

# EX-TRAFIRE® I25HD

## INDUSTRIAL CUTTING. HEAVY-DUTY PERFORMANCE.

### SOLUTIONS / INDUSTRIES



Heavy Fabrication



Steel mills and steel service centers



Structural



Shipyards and Offshore



Heavy fabrication

Last update of this page: 30.6.2023. See Revision history for details.



# EX-TRAFIRE® 125HD

# EX-TRAFIRE® 125HD



CUTTING  
**125 A**  
CURRENT

MATERIAL  
**55+**  
THICKNESS

INCLUDING  
**MARKING**  
MODE

## SPECIFICATIONS

Output current [A]	30-125
Modes	cutting / grid cutting / gouging / marking
Duty cycle	100 % @ 125 A
Rated output voltage [VDC]	382,5
Severance cutting capacity [mm]	60 <sup>(1)</sup>
Piercing capacity [mm]	25 <sup>(1)</sup>
Recommended cutting capacity [mm]	40 <sup>(1)</sup>
Plasma gas	compressed air/nitrogen
Max. Air flow [lpm/bar]	175/5.2
CNC interface / CAN BUS interface	optional / optional
Preadjusted voltage divider ratio	50:1
Input voltage [VAC]	3 x 400 ± 15 % <sup>(2)</sup>
Frequency [Hz]	50/60
Dimensions (LxHxW) [mm]	615 x 295 x 505
Weight [kg]	37.7
Certification depending on region	CE, RCM, CSA
Maximum input pressure [bar/psi]	10/145
Protection level	IP23S
Insulation class	F
Type of hand torch	FHT-EX®125TTH
Type of machine torch	FHT-EX®125TTM

<sup>(1)</sup> related to low-alloy steel (mild steel)

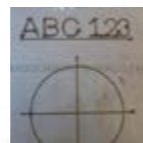
<sup>(2)</sup> suitable for generator use

### IMPRESSIVE PERFORMANCE



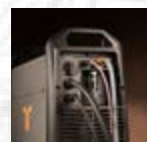
- + Extremely high cutting speed
- + Maximum cutting quality, even with long cuts
- + Also ideal for automated processes

### MARKING MODE



- + Automatic gas identification (air, nitrogen, argon)
- + Integrated gas saving function
- + Fine, deep or wide markings
- + Optional smooth marking for applications below 30A

### READY FOR INDUSTRY 4.0



- + Industry leading connectivity
- + CAN / RS 485 / RS 422 Bus interface (optional)
- + Easy monitoring
- + Expandable and updatable

### AUTOMATIC SETTINGS



- + Cutting gas media, electricity and pilot current
- + Compensation for pressure drops
- + Fewer operating errors, better cutting quality

### HIGHEST FLEXIBILITY



- + Plate thicknesses up to 55 mm
- + For mechanized and manual applications
- + Gouging with high removal rate
- + Suitable for worldwide use

