



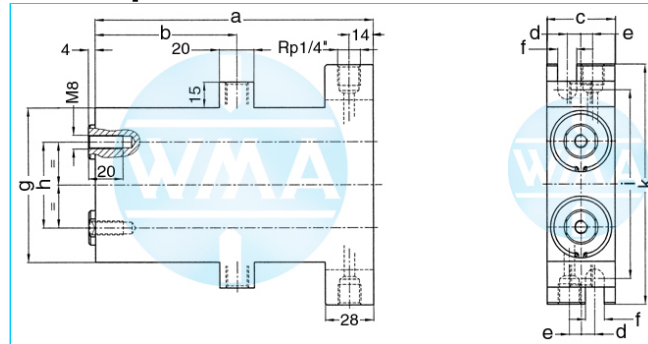
Welding cylinder

Duplex

Version: 2011-01

**bilateral air connection,
double-stage pressurized**

undamped



Nominal size 025

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	81	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.036.20
50	188	95	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.050.20
65	218	110	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.065.20
80	248	125	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.080.20
100	288	145	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.100.20
130	348	175	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.130.20
150	388	195	30	7	7	11	80	50	100	130	0.17 kN	107.120.121.025.150.20

*at 1 bar pressure

Nominal size 032

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	81	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.036.20
50	188	95	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.050.20
65	218	110	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.065.20
80	248	125	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.080.20
100	288	145	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.100.20
130	348	175	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.130.20
150	388	195	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.032.150.20

*at 1 bar pressure

Nominal size 034

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	81	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.036.20
50	188	95	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.050.20
65	218	110	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.065.20
80	248	125	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.080.20
100	288	145	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.100.20
130	348	175	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.130.20
150	388	195	40	8	7	11	90	50	110	140	0.3 kN	107.120.121.034.150.20

*at 1 bar pressure

We reserve the right to make changes which are in the interest of technical progress.

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Cylinder-Duplex-1



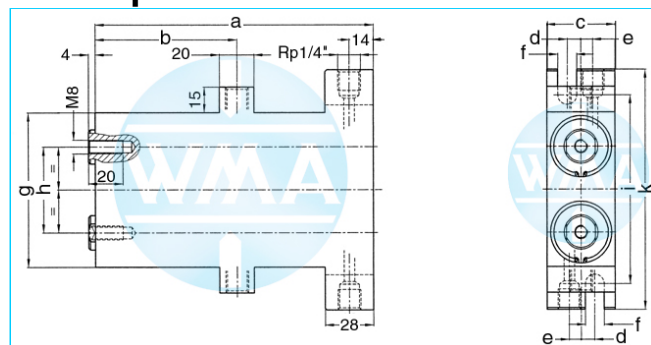
Welding cylinder

Duplex

Version: 2011-01

**bilateral air connection,
double-stage pressurized**

undamped



Nominal size 038

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	81	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.036.30
50	188	95	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.050.30
65	218	110	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.065.30
80	248	125	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.080.30
100	288	145	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.100.30
130	348	175	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.130.30
150	388	195	48	10	8	13	100	50	124	160	0.4 kN	107.120.121.038.150.30

*at 1 bar pressure

Nominal size 044

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	81	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.036.30
50	188	95	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.050.30
65	218	110	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.065.30
80	248	125	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.080.30
100	288	145	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.100.30
130	348	175	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.130.30
150	388	195	52	10	8	13	102	50	124	160	0.56 kN	107.120.121.044.150.30

*at 1 bar pressure

Nominal size 058

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	81	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.036.30
50	188	95	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.050.30
65	218	110	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.065.30
80	248	125	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.080.30
100	288	145	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.100.30
130	348	175	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.130.30
150	388	195	70	10	8	13	140	70	164	190	1.0 kN	107.120.121.058.150.30

*at 1 bar pressure

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Cylinder-Duplex-2



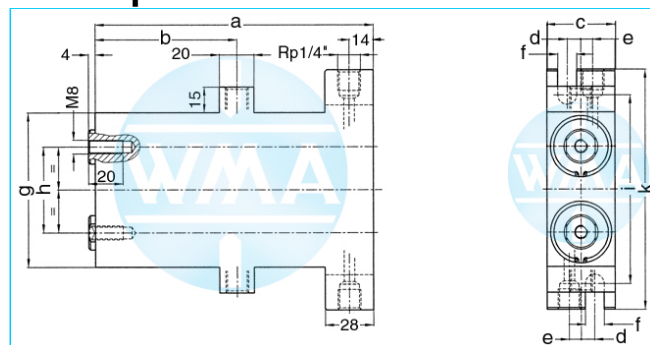
Welding cylinder

Duplex

Version: 2011-01

**bilateral air connection,
three-stage pressurized**

undamped



Nominal size 025

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	138	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.036.20
50	259	166	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.050.20
65	304	196	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.065.20
80	349	226	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.080.20
100	409	266	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.100.20
130	499	326	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.130.20
150	559	366	30	7	7	11	80	50	100	130	0.23 kN	107.120.131.025.150.20

*at 1 bar pressure

Nominal size 032

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	138	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.036.20
50	259	166	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.050.20
65	304	196	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.065.20
80	349	226	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.080.20
100	409	266	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.100.20
130	499	326	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.130.20
150	559	366	40	8	7	11	90	50	110	140	0.42 kN	107.120.131.032.150.20

*at 1 bar pressure

Nominal size 034

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	138	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.036.20
50	259	166	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.050.20
65	304	196	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.065.20
80	349	226	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.080.20
100	409	266	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.100.20
130	499	326	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.130.20
150	559	366	40	8	7	11	90	50	110	140	0.48 kN	107.120.131.034.150.20

