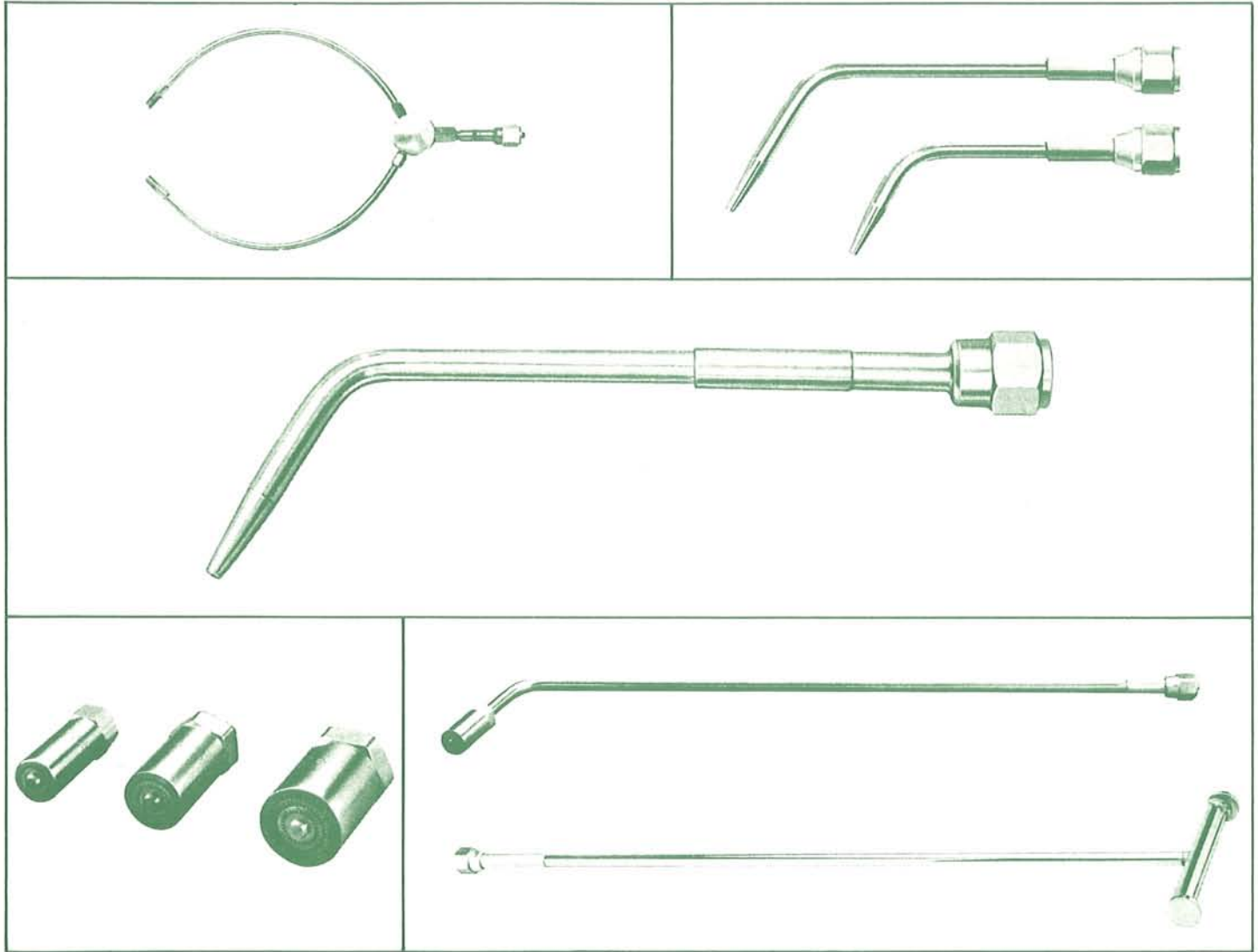




## WELDING & HEATING NOZZLES COMPONENTS PARTS BREAKDOWN

FORM NO. 56-502

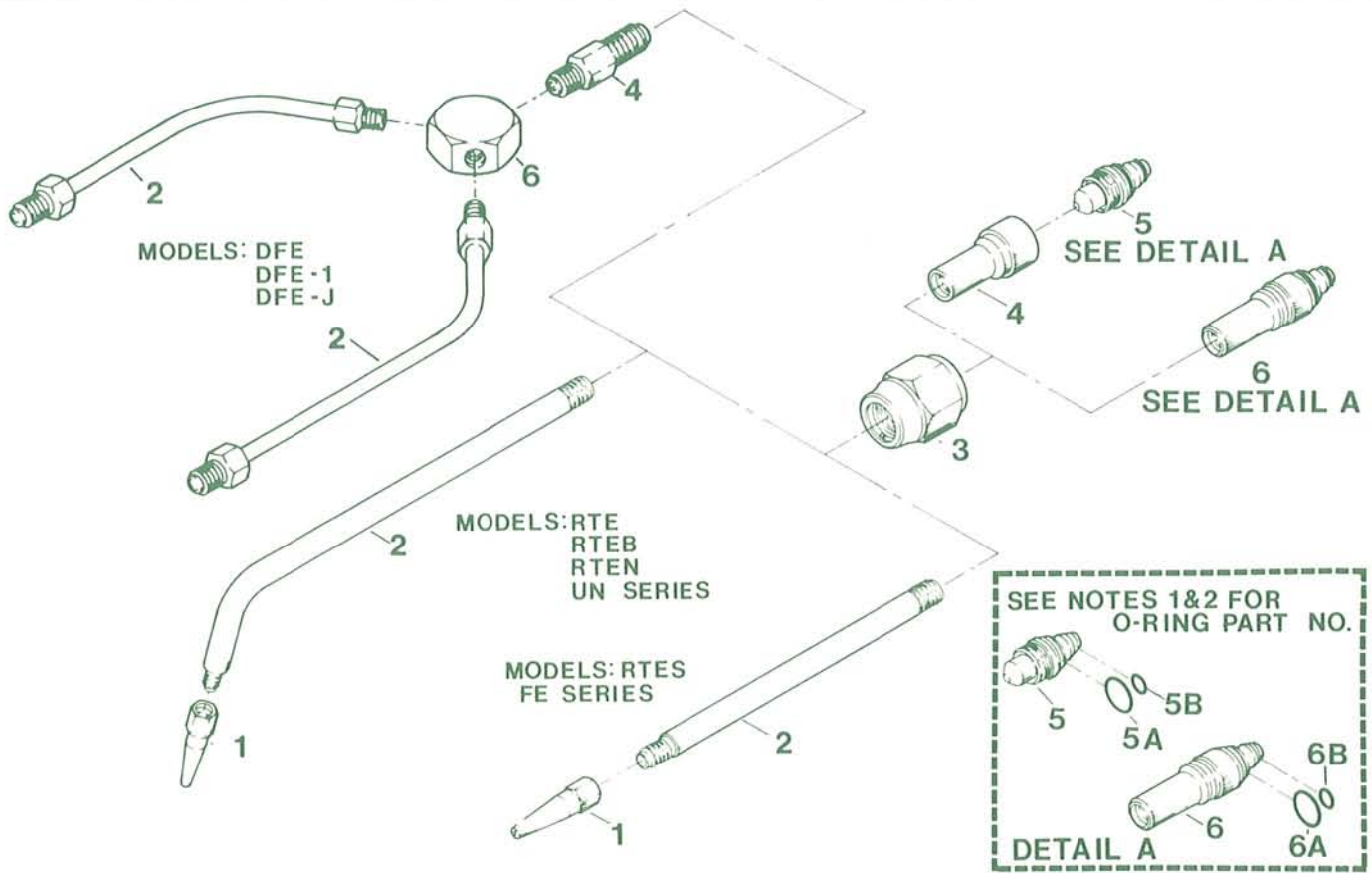
EFFECTIVE 2-87



### WARNING

Welding apparatus improperly operated, maintained or repaired can be dangerous. Some parts and accessories manufactured by others may fit VICTOR apparatus but not conform to VICTOR's exacting standards. For your own protection, specify and use only VICTOR-made parts and accessories with your VICTOR apparatus.

Service or repair of VICTOR apparatus should be performed only by a qualified repair technician. Improper service or repair, or modification of the product could result in damage to the product or injury to the operator.



- NOTES**
1. O-Rings for RTE, RTEB, RTES, RTEN, UN, FE/5A — Part No. 1407-0178, 5B — Part No. 1407-0177.
  2. O-Rings for UN-1, UN-J, UNN-J, FE-1, FE-J, DFE, DFE-1, DFE-J/6A — Part No. 1407-0176  
6B — Part No. 1407-0175.
  3. Apply Loctite #222 sparingly to the second and third male threads immediately prior to assembly.
  4. \*Nozzles supplied less tip. See Chart I for selection of tip ends available.

### NOZZLE COMPONENTS

SIZE & MODEL	COMPLETE NOZZLE PART NO.	1 NOZZLE TIP	2 ELBOW	3 NUT	4 CENTER-PIECE	5 MIXER	6 MIXER
