



WALLCOLMONOY

**“Fast and Easy Detailed Hardsurfacing Build-Up”**

## Fusewelder™ Torch

# WALL COLMONOY'S HARD-SURFACING EQUIPMENT

The Fusewelder™ Torch is a special oxy-acetylene torch which preheats the base metal, sprays powdered alloy and fuses deposits to the workpiece – all with one integrated unit.

### Benefits & Usage:

- Protects critical parts against wear
- Repairs cast iron and most ferrous metals
- Restores undersized parts

### Superior Results with Easy, Trouble-Free Operation:

**Precision control** – plunger-type valve assembly provides instant powder flow shut-off.

**Durability** – sturdy metal hoppers and heavy-duty copper tips with wear-resistant inserts.

**Versatility** – spraying small, narrow areas and even overhead work is possible.

**Powders** - Wall Colmonoy's Fusewelder™ Powders are designed for use in the Fusewelder™ Torch. It may also be used to apply Wall Colmonoy's Spraywelder™ powders and Nicrobraz® high-temperature brazing filler metal powders.

**Easy Maintenance** – entire torch is easily disassembled for quick clean-up and maintenance.

**Safety** - supplied with built-in flash-back arrestors and reverse flow check valves.

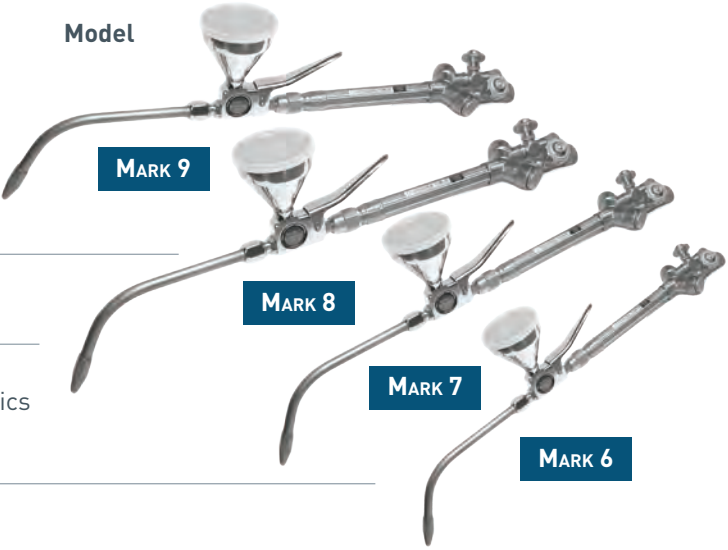
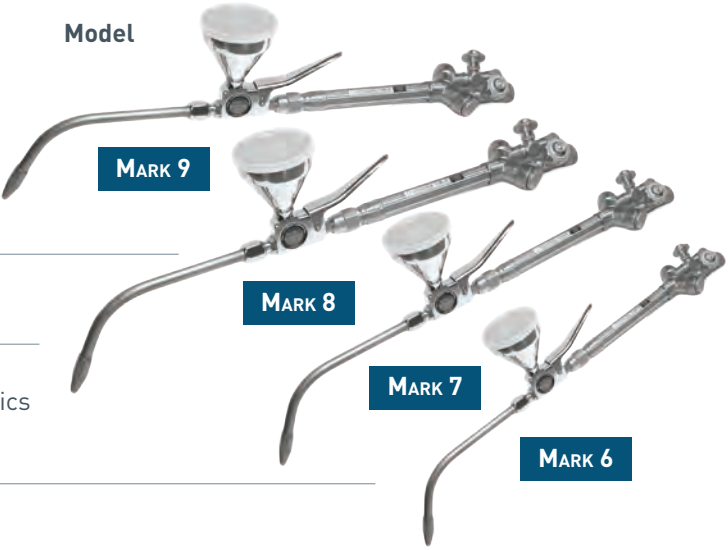
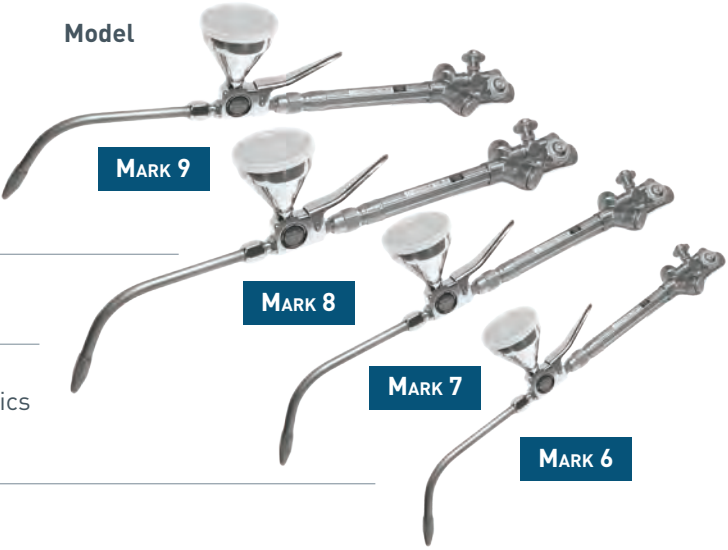
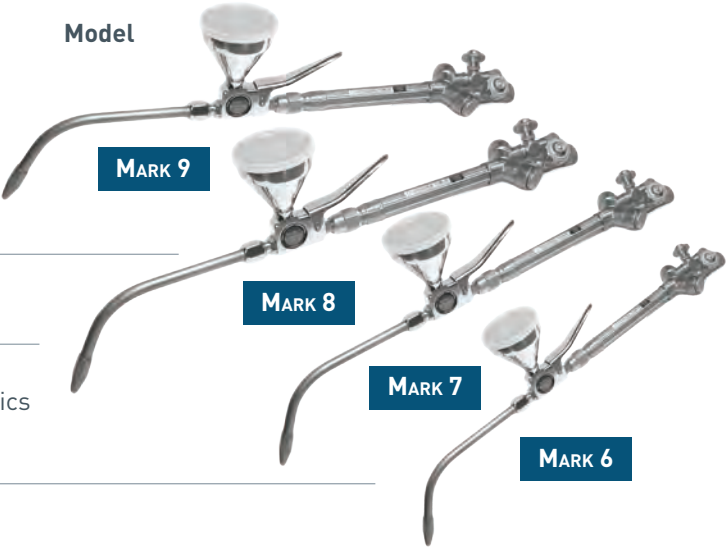
**Flexibility** - Four models are available with different powder spray capacities for fine detail work or larger components.

