" | 145.0148 |
| Spot Weld | 5/8" | 145.0168 | — | — | 3/4" | 145.0172 | 3/4" | 145.0179 |
| Contact Tip Wrench | — | 191.0001 | — | 191.0001 | — | 191.0001 | — | 191.0001 |



SWANNECKS AND PARTS

| DESCRIPTION | MB 15 | MB 24 | MB 36 | |
|------------------------|-----------|----------|-------------|----------|
| | | | STANDARD | SHORT |
| SWANNECK | | | | |
| Swanneck 50 degree | 002.0009 | 012.0001 | 014.0006 | 018.0001 |
| Swanneck 60 degree | — | 012.9009 | 014.9330.US | 018.9002 |
| Swanneck Flexneck | 002.0029 | — | — | — |
| SWANNECK PARTS | | | | |
| Spring Nozzle Retainer | 002.0058 | — | — | — |
| Nozzle Holder | *002.0078 | — | — | — |
| Insulator Head | 002.0050 | — | — | — |
| Body Torch Plastic | 400.0044 | 400.0044 | 400.0044 | 400.0044 |
| Nut Lock Brass M10x1 | 001.0009 | — | — | — |

*Left-hand thread

MB Series MIG Torches

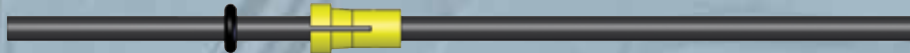
Consumables: Liners

SI-2435-17PT



| LINERS FOR STEEL WIRES | MB-15 | MB-24 | MB-36 |
|---|--------------|--------------|--------------|
| Insulated Pass-through 17' .024"-.035" PT | SI-2435-17PT | SI-2435-17PT | SI-2435-17PT |
| Insulated Pass-through 17' .035"-.045" PT | – | SI-3545-17PT | SI-3545-17PT |
| Insulated Pass-through 17' .052"-.062" PT | – | – | SI-5262-17PT |
| Insulated Pass-through 28' .035"-.045" PT | – | SI-3545-28PT | SI-3545-28PT |
| Insulated Pass-through 28' .052"-.062" PT | – | – | SI-5262-28PT |

127.9001



| LINERS FOR STAINLESS WIRES | MB-15 | MB-24 | MB-36 |
|---|--------------|--------------|--------------|
| Liner C-TFE 024"-030" 12' (for 10' gun) | 127.9007 | 127.9007 | 127.9007 |
| Liner C-TFE 024"-030" 17' (for 12' & 15' gun) | 127.9009 | 127.9009 | 127.9009 |
| Liner C-TFE 035"-045" 12' (for 10' gun) | 127.9001 | 127.9001 | 127.9001 |
| Liner C-TFE 035"-045" 17' (for 12' & 15' gun) | 127.9003 | 127.9003 | 127.9003 |
| Liner C-TFE 035"-045" 28' | 127.9011 | 127.9011 | 127.9011 |
| Liner C-TEF 052"-062" 12' (for 10' gun) | – | – | 127.9004 |
| Liner C-TEF 052"-062" 17' (for 12' & 15' gun) | – | – | 127.9006 |
| Liner C-TEF 052"-062" 28' | – | – | 127.9010 |

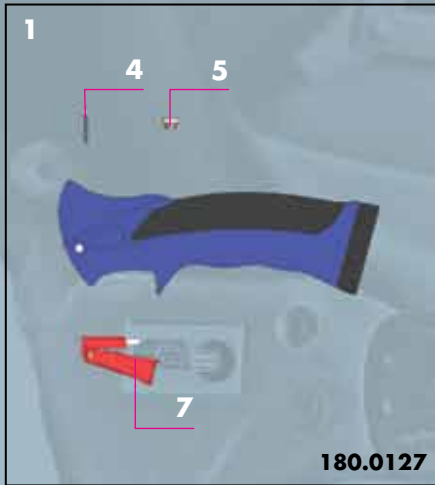
| LINER PARTS | MB-15 | MB-24 | MB-36 |
|---|--------------|--------------|--------------|
| Liner C-TFE - 024"-030" Bulk | 125.0005 | 125.0005 | 125.0005 |
| Liner C-TFE - 035"-045" Bulk | 125.0007 | 125.0007 | 125.0007 |
| Collet Plastic Liner - 024"-045" | 131.0001 | 131.0001 | 131.0001 |
| Collet Plastic Liner - 052"-078" | – | – | 131.0002 |
| O-Ring 3.5X1.5mm | 165.0008 | 165.0008 | 165.0008 |
| Liner Support for small PA Liner (specify feeder) | *129.xxxx | *129.xxxx | *129.xxxx |
| Wrench Contact Tip | 191.0001 | 191.0001 | 191.0001 |

* Contact Technical Department for complete part numbers 1-800-542-4867.

