Air Cooled CO2/MAG Welding Torch

BLUE TORCH III

OWNER’S MANUAL

『Parts List』

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts List</th>
</tr>
</thead>
<tbody>
<tr>
<td>BT5000-30UT</td>
<td>1U6324</td>
</tr>
<tr>
<td>BT5000-45UT</td>
<td>1U6325</td>
</tr>
<tr>
<td>BT5000-60UT</td>
<td>1U6326</td>
</tr>
</tbody>
</table>

■ Rated Specification

<table>
<thead>
<tr>
<th>Rated Current and Duty Cycle</th>
<th>500A 60%(CO2) / 450A 30%(MAG)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Torch Length</td>
<td>3.0m/10ft 4.5m/15ft 6.0m/20ft</td>
</tr>
<tr>
<td>Net Weight</td>
<td>3.6kg/7.9lb 4.8kg/10.6lb 5.9kg/13.0lb</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Diameter range of the electrode ※1</th>
<th>mm</th>
<th>.045, .052, (1/16)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>inch</td>
<td>1.2, (1.4), (1.6)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Type of the electrode</th>
<th>Mild steel wire, Flux-cored wire</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type of shielding gas</td>
<td>CO2, MAG</td>
</tr>
<tr>
<td>Type of cooling</td>
<td>Air Cooled</td>
</tr>
<tr>
<td>Method of guidance</td>
<td>Manual</td>
</tr>
<tr>
<td>Voltage rating</td>
<td>DC30V (Peak)</td>
</tr>
<tr>
<td>Torch switch technical data</td>
<td>DC30V 3A</td>
</tr>
</tbody>
</table>

※1: "()": Optional parts are necessary.
<table>
<thead>
<tr>
<th>No.</th>
<th>Part Description</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>①</td>
<td>Nozzle (I.D.19mm)</td>
<td>U4173G01</td>
</tr>
<tr>
<td>②</td>
<td>Insulator</td>
<td>U4173L00</td>
</tr>
<tr>
<td>③</td>
<td>Contact Tip (1.2mm/0.45&quot;)</td>
<td>K980C26</td>
</tr>
<tr>
<td>④</td>
<td>Tip Body</td>
<td>U4173G21</td>
</tr>
<tr>
<td>⑤</td>
<td>Orifice</td>
<td>U4173G02</td>
</tr>
<tr>
<td>⑥</td>
<td>Torch Body (R130, 55°)</td>
<td>U6202B00</td>
</tr>
<tr>
<td>⑦-1</td>
<td>O-Ring (S9-4D)</td>
<td>3574-001</td>
</tr>
<tr>
<td>⑦-2</td>
<td>Handle (L/R)</td>
<td>U6256D00</td>
</tr>
<tr>
<td>⑦-3</td>
<td>Handle (Upper)</td>
<td>U6196H03</td>
</tr>
<tr>
<td>⑦-4</td>
<td>Handle (Lower)</td>
<td>U6196H04</td>
</tr>
<tr>
<td>⑧</td>
<td>LockRing</td>
<td>U6196H05</td>
</tr>
<tr>
<td>⑨-1</td>
<td>Trigger ASSY (⑨-1～3 is included.)</td>
<td>U6190T00</td>
</tr>
<tr>
<td>⑨-2</td>
<td>Trigger</td>
<td>U6190T01</td>
</tr>
<tr>
<td>⑨-3</td>
<td>Trigger Spring</td>
<td>U157E04</td>
</tr>
<tr>
<td></td>
<td>Switch ASSY (⑨-3 is included.)</td>
<td>U6190Q00</td>
</tr>
<tr>
<td>⑩</td>
<td>Cable Support (with Screw)</td>
<td>U6190S00</td>
</tr>
<tr>
<td>⑪</td>
<td>Liner</td>
<td>U6199L00</td>
</tr>
<tr>
<td>⑫</td>
<td>Power Cable (Screw, Reinforcing Spring is included.)</td>
<td>U6201L00</td>
</tr>
<tr>
<td>⑬</td>
<td>Cap</td>
<td>U5341G01</td>
</tr>
<tr>
<td>⑭</td>
<td>Trigger</td>
<td>U6190T01</td>
</tr>
<tr>
<td>⑮</td>
<td>Wire Guide (1.2〜1.6mm/0.45&quot;〜1/16&quot;)</td>
<td>U5978G02</td>
</tr>
<tr>
<td>⑯</td>
<td>Terminal (LOM-21T-187)</td>
<td>100-0820</td>
</tr>
<tr>
<td>⑰</td>
<td>Cap (253224)</td>
<td>100-0821</td>
</tr>
<tr>
<td>⑱</td>
<td>Rubber Sleeve</td>
<td>U5972G01</td>
</tr>
<tr>
<td></td>
<td>Power Cable (Screw, Reinforcing Spring is included.)</td>
<td>U5972F00</td>
</tr>
</tbody>
</table>

