



Request for Proposal – Mobile Welding Classroom/Laboratory

Proposal submissions due not later than: 4:00PM, Friday, March 24th 2017

Completion/delivery date of project: July 3rd, 2017

Submit bid proposal documents to the following address:

Pine Technical & Community College

Attn: Jason Spaeth, Dean of Continuing Education and Customized Training

900 Fourth Street SE

Pine City, MN 55063

Scope of work and specifications:

Pricing for this RFP is being requested as follows:

- 1.) Bid pricing for a turnkey welding classroom with all specifications in RFP**
- 2.) Bid pricing for alternates 1 and 2**
- 3.) Bid pricing with the exclusion of alternate 3 (Welding stations would still need to be designed to house (accept) equipment in RFP)**

Trailer Exterior:

New 53 ft. drop trailer X 8.5 ft. X 13.5 ft. height, dual tandem axle, air brakes, air ride suspension,

Thirty five foot slide out on passenger side (*see concept drawing*)

40,000 lbs. capacity, insulated walls & ceilings

Four point leveling system (**Alternate #1**)

1 each - 36 X 76 RV style side entry door (*located in the slide out*)

1 each – barn style rear entry door (*two conventional swing opening doors*)

Exterior walls aluminum .050, post & panel construction.

Exterior color - white

Aluminum platform & step at side door

Window located in right rear of trailer (*see concept drawing*)

Window located in right front of trailer (*see concept drawing*)

HVAC equipment mounted on the exterior front of trailer

Trailer Interior configuration:

See concept drawing for details and preferred location of fixed equipment

Air, gas, electrical plumbing along trailer wall where welding stations are located. Individual feeds into each booth for gas cutting systems, adequate number of power connection for welders, 120V receptacles

Air feed to steel worktables along with four 120V receptacles spaced adequately apart

Twelve (12) welding stations (32"D x 42"W x 39"H), welding equipment mounted above worktables

Twelve (12) welding curtain wrap around (*right to left opening on curtain rail*)

Storage bay in left rear corner bay for gas bottles for Mig, Tig and plasma (75/25 Mig, Argon for Tig)

Separate regulators for gases, mounted in location of each booth which are visible and adequate lighting

Steel worktable located in right rear of trailer, 30"W x 10' long x 39"H: Five under table top, 18"H x 24"W x 30"D: Storage shelf located 10" off of floor 30"W x 10" long

Steel worktable 24"W x 90" in right front corner of trailer

Plasma cutting table 36"W, located in front of trailer spanning the width up to the steel worktable

Direct vent exhaust above table work area

Horizontal mounted air compressor mounted near ceiling in right front of trailer near ceiling

Electrical:

Electrical panels located on left side of trailer wall between welding booth #12 and plasma table area, (*see concept drawing*)

Shore power electrical cord and reel assembly located under plasma table in right front corner of trailer, 30' connection cord

3-phase panel with 200 amp main 8 X 3 pole 3 amp breakers, 30 a 2 pole breaker

Single phase 30 amp panel with 10 X 1 pole 30 amp

Single phase 50 amp panel with 10 X 1 pole 30 amp

25 ft. 3/o black wire, single conductor

Fourteen (14) 48", 2-bulb fluorescent lights 120V, or equivalent LED lighting with comparable lumens

5 - Single pole male plug, 400 A

5 - Single pole female plug, 400 A

One (1) 110V light switch

Four (4) 110 volt interior receptacles spaced adequately on wall over steel work tables

Two (2) 110 volt exterior receptacles, one on each side of trailer, all wiring routed through EMT conduit in walls.

Vents & Air-conditioning

Two 27,000 BTU central air conditioner / heat pump

Three (3) power roof vents with rain sensors (if required)

Filtered air recirculation system which will support adequate air flow and make up air for trailer when all exterior openings are in a closed position

Interior Configuration & Specifications:

Partitions between booths and protective panels above worktables and behind the lower portion of the worktable to protect interior walls of trailer, 1/8th inch aluminum checker plate, or spec as designed

Hardwood trailer floor covered with appropriate thickness steel diamond plate, material with durable non-skid finish

Horizontal mount 5HP air compressor, (*see concept drawing*)

Hood ventilation system over welding booths. (**Alternate #2 Downdraft tables in welding booths**).