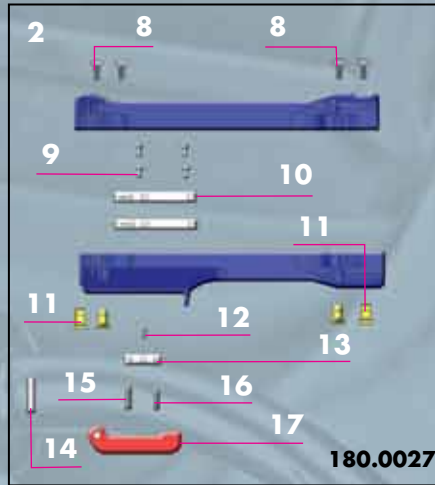
MB Series MIG Torches

Handles and Parts

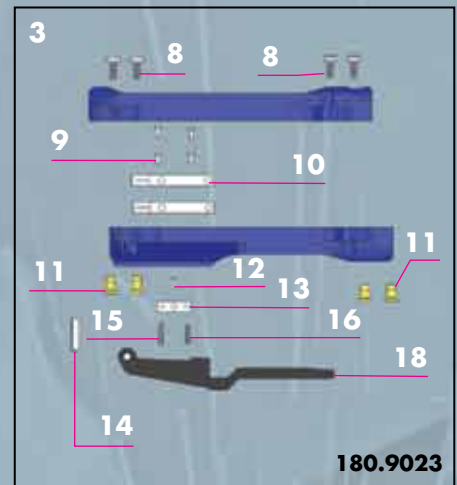
ERGONOMIC



EASYGRIP



EASYGRIP WITH EXTENDED TRIGGER



| ITEM NO. | DESCRIPTION | MB-15 | MB-24 | MB-36 |
|----------|--------------------------------|----------|----------|----------|
| 1 | Handle Ergonomic | 180.0127 | 180.0127 | 180.0127 |
| 2 | Handle Easygrip | 180.0027 | 180.0027 | 180.0027 |
| 3 | Handle Easygrip SM ET | 180.9023 | 180.9023 | 180.9023 |
| 4 | Screw Pan Head Ergo Handle | 400.1091 | 400.1091 | 400.1091 |
| 5 | Nut M4 | 400.1123 | 400.1123 | 400.1123 |
| 7 | Trigger Switch Ergo | 185.0031 | 185.0031 | 185.0031 |
| 8 | Screw Slotted Head M4x10 | 000.0554 | 000.0554 | 000.0554 |
| 9 | Screw - Sheet Metal M3 5x9.5 | 400.0199 | 400.0199 | 400.0199 |
| 10 | Trigger Blade - Long | 400.0039 | 400.0039 | 400.0039 |
| 11 | Nut Insertion M4x10 | 400.0095 | 400.0095 | 400.0095 |
| 12 | Screw - Slotted Shoulder M3x12 | 400.0036 | 400.0036 | 400.0036 |
| 13 | Trigger Blade - Center | 400.0038 | 400.0038 | 400.0038 |
| 14 | Trigger Pin 4x20mm | 000.0217 | 000.0217 | 000.0217 |
| 15 | Trigger Spring Pressure | 400.0037 | 400.0037 | 400.0037 |
| 16 | Trigger Spring (small) | 400.0056 | 400.0056 | 400.0056 |
| 17 | Trigger Easygrip | 400.0032 | 400.0032 | 400.0032 |
| 18 | Trigger Extension Easygrip | 400.0166 | 400.0166 | 400.0166 |
| 19 | Heat Shield, Easygrip | 181.0002 | 181.0002 | 181.0002 |
| N/S | Trigger Repair Kit Easygrip | 400.9022 | 400.9022 | 400.9022 |

