



Gas Control Equipment



COMBINED WELDING & CUTTING TORCH FOR MEDIUM DUTY APPLICATIONS

GCE X20™ MK 4/5 ORIGINAL

GCE continues introducing the new torch design across the extensive Cutting & Welding product range. Now it's time to present the GCE X20™ MK 4/5 ORIGINAL torch program.

The GCE X20™ MK 4/5 ORIGINAL is a high pressure, sturdily constructed and well-balanced welding and cutting torch replacing the MK 4/5, together with additional improved progressive features. Each component (shank, mixer, cutting attachment) is interchangeable with other leading makes of type 3/4/5 equipment. It has a new design and well-balanced front-mounted colour-coded control valves, employing stainless valve spindles. Providing fine adjustment and leak-free conditions. The shank is common to both welding and cutting attachment the same quick positive positioning and leak-free means of attachment being used for both. The GCE X20™ MK 4/5 ORIGINAL torch system and nozzles conform to the EN ISO 5172.



GCE X20™ MK 4/5 ORIGINAL

FEATURES

WELDING AND HEATING

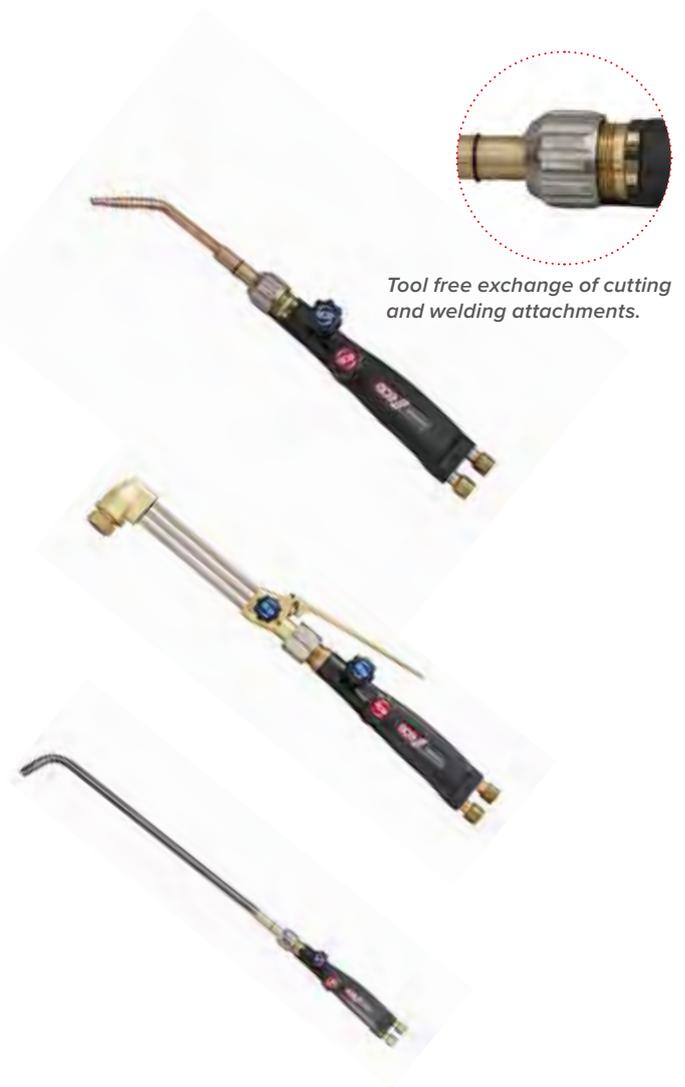
- Designed for welding work from 1 mm to over 25 mm thickness using type GCE X20™ MK 4/5 ORIGINAL swaged nozzles sizes 1 - 90 ft³/h litres.
- The mixer seats on serrated toothed faces allowing the operator a selection of positive nozzle positioning through 360°.
- Can also be used for heating, with either acetylene or propane heating nozzles, together with a heating neck.

CUTTING

- The cutting head is nozzle mixing, enabling the operator to use either acetylene or propane fuel gases by fitting the appropriate nozzle.
- A range of ANM and PNM nozzles are available for clean efficient cutting of material thickness from sheet metal to 150 mm.
- Its versatility allows gouging, flame cleaning etc., to be supplied to customer's requirements.