Welding booths partitioned with curtain & track system

Liquid oxygen storage compartment with plumbing to each booth, (*see concept drawing*)

Acetylene gas bottle storage compartment with plumbing to each booth, (*see concept drawing*)

Plasma cutting table the front end of unit with overhead ventilation and gas leads, (*see concept drawing*)

Certifications to be met: NSM, ESA & TSSA

Miller Welding Equipment (Alternate #3):

Quantity	Unit of Measure	Miller part #	Product Description
12	EA	907366	XMT 350MPA
12	EA	951291	S-74MPa plus wire feeder
12	EA	300405	Industrial Mig 4/0 Dinse kit
12	EA	300972	Coolmate 1.3, 115 V/AC 1.3 gallon capacity
12	EA	194744	RFCS-14HD (foot control)
12	EA	195377	Adapter Torch-initial style water (#18 #20)
12	EA		25' 300 AMP stinger w/50MM Dinse connect
12	EA		25' 300 AMP ground w/50MM Dinse connect
12	EA	195286	Gas valve kit for XMT350
12	EA	WP-18-12-R	Braided 12.5 ft. torch package
12	EA	WP-9-12-R	A-125, Rubber 12.5 ft. torch package
24	EA	16530	Flowmeter Argon/CO2 80 PSIG
12	EA	MB54-510L	Toughcut acetylene outfit w/o acc, CGA 510
12	EA	H753	Regulator mount flashback arrestors
12	EA	M14TX25	Twin hose grade "T" ¼" x 25' BB fittings (safe for all gases)
1	EA	1-5130-1	Thermal Dynamics CUTMASTER 52 208/230 volt plasma cutter

Alternate #1

Option 1 - configured as a manual operated leveling system

Option 2 - configured as an automated operated leveling system

Alternate #2 Diversitech Downdraft welding tables

Twelve (12) downdraft tables:

Airflow: 2600cfm, Downdraft velocity: 450 fpm

32" Deep x 42" Wide x 39" High

3hp 230/460/575v motor,

Rotary starter

Reverse-pulse filter self-cleaning system

(90psi compressed air required)