### NEW CUTTING TORCH FHT®EX125TT

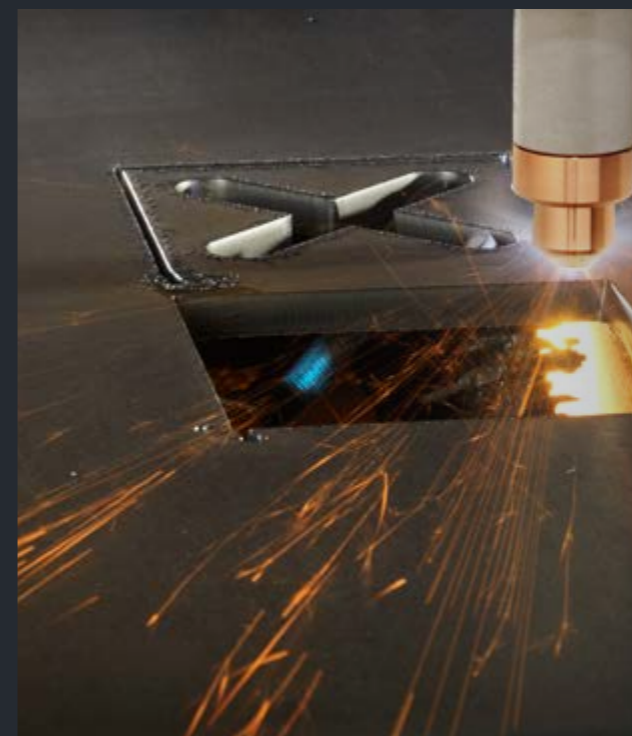


- + Torch design award winner
- + Optimized ergonomics
- + Relaxed PE and PA cutting
- + 100% duty cycle

Last update of this page: 01/07/2022. See Revision history for details.

## 4 DIFFERENT OPERATION MODES

The plasma cutting systems in the EX-TRAFIRE®HD range are the absolute specialists in meeting tough demands in continuous operation. The mobile EX-TRAFIRE®125HD plasma cutting system with 100% duty cycle is the perfect solution for demanding heavy duty applications in industry.



**CUTTING**

**GRID CUTTING**

**MARKING**

**GOUGING**

Last update of this page: 22/03/2023. See Revision history for details.

# EX-TRAFIRE® 125HD

## ORDERING INFORMATION

Description	Length	Part No.
<b>MANUAL PLASMA CUTTING SYSTEMS</b>		
EX-TRAFIRE®125HD/CE/3x400 V Hand System/FHT-EX®125TTH Torch 8m (26.2')/Starter Kit	8 m	EX-6-010-001
EX-TRAFIRE®125HD/CE/3x400 V Hand System/FHT-EX®125TTH Torch 15m (49.2')/Starter Kit	15 m	EX-6-010-002
<b>MECHANIZED PLASMA CUTTING SYSTEMS</b>		
EX-TRAFIRE®125HD/CE/3x400 V Machine System/FULLY EQUIPPED/FHT-EX®125TTM 8m (26.2')/Starter Kit	8 m	EX-6-011-001
EX-TRAFIRE®125HD/CE/3x400 V Machine System/FULLY EQUIPPED/FHT-EX®125TTM 15m (26.2')/Starter Kit	15 m	EX-6-011-002
EX-TRAFIRE®125HD/CE/3x400 V Machine System/STD EQUIPPED/FHT-EX®125TTM 8m (26.2')/Starter Kit	8 m	EX-6-013-005
EX-TRAFIRE®125HD/CE/3x400 V Machine System/STD EQUIPPED/FHT-EX®125TTM 15m (26.2')/Starter Kit	15 m	EX-6-013-006
<b>PLASMA CUTTING UNITS</b>		
EX-TRAFIRE® 125HD/CE/3x400V (Fighter version) power supply unit/FULLY EQUIPPED		EX-6-001-002
EX-TRAFIRE® 125HD/CE/3x400V (Fighter version) power supply unit/STD EQUIPPED		EX-6-003-001