**Notes:**
- Nozzle: I.D. 19mm
- Insulator: 1.2mm/0.45"
- Contact Tip: 1.2mm/0.45"~1/16"
- Tip Body: 1.2mm/0.45"~1/16"
- Orifice: 1.2mm/0.45"~1/16"
- Torch Body: R130, 55°
- O-Ring: S9-4D
- Handle Kit: includes ⑦-1 to ⑦-4
- LockRing: 1.2mm/0.45"~1/16"
- Power Fitting: "NO.5" (with Screw)
- Cap: 253224
- Rubber Sleeve: 1.2mm/0.45"~1/16"
- Switch Cord: 1.2mm/0.45"~1/16"
- Terminal: LOM-21T-187
- Switch Assy: includes ⑨-1 to ⑨-3
- Wire Guide: 1.2mm/0.45"~1/16"
- Cap (253224): 1.2mm/0.45"~1/16"
### Optional Parts List

- **Contact Tip**
  - **A-Tip (Standard)**
  - **T-Tip (High Current)**
  - **CW-Tip (Long Life)**
  - **Heavy Current**

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>A-Tip</th>
<th>T-Tip</th>
<th>CW-Tip</th>
<th>Heavy Current</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2mm (.045&quot;)</td>
<td>K980C28</td>
<td>K980C19</td>
<td>K990E12</td>
<td>U4167H12</td>
</tr>
<tr>
<td>1.4mm (.052&quot;)</td>
<td>K980C27</td>
<td>K980C20</td>
<td>K990E14</td>
<td>U4167H11</td>
</tr>
<tr>
<td>1.6mm (1/16&quot;)</td>
<td>K980C28</td>
<td>K980C21</td>
<td>K990E16</td>
<td>U4167H10</td>
</tr>
</tbody>
</table>

- **Nozzle**
  - Low Current: U5353V01
  - Arc Spot: U4173H01, U4173H02

- **Heat Shield**
  - Standard: U6256H00
  - For "Pistol Grip Handle": U6256N00

- **Torch Body**
  - R115, 45°: U535OB00
  - R130, 45°: U5339R00
  - R115, 55°: U6199B00
  - Straight: U5339J00

- **Modular Torch Handle/Trigger Options**
  - Extended Trigger: U6256T00
  - Slim Grip Handle: U6256B01
  - Trigger Guard Grip Handle: U6256B02
  - Pistol Grip Handle Kit: U6256K00

- **Inner Liner**
  - Wire Size: 1.2~1.6mm/.045"~1/16"
  - Part No.: U5003L26

- **Liner**
  - Wire Size: 1.2mm/.045"
  - Length: 6.0m/20ft
  - Part No.: U6195L00

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※1 "Extended Trigger" is not made in combination with "Trigger Guard Grip Handle" and "Pistol Grip Handle Kit".
※2 "Switch ASSY(U6190Q00)" and "Trigger Spring(U157E04)" are not included in "Extended Trigger".
※3 "Trigger ASSY(U6190T00)" is not included in "Slim Grip Handle" and "Trigger Guard Grip Handle".
※4 Please order "U6256M00" towards "Trigger ASSY(U6190T00)" is not required to "Pistol Grip Handle Kit".

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Voltage Detecting Cable
Part No.: U5365P00
For detail, see owner’s manual of the welding power source and wire feeder.

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※The dimension of the drawing is a reference value.

UNIT (mm)
**Torch Type**

**BT 5000 - 30**

- **Rated Current** (500A)
- **Series No.**
- **Torch Length**
  - 30: 3.0m/10ft
  - 45: 4.5m/15ft
  - 60: 6.0m/20ft

The dimension of the drawing is a reference value.

*1 OTC black torch Power cable adaptor, guide adapter and outlet guide are not attached. The Parts that you use now or new parts are required.

If new parts are required, order parts below separately.

- **Power Cable Adaptor**
  - U785013 (For CM[H]-23Series, CM[H]-14Series)
- **Guide Adapter**
  - U785013 (For CM[H]-23Series, CM[H]-14Series)
- **Outlet Guide** (1.2~1.6mm/0.045"~1/16")

**Direct Plugs**

- **T**: TWECO
- **B**: Black Torch *1
- **P**: Panasonic
- **E**: Euro (Binzel)
- **M**: Miller
- **MS**: Miller (Separate Gas Hose)
- **L**: Lincoln
- **HT**: Hitachi

**Dimensional Outline Drawing**

UNIT (mm)

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