1 nano-fiber filter cartridge MERV 15 [99.999%@0.5](#) micron

Set of 2 metal mesh pre-filters, 16" x 25" x 1" w/ flange

14ga. mild steel, powder coated dark gray

Work surface: steel bar grating

Four 4 lockable casters

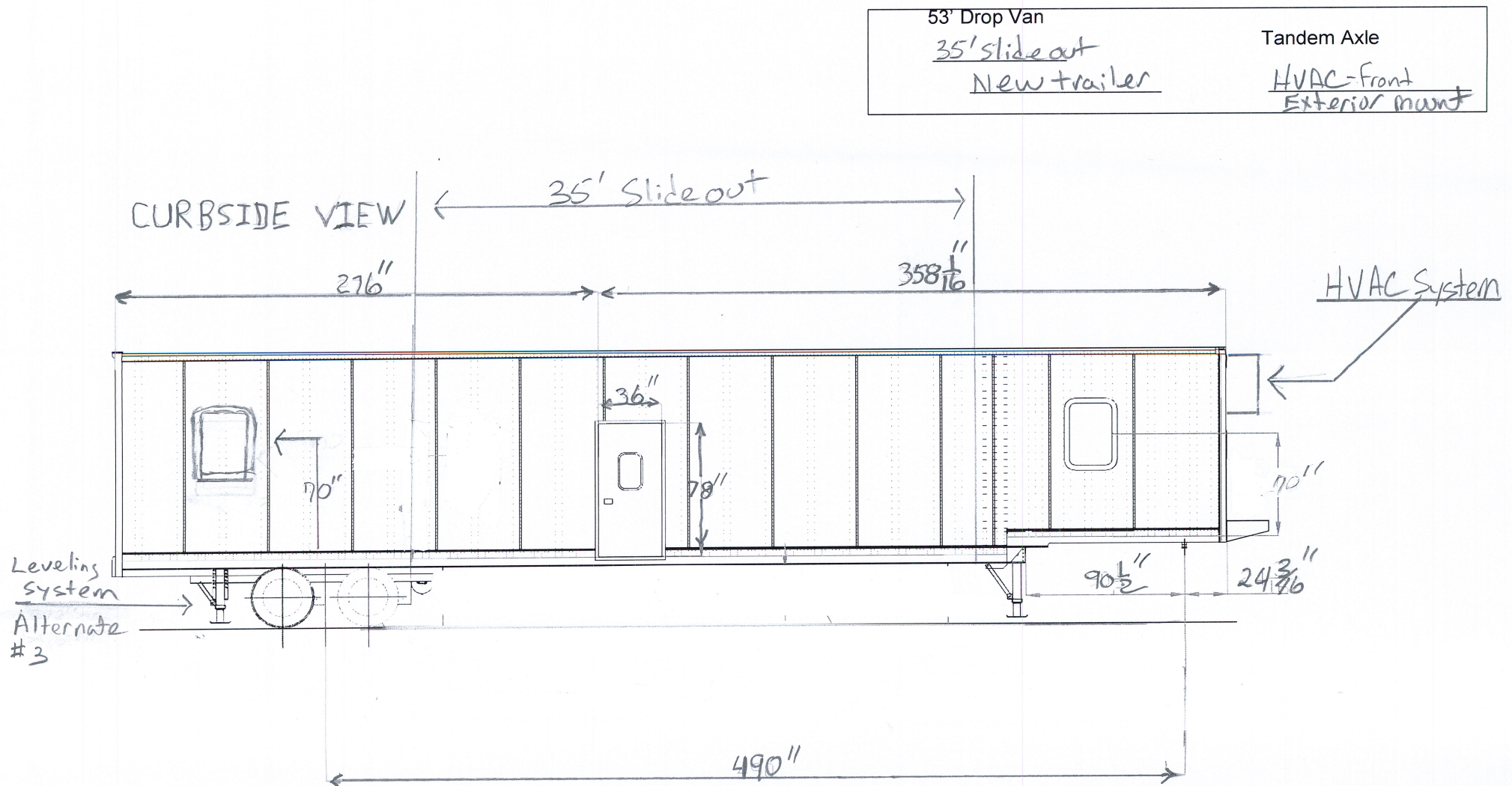
Side and back walls, grounding lug, backdraft hood

Alternate #3

Pricing excluding welding equipment referenced in table on page 4.

Note: This alternative includes fabricating each welding booth to house the equipment noted in table on page 4.

Pine Technical and Community College
Request for Proposal for Fabrication of a Mobile Welding Laboratory
Concept of Layout Configuration



