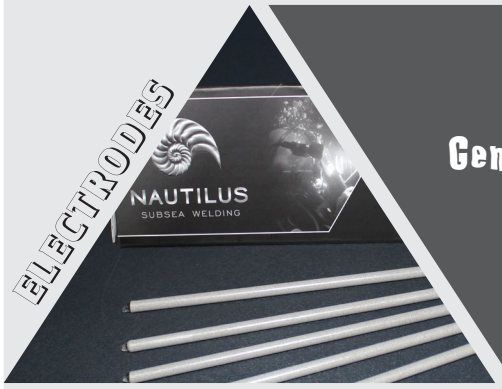
NAUTILUS
SUBSEA WELDING

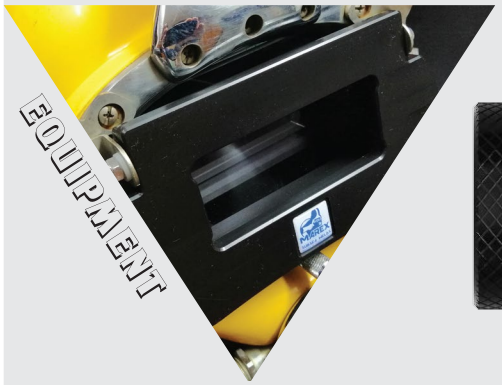
Experts to the Welding Industry

Nautilus Welding Torch



General

The **NAUTILUS** Welding **Torch** is the only electrode holder you will ever need. Its unique design allows for complete dismantling and replacement of all parts, on site, without the need for any special tool or training. The holder can also be adjusted for wear through it's patented design, which allows the main collet body to be turned, with each full revolution moving the body up 1.0mm, to allow for over 10mm of adjustment to be made. It has a simple mechanism to tighten and release electrodes. It is manufactured from a tough, hardwearing, fully insulating material that is virtually inderstructible and provides the maximum protection for the diver. The holder can also be used safely above water, where it offers a 250 amperage rating at 60% duty cycle. Design allows for the electrodes ranging from 2.5mm (3/32") to 5.0mm (3/16") to be used, and is available with or without a whip lead. All parts are available separately, making it the only **Torch** you will ever need.



Benefits

- Parts can be easily and quickly assembled/dis-assmbled on site without special tools
- Large replaceable wear face in head
- Adjustable for wear, through the main cable connector
- Non-conductive, tough, hardwearing material
- Size & style allows for firm grip, even when wearing gloves
- Electrode guide-slot, to help fit electrodes in poor visibility
- Can be used on surface / Fits electrodes 2.5mm - 5.0mm

Available with or without cable fitted

Operational lifetime depends on the handling, not on the design
* Only competent person (in accordance to IMCA D018) following fitting instructions shall conduct products' installation

To place an order contact our local partner or vistit our website

Nautilus Subsea Welding
41 Propylaion Street, Rita Court 50
4th Floor, Flat 401, P.O.: 1048
Nicosia, CYPRUS
Registaration No.: HE 401334
Tax Identification No.: 10401334

www.nautilussubseawelding.com

David J. Keats
+44 (0) 7974 931591
david.keats@nautilussubseawelding.com

George A. Maroudas
+30 6955 58 99 28
g.maroudas@nautilussubseawelding.com

Bart Cassiers
+31 6 53 59 17 17
bart.cassiers@nautilussubseawelding.com

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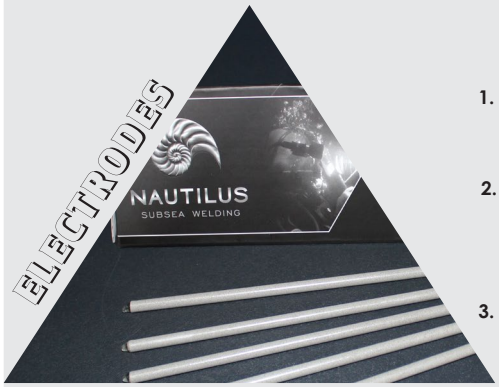

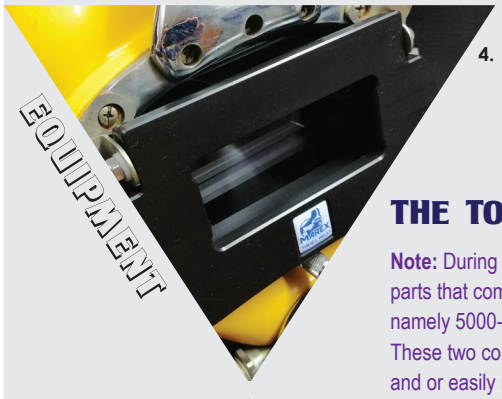

Instructions

1. • Place cable retainer 5000-5 over your welding cable[1]. (If Torch supplied with whip lead already fitted, ignore this instruction).

2. • Fit welding cable into cable connector, 5000-4 and tighten the two stainless steel grub screws.
   • Ensure cable covering is cut back to the appropriate length.

3. • Remove securing pin 5000-3A from main body. Take note of milled slot in side of cable connector UW5005 as this is where the securing pin sits, to make secure.

4. • The thread on 5000-4 can now be screwed up into the main body 5000-3. Continue turning 5000-3 until slot comes into view through securing pinhole.
   • Now secure the pin 5000-3A into side of main body 5000-3.