000-RTE	0323-0306	0311-0471	0304-0083	0309-0015	N/A	N/A	0305-0182
00-RTE	0323-0307	0311-0472	0304-0083	0309-0015	N/A	N/A	0305-0182
0-RTE	0323-0308	0311-0473	0304-0083	0309-0015	N/A	N/A	0305-0182
1-RTE	0323-0309	0311-0474	0304-0083	0309-0015	N/A	N/A	0305-0182
2-RTE	0323-0310	0311-0475	0304-0083	0309-0015	N/A	N/A	0305-0182
3-RTE	0323-0311	0311-0587	0304-0084	0309-0015	N/A	N/A	0305-0183
4-RTE	0323-0312	0311-0588	0304-0084	0309-0015	N/A	N/A	0305-0183
5-RTE	0323-0313	0311-0589	0304-0084	0309-0015	N/A	N/A	0305-0183
6-RTE	0323-0314	0311-0590	0304-0085	0309-0015	N/A	N/A	0305-0184
7-RTE	0323-0315	0311-0591	0304-0085	0309-0015	N/A	N/A	0305-0184
8-RTE	0323-0316	0311-0592	0304-0085	0309-0015	N/A	N/A	0305-0184
10-RTE	0323-0317	0311-0593	0304-0086	0309-0015	N/A	N/A	0305-0185
12-RTE	0323-0318	0311-0038	0304-0086	0309-0015	N/A	N/A	0305-0185
1-RTEB	0323-0030	0311-0565	0304-0083	0309-0015	N/A	N/A	0305-0182
2-RTEB	0323-0031	0311-0566	0304-0083	0309-0015	N/A	N/A	0305-0182
3-RTEB	0323-0032	0311-0567	0304-0084	0309-0015	N/A	N/A	0305-0183
4-RTEB	0323-0040	0311-0568	0304-0084	0309-0015	N/A	N/A	0305-0183
6-RTEB	0323-0041	0311-0069	0304-0085	0309-0015	N/A	N/A	0305-0184
8-RTEB	0323-0042	0311-0570	0304-0085	0309-0015	N/A	N/A	0305-0184
10-RTEB	0323-0050	0311-0571	0304-0086	0309-0015	N/A	N/A	0305-0185