*at 1 bar pressure

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Cylinder-Duplex-3



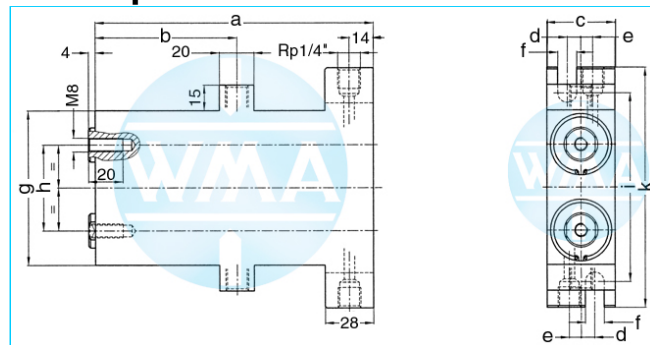
Welding cylinder

Duplex

Version: 2011-01

**bilateral air connection,
three-stage pressurized**

undamped



Nominal size 038

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	138	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.036.30
50	259	166	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.050.30
65	304	196	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.065.30
80	349	226	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.080.30
100	409	266	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.100.30
130	499	326	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.130.30
150	559	366	48	10	8	13	100	50	124	160	0.56 kN	107.120.131.038.150.30

*at 1 bar pressure

Nominal size 044

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	138	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.036.30
50	259	166	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.050.30
65	304	196	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.065.30
80	349	226	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.080.30
100	409	266	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.100.30
130	499	326	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.130.30
150	559	366	52	10	8	13	102	50	124	160	0.78 kN	107.120.131.044.150.30

*at 1 bar pressure

Nominal size 058

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	138	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.036.30
50	259	166	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.050.30
65	304	196	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.065.30
80	349	226	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.080.30
100	409	266	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.100.30
130	499	326	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.130.30
150	559	366	70	10	8	13	140	70	164	190	1.44 kN	107.120.131.058.150.30

*at 1 bar pressure

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Cylinder-Duplex-4



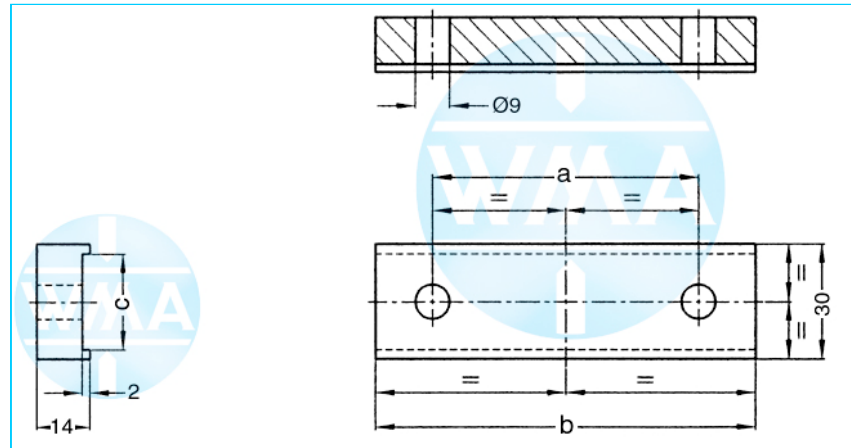
Welding cylinder

Duplex

Version: 2011-01

Holding plate for Duplex cylinder

For Cylinder piston diameter (Nominal size) 25,32, 34, 38, 44 and 58 mm

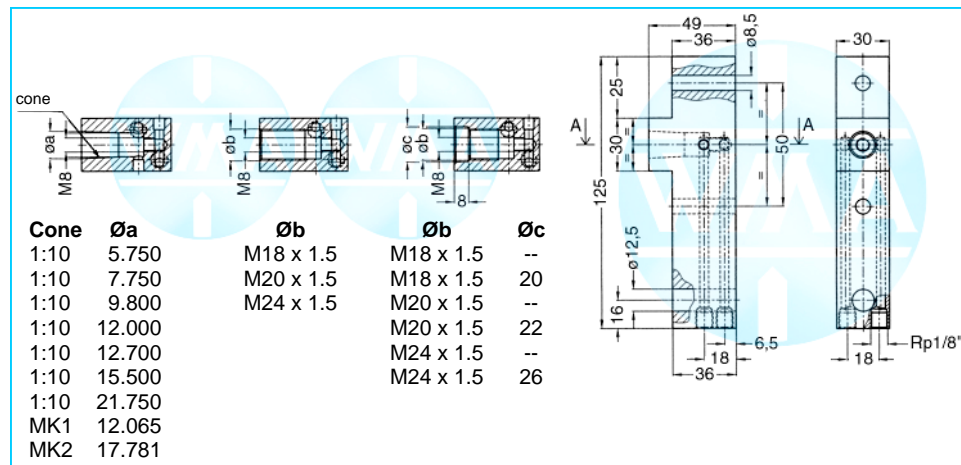


Cylinder piston diameter

Cylinder piston diameter	a	b	c	Order-number
25, 32, 34	50	80	17	
38, 44	50	80	25	
58	70	100	25	

Electrode holder for Duplex cylinder

For Cylinder piston diameter (Nominal size) 25,32, 34, 38, 44 and 58 mm



Cone	Øa	Øb	Øb	Øc
1:10	5.750	M18 x 1.5	M18 x 1.5	--
1:10	7.750	M20 x 1.5	M18 x 1.5	20
1:10	9.800	M24 x 1.5	M20 x 1.5	--
1:10	12.000		M20 x 1.5	22
1:10	12.700		M24 x 1.5	--
1:10	15.500		M24 x 1.5	26
1:10	21.750			
MK1	12.065			
MK2	17.781			

Piston diameter

Piston diameter	d	e	f
25, 32, 34, 38, 44	125	25	50
58	154	35	70

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Cylinder-Duplex-5