N/S = Not Shown

MB15AK MIG Torches

Parts List, Body-Cable Assembly



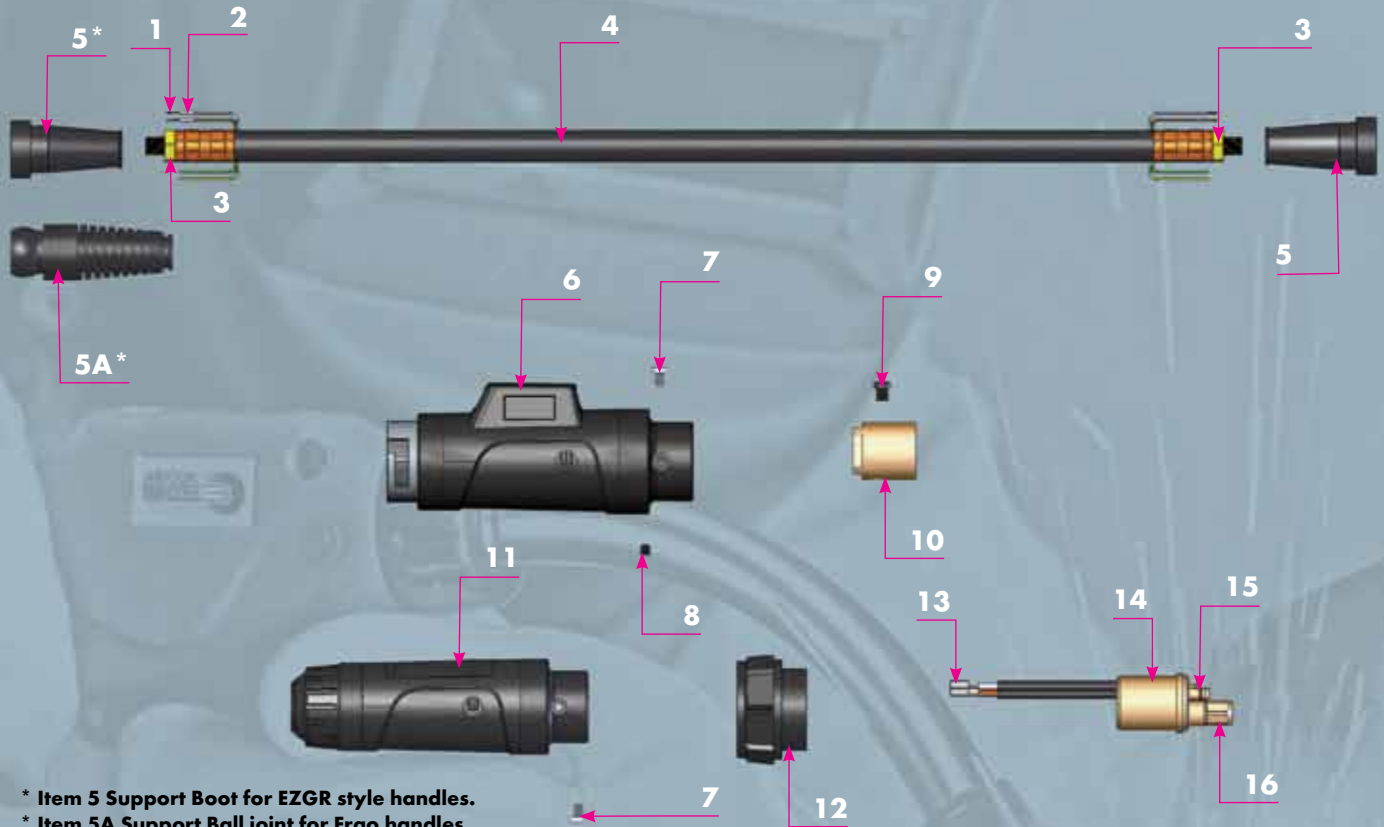
* Item 5 Support Boot for EZGR style handles.
 * Item 5A Support Ball joint for Ergo handles.

