



Gas Control Equipment



COMPLETE TORCH SYSTEM

X21® ORIGINAL

The GCE X21® Original with large capacity for welding, cutting, soldering, heating and straightening. X21® Original is a combined gas welding and gas cutting torch for manual work. It is a pressure torch (II) that is designed on the basis of the stringent demands stipulated by standard EN ISO 5172.

X21 is a versatile and complete torch system, with cutting attachments for injector or pressure principle, and with round or oval shank, for all medium and heavy duty cutting, welding, and heating jobs. With the pressure principle you use 3-cone cutting nozzles, with the injector principle you use fl at seal cutting nozzles. The choice is yours.

All X21 equipment fully meets the requirement of EN ISO 5172 and is manufactured at our factory under the Quality Management System ISO 9001.



X21® ORIGINAL

X21 CAN BE USED IN THE FOLLOWING OPERATIONS

- Welding in thicknesses up to 14 mm
- Cutting in carbon steel in thicknesses up to 500 mm, circle cutting, hole cutting, bevel cutting, and rivet washing
- Braze welding
- Brazing
- Heating, bending, and straightening
- Gouging
- Flame cleaning
- Flame straightening



X21 satisfies the high expectations that users have of a quality torch. With the X 21 pressure torch, the gases are mixed in the torch head, which increases safety against flashbacks. Pressure torches entail that Oxygen and fuel gas for the heating flame have the same inlet pressure to the nozzle. X21® Original is available for the fuel gases Acetylene and Propane (LPG). Using Propane as the fuel gas, all the processes apart from gas welding can be used.

COMPLETE KITS

GCE offer complete equipment kits containing a wide range of components' to fulfill the work to be done by the user. They are all supplied in robust boxes and easy to transport.



Art. Nr.	Packing	Shank	Cutting attachment	Welding attachment	Nozzles	Other Equipment
0767937	red metal case	X	X	6 sizes	HA311 - 3 sizes	spanner, cleaning needles, cutt. guide, BV12 + nuts, set of O-rings,
0764267	red metal case	X	X	2 sizes	HA311 - 1 size	cleaning needles, BV12 + nuts

BENEFITS WITH X21® ORIGINAL

- Choose between round and oval torch handle
- Color marking: red for fuel gas and blue for Oxygen on the handle and cutting attachment
- Potential to weld material thicknesses up to 14 mm
- Cut up to 500 mm
- Heat for straightening and heat forming
- Special flame-straightening torches
- Flame-cleaning torches
- Large range of accessories
- Suitable for powder cutting

X21 FOR WELDING

The welding attachments, 8 inserts from 40 to 1250 l/h, are entirely forged from copper with deflect weld spatter. For weld locations that are difficult to access, here are three flexible welding attachments, ranging from 160 to 500 l/h, that are not chrome-plated.

AVAILABLE SHANK TYPES

ROUND TYPE

Art. Nr.	Gas	Quantity
0764658	SHANK	G3/8" + G3/8" LH (hose nipples 6,3 mm)
0767946	SHANK	G3/8" + G3/8" LH (BV12 - 6,3 mm)



FLAT TYPE (OVAL.)

Art. Nr.	Gas	Quantity
0763939	SHANK	G3/8" + G3/8" LH



CUTTING ATTACHMENT

STANDARD SIZE

Art. Nr.	Control	Heating gas	Type	Head angle	Lenght (mm)
0766261	Knob	Ace/Prop	Nozzle MIX	90°	238
0766263	Buterfly	Ace/Prop	Nozzle MIX	90°	238
0764574	Lever	Ace/Prop	Nozzle MIX	90°	239
0766264	Buterfly	Ace/Prop	Nozzle MIX	75°	242
0764575	Lever	Ace/Prop	Nozzle MIX	180°	267
0767941	Lever	Ace/Prop	Nozzle MIX	90°	319
0764561	Lever	Ace/Prop	Nozzle MIX	75°	322
0764560	Lever	Ace/Prop	Nozzle MIX	45°	340
0764559	Lever	Ace/Prop	Nozzle MIX	180°	347