**NOTE:**  
 STD (standard) EQUIPPED - CNC-Port  
 FULLY EQUIPPED - CNC-Port & Serial Interface

## ACCESSORIES

Description	Pcs	Part No.
DN 7.2 ES Quick Connect Plug with male thread G 1/4"	1	EX-0-802-001
DN 7.2 ES Quick Connect Coupling with male thread G 1/4"	1	EX-0-802-002
CNC Interface 14-pin Plug Kit	1	EX-0-803-001
CNC Interface connection lead 3 m	1	EX-0-803-003
CNC Interface connection lead 6 m	1	EX-0-803-004
Plasma Arc START/STOP Remote Controller for STD/FULLY EQUIPPED power supplies	1	EX-0-803-005
FILTER-EX Compressed Air Filter	1	EX-0-804-001
FILTER-EX Air Filter Cartridge	1	EX-0-804-002
Silicone Grease 25ml	1	EX-0-805-001
THERMACUT® Cutting Gloves	1	EX-0-806-001
CAN bus connection cable 10m (32.8')	1	EX-0-803-006
CAN bus connection cable 5m (16.4')	1	EX-0-803-007
RS422 bus connection cable 10m (32.8')	1	EX-0-803-008
RS422 bus connection cable 5m (16.4')	1	EX-0-803-009
Universal connection cable 10m (32.8')	1	EX-0-803-010
Universal connection cable 5m (16.4')	1	EX-0-803-011
Work lead with clamp 300A/4m/16mm2/EU-plug 35-70mm2	1	EX-5-543-037
Work lead with clamp 300A/23m/16mm2/EU-plug 35-70mm2	1	EX-5-543-003
Work lead with clamp 300A/15m/16mm2/EU-plug 35-70mm2	1	EX-5-543-002
Work lead with clamp 300A/8m/16mm2/EU-plug 35-70mm2	1	EX-5-543-001
EX-TRAFIRE®65-125HD CAN/RS Bus Upgrade Kit	1	EX-0-803-013

Last update of this page: 01/07/2022. See Revision history for details.

# EX-TRAFIRE® 125HD



FRONT VIEW



BACK VIEW



SIDE VIEW

Last update of this page: 01/07/2022. See Revision history for details.