See page 13-14 for connector plugs and electrical leads.

| ITEM NO. | DESCRIPTION | PART NO. |
|----------|--|----------|
| 1 | Connector Female Spade Trigger | 175.0022 |
| 2 | Insulator Connector | 400.0119 |
| 3 | Nut Lock Brass M10x1 | 001.0009 |
| 4 | Bikox 16 10' | 160.0065 |
| | Bikox 16 12' | 160.0587 |
| | Bikox 16 15' | 160.0090 |
| 5 | Cable Support Bikox for EZGR Handle | 400.0100 |
| 5A | Support Ball Joint for 180.0127 Handle | 400.1124 |
| 6 | Rear Housing Complete, Direct | 501.D501 |
| 7 | Screw Slotted Head M4x6 | 000.0552 |
| 8 | Set Screw Hex Head M5x5 | 009.0136 |
| 9 | Gas Seal | 001.D092 |
| 10 | Adapter Block, Direct | 501.D333 |
| 11 | Rear Housing Complete, Euro | 501.D508 |
| 12 | Nut Adapter | 500.0213 |
| 13 | Connector Female Trigger (black) | 175.0003 |
| 14 | Block Adapter Central Rear | 501.0003 |
| 15 | O-Ring 4.16x1.07mm | 165.0002 |
| 16 | Nut Liner Retaining M10x1 | 501.0082 |

MB24KD/36KD MIG-Gun

Parts List, Body-Cable Assembly



* Item 5 Support Boot for EZGR style handles.
 * Item 5A Support Ball joint for Ergo handles.

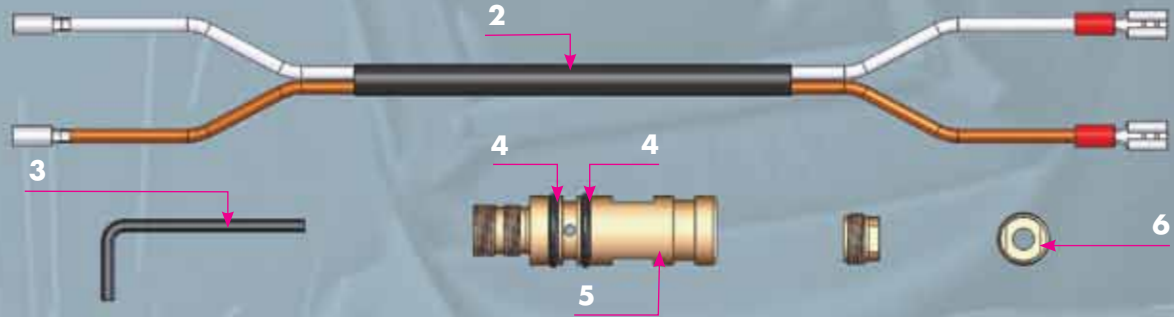
See page 13-14 for connector plugs and electrical leads.

| ITEM NO. | DESCRIPTION | PART NO. |
|----------|---|----------|
| 1 | Connector Female Spade Trigger | 175.0022 |
| 2 | Insulator Connector | 400.0119 |
| 3 | Nut Lock Brass M10x1 | 001.0009 |
| 4 | Bikox 35 10' MB 24 | 160.0215 |
| | Bikox 50 10' MB 36 | 160.0364 |
| | Bikox 35 12' MB 24 | 160.0254 |
| | Bikox 50 12' MB 36 | 160.0378 |
| | Bikox 35 15' MB 24 | 160.0266 |
| | Bikox 50 15' MB 36 | 160.0390 |
| 5 | Cable Support Bikox MB-24 for EZGR Handle | 400.0100 |
| | Cable Support Bikox MB-36 for EZGR Handle | 400.0099 |
| 5A | Support Ball Joint for 180.0127 Handle | 400.1124 |
| 6 | Rear Housing Complete, Direct | 501.D501 |
| 7 | Screw Slotted Head M4x6 | 000.0552 |
| 8 | Set Screw Hex Head M5x5 | 009.0136 |
| 9 | Gas Seal | 001.D092 |
| 10 | Adapter Block, Direct | 501.D333 |
| 11 | Rear Housing Complete, Euro | 501.D508 |
| 12 | Nut Adapter | 500.0213 |
| 13 | Connector Female Trigger (black) | 175.0003 |
| 14 | Block Adapter Central Rear | 501.0003 |
| 15 | O-Ring 4.16x1.07mm | 165.0002 |
| 16 | Nut Liner Retaining M10x1 | 501.0082 |