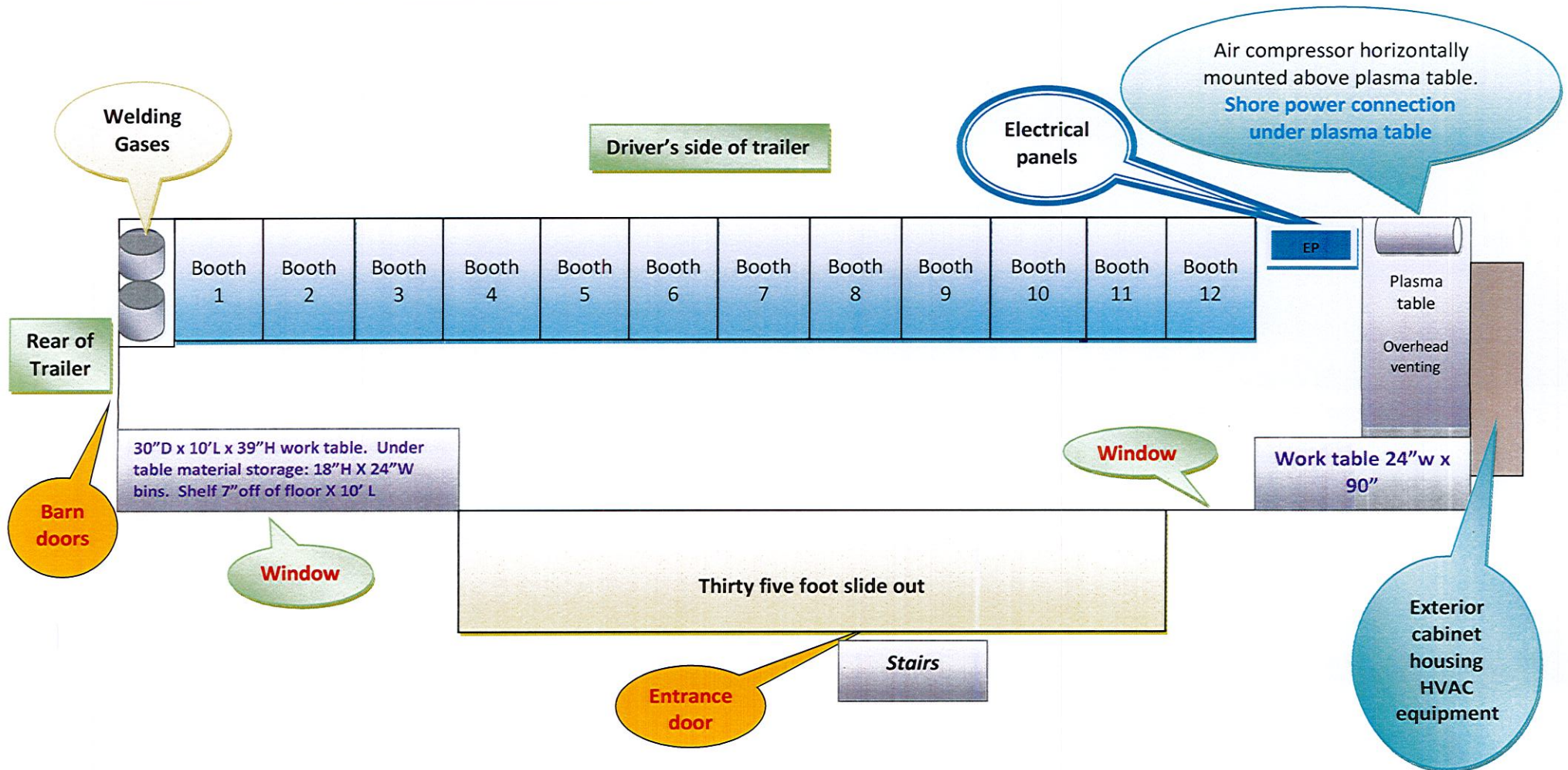
Pine Technical and Community College

Request for Proposal for Fabrication of a Mobile Welding Laboratory

Concept of Layout Configuration

Top View of Welding Laboratory

Orientation, right side is front of trailer, left side rear. This illustration is to present design concept.





XMT® 350 MPa, Dinse®

907366

Portability and excellent arc performance make the XMT family the most popular in the industry. The XMT 350 MPa offers built-in pulse programs for standard steels, high-strength steels and aluminum.

Select One

[Compare](#)

XMT® 350 MPa, Dinse® - 907366

[Spec Sheet \(ENG\)](#)

\$5,270.00 Manufacturer Suggested Price (USD)



ArcReach™ technology saves time and money – [see how](#)

Features

Built-in Pulse programs

Provide reduced heat affected zone, weld in all positions, great for thick-to-thin metal, good gap filling ability and faster travel speeds and deposition.

SharpArc®

Controls the arc in Pulsed MIG mode and gives total control over the arc cone shape, puddle fluidity and bead profile.



Auto-Line™ Power Management Technology

Allows for any input voltage hookup (208-575 VAC, single- or three phase) with no manual linking,

providing convenience in any job setting. Ideal solution for dirty or unreliable input power. [Learn More](#)

Advanced features for the professional welder

Adaptive Hot Start™ makes starting stick electrodes easy without creating an inclusion. Infinite arc control available in the Stick and Wire modes for easier fine tuning of tough-to-weld materials and out-of-position applications. Lift-Arc™ provides arc starting that minimizes contamination of the electrode and without the use of high frequency. [Learn More](#)

Standard 14-pin Receptacle

Has the flexibility to be used with spool guns, feeders, and remote controls.