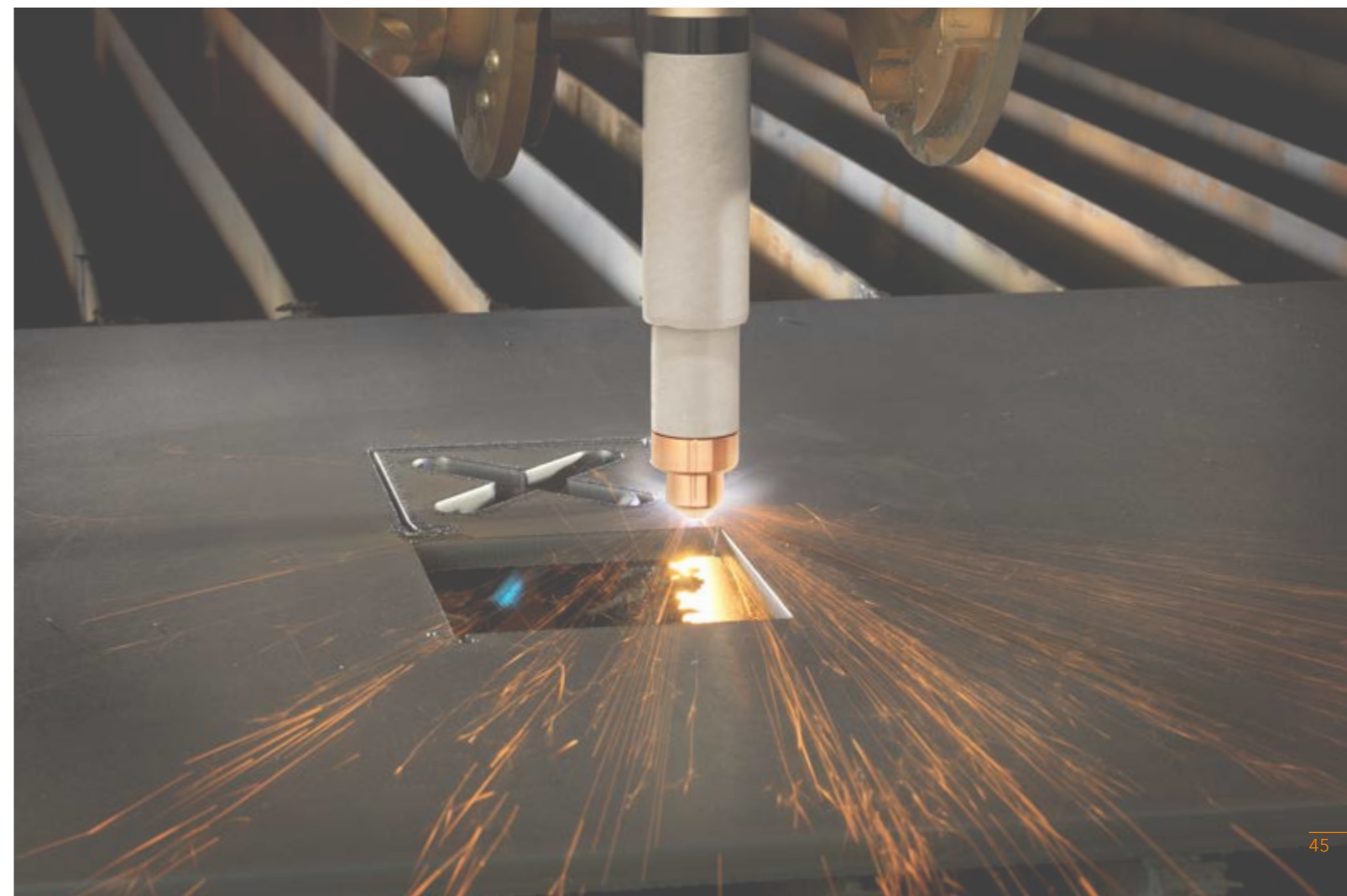
# FHT-EX® 125TT

## HAND / MACHINE TORCHES AND CONSUMABLES

SUITABLE FOR EX-TRAFIRE® 125HD



Last update of this page: 30.06.2023. See Revision history for details.



# FHT-EX® 125TT



The high-performant FHT-EX®125TT H/M hand and machine torches are ideal for meeting tough demands in continuous operation. These torches are optimally designed for use with EX-TRAFIRE®105HD power supplies and are suitable for cutting, gouging, grid-cutting and marking. They can cut plate thickness of up to 60 mm and more precisely and quickly.

Thanks to the THERMACUT® Torch Connection System (TCS), changing the torch is a quick and easy process. The powerful torches are the result of decades of experience in the field of plasma cutting. They feature an extremely robust and durable design in which all consumables can be replaced quickly and easily.

## BENEFITS

- High-performant torches for mechanised applications and handheld use
- Ergonomic handheld torches for safe and reliable holding and guiding in all positions
- Compact and flexible for handheld applications, even in the case of tight radii or gouging of fillet welds
- 100 % duty cycle at 125 A, ideal for continuous use
- Ideal for plate thicknesses of up to 60 mm and more with high power reserves
- Consumables with an extended lifetime
- Quick and tool-free replacement of consumables
- Piercing 25+ mm
- Perfectly designed for use with EX-TRAFIRE®125HD power supplies

Last update of this page: 30.06.2023. See Revision history for details.