THE GCE CUTTING NOZZLES, 3-CONE (NOZZLE MIX)

AGN COOLEX

Art. Nr.	Thickness (mm)	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0768691	3 - 10	2,5 - 3,5	0,3	1,250 - 1,650	0,300
0768692	10 - 25	3,0 - 4,0	0,3	2,120 - 3,200	0,400
0768693	25 - 40	3,5 - 4,5	0,3	3,200 - 4,450	0,450
0768694	40 - 60	4,5 - 5,0	0,3	4,500 - 5,500	0,500
0768695	60 - 150	4,5 - 5,5	0,3	8,400 - 9,800	0,600



FGA COOLEX: ACETYLENE

Art. Nr.	Thickness (mm)	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0768698	Size 1	4,0 - 5,0	0,6	4,0 - 4,7	1,1
0768661	Size 2	5,0 - 6,0	0,7	6,3 - 7,3	1,3
0768699	Size 3	6,0 - 7,0	0,8	9,3 - 10,0	1,5



ANME: ACETYLENE



Art. Nr.	Thickness (mm)	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0768670	3 - 10	2,5 - 3,5	0,3	1,25 - 1,65	0,3
0768635	10 - 25	3,0 - 4,0	0,3	2,12 - 3,20	0,4
0768599	25 - 40	3,5 - 4,5	0,3	3,20 - 4,45	0,45
0768636	40 - 60	4,5 - 5,0	0,5	4,50 - 5,50	0,5
0768662	60 - 100	4,5 - 5,5	0,5	8,40 - 9,80	0,6
0768598	100 - 200	5,0 - 6,5	0,5	13,0 - 15,0	0,75
0769041	200 - 300	6,0 - 7,5	0,8	15,0 - 19,0	1,0

THE GCE CUTTING NOZZLES, 3-CONE (NOZZLE MIX)

PNME: PROPANE-NATURAL GAS



Art. Nr.	Thickness (mm)	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0769494	3 - 6	2	0,3	2,1	0,3
0769495	5 - 12	3	0,3	3,2	0,4
0769496	10 - 75	3	0,3	5,2	0,6
0769497	70 - 100	3,5	0,3	7,4	0,8
0769498	90 - 150	3,5	0,3	13,6	1,0
0769499	150 - 200	3,5 - 6,5	0,3	34,7	1,3
0769501	190 - 300	7,0 - 8,5	0,3	42	1,8

PNME COOLEX



Art. Nr.	Thickness (mm)	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0768652	3 - 10	2	0,3	2,1	0,3
0768653	10 - 25	3	0,3	3,2	0,4
0768696	25 - 40	3	0,3	5,2	0,6
0768697	40 - 60	3,5	0,3	7,4	0,8
0768654	60 - 150	3,5	0,3	13,6	1,0
0768785	140 - 200	3,5 - 6,5	0,3	34,7	1,3
0768786	190 - 300	7,0 - 8,5	0,3	42	1,8

COOLEX A 361 GOUGING AND RIVET CUTTING NOZZLE FOR ACETYLENE



Art. Nr.	Thickness (mm)	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0768739	3 - 4	4	0,2 - 0,5	3,1	0,5
0768740	3 - 6	4	0,2 - 0,5	5,6	0,6
0768741	5 - 7	4	0,2 - 0,5	8,7	0,8

COOLEX A 341 BENT RIVET NOZZLE FOR ACETYLENE



Art. Nr.	Pressure - Ox (bar)	Pressure - f. gas (bar)	Flow rate - Ox. (m³/h)	Flow rate - f. gas (m³/h)
0768743	3	0,2 - 0,5	2,8-3,8	0,5
0768744	4	0,2 - 0,5	4,6	0,5
0768745	3 - 6	0,2 - 0,5	5,5	0,6
0768746	4 - 7	0,2 - 0,5	6,5 - 7,7	0,7 - 0,8