		1	2	3	4	5	6
000-RTES	0323-0060	0311-0471	0304-0087	0309-0015	N/A	N/A	0305-0182
00-RTES	0323-0061	0311-0472	0304-0087	0309-0015	N/A	N/A	0305-0182
0-RTES	0323-0062	0311-0473	0304-0087	0309-0015	N/A	N/A	0305-0182
1-RTES	0323-0070	0311-0474	0304-0087	0309-0015	N/A	N/A	0305-0182
2-RTES	0323-0071	0311-0475	0304-0087	0309-0015	N/A	N/A	0305-0182
3-RTES	0323-0072	0311-0587	0304-0088	0309-0015	N/A	N/A	0305-0183
4-RTES	0323-0080	0311-0588	0304-0088	0309-0015	N/A	N/A	0305-0183
5-RTES	0323-0081	0311-0589	0304-0088	0309-0015	N/A	N/A	0305-0183
6-RTES	0323-0082	0311-0590	0304-0089	0309-0015	N/A	N/A	0305-0184
7-RTES	0323-0090	0311-0591	0304-0089	0309-0015	N/A	N/A	0305-0184
8-RTES	0323-0091	0311-0592	0304-0089	0309-0015	N/A	N/A	0305-0184
10-RTES	0323-0092	0311-0593	0304-0090	0309-0015	N/A	N/A	0305-0185
12-RTES	0323-0100	0311-0038	0304-0090	0309-0015	N/A	N/A	0305-0185

0-RTEN	0323-0280	0311-0483	0304-0083	0309-0015	0310-0071	0305-0107	N/A
2-RTEN	0323-0281	0311-0485	0304-0083	0309-0015	0310-0072	0305-0109	N/A
4-RTEN	0323-0282	0311-0487	0304-0084	0309-0015	0310-0073	0305-0114	N/A
6-RTEN	0323-0284	0311-0585	0304-0085	0309-0015	0310-0074	0305-0116	N/A
8-RTEN	0323-0285	0311-0586	0304-0085	0309-0015	0310-0075	0305-0118	N/A

**SEE CHART I TO SELECT TIPS FOR THE FOLLOWING MODELS**

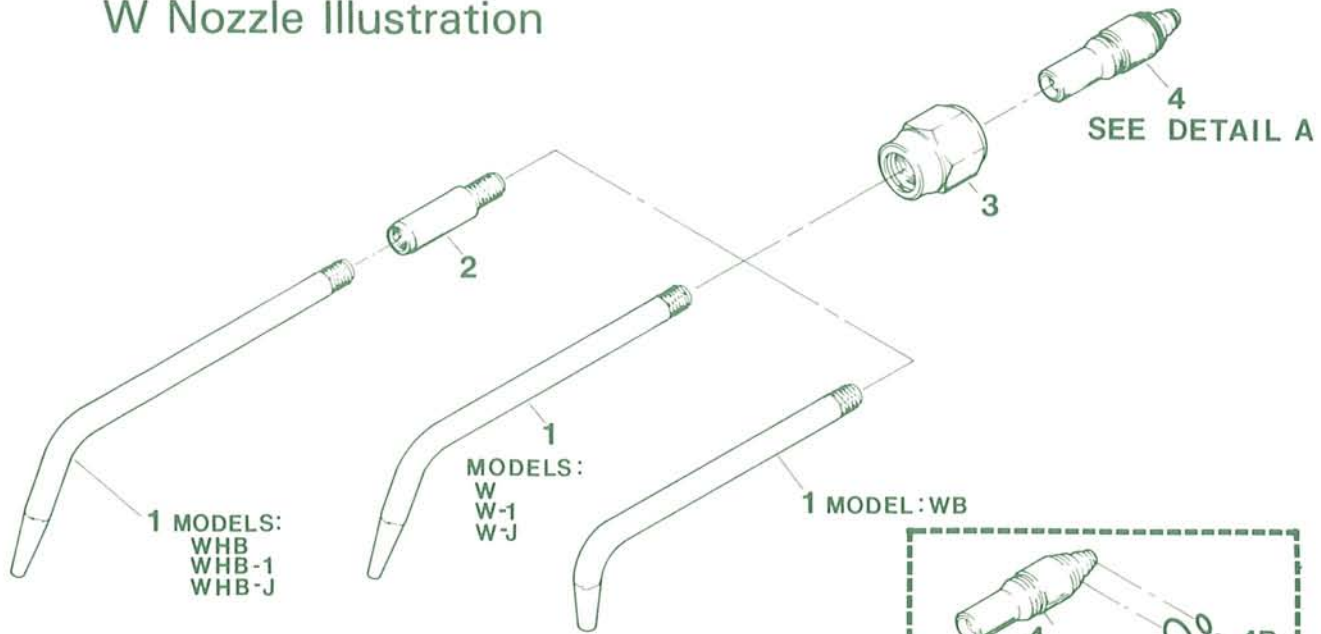
UN	★	0323-0242	GROUP 1&2	0304-0067	0309-0015	N/A	N/A	0305-0191
UN-1	★	0324-0094	GROUP 1&2	0304-0067	0309-0013	N/A	N/A	0305-0165
UN-J	★	0325-0101	GROUP 1&2	0304-0067	0309-0077	N/A	N/A	0305-0168
UNN-J	★	0325-0046	GROUP 2	0304-0067	0309-0008	0310-0039	0305-0124	N/A
FE	★	0323-0191	GROUP 1&2	0304-0077	0309-0015	N/A	N/A	0305-0191
FE-1	★	0324-0066	GROUP 1&2	0304-0077	0309-0013	N/A	N/A	0305-0165
FE-J	★	0325-0102	GROUP 1&2	0304-0077	0309-0077	N/A	N/A	0305-0168