4 models each spraying at different rates



## EQUIPMENT

Four Fusewelder™ models are available with different powder spray capacities for fine detail work or larger components

Tip	Powder Spray No. Capacity kg/hr (lbs/hr)	Features	Model
84	4.5 (9.9)	Designed for work on larger parts Up to 62,500 BTUs	
80 MF*	4.5 (9.9)		
94	6.4 (14.2)		
64	3.2 (7.0)	Larger powder hopper Up to 33,500 BTUs	
74	4.1 (9.0)		
44	1.7 (3.7)	Widest spray capacity range and characteristics Up to 22,000 BTUs	
54	2.8 (6.2)		
40 MF*	1.7 (3.7)		
50 MF*	2.8 (6.2)		
24	0.59 (1.3)	For fine detail work (edges and corners) Up to 14,000 BTUs	
34			

\*Multi-flame tips provide wider spray patterns

## ACCESSORIES

### Detached Production Hopper

The production hopper holds more than 9 kg (20 lbs.) of powder, permitting continuous spraying. Hopper includes cover and hose. Powder is gravity-fed to the torch. May be used with all Fusewelder™ models.

### Water/Air-Cooled Nozzle

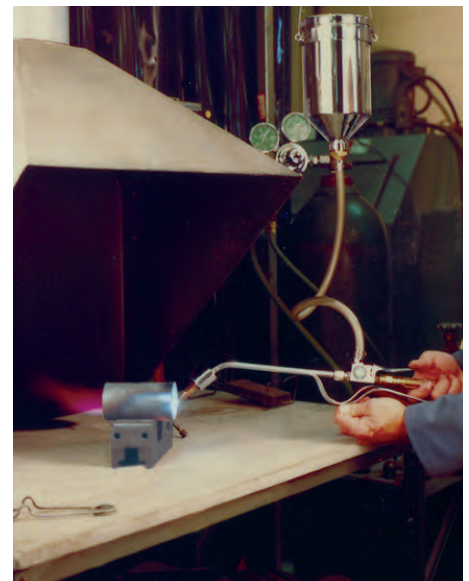
This special nozzle is surrounded with tubing for circulating water or air to cool the nozzle and tip. This is useful where a cavity entraps heat around the tip end, or to prevent undue wear when the torch is used in high production work. May be used with all models.

### Nozzle Extensions

Extensions are made to order and available in three lengths (7, 10 and 18 inches) to spray difficult-to-reach areas. They may be joined to achieve longer lengths.

### Gas Regulators

Oxygen and acetylene regulators provide reliable, precise gas control. Each consists of a two-stage design, displaying both supply and regulated pressure.



Detached production hopper permits continuous spraying

## COLMONOY® (nickel-based)

ALLOY	HARDNESS HRC	FUSING TEMP °C (°F)	DESCRIPTION
<b>24</b>	16-23	1065 (1950)	<b>Ductile, Easily Finished Alloys</b> Atomized nickel-based alloys for use on cast iron parts, can be finished by filing or grinding
<b>23A</b>	16-23	1065 (1950)	
<b>21</b>	22-27	915 (1680)	
<b>22</b>	28-33	930 (1705)	
<b>43</b>	35-40	980 (1800)	<b>Chromium-Carbide Alloys</b> Atomized nickel-based alloys containing chromium carbides for abrasion and corrosion resistance.
<b>63</b>	56-63	1025 (1875)	
<b>705</b>	58-63	1025 (1875)	<b>Composite Alloys</b> Uniquely formulated nickel-based composites containing tungsten carbide for resistance to sliding abrasion.
<b>225</b>	13-17	900 (1650)	<b>Specially Formulated Alloys for Glass Moulds</b> Colmonoy 200-series Alloys are specially formulated for protecting and restoring glass container moulds (cast iron and aluminum bronze).
<b>226</b>	18-21	935 (1715)	
<b>227</b>	22-27	915 (1680)	
<b>228</b>	28-33	930 (1705)	
<b>229</b>	25-30	915 (1680)	
<b>234</b>	32-36	995 (1825)	
<b>323</b>	20-25	865 (1590)	<b>For Application to Poor Quality Cast Iron and Steel Base Metals</b> Low melting with excellent wettability on cast irons and bronze. Deposits have high oxidation resistance and are easily finished with a file or by grinding.
<b>88*</b>	59-64	1100 (2020)	<b>Wear, Heat &amp; Corrosion-Resistant Alloy</b> Unique alloy contains chromium/tungsten borides and carbides for maximum abrasion and corrosion resistance. For high-temperature, highly abrasive applications.

\*Colmonoy 88 HV is also available as a finer cut for the Fusewelder™ Torch



Water-cooled nozzle prevents undue wear when the torch is used in high production work



Fusewelder™ Torch spraying Colmonoy 227 on glass container moulds

[www.fusewelder.com](http://www.fusewelder.com)

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**WALLCOLMONOY**

**Wall Colmonoy. Making Metals Work Harder Since 1938.**

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