



ARC MACHINES, INC. *The widest range of orbital welding equipment in the world*

ELECTRODE SELECTOR for inch (OD) tube and IPS pipe sizes

All dimensions shown in inches

Weld Head Model	Tube O.D.	Wall Thickness (Schedule)	Part Number	Arc Gap	Weld Head Model	Tube O.D.	Wall Thickness (Schedule)	Part Number	Arc Gap	
9-250		.125 .020/.035	TC04-0318-01	.020	9AFM-750 <i>Continued</i>		.375 .022/.035	TC04-0438-02	.030	
		.250 .020/.035	TC04-0246-02	.030				.375 .049/.065	TC04-0418-02	.050
9-500	1/8" ABW/ATW	.020/.035	TC04-0584-02	.030			.500 .022/.035	TC04-0376-02	.030	
	1/4" ABW/ATW	.028/.049	TC04-0506-02	.045			.500 .049/.065	TC04-0356-02	.050	
	3/8" ABW/ATW	.028/.049	TC04-0444-02	.045		.540 (1/4" pipe)	(5-10)	TC04-0336-03	.050	
		.125 .020/.035	TC04-0611-01	.020			.625 .022/.035	TC04-0313-02	.030	
		.250 .020/.035	TC04-0539-02	.030			.625 .049/.065	TC04-0293-03	.050	
		.250 .049/.065	TC04-0524-02	.045	9-1500		.250 .022/.035	TC06-1438-02	.030	
		.375 .022/.035	TC04-0476-02	.030				.250 .049/.065	TC06-1418-03	.050
		.375 .049/.065	TC04-0461-02	.045				.375 .022/.035	TC06-1376-02	.030
		.500 .022/.035	TC04-0414-02	.030				.375 .049/.065	TC06-1356-03	.050
		.500 .049/.065	TC04-0399-02	.045				.500 .022/.035	TC06-1313-02	.030
							.500 .049/.083	TC06-1293-03	.050	
							.500 .095/.120	TC09-1273-04	.070	
							.540 (1/4" pipe)	(5-40)	TC06-1273-03	.050
							.625 .022/.035	TC06-1251-02	.030	
							.625 .049/.083	TC06-1231-03	.050	
9-750	1/8" ABW/ATW	.020/.035	TC04-0890-02	.030		.675 (3/8" pipe)	(5-10)	TC06-1206-03	.050	
	1/4" ABW/ATW	.028/.049	TC06-0806-03	.050		.675 (3/8" pipe)	(40)	TC09-1186-04	.070	
	3/8" ABW/ATW	.028/.049	TC06-0745-03	.050		.750 .022/.035	TC06-1188-02	.030		
	1/2" ABW/ATW	.028/.065	TC06-0677-03	.050		.750 .049/.083	TC06-1168-03	.050		
	5/8" ABW/ATW	.028/.065	TC06-0612-03	.050		.750 .095/.120	TC09-1148-04	.070		
	3/4" ABW/ATW	.028/.065	TC06-0546-03	.050		.750 .049/.083	TC06-1148-04	.070		