MODELS	PART NO.	TIP ASS'Y	TUBE ASS'Y	NOZZLE NUT	ADAPTOR	MIXER	HEAD	
DFE	★	0323-0192	GROUP 1&2	0304-0077(2)	0309-0015	0312-0058	0305-0184	0312-0011
DFE-1	★	0324-0192	GROUP 1&2	0304-0077(2)	0309-0013	0312-0060	0305-0166	0312-0011
DFE-J	★	0325-0108	GROUP 1&2	0304-0077 2	0309-0077	0312-0045	0305-0168	0312-0011

**CHART I (REPLACEMENT TIPS)**

GROUP 1				GROUP 2	
SIZE & MODEL NO.	PART NUMBER	SIZE & MODEL NO.	PART NUMBER	SIZE & MODEL NO.	PART NUMBER
000 TE	0311-0471	3 TEMFA	0311-0217	000 TEN	0311-0481
00 TE	0311-0472	4 TEMFA	0311-0218	00 TEN	0311-0482
0 TE	0311-0473	5 TEMFA	0311-0219	0 TEN	0311-0483
1 TE	0311-0474			1 TEN	0311-0484
2 TE	0311-0475	1 TECA	0311-0491	2 TEN	0311-0485
3 TE	0311-0587	2 TECA	0311-0492	3 TEN	0311-0486
4 TE	0311-0588	3 TECA	0311-0493	4 TEN	0311-0487
5 TE	0311-0589			5 TEN	0311-0488
1 TEB	0311-0565			3 TEMPN	0311-0306
2 TEB	0311-0566			4 TEMPN	0311-0307
3 TEB	0311-0567			5 TEMFN	0311-0308
4 TEB	0311-0568				
1 TEMFA	0311-0215			1 TECN	0311-0494
2 TEMFA	0311-0216			2 TECN	0311-0495
				3 TECN	0311-0496

# W Nozzle Illustration

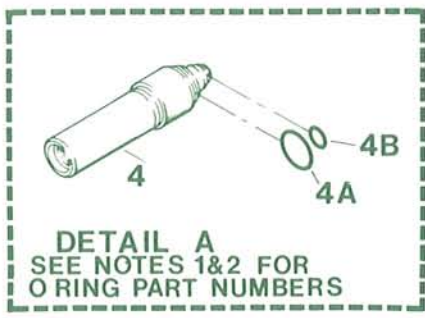
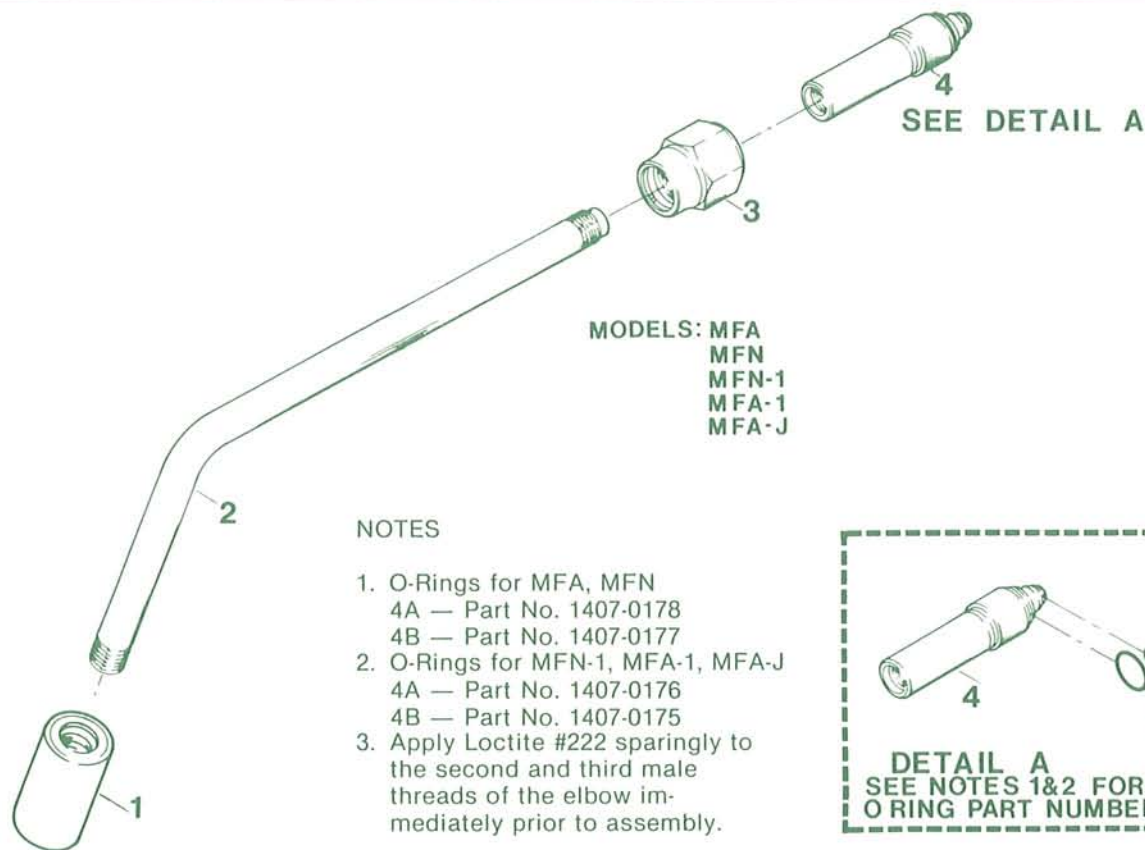