THE TORCH NOW IS READY FOR USE

Note: During use the parts of the torch that will wear are those parts that come directly into contact with the electrode; namely 5000-2 wear plug and 5000-5 cable connector. These two components have been designed to be adjustable and or easily replaceable.

5. • Wear plug 5000-2 is fixed into the head UW5000-1 by a thread and can be removed as required. During normal welding operations wear will take place on the wear plug and cable connector, thereby reducing their thickness.
   • To ensure secure fixture of the electrode at all times adjustments can be made through the cable connector to compensate for this wear.
   • By removing the securing pin and loosening the cable retainer the cable connector UW5004 can be rotated 360° One turn clockwise, or as many turns as is required to compensate for the degree of wear that has taken place.
   • Once the degree of wear has reduced the wear plug to less than the degree of adjustment that can be made by the cable connector, the plug and/or cable connector should be replaced.

HEAD/CUP (5000-1)

WEAR PLUG (5000-2)

SECURING PIN (5000-3A)

CABLE CONNECTOR (5000-4)

CABLE RETAINER (5000-5)

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Quality
Innovation
Expertise
Training & Certification

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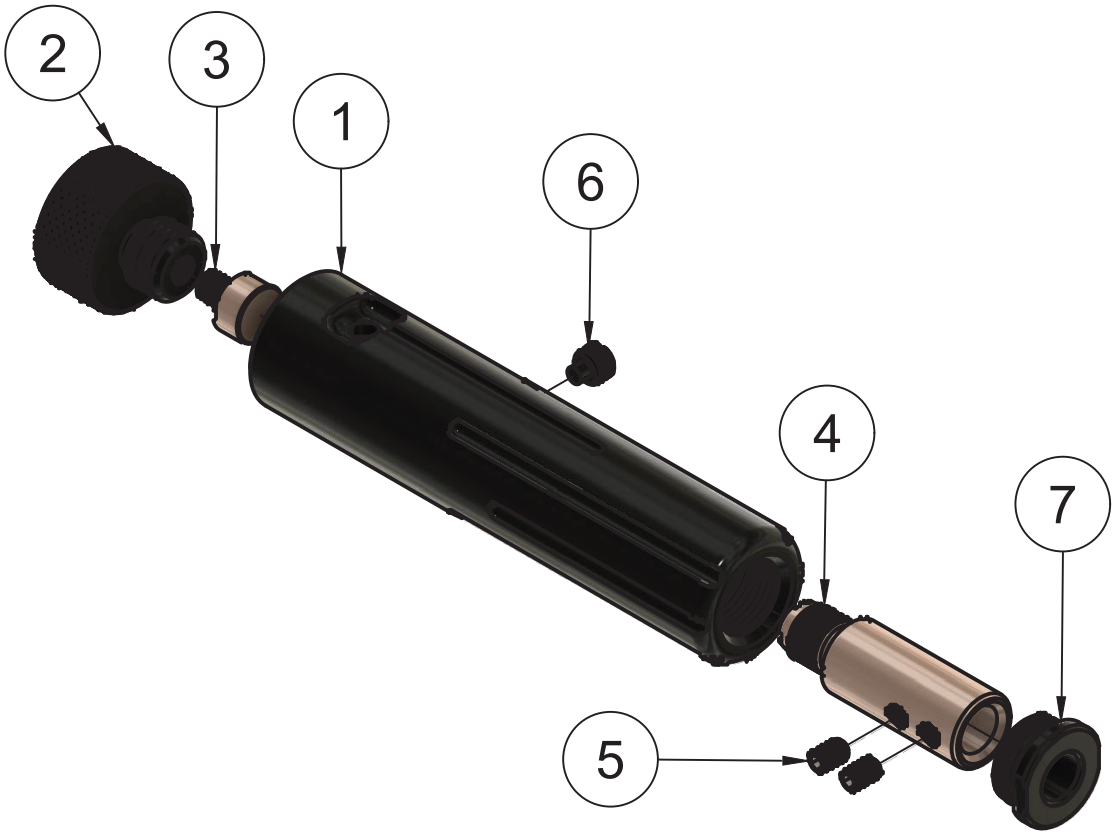
David J. Keats
+44 (0) 7974 931591
david.keats@nautilussubseawelding.com

George A. Maroudas
+30 6955 58 99 28
g.maroudas@nautilussubseawelding.com

Bart Cassiers
+31 6 53 59 17 17
bart.cassiers@nautilussubseawelding.com

Parts List

Item	Qty	Part Number	Part Name	Material
1	1	5000-3 Main Body	5000-3 Main Body v27	Acetal Resin, Black
2	1	5000-1	5000-1 Cup v7	Acetal Resin, Black
3	1	5000-2	5000-2 Wear Plug v1	Copper
4	1	5000-4 Cable Connector	5000-4 Cable Connector v4	Copper
5	2	5000-4A Securing Pin	5000-4A Securing Pin v2	Stainless Steel 316L
6	1	5000-3A Securing Pin	5000-3A Securing Pin v4	Acetal Resin, Black
7	1	5000-5 Cable Retainer	5000-5 Cable Retainer v3	Acetal Resin, Black



NAUTILUS
SUBSEA WELDING

MANUFACTURER **MAREX SUBSEA WELDS LTD**	DATE 26/04/2020
OWNER **NAUTILUS SUBSEA WELDING LTD**	DOCUMENT STATUS ACTIVE
TITLE PART # 5000 NAUTILUS WELDING TORCH	DWG No MSSW-DWG-2020-003

REV.	DATE OF ISSUE	SHEET No
07	01/05/2020	1/1