	3/4" ABW/ATW	.072/.095	TC06-0526-04	.070		.840 (1/2" pipe)	(5-10)	TC06-1123-03	.050	
		.125 .020/.035	TC04-0917-01	.020		.840 (1/2" pipe)	(40)	TC09-1103-04	.070	
		.250 .022/.035	TC06-0845-02	.030		1.000 .049/.083	TC06-1043-03	.050		
		.250 .049/.065	TC06-0825-03	.050		1.000 .095/.120	TC09-1023-04	.070		
		.375 .022/.035	TC06-0782-02	.030		1.050 (3/4" pipe)	(5-10)	TC06-1018-03	.050	
		.375 .049/.065	TC06-0762-03	.050		1.050 (3/4" pipe)	(40)	TC09-0998-04	.070	
		.500 .022/.035	TC06-0720-02	.030		1.250 .049/.083	TC06-0918-03	.050		
		.500 .049/.083	TC06-0700-03	.050		1.315 (1" pipe)	(5)	TC06-0886-03	.050	
		.500 .095/.120	TC06-0680-04	.070		1.315 (1" pipe)	(10-40)	TC09-0866-04	.070	
		.540 (1/4" pipe)	(5-10)	TC06-0680-03	.050		1.500 .049/.083	TC06-0793-03	.050	
		.540 (1/4" pipe)	(40)	TC06-0660-04	.070		1.500 .095/.120	TC09-0773-04	.070	
		.625 .022/.035	TC06-0657-02	.030	9AF-1500	*1/4" ABW/ATW	.028/.049	TC06-0933-03	.050	
		.625 .049/.083	TC06-0637-03	.050			*3/8" ABW/ATW	.028/.049	TC06-0871-03	.050
		.675 (3/8" pipe)	(5-10)	TC06-0612-03		.050		*1/2" ABW/ATW	.028/.065	TC06-0803-03
	.675 (3/8" pipe)	(40)	TC06-0592-04	.070			5/8" ABW/ATW	.028/.065	TC06-0738-03	.050
	.750 .022/.035	TC06-0595-02	.030			3/4" ABW/ATW	.035/.065	TC06-0668-03	.050	
	.750 .049/.083	TC06-0575-03	.050			3/4" ABW/ATW	.072/.095	TC09-0648-04	.070	
	.750 .095/.120	TC06-0555-04	.070			1" ABW/ATW	.049/.065	TC06-0543-03	.050	
	.840 (1/2" pipe)	(5-10)	TC06-0530-03	.050			1" ABW/ATW	.083/.109	TC09-0523-04	.070
							.250 .022/.035	TC06-0971-02	.030	
							.250 .049/.065	TC06-0951-03	.050	
						.375 .022/.035	TC06-0908-02	.030		
						.375 .049/.065	TC06-0888-03	.050		
9AFM-750	1/8" ABW/ATW	.020/.035	TC04-0546-02	.030						
	1/4" ABW/ATW	.028/.049	TC04-0463-02	.050						
	3/8" ABW/ATW	.028/.049	TC04-0401-02	.050						
	1/2" ABW/ATW	.028/.065	TC04-0333-02	.050						
		.125 .020/.035	TC04-0573-01	.020						
		.250 .022/.035	TC04-0501-02	.030						
	.250 .049/.065	TC04-0481-02	.050							