- NOTES
- O-Rings for W, WB, WHB  
4A — Part No. 1407-0178  
4B — Part No. 1407-0177
  - O-Rings for W-1, WHB-1, WHB-J, W-J, WSB-J, WSB-1  
4A — Part No. 1407-0176  
4B — Part No. 1407-0175
  - Apply Loctite #222 sparingly to the second and third male threads immediately prior to assembly.

## NOZZLE COMPONENTS

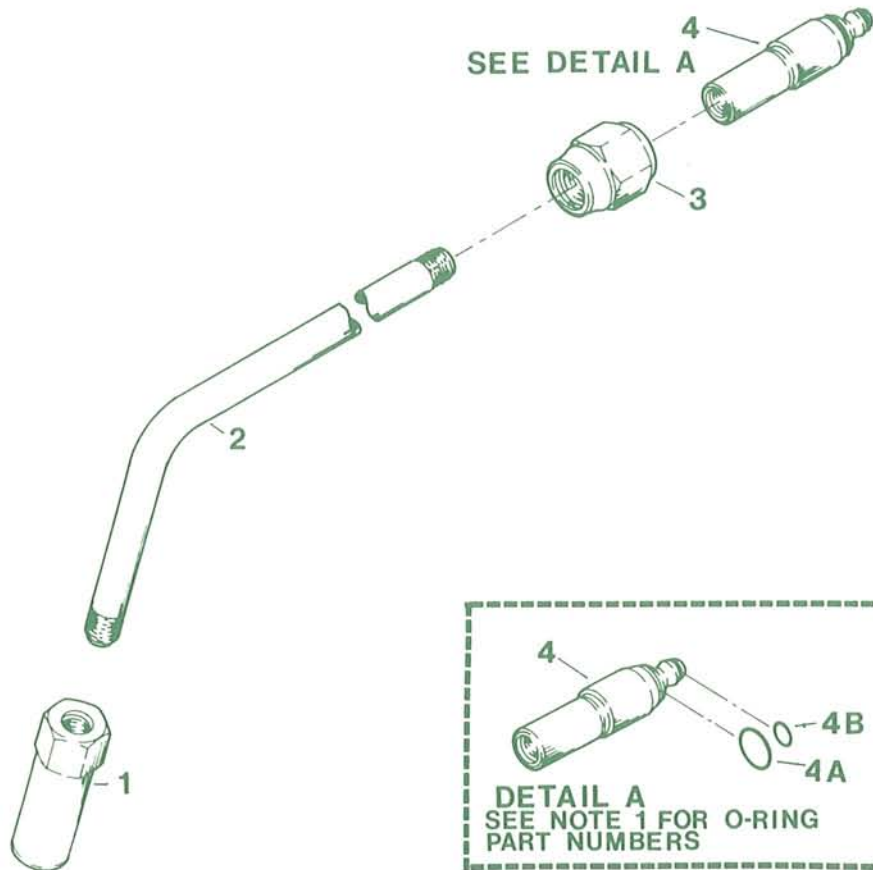
SIZE & MODEL	COMPLETE NOZZLE PART NO.	1 ELBOW	2 BARRIER	3 NOZZLE NUT	4 MIXER
000-W	0323-0110	0311-0055	N/A	0309-0015	0305-0191
00-W	0323-0111	0311-0056	N/A	0309-0015	0305-0191
0-W	0323-0112	0311-0057	N/A	0309-0015	0305-0191
1-W	0323-0120	0311-0058	N/A	0309-0015	0305-0191
2-W	0323-0121	0311-0059	N/A	0309-0015	0305-0191
3-W	0323-0122	0311-0572	N/A	0309-0015	0305-0183
4-W	0323-0130	0311-0573	N/A	0309-0015	0305-0183
5-W	0323-0131	0311-0574	N/A	0309-0015	0305-0184
6-W	0323-0132	0311-0575	N/A	0309-0015	0305-0184
7-W	0323-0140	0311-0576	N/A	0309-0015	0305-0171
8-W	0323-0141	0311-0577	N/A	0309-0015	0305-0171
10-W	0323-0142	0311-0073	N/A	0309-0015	0305-0185
00-WB	0323-0150	0311-0075	N/A	0309-0015	0305-0191
0-WB	0323-0151	0311-0076	N/A	0309-0015	0305-0191
1-WB	0323-0152	0311-0077	N/A	0309-0015	0305-0191
2-WB	0323-0160	0311-0078	N/A	0309-0015	0305-0191
3-WB	0323-0161	0311-0578	N/A	0309-0015	0305-0183
4-WB	0323-0162	0311-0579	N/A	0309-0015	0305-0183
5-WB	0323-0171	0311-0580	N/A	0309-0015	0305-0184
6-WB	0323-0172	0311-0581	N/A	0309-0015	0305-0184
7-WB	0323-0180	0311-0582	N/A	0309-0015	0305-0171
8-WB	0323-0181	0311-0583	N/A	0309-0015	0305-0171
10-WB	0323-0182	0311-0584	N/A	0309-0015	0305-0185