Welder friendly control panel

Process selector switch reduces the number of control setup combinations without reducing any features. Ultra-tough, polycarbonate-blended cover protects front controls from damage. Large, dual digital meters are easy to view and presettable to ease setting weld output.

Output connector choices

Dinse- or Tweco® -style weld cable connectors provide high-quality weld cable connections. (Note: Two Dinse connectors are supplied with each Dinse machine. Tweco connectors must be ordered separately.)

Reliability

Wind Tunnel Technology™ protects internal components, greatly improving reliability. Fan-On-Demand™ cooling system operates only when needed, reducing noise, energy use and amount of contaminants pulled through machine. [Learn More](#)

Added Features

70 Series MPa wire feeder provides synergic pulsed MIG - as you increase/decrease the wire feed speed, the pulse parameters increase/decrease, matching the right amount of power output to match the wire speed, eliminating the need to make additional adjustments. 70 Series MPa adds wire deposition capabilities with Insight Core™. XR-AlumaFeed™ wire feeder provides Profile Pulse™ - TIG appearance with MIG simplicity and productivity. Achieve "stacked dimes" without gun manipulation. Profile Pulse frequency can be changed to increase or decrease the spacing between the ripple pattern to achieve the desired weld appearance.

Specifications

PRODUCT LITERATURE

[DC/18.93 XMT 350 Series - English](#)

PROCESSES

Air Carbon Arc Cutting and Gouging (CAC-A)
Stick (SMAW)

Flux Cored (FCAW)
TIG (GTAW)

MIG (GMAW)

GENERAL SPECIFICATIONS

Title	XMT® 350 MPa, Dinse®
Industries Interests	Aerospace Construction Heavy Equipment Manufacturing Infrastructure Manufacturing Railcar Shipbuilding DIY / Home Hobbyist High Purity Processing Boat / Yacht
Weldable Metals	Aluminum Specialty Metals Stainless Steel Steel
Carbon Diameter	1/4 in (6.4 mm)
Input Voltage	208 V 220/230/240 V 380/400/440 V 460/480 V 575 V
Input Phase	1- and 3-Phase
Input Hz	50 / 60 Hz
Current Type	CC / CV
Net Width	12.5 in
Net Height	17 in
Net Length	24 in
Net Weight	80 lbs
Warranty	Miller's True Blue Warranty
Portability	Handle(s) Running Gear / Cart (Optional)
Weld Output	CC / CV



S-74 MPa Plus (Single)

951291

Expanded capabilities from 74D, adds push-pull aluminum capabilities. Optimized with Invision™ MPa or XMT® MPa power sources.

Select One

[Compare](#)

S-74 MPa Plus (Single) - 951291

[Spec Sheet \(ENG\)](#)

\$2,531.00 Manufacturer Suggested Price (USD)

Features

WHAT'S INCLUDED

- S-74 MPa Plus (Single)
- BTB 400A Gun
- Centerfire contact tips, .035 (QTY 3), .045 (QTY 2)

- .035-.045 reversible dual V drive rolls

Trigger Schedule Select

Save time when switching between two weld settings by simply tapping gun trigger.

Complete Your System

Dedicated XR™Pistol Plus and XR-Aluma-Pro™ Plus guns work with this feeder to coordinate wire feed speed of the gun and the feeder. This provides optimized aluminum feeding and welding performance.

Accu-Mate™

Properly seats the MIG gun power pin for best feeding performance.

Additional features when used with Invision MPa or XMT MPa power sources

Synergic Pulsed MIG. As wire speed increases/decreases, pulse parameters also increase/decrease to match the right amount of power needed, eliminating the need to make additional adjustments. Profile Pulse™ provides TIG appearance with MIG simplicity and productivity. Achieve "stacked dimes" without gun manipulation. Profile Pulse frequency can be changed to increase or decrease the spacing between the ripple pattern to achieve the desired weld appearance.