Connector Kits and Parts

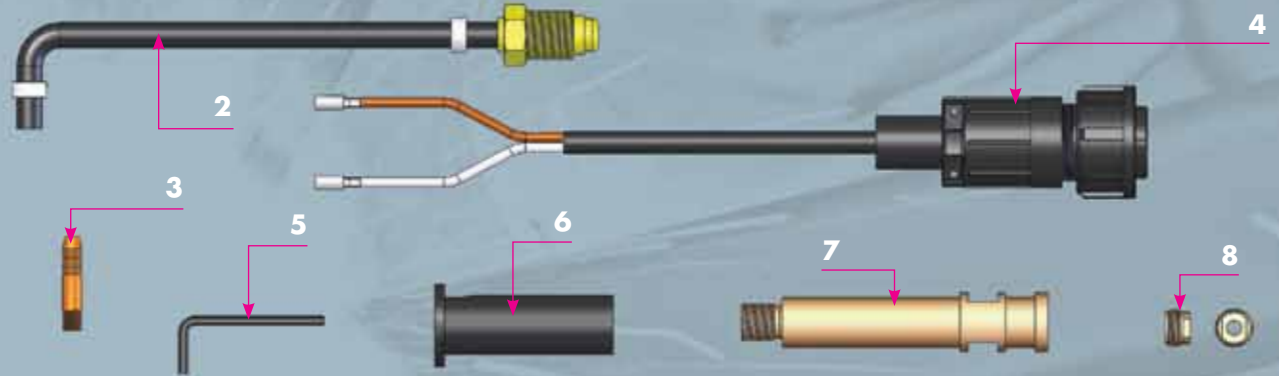
Shown are the most popular Connector Kits. Contact Abicor Binzel for additional Connector Kits

MB Mig-Gun Direct Plug Connector Kit: Hobart/Tweco



| ITEM NO. | DESCRIPTION | MB 15 AK PART NO. | MB 24 KD PART NO. | MB 36 KD PART NO. |
|----------|----------------------------|----------------------|----------------------|----------------------|
| 2 | Trigger Lead Jumper HT | 175.9138.US | 175.9138.US | 175.9138.US |
| 3 | Allen Wrench 2.5 mm | 191.0017 | 191.0017 | 191.0017 |
| 4 | O-Rings (2 required) | 165.0025 | 165.0025 | 165.0025 |
| 5 | Connector Plug HT Complete | 331.9003 | 331.9003 | 331.9003 |
| 6 | Liner Nut HT/LN | 272.9017 | 272.9017 | 272.9017 |

MB Mig-Gun Direct Plug Connector Kit: Lincoln

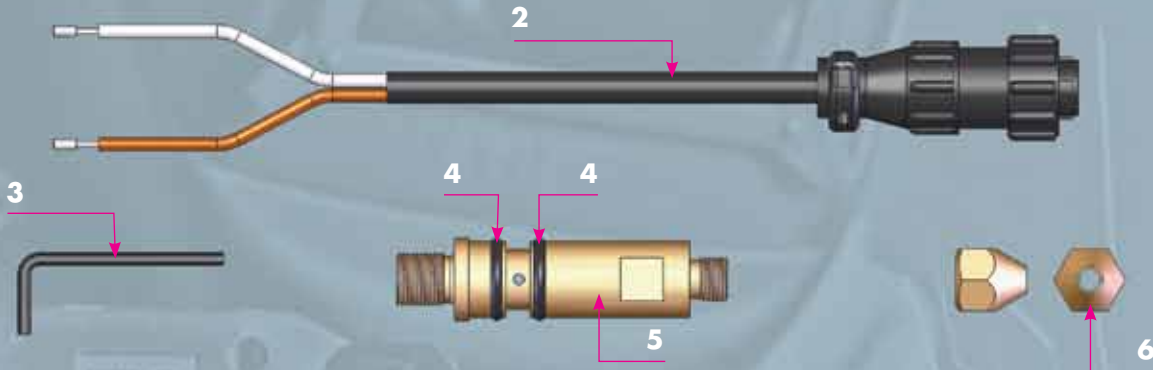


| ITEM NO. | DESCRIPTION | MB 15 AK PART NO. | MB 24 KD PART NO. | MB 36 KD PART NO. |
|----------|-------------------------|----------------------|----------------------|----------------------|
| 2 | Gas Hose Assembly | 102.9149 | 102.9149 | 102.9149 |
| 3 | Gas Fitting with M6 THD | 353.0002 | 353.0002 | 353.0002 |
| 4 | Trigger Lead Jumper LN | AC2020 | AC2020 | AC2020 |
| 5 | Allen Wrench 2.5 mm | 191.0017 | 191.0017 | 191.0017 |
| 6 | Insulator Bushing | AC2030 | AC2030 | AC2030 |
| 7 | Connector Plug L | 501.9191 | 501.9191 | 501.9191 |
| 8 | Liner Nut HT/LN | 272.9017 | 272.9017 | 272.9017 |