		1	2	3	4
000-WHB	0323-0200	0311-0055	0315-0004	0309-0015	0305-0191
00-WHB	0323-0201	0311-0056	0315-0004	0309-0015	0305-0191
0-WHB	0323-0202	0311-0057	0315-0004	0309-0015	0305-0191
1-WHB	0323-0210	0311-0058	0315-0004	0309-0015	0305-0191
2-WHB	0323-0211	0311-0059	0315-0004	0309-0015	0305-0191
3-WHB	0323-0212	0311-0572	0315-0021	0309-0015	0305-0183
4-WHB	0323-0220	0311-0573	0315-0021	0309-0015	0305-0183
5-WHB	0323-0221	0311-0574	0315-0023	0309-0015	0305-0184
6-WHB	0323-0222	0311-0575	0315-0023	0309-0015	0305-0184
7-WHB	0323-0230	0311-0576	0315-0022	0309-0015	0305-0171
8-WHB	0323-0231	0311-0577	0315-0022	0309-0015	0305-0171
10-WHB	0323-0232	0311-0073	0315-0022	0309-0015	0305-0185
000-W-1	0324-0068	0311-0055	N/A	0309-0013	0305-0165
00-W-1	0324-0069	0311-0056	N/A	0309-0013	0305-0165
0-W-1	0324-0070	0311-0057	N/A	0309-0013	0305-0165
1-W-1	0324-0071	0311-0058	N/A	0309-0013	0305-0165
2-W-1	0324-0072	0311-0059	N/A	0309-0013	0305-0165
3-W-1	0324-0073	0311-0345	N/A	0309-0013	0305-0165
4-W-1	0324-0074	0311-0346	N/A	0309-0013	0305-0165
5-W-1	0324-0075	0311-0602	N/A	0309-0013	0305-0166
6-W-1	0324-0076	0311-0603	N/A	0309-0013	0305-0166
7-W-1	0324-0077	0311-0604	N/A	0309-0013	0305-0166
0-WHB-1	0324-0081	0311-0057	0315-0004	0309-0013	0305-0165
1-WHB-1	0324-0082	0311-0058	0315-0004	0309-0013	0305-0165
2-WHB-1	0324-0083	0311-0059	0315-0004	0309-0013	0305-0165
3-WHB-1	0324-0084	0311-0345	0315-0004	0309-0013	0305-0165
4-WHB-1	0324-0085	0311-0346	0315-0004	0309-0013	0305-0165
5-WHB-1	0324-0086	0311-0602	0315-0021	0309-0013	0305-0166
6-WHB-1	0324-0087	0311-0603	0315-0021	0309-0013	0305-0166
7-WHB-1	0324-0088	0311-0604	0315-0021	0309-0013	0305-0166
000-W-J	0325-0081	0311-0123	N/A	0309-0077	0305-0167
00-W-J	0325-0082	0311-0124	N/A	0309-0077	0305-0167
0-W-J	0325-0083	0311-0125	N/A	0309-0077	0305-0167
1-W-J	0325-0084	0311-0126	N/A	0309-0077	0305-0167
2-W-J	0325-0085	0311-0127	N/A	0309-0077	0305-0167
3-W-J	0325-0086	0311-0128	N/A	0309-0077	0305-0167
4-W-J	0325-0087	0311-0129	N/A	0309-0077	0305-0167
5-W-J	0325-0088	0311-0133	N/A	0309-0077	0305-0168
6-W-J	0325-0089	0311-0134	N/A	0309-0077	0305-0168
7-W-J	0325-0090	0311-0135	N/A	0309-0077	0305-0168
0-WHB-J	0325-0093	0311-0125	0315-0024	0309-0077	0305-0167
1-WHB-J	0325-0094	0311-0126	0315-0024	0309-0077	0305-0167
2-WHB-J	0325-0095	0311-0127	0315-0024	0309-0077	0305-0167
3-WHB-J	0325-0096	0311-0128	0315-0024	0309-0077	0305-0167
4-WHB-J	0325-0097	0311-0199	0315-0024	0309-0077	0305-0167
5-WHB-J	0325-0098	0311-0133	0315-0024	0309-0077	0305-0168
1-WSB-1	0324-0105	0311-0417	N/A	0309-0013	0305-0165
3-WSB-1	0324-0106	0311-0418	N/A	0309-0013	0305-0165
5-WSB-1	0324-0107	0311-0419	N/A	0309-0013	0305-0165
1-WSB-J	0325-0111	0311-0417	N/A	0309-0077	0305-0168
3-WSB-J	0325-0112	0311-0418	N/A	0309-0077	0305-0168
5-WSB-J	0325-0113	0311-0419	N/A	0309-0077	0305-0168