X21 FOR WELDING



WELDING ATTACHMENT OXYGEN-ACETYLENE

Art. Nr.	Size Nr.	Gas flow (l/h)	Thickness (mm)
9389430P	0	40	0,2 - 0,5
9389440P	1	80	0,5 - 1,0
9389450P	2	160	1,0 - 2,0
9389460P	2E	230	2,0 - 3,0
9389470P	3	315	2,0 - 4,0
9389480P	3E	400	3,5 - 5,0
9389490P	4	500	4,0 - 6,0
9389500P	4E	650	5,0 - 7,0
9389510P	5	800	6,0 - 9,0
9389520P	5E	1000	7,0 - 10,0
9389530P	6	1250	9,0 - 14,0

X21 FOR HEATING



In addition to various welding attachments, there are three single flame heating attachments for Acetylene, ranging from 1800 to 5000 l/h, as well as three multiple flame heating attachments ranging from 1000 to 5000 l/h. In addition there are four multiple flame heating attachments for Propane, ranging from 1000 to 7000 l/h.

HEATING ATTACHMENT, SINGLE FLAME OXYGEN-ACETYLENE

Art. Nr.	Size Nr.	Working pressure Oxygen (bar)	Working pressure Acetylene (bar)
9389540P	1800 l/h	3	0,3
9389550	2500 l/h	6	0,4
219100228	5000 l/h	8	0,6

HEATING ATTACHMENT, MULTIFLAME OXYGEN-ACETYLENE

Art. Nr.	Size Nr.	Working pressure Oxygen (bar)	Working pressure Acetylene (bar)
202232210	1000 l/h	3	0,3
202232211	2500 l/h	6	0,4
202232212	5000 l/h	8	0,6

HEATING ATTACHMENT, MULTIFLAME OXYGEN-PROPANE

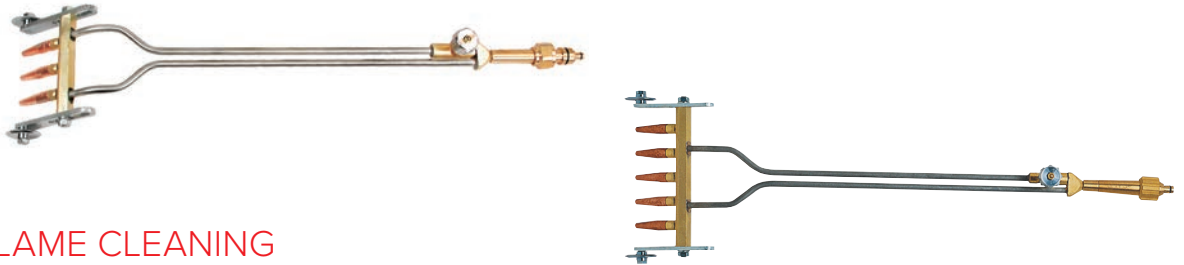
Art. Nr.	Size Nr.	Working pressure Oxygen (bar)	Working pressure Propane (bar)
202232217	1000 l/h	0,9	0,7
202232218	2000 l/h	2,4	0,8
202232219	4000 l/h	4,9	1,9
202232220	7000 l/h	8,0	2,5



X21 FOR FLAME STRAIGHTENING

ACETYLENE

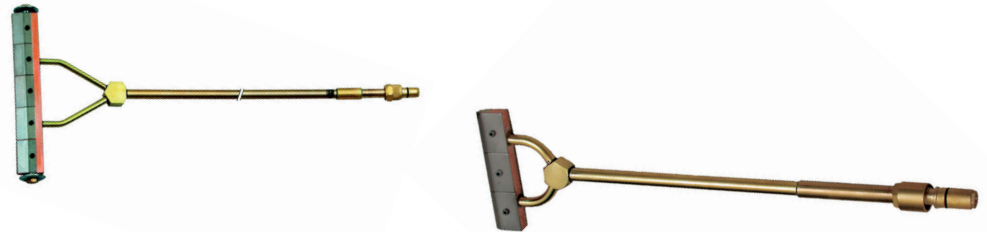
Art. Nr.	Type	Working pressure Oxygen (bar)	Working pressure Acetylene (bar)	Lenght (mm)
14070514	3 nozzles	7	0,7	730
202232267	5 nozzles	7	0,7	690