PROPANE SUPER HEATING

- Using a propane super heating mixer and 10" or 28" stainless steel super heating neck an intense heat output of up to 175 KW/h is obtained.
- Ideal for heating castings and similar large articles.



TECHNICAL DATA	
Hose connections:	3/8" (other threads available on request)
Welding capacity:	25 mm
Cutting capacity:	150 mm
Welding nozzles:	Type 2/3/4/5 Swaged Welding Nozzles Sizes 1-90
Cutting nozzles:	ANM (Acetylene) Cutting Nozzles
	PNM (Propane) Cutting Nozzles
	ANME (Acetylene) Cutting Nozzles
	PNME (Propane) Cutting Nozzles
	FGA
Heating nozzles:	AHT (Acetylene) Heating Nozzles
Super heating nozzles:	Super Heating Nozzles (Propane) Sizes 1H-5H

SHANK GCE X20™ MK 4/5 ORIGINAL

Article number	Inlet connection	Outlet connection
G0766241	G3/8 × G3/8" LH	15/16"X16 RN



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CUTTING ATTACHMENT



CUTTING NOZZLES

Art. Nr.	Type	Gas	Version	Nozzle type
G0766242	nozzle mix	A/P	Lever	ANM, ANME, PNM, PNME, FGA



ANM

Art. Nr.	Thickness mm (")	Size	Acetylene		Oxygen	
			Pressure Bar (Psi)	Flow rate (m³/h)	Pressure Bar (Psi)	Flow rate (m³/h)
0768554	3-6 (0-1/4")	1/32"	0,2 (2)	0,3	2 (25)	1,25
0768555	5-12 (1/4-1/2")	3/64"	0,2-0,3 (2-3)	0,5	2 (30)	2,3
0768556	10-75 (1-3")	1/16"	0,2 (2)	0,45	3-4 (50-60)	4,5-5,45
0768557	70-100 (3-4")	5/64"	0,2 (2)	0,79	3-5 (45-70)	7,4-9,8



ANME

Art. Nr.	Thickness mm (")	Size	Acetylene		Oxygen	
			Pressure Bar (Psi)	Flow rate (m³/h)	Pressure Bar (Psi)	Flow rate (m³/h)
0768670	3-6 (0-1/4")	1/32"	0,3 (4)	0,3	2,5-3,5 (40-50)	1,25-1,65
0768635	5-12 (1/4-1/2")	3/64"	0,3 (4)	0,5	2,5-3,5 (40-50)	1,25-1,65
0768599	10-75 (1/2-3")	1/16"	0,3 (4)	0,45	3,5-4,5 (50-65)	3,2-4,45
0768636	70-100 (3-4")	5/64"	0,5 (7)	0,6	4,5-5,5 (65-80)	8,4-9,8



PNM

Art. Nr.	Thickness mm (")	Size	Acetylene		Oxygen	
			Pressure Bar (Psi)	Flow rate (m³/h)	Pressure Bar (Psi)	Flow rate (m³/h)
0768880	3-6 (1/4)	1/32"	0,3 (4)	0,3	2 (30)	2,3
0768865	5-12 (1/2)	3/64"	0,3 (4)	0,4	2 (30)	3,4
0768879	10-75 (2)	1/16"	0,3 (4)	0,45	3 (45)	4,7
0768878	70-100 (4)	5/64"	0,5 (7)	0,6	3,5 (50)	10



PNME

Art. Nr.	Thickness mm (")	Size	Acetylene		Oxygen	
			Pressure Bar (Psi)	Flow rate (m³/h)	Pressure Bar (Psi)	Flow rate (m³/h)
0769494	3-6 (1/4)	1/32"	0,3 (4)	0,3	2,5-3,5 (40-50)	1,8-2,95
0769495	5-12 (1/2)	3/64"	0,3 (4)	0,4	3-4 (45-60)	3,3-4,95
0769496	10-75 (2)	1/16"	0,3 (4)	0,45	3,5-4,5 (50-65)	5-8,6
0769497	70-100 (4)	5/64"	0,5 (7)	0,6	4,5-5,5 (65-80)	9,4-12,8