**NOZZLE COMPONENTS**

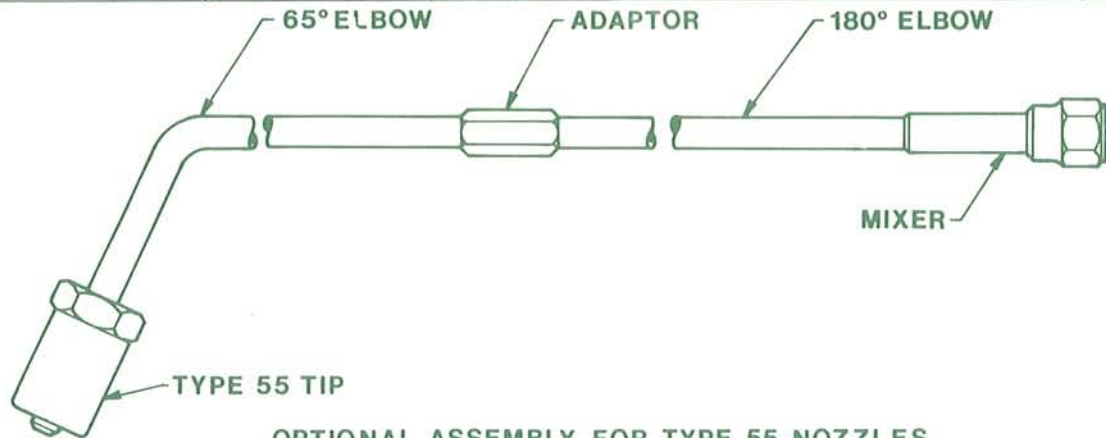
SIZE & MODEL	COMPLETE NOZZLE PART NO.	1 TIP	2 ELBOW	3 NOZZLE NUT	4 MIXER
4-MFA	0323-0250	0311-0536	0304-0081	0309-0015	0305-0171
6-MFA	0323-0251	0311-0537	0304-0081	0309-0015	0305-0171
8-MFA	0323-0252	0311-0538	0304-0081	0309-0015	0305-0171
10-MFA	0323-0260	0311-0648	0304-0082	0309-0015	0305-0403
12-MFA	0323-0261	0311-0649	0304-0082	0309-0015	0305-0403
15-MFA	0323-0262	0311-0650	0304-0082	0309-0015	0305-0403
4-MFN	0323-0290	0311-0558	0304-0081	0309-0015	0305-0171
6-MFN	0323-0291	0311-0559	0304-0081	0309-0015	0305-0171
8-MFN	0323-0292	0311-0560	0304-0081	0309-0015	0305-0171
10-MFN	0323-0302	0311-0661	0304-0082	0309-0015	0305-0404
12-MFN	0323-0303	0311-0662	0304-0082	0309-0015	0305-0404
15-MFN	0323-0304	0311-0663	0304-0082	0309-0015	0305-0404
20-MFN	0323-0305	0311-0664	0304-0082	0309-0015	0305-0404
2 MFN-1	0324-0115	0311-0609	0304-0096	0309-0013	0305-0166
4 MFN-1	0324-0116	0311-0610	0304-0096	0309-0013	0305-0166
6 MFN-1	0324-0117	0311-0611	0304-0096	0309-0013	0305-0166
8 MFN-1	0324-0118	0311-0612	0304-0096	0309-0013	0305-0166
2-MFA-1	0324-0108	0311-0598	0304-0096	0309-0013	0305-0166
4-MFA-1	0324-0109	0311-0599	0304-0096	0309-0013	0305-0166
6-MFA-1	0324-0110	0311-0600	0304-0096	0309-0013	0305-0166
8-MFA-1	0324-0111	0311-0601	0304-0096	0309-0013	0305-0166
2-MFA-J	0325-0104	0311-0497	0304-0068	0309-0077	0305-0168
4-MFA-J	0325-0105	0311-0498	0304-0068	0309-0077	0305-0168
6-MFA-J	0325-0106	0311-0499	0304-0068	0309-0077	0305-0168



- NOTES
- O-Rings for Type 55 Nozzle  
4A — Part No. 1407-0178, 4B — Part No. 1407-0177
  - Apply Loctite #222 sparingly to the second and third male threads immediately prior to assembly.
  - The tip and mixer of the Type 25 and 45 nozzles have been obsoleted and are interchangeable with the Type 55 nozzles.