X21 FOR FLAME CLEANING

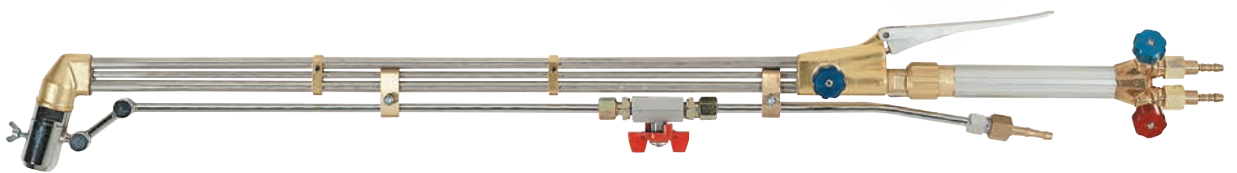
ACETYLENE

Art. Nr.	Width of head (mm)	Working pressure Oxygen (bar)	Working pressure Acetylene (bar)
202235735	50	3	0,7
202235736	150	5	0,7
202235731	250	5	0,8



X21 FOR POWDER CUTTING

Lenght	Head angle
655 mm	75°



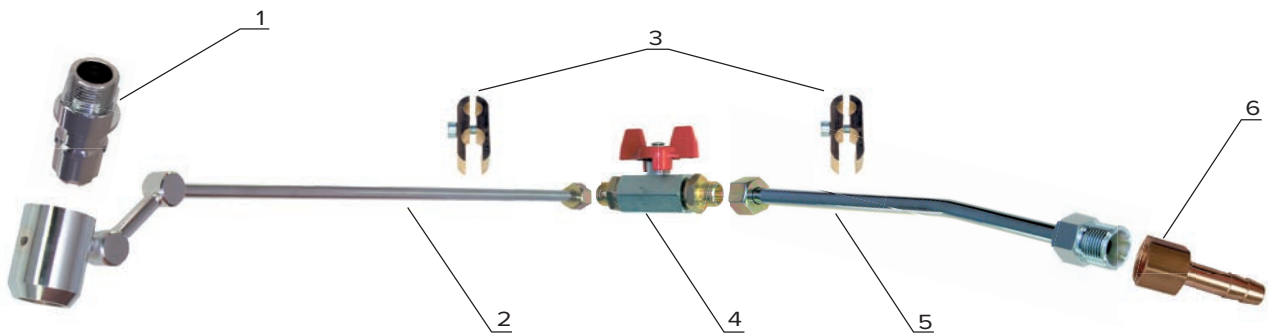
CUTTING NOZZLES HP337 FOR POWDER CUTTING

Art. Nr.	Thickness (mm)	Gas	Working pressure Oxygen (bar)	Working pressure Propane (bar)
14001276	0 - 50	Propane	5	1
14001277	50 - 100	Propane	7	1
14001278	100 - 200	Propane	8	1
14001279	200 - 300	Propane	12	1

POWDER ATTACHMENT

Art. Nr.	Lenght	
14030002	815 mm	

Art. Nr.	Description	Position
14030004	Powder nozzle	1
14030003	Powder head with neck	2
14030007	Clamp	3
14030006	Ball valve	4
14030005	Tube with fittings	5
14099611	Hose nipple 6,3×G3/8"	6
14099672	Nut G3/8"	
IPF2007	Iron powder feeding	



X21 ACCESSORIES

Art. Nr.	Description	Position
219100280	Radius arm with centre point, big wheel	1
548219100297P	Radius arm with centre point, small wheel	2
202130143	Hole cutting attachment	3
219100296	Twin wheel cutting guide, big wheels for bevel cutting	4
548219100295	Twin wheel cutting guide, big wheels	5
214100454	Twin wheel cutting guide, small wheels	6
548219100509	Bushing	7