Alumination™

Gives you the ability to use the extended reach of a push-pull system for consistent, versatile and dependable aluminum wire feeding.

Digital Meters

Ensure accuracy when presetting and reading actual voltage, amperage and wire feed speed.

Remote Configurations

Remote wire feeder control boxes and wire drive assemblies are available for non-Miller boom applications.

Remote Voltage Control

Allows you to set both voltage and wire feed speed at the feeder, saving time and increasing weld quality because optimal weld parameters are easy to set.

Specifications

PRODUCT LITERATURE

M/3.0 70 Series - Spanish

M/3.0 70 Series - English

Spanish

PROCESSES

Flux Cored (FCAW)

GENERAL SPECIFICATIONS

Title	S-74 MPa Plus (Single)
Industries Interests	Aerospace Construction Heavy Equipment Manufacturing Infrastructure Manufacturing Railcar Shipbuilding Boat / Yacht High Purity Processing
Input Circuit Welding Rating	750A at 100% duty cycle
Power Source Compatibility	CV
Welding Power Source Type	CV
Wire Feeder Type	Bench
Wire Feed Speed	50 IPM - 780 IPM
Wire Diameter	Solid Wire 0.023 in 0.094 in Flux Cored 0.023 in 0.094 in Aluminum 0.03 in 0.0625 in
Warranty	Miller's True Blue Warranty

Accessories



XR-Aluma-Pro™ Plus 15 ft. Air

Dedicated gun designed for the 74 MPa Plus feeder to complete a push-pull system. This provides optimized aluminum feeding and welding performance.



XR-Aluma-Pro™ Plus 25 ft. Air

Dedicated gun designed for the 74 MPa Plus feeder to complete a push-pull system. This provides optimized aluminum feeding and welding performance.



XR-Aluma-Pro™ Plus 15 ft. Water

Dedicated gun designed for the 74 MPa Plus feeder to complete a push-pull system. This provides optimized aluminum feeding and welding performance.



XR-Aluma-Pro™ Plus 25 ft. Water

Dedicated gun designed for the 74 MPa Plus feeder to complete a push-pull system. This provides optimized aluminum feeding and welding performance.



Industrial MIG 4/0 Kit, Dinse Connections

300405

Includes flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable with Dinse connector on one end and a lug on the other, 15-foot (4.6 m) work cable with Dinse connector on one end and 600-amp C-clamp on the other.

\$684.00 Manufacturer Suggested Price (USD)

Specifications

PROCESSES

MIG (GMAW)

Pulsed MIG (GMAW-P)

GENERAL SPECIFICATIONS

Title

Industrial MIG 4/0 Kit, Dinse Connections

Warranty

[Miller's True Blue Warranty](#)

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Coolmate® 1.3 115 V

300972

Select One [Compare](#)

Coolmate® 1.3 115 V - 300972

[Spec Sheet \(ENG\)](#)

\$770.00 Manufacturer Suggested Price (USD)

Specifications

PRODUCT LITERATURE
[AY/7.2 Coolmate Series - English](#)

GENERAL SPECIFICATIONS

Title	Coolmate® 1.3 115 V
Max Cooling Capacity	3400
Input Voltage	110/115/120 V
Input Phase	1-Phase
Input Hz	60 Hz
Max Current Draw	4.7 A
Rated Cooling Capacity	1330
Tank Capacity	1.3 4.9
Warranty	Miller's True Blue Warranty

Products

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Site Feedback



Foot Control, Heavy Duty, 14-pin plug

194744

★★★★★ 5.0 (2) [Write a review](#)

20 ft. (6 m.) cord

Select One

[Compare](#)

Foot Control, Heavy Duty, 14-pin plug - 194744

[Spec Sheet \(ENG\)](#)

\$332.00 Manufacturer Suggested Price (USD)

Specifications

PRODUCT LITERATURE

[AY/14.0 Remote Controls - English](#)