* Except Parker ** Except 9E-3500

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AMI is an ISO Certified Company

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ELECTRODE SELECTOR FOR INCH (OD) TUBE AND IPS PIPE SIZES

All dimensions shown in inches

Weld Head Model	Tube O.D.	Wall Thickness (Schedule)	Part Number	Arc Gap	Weld Head Model	Tube O.D.	Wall Thickness (Schedule)	Part Number	Arc Gap	
9AF-1500 <i>Continued</i>	.500	.022/.035	TC06-0846-02	.030	8-2000 <i>Continued</i>	1.050 (3/4" pipe)	(40)	TC09-1131-04	.070	
	.500	.049/.083	TC06-0826-03	.050		1.250	.049/.083	TC06-1051-03	.050	
	.500	.095/.120	TC09-0806-04	.070		1.315 (1" pipe)	(5)	TC06-1018-03	.050	
	.540 (1/4" pipe)	(5-40)	TC06-0806-04	.050		1.315 (1" pipe)	(10-40)	TC09-0998-04	.070	
	.625	.022/.035	TC06-0783-02	.030		1.500	.049/.083	TC06-0926-03	.050	
	.625	.049/.065	TC06-0763-03	.050		1.500	.095/.120	TC09-0906-03	.070	
	.675 (3/8" pipe)	(5-10)	TC06-0738-03	.050		1.660 (1 1/4" pipe)	(5)	TC06-0846-03	.050	
	.675 (3/8" pipe)	(40)	TC09-0718-04	.070		1.660 (1 1/4" pipe)	(10-40)	TC09-0826-04	.070	
	.750	.020/.035	TC06-0721-02	.030		1.900 (1 1/2" pipe)	(5)	TC06-0726-03	.050	
	.750	.049/.083	TC06-0701-03	.050		1.900 (1 1/2" pipe)	(10-40)	TC09-0706-04	.070	
	.750	.095/.120	TC09-0681-04	.070		2.000	.049/.083	TC06-0676-03	.050	
	.840 (1/2" pipe)	(5-10)	TC06-0656-03	.050		2.000	.095/.120	TC09-0656-04	.070	
	.840 (1/2" pipe)	(40)	TC09-0636-04	.070						
	1.000	.049/.083	TC06-0576-03	.050		9-2500	.750	.049/.083	TC06-1765-03	.050
	1.000	.095/.120	TC09-0556-04	.070			.750	.095/.120	TC09-1745-04	.070
	1.050 (3/4" pipe)	(5-10)	TC06-0551-03	.050			.840 (1/2" pipe)	(5-10)	TC09-1720-03	.050
	1.050 (3/4" pipe)	(40)	TC09-0531-04	.070			.840 (1/2" pipe)	(40)	TC09-1700-04	.070
							1.000	.049/.083	TC06-1640-03	.050
							1.000	.095/.120	TC09-1620-04	.070
							1.050 (3/4" pipe)	(5-10)	TC06-1615-03	.050
				1.050 (3/4" pipe)	(40)		TC09-1595-04	.070		
				1.250	.049/.083		TC06-1515-03	.050		
				1.315 (1" pipe)	(5)		TC06-1482-03	.050		
				1.315 (1" pipe)	(10-40)		TC09-1462-04	.070		
				1.500	.049/.083		TC06-1390-03	.050		
				1.500	.095/.120		TC09-1370-04	.070		
				1.660 (1 1/4" pipe)	(5)		TC06-1310-03	.050		
				1.660 (1 1/4" pipe)	(10-40)		TC09-1290-04	.070		
				1.900 (1 1/2" pipe)	(5)		TC06-1190-03	.050		
				1.900 (1 1/2" pipe)	(10-40)		TC09-1170-04	.070		
				2.000	.049/.083		TC06-1140-03	.050		
				2.000	.095/.120		TC09-1120-04	.070		
				2.375 (2" pipe)	(5)		TC06-0952-03	.050		
				2.375 (2" pipe)	(10-40)	TC09-0932-04	.070			
				2.500	.049/.083	TC06-0870-03	.070			
				2.500	.095/.120	TC09-0870-04	.070			
				9E-2500	.750	.049/.083	TC06-1715-03	.050		
					.750	.095/.120	TC09-1695-04	.070		
					.840 (1/2" pipe)	(5-10)	TC06-1670-03	.050		
					.840 (1/2" pipe)	(40)	TC09-1650-04	.070		
					1.000	.049/.083	TC06-1590-03	.050		
					1.000	.095/.120	TC09-1570-04	.070		
					1.050 (3/4" pipe)	(5-10)	TC06-1565-03	.050		
					1.050 (3/4" pipe)	(40)	TC09-1545-04	.070		
					1.250	.049/.083	TC06-1465-03	.050		
					1.315 (1" pipe)	(5)	TC06-1432-03	.050		
					1.315 (1" pipe)	(10-40)	TC09-1412-04	.070		
					1.500	.049/.083	TC06-1340-03	.050		
					1.500	.095/.120	TC09-1320-04	.070		
					1.660 (1 1/4" pipe)	(5)	TC06-1260-03	.050		
					1.660 (1 1/4" pipe)	(10-40)	TC09-1240-04	.070		
					1.900 (1 1/2" pipe)	(5)	TC06-1140-03	.050		
					1.900 (1 1/2" pipe)	(10-40)	TC09-1120-04	.070		
					2.000	.049/.083	TC06-1090-03	.050		
					2.000	.095/.120	TC09-1070-04	.070		
					2.375 (2" pipe)	(5)	TC06-0902-03	.050		
				2.375 (2" pipe)	(10-40)	TC09-0882-04	.070			