**NOZZLE COMPONENTS**

SIZE AND MODEL	COMPLETE NOZZLE PART NO.	1 TIP	2 ELBOW	3 NOZZLE NUT	4 MIXER
10 T 55	0323-0324	0311-0230	0304-0011	0309-0015	0305-0404
15 T 55	0323-0325	0311-0231	0304-0011	0309-0015	0305-0404
20 T 55	0323-0326	0311-0232	0304-0011	0309-0015	0305-0404



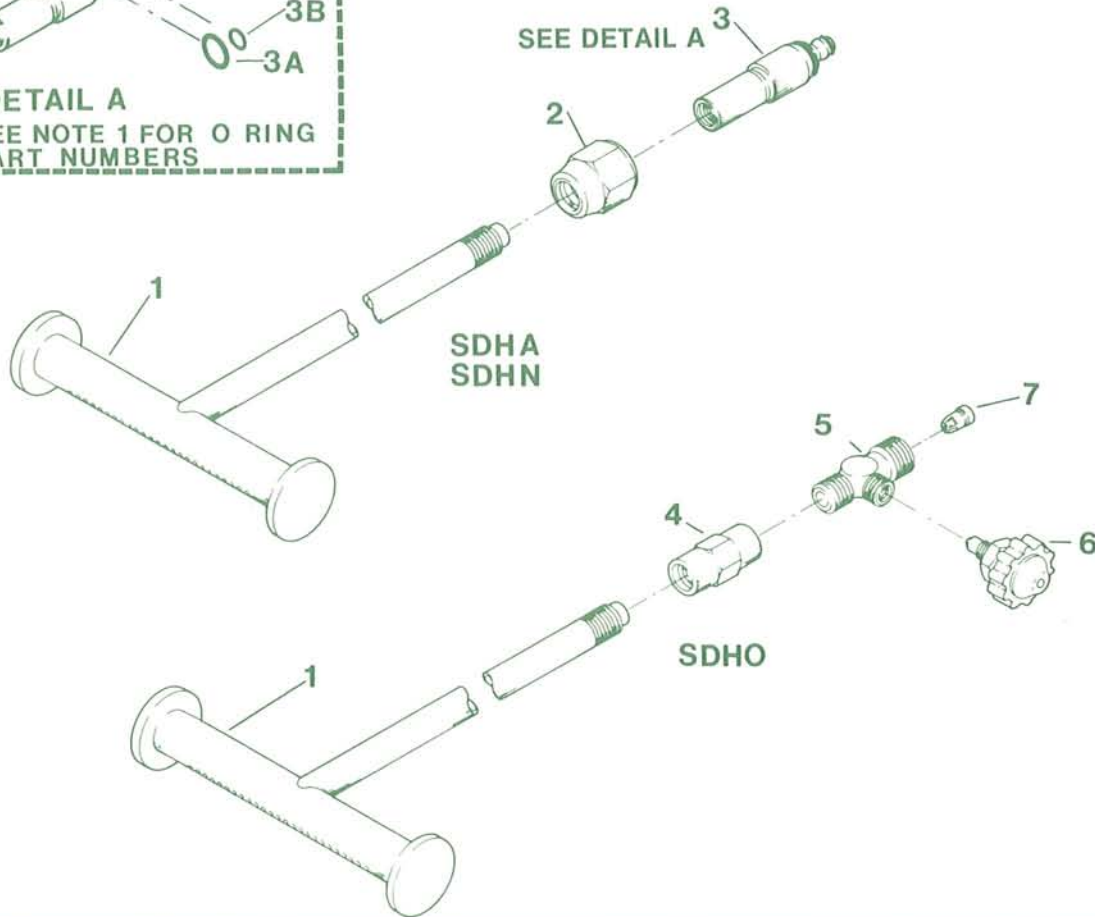
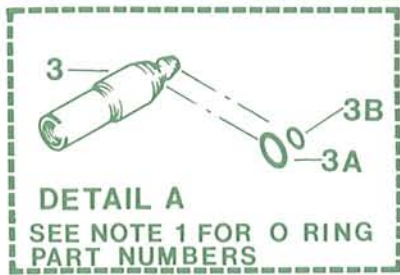
**OPTIONAL ASSEMBLY FOR TYPE 55 NOZZLES**

**OPTIONAL PARTS**

180° ELBOW	
LENGTH	PART NO.
12"	0304-0093
16"	0304-0094
28"	0304-0095

65° ELBOW	
LENGTH	PART NO.
14½"	0304-0002
26½"	0304-0011

ADAPTOR
PART NO.
0312-0064



**NOZZLE COMPONENTS**

DESCRIPTION	PART NO.	1 HEAD	2 NOZZLE NUT	3 MIXER	4 ADAPTOR	5* VALVE BODY	6* VALVE STEM	7* INTERNAL CHECK VALVE
SDHA	0323-0240	0314-0065	0309-0015	0305-0403	N/A	N/A	N/A	N/A
SDHN	0323-0241	0314-0066	0309-0015	0305-0403	N/A	N/A	N/A	N/A
SDHO	0323-0323	0314-0066	N/A	N/A	0312-0059	0661-0207	0662-0014	0652-0029

\*Items 5, 6 and 7 may be purchased as an assembly under P/N 0660-0229.

- NOTES:** 1. O-Rings for SDHA, SDHN, 3A — Part No. 1407-0178 3B — Part No. 1407-0177  
2. Apply Loctite #222 sparingly to the second and third male threads of the head immediately prior to assembly.

WORLD HEADQUARTERS: Suite 300, 16052 Swingley Ridge Road • St. Louis, MO 63017 • 636-728-3000



**CUSTOMER CARE: 800-426-1888 • FAX 800-535-0557**  
**INTERNATIONAL CUSTOMER CARE: 905-827-9777 • FAX 905-827-9797**  
**U.S. AUTOMATION CUSTOMER CARE: 866-279-2628 • FAX 316-941-4491**

International Customer Care  
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