FGA

Art. Nr.	No. of slots	Acetylene		Oxygen		Width mm (")	Depth mm (")
		Pressure Bar (Psi)	Flow rate (m³/h)	Pressure Bar (Psi)	Flow rate (m³/h)		
0768698	N°1	1 (10)	1,1	4-5 (60-72)	4-4,76	8 (1/4"-5/16")	3-9 (1/8"-3/8")
0768661	N°2	1 (10)	1,3	5-6 (72-90)	6,3-7,3	8-11 (5/16"-1/2")	6-11 (1/4"-1/2")
0768699	N°3	1 (10)	1,5	6-8 (90-120)	9,3-10,9	9-12 (3/8"-1/2")	9-12 (3/8"-1/2")

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MIXER



Art. Nr.	Description
0766243	GCE X20™ MK 4/5 ORIGINAL Welding Mixer
0766253	GCE X20™ MK 4/5 ORIGINAL Propane Superheating Mixer

HEATING NOZZLE & NECK



Art. Nr.	Description
68666	GCE X20™ MK 4/5 ORIGINAL Brass Heating Neck (for AHT heating nozzles)
68777	GCE X20™ MK 4/5 ORIGINAL Long Brass Heating Neck (for AHT heating nozzles)
0766255	GCE X20™ MK 4/5 ORIGINAL Superheating 28" Neck

WELDING NOZZLES



Art. Nr.	Size	Output
0766244 (68501)	to 1 mm	size 1
0766245 (68502)	1 - 1,5 mm	size 2
0766246 (68503)	1,5 - 2 mm	size 3
0766247 (68505)	2- 2,5 mm	size 5
0766248 (68507)	2,5 - 3 mm	size 7
0766249 (68510)	3 - 4 mm	size 10
0766250 (68513)	4 - 5 mm	size 13
0766251 (68518)	5 - 6 mm	size 18
0766242 (68525)	6 - 8 mm	size 25

AHT HEATING NOZZLES



Art. Nr.	Description	Output
48425	AHT 25 heating tip	52 000 Btu/H
48450	AHT 50 heating tip	91 000 Btu/H
48410	AHT 10 heating tip	139 000 Btu/H

SUPER HEATING NECKS AND NOZZLES



Art. Nr.	Description
0766255 (78777)	Superheating 28" neck



Art. Nr.	Pressure Propane (bar)	Pressure Oxygen (bar)	Flow Propane (l/h)	Flow Oxygen (l/h)	Heat(W)
78995	0,14	0,7	830	350	21101
	0,49	2,1	1900	7300	47771
78994	0,21	1,1	1200	4800	29893
	0,46	2,5	2100	8700	55097
78993	0,28	1,8	2100	8300	53632
	1,1	5,0	4100	16500	105799
78992	0,35	2,5	2700	10600	69165
	1,3	5,7	4800	18800	118987
78991	0,85	3,5	3200	12700	82353
	2,1	8,7	7000	28000	181118

COMPLETE KITS



Art. Nr.	Description	Consisting of
677000	GCE X20™ MK 4/5 ORIGINAL COMBINED WELDING & CUTTING OUTFIT	Shank, Mixer, Cutting Attachement, Cutting Nozzle ANM 5-12, 10-75, Welding attach 2, 5, 7, 10, 13, 18, 25, Cleaning needles, Data Card
677777	GCE X20™ MK 4/5 ORIGINAL COMPLETE WELDING & CUTTING OUTFIT	Shank, Mixer, Cutting Attachement, Welding Nozzle 2, 5, 7, 13, Cutting Nozzle ANM 10-75, Plug G3/8, Regulator Unicontrol Ace, Regulator Unicontrol Oxy, Combination Spanner, Spindle Key, Lighter with Cup, Goggles, Hose Twin Oxy/ACE 5m, Cleaning needles
677778FB	GCE X20™ MK 4/5 ORIGINAL COMPLETE WELDING & CUTTING OUTFIT	Shank, Mixer, Cutting Attachement, Welding Nozzle 2, 5, 7, 13, Cutting Nozzle ANM 10-75, Plug G3/8, Regulator Unicontrol Ace, Regulator Unicontrol Oxy, Safe Guard 3 Oxy, Safe Guard 3 Fuel, Combination Spanner, Spindle Key, Lighter Gun, Goggles, Cleaning Needles, Hose Twin Oxy/ACE 5m, Data Card