GENERAL SPECIFICATIONS

Title	Foot Control, Heavy Duty, 14-pin plug
Warranty	Miller's True Blue Warranty

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Gas Valve Kit For Xmt 350

195286

\$120.00 Manufacturer Suggested Price (USD)



Specifications

GENERAL SPECIFICATIONS

Title	Gas Valve Kit For Xmt 350
Input Phase	1- and 3-Phase
Warranty	Miller's True Blue Warranty

Products

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Weldcraft™ W-350, Braided, 12.5 ft., Torch Package

WP-18-12-R

Formerly known as the WP-18 Series, the W-350 Series is comprised of rugged torches engineered for high-amperage and continuous hand-held welding in mechanized applications.

Select One

[Compare](#)

Weldcraft™ W-350, Braided, 12.5 ft., Torch Package - WP-18-12-R

[Spec Sheet \(ENG\)](#)

\$255.47 Manufacturer Suggested Price (USD)

Features

WHAT'S INCLUDED

- W-350 Torch Body
- Handle
- Vinyl Power Cable
- 12.5 ft. (3.8 m)
- Long back cap

- Gas hose
- Water hose

Two Models Available
W-350, W-350 Valve

Reduced Downtime and Costs

Minimize overheating with the unique cooling design engineered for operator comfort to reduce downtime and costs.

Comfortable Handle

Eliminate discomfort and fatigue using the comfortable handle design.

Built-In Fingertip Gas Control

Superior gas flow control offered through the built-in fingertip gas control on the W-350 Valve.



Weldcraft™ A-125, Rubber, 12.5Ft, Torch Package

WP-9-12-R

★★★★★

[Write a review](#)

Formerly known as the WP-9 Series, the A-125 Series torches are designed for optimal control while welding thin gauge materials, especially in hard-to-reach places.

Select One

[Compare](#)

Weldcraft™ A-125, Rubber, 12.5Ft, Torch Package - WP-9-12-R

[Spec Sheet \(ENG\)](#)

\$100.53 Manufacturer Suggested Price (USD)

Features

WHAT'S INCLUDED

- A-125 Torch Body
- Handle
- 1-Piece Rubber 12.5ft (3.8M) Power Cable

- Long Back Cap

Seven Models Available

A-125, A-125 Flex, A-125 Flex Valve, A-125 Valve, A-125 Pencil, A-125 Flex Redhead, A-125 Flex Valve Redhead

Pencil-Style Model

Utilize the pencil-style model to work without a back cap for superior access to confined areas (A-125 Pencil).

Reduce Fatigue and Downtime

The lightweight body increases operator comfort.

Ideal Combination

Combining the flexible neck and the gas valve is ideal for welding limited-access joints using power sources without gas solenoids (A-125FV).

Perfected Control

The gas valve on the A-125 Valve offers improved shielding gas control.

Maximum Versatility

Weld on multiple applications using the A-125 Flex Redhead or A-125 Flex Valve Redhead without adding expenses.

Flexibility

Using the A-125 Flex, the flexible neck easily adjusts to any angle for improved torch control.



HD Argon/Co2 flowmeter, 80 PSIG

16530

[Write a review](#)

This Heavy-Duty flowmeter is designed to operate at inlet pressures of 80 PSIG. They can be attached to regulators or pipeline installations. Features include an extra-long flow tube made of shatter-resistant polycarbonate resin. Flow tubes have a unique ball guide which centers the ball in the tube and keeps it centered (competitors use a ball floating in a non-centering tube which allows the ball to float off-center resulting in greater flows than the reading indicates).

Select One[Compare](#)

HD Argon/Co2 flowmeter, 80 PSIG - 16530

[Spec Sheet \(ENG\)](#)

\$90.15 Manufacturer Suggested Price (USD)

Features

Rugged Protective Flowmeter Housing

Flow tubes are protected from accidental damage while offering unobstructed view of flow reading. Note: Protective housing available on 16530 and 16531 models only

Shatter-Resistant Multi-Scale Flow Tube

Tubes are made of shatter-resistant polycarbonate resin and feature multiple scales.