* Except Parker ** Except 9E-3500

ELECTRODE SELECTOR FOR INCH (OD) TUBE AND IPS PIPE SIZES

All dimensions shown in inches

Weld Head Model	Tube O.D.	Wall Thickness (Schedule)	Part Number	Arc Gap	
9E-4500 <i>Continued</i>	2.500	.065/.083	TC06-1820-03	.070	
	2.500	.095/.120	TC09-1820-04	.070	
	2.875 (2 1/2" pipe)	(5)	TC06-1632-03	.070	
	2.875 (2 1/2" pipe)	(10)	TC09-1632-04	.070	
	3.000	.065/.083	TC06-1570-03	.070	
	3.000	.095/.120	TC09-1570-04	.070	
	3.500	.065/.083	TC06-1320-03	.070	
	3.500	.095/.120	TC09-1320-04	.070	
	3.500 (3" pipe)	(5-10)	TC09-1320-04	.070	
	4.000	.065/.083	TC06-1070-03	.070	
	4.000	.095/.120	TC09-1070-04	.070	
	4.000 (3 1/2" pipe)	(5-10)	TC09-1070-04	.070	
	9ER-4500	1.500	.049/.083	TC09-2088-03	.050
		1.500	.095/.120	TC09-2068-04	.070
1.660 (1 1/4" pipe)		(5)	TC09-2008-03	.050	
1.660 (1 1/4" pipe)		(10-40)	TC09-1988-04	.070	
1.900 (1 1/2" pipe)		(5)	TC09-1888-03	.050	
1.900 (1 1/2" pipe)		(10-40)	TC09-1868-04	.070	
2.000		.049/.083	TC09-1838-03	.050	
2.000		.095/.120	TC09-1818-04	.070	
2.375 (2" pipe)		(5)	TC09-1651-03	.050	
2.375 (2" pipe)		(10-40)	TC09-1631-04	.070	
2.500		.065/.083	TC09-1568-03	.070	
2.500		.095/.120	TC09-1568-04	.070	
2.875 (2 1/2" pipe)		(5)	TC09-1380-03	.070	
2.875 (2 1/2" pipe)		(10)	TC09-1380-04	.070	
3.000		.065/.083	TC09-1318-03	.070	
3.000		.095/.120	TC09-1318-04	.070	
3.500		.065/.083	TC09-1068-03	.070	
3.500		.095/.120	TC09-1068-04	.070	
3.500 (3" pipe)		(5)	TC09-1068-03	.070	
3.500 (3" pipe)		(10)	TC09-1068-04	.070	
4.000		.065/.083	TC09-0818-03	.070	
4.000		.095/.120	TC09-0818-04	.070	
4.000 (3 1/2" pipe)		(5)	TC09-0818-04	.070	
4.000 (3 1/2" pipe)		(10)	TC09-0818-04	.070	
4.500		.095/.120	TC09-0568-04	.070	
4.500 (4" pipe)		(5)	TC09-0568-03	.070	
4.500 (4" pipe)		(10)	TC09-0568-04	.070	
8-6625		1.000	.049/.083	TC06-3497-03	.050
		1.000	.095/.120	TC09-3477-04	.070
		1.050 (3/4" pipe)	(5-10)	TC06-3472-03	.050
	1.050 (3/4" pipe)	(40)	TC09-3452-04	.070	
	1.315 (1" pipe)	(5)	TC06-3339-03	.050	
	1.315 (1" pipe)	(10-40)	TC09-3319-04	.070	
	1.500	.049/.083	TC06-3247-03	.050	
	1.500	.095/.120	TC09-3227-04	.070	
	1.660 (1 1/4" pipe)	(5)	TC06-3167-03	.050	
	1.660 (1 1/4" pipe)	(10-40)	TC09-3147-04	.070	
	1.900 (1 1/2" pipe)	(5)	TC06-3047-03	.050	
	1.900 (1 1/2" pipe)	(10-40)	TC09-3027-04	.070	
	2.000	.049/.083	TC06-2997-03	.050	
	2.000	.095/.120	TC09-2977-04	.070	
	2.375 (2" pipe)	(5)	TC06-2809-03	.050	
	2.375 (2" pipe)	(10-40)	TC09-2789-04	.070	
	2.500	.049/.083	TC06-2727-03	.070	
	2.500	.095/.120	TC09-2727-04	.070	
	2.875	(5)	TC06-2539-03	.070	
	2.875	(10)	TC09-2539-04	.070	