Connector Kits and Parts

Shown are the most popular Connector Kits. Contact Abicor Binzel for additional Connector Kits

MB Mig-Gun Direct Plug Connector Kit: Miller



| ITEM NO. | DESCRIPTION | MB 15 AK PART NO. | MB 24 KD PART NO. | MB 36 KD PART NO. |
|----------|--------------------------------|----------------------|----------------------|----------------------|
| 2 | Trigger Lead Jumper MR | 175.9122 | 175.9122 | 175.9122 |
| 3 | Allen Wrench 2.5 mm | 191.0017 | 191.0017 | 191.0017 |
| 4 | O-Rings (2 required) | 165.9006 | 165.9006 | 165.9006 |
| 5 | Connector Plug Miller Complete | 501.9183 | 501.9183 | 501.9183 |
| 6 | Liner Nut MR | 272.9018 | 272.9018 | 272.9018 |

MB Mig-Gun Direct Plug Connector Kit: Lincoln 10



| ITEM NO. | DESCRIPTION | MB 15 AK PART NO. | MB 24 KD PART NO. | MB 36 KD PART NO. |
|----------|----------------------------|----------------------|----------------------|----------------------|
| 2 | Trigger Lead Jumper LN | AC2020 | AC2020 | AC2020 |
| 3 | Allen Wrench 2.5 mm | 191.0017 | 191.0017 | 191.0017 |
| 4 | O-Rings (2 required) | 165.0025 | 165.0025 | 165.0025 |
| 5 | Connector Plug HT Complete | 331.9003 | 331.9003 | 331.9003 |
| 6 | Liner Nut HT/LN | 272.9017 | 272.9017 | 272.9017 |



WARNING

Read and follow the manufacturer's instructions, employer's safety practices, and Material Safety Data Sheets (MSDSs).

Only qualified personnel should install, use, or service this material and/or equipment

WELDING SPARKS can cause fire or explosion



- Do not weld near flammable material
- Do not weld on closed containers.
- Remove combustibles from the work area and/or provide a fire watch.
- Avoid oily or greasy clothing as a spark may ignite them.

ARC RAYS can injure eyes and burn skin



- Always wear correct eye, ear, and body protection
- Always wear a welding helmet with the proper grade filter lens. Protect yourself and others from spatter arc flash rays by using protective screens, barriers and welding curtains.
- Always wear protective gloves and clothing to cover exposed skin. This will aid in the prevention of arc and spatter burns.

ELECTRIC SHOCK can kill.



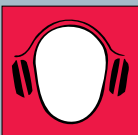
- Always wear dry installing gloves
- Do not touch live electrical parts.
- Always disconnect power source before hooking up or changing electrodes, nozzles and other parts.

FUMES AND GASES can be hazardous to your health.



- Keep your head out of the fumes
- Use enough ventilation or exhaust at the arc to keep fumes and gases from your breathing zone, and general area.
- Fumes from cutting and welding can deplete air quality, causing injury or death. Always wear an air supplied respirator in confined areas, or if breathing air is not safe.

LOUD NOISE can damage hearing.



- Always wear protective hearing devices to ensure protection when noise levels exceed OSHA standards.

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Read American National Standard Z49.1, "Safety in Welding, and Cutting, and Allied Processes," available from American Welding Society, 550 N.W. LeJune Rd., Miami, FL 33126; OSHA Safety and Health Standards, available from U.S. Government Printing Office, Washington, DC 20402.



Our product range:

■ MIG/MAG

- Welding Torches
- Automatic and Special Torches
- Push-Pull Welding Torches
- Fume Extraction Torches
- Central Adaptor System

■ TIG

- Welding Torches
- Automatic and Special Torches

■ Robotics

- Robot Torches
MIG/TIG/Plasma
- Robot Mount CAT2
- Torch Change System ATS-Rotor
- Wire Cutting Station WCS
- Torch Cleaning Station
BRS-LC and BRS-FP
- Laser Wire Feeding Systems

■ Welding Accessories

- Cooling Device
- Welding Cable Plug and
Socket
- Anti Spatter Spray

Technology for the Welder's World.

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IBRG
GROUP

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