Unique Self-Centering Ball Guide

Miller-Smith's exclusive ball-centering flow tube provides accurate flow readings even if the tube is tipped. This ensures good weld quality and gas savings. Non self-centering flow tube ball tends to float off center. Actual gas flow can be up to 2-1/2 times greater than is indicated. Note: Self-centering ball guide available on 16530 and 16531 models only



Toughcut™ acetylene outfit w/o acc, CGA 510

MB54-510L

★★★★★ [Write a review](#)

Versatile Toughcut outfits include many features found on more expensive outfits. The Toughcut series is perfect for a multitude of applications such as farm, ranch, hobby, automotive, refrigeration, light fabrication, and repair. Outfits feature rugged, reliable Series 30™ medium-duty regulators and can cuts up to 6" with optional tips.

Select One [Compare](#)

Toughcut™ acetylene outfit w/o acc, CGA 510 - MB54-510L

\$243.00 Manufacturer Suggested Price (USD)

Features

WHAT'S INCLUDED

- Torch handle (CW5A)
- Cutting Attachment (CC509P)
- Oxygen Regulator (30-100-540)
- Acetylene Regulator (30-15-510)
- Cutting Tip (MC12-1)
- Welding tip (MW205)
- Safety Glasses (78000)
- Regulator mount check valves (H698)
- Operations Manual

Cutting Tip

Graf-Tite® soft seats Resilient Graf-Tite® seat material protects tip seating areas from nicking to maintain positive seating. Requires less replacement than metal-to-metal seat designs. Compressible soft seats are practically indestructible and withstand extremely high temperatures, resulting in longer tip life.

In-tip mix Each tip is a precision engineered mixer for combining preheat oxygen and fuel gas to attain maximum efficiency. Adds resistance to flashback.

Slip-in tip design — just hand tighten After the first tightening with a wrench, only hand tightening is required to seat the tip, saving time when changing tips. Quick and easy tip changes encourage use of right tip for the job.

Removable high-pressure seat Allows cleaning from back of tip.

Cutting Attachment

Slip-in cutting tips Save time when changing tips — no wrench needed.

Resilient Graf-Tite® seat material protects tip from nicking and maintains positive seating. Requires less replacement than metal-to-metal seat designs.

Three-tube construction Gases are kept separated, eliminating mixing tube burnout. Our thick-wall, high-capacity stainless steel tubes provide high gas flow and superior strength.

Ease-on oxygen cutting valve Allows smooth piercing and keyhole free starts and restarts.

Triple o-ring seal Provides positive gas seal, and allows rotation.

Torch Handles

Internal threads Threads are protected from damage if the torch is dropped, eliminating costly torch repair, replacement or downtime.

Double-tube handle Tube-within-a-tube design provides strength while reducing weight. Internal tube is silver brazed for extra protection, strength and leak resistance.

Adjustable valve resistance Special PTFE packing provides a gas-tight seal while allowing the "drag" to be adjusted to the individual preference.

Stainless steel ball-style valves Corrosion-resistant balls and brass seating surfaces provide gall resistance and positive, chatter-free seating.

Replaceable hose connections Hose connections are easily replaced if damaged.



Regulator Mount Flashback Arrestors

H753

★★★★★

[Write a review](#)

Select One

[Compare](#)

Regulator Mount Flashback Arrestors - H753

\$57.00 Manufacturer Suggested Price (USD)

Specifications

GENERAL SPECIFICATIONS

Title	Regulator Mount Flashback Arrestors
Industries Interests	Aerospace Racing / Customizing / Restoring Construction DIY / Home Hobbyist Farm and Ranch Heavy Equipment Manufacturing Infrastructure Manufacturing Metal Art / Sculptures Railcar Shipbuilding Boat / Yacht High Purity Processing
Warranty	Oxy-Fuel/Pressure Regulation Equipment Warranty

Resources

VIDEOS

Southwest Welding Eliminates Clutter,
Improves Productivity with Wireless Remote
Welding Controls
Southwest Welding has found that wireless
remote welding hand controls help improve
productivity, reduce hassle and...