Weld Head Model	Tube O.D.	Wall Thickness (Schedule)	Part Number	Arc Gap
8-6625 <i>Continued</i>	3.000	.065/.083	TC06-2477-03	.070
	3.000	.095/.120	TC09-2477-04	.070
	3.500	.065/.083	TC06-2227-03	.070
	3.500	.095/.120	TC09-2227-04	.070
	3.500 (3" pipe)	(5)	TC06-2227-03	.070
	3.500 (3" pipe)	(10)	TC09-2227-04	.070
	4.000	.065/.083	TC06-1977-03	.070
	4.000	.095/.120	TC09-1977-04	.070
	4.500	.095/.120	TC09-1727-04	.070
	4.500 (4" pipe)	(5-10)	TC09-1727-04	.070
	5.000	.065/.083	TC06-1477-03	.070
	5.000	.095/.120	TC09-1477-04	.070
	5.563 (5" pipe)	(5-10)	TC09-1195-04	.070
	6.000	.065/.083	TC06-0977-03	.070
6.000	.095/.120	TC09-0977-04	.070	
6.625 (6" pipe)	(5-10)	TC09-0664-04	.070	
9-7500	2.875 (2 1/2" pipe)	(5)	TC06-3712-03	.070
	2.875 (2 1/2" pipe)	(10)	TC09-3712-04	.070
	3.000	.065/.083	TC06-3650-03	.070
	3.000	.095/.120	TC09-3650-04	.070
	3.500	.065/.083	TC06-3400-03	.070
	3.500	.095/.120	TC09-3400-04	.070
	3.500 (3" pipe)	(5-10)	TC09-3400-04	.070
	4.000	.065/.083	TC06-3150-03	.070
	4.000	.095/.120	TC09-3150-04	.070
	4.000 (3 1/2" pipe)	(5-10)	TC09-3150-04	.070
	4.500	.083/.120	TC09-2900-04	.070
	4.500 (4" pipe)	(5-10)	TC09-2900-04	.070
	5.000	.065/.083	TC06-2650-03	.070
	5.000	.095/.120	TC09-2650-04	.070
	5.563 (5" pipe)	(5-10)	TC09-2368-04	.070
	6.000	.065/.083	TC06-2150-03	.070
	6.000	.095/.120	TC09-2150-04	.070
	6.625 (6" pipe)	(5-10)	TC09-1837-04	.070
7.000	.095/.120	TC09-1650-04	.070	
9E-7500	2.875 (2 1/2" pipe)	(5)	TC06-3180-03	.070
	2.875 (2 1/2" pipe)	(10)	TC09-3180-04	.070
	3.000	.065/.083	TC06-3117-03	.070
	3.000	.095/.120	TC09-3117-04	.070
	3.500	.065/.083	TC06-2867-03	.070
	3.500	.095/.120	TC09-2867-04	.070
	3.500 (3" pipe)	(5-10)	TC09-2867-04	.070
	4.000	.065/.083	TC06-2617-03	.070
	4.000	.095/.120	TC09-2617-04	.070
	4.000 (3 1/2" pipe)	(5-10)	TC09-2617-04	.070
	4.500	.095/.120	TC09-2367-04	.070
	4.500 (4" pipe)	(5-10)	TC09-2367-04	.070
	5.000	.065/.083	TC06-2117-03	.070
	5.000	.095/.120	TC09-2117-04	.070
	5.563 (5" pipe)	(5-10)	TC09-1836-04	.070
	6.000	.065/.083	TC06-1617-03	.070
	6.000	.095/.120	TC09-1617-04	.070
	6.625 (6" pipe)	(5-10)	TC09-1305-04	.070

ABW/ATW Fittings: Some fittings will not fit in certain weld heads, and some "ABW/ATW" type fittings (with a filler lip on the weld end) are not designated as ABW or ATW by the manufacturer.

Electrode part numbers for tube or pipe sizes not listed on this chart are available.

Consult factory or sales representative for application or part number information.

* Except Parker ** Except 9E-3500