# FHT-EX® 125TTH

## HAND TORCH ASSEMBLY



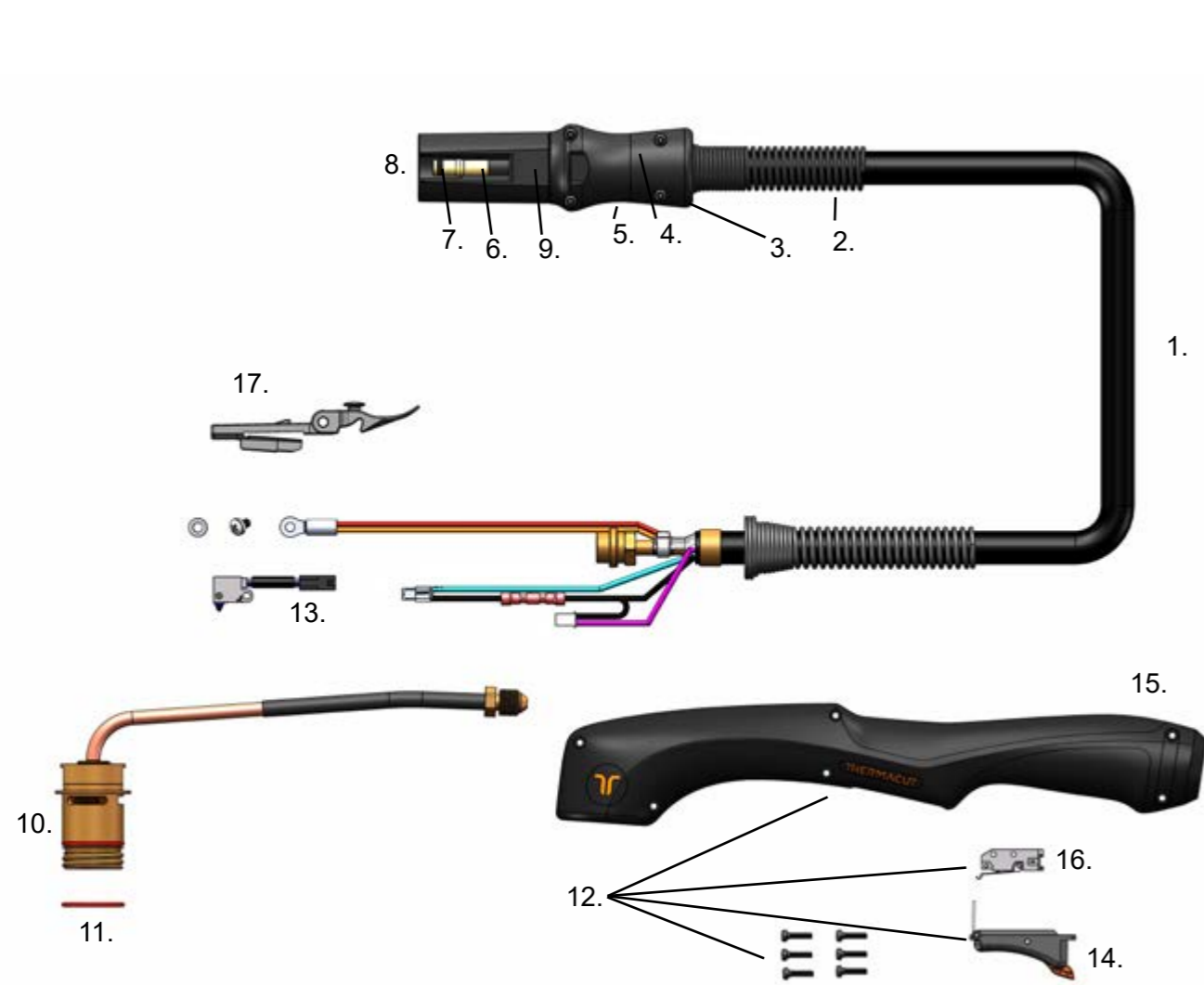
Item	Part No.	Description	Pcs
NS	EX-6-133-001	DEMO FHT-EX®125TTH Hand Torch Assembly/TCS13	1
1.	EX-6-139-001	FHT-EX®125TTH Hand Torch Assembly-w/o consumables w/5m (16.5')Lead/TCS13	1
1.	EX-6-139-002	FHT-EX®125TTH Hand Torch Assembly-w/o consumables w/8m (26.2') Lead/TCS13	1
1.	EX-6-139-003	FHT-EX®125TTH Hand Torch Assembly-w/o consumables w/15m (49.2') Lead/TCS13	1
1.	EX-6-139-004	FHT-EX®125TTH Hand Torch Assembly-w/o consumables w/23m (75.5') Lead/TCS13	1
2.	EX-0-321-003	Latch with Key Assembly	1

⊕ LATCH WITH KEY IS NOT CONTENT OF TORCHES ABOVE. IF YOU NEED IT, YOU HAVE TO ORDER SEPARATELY.

Last update of this page: 30.06.2023. See Revision history for details.

# FHT-EX® 125TTH

## HAND TORCH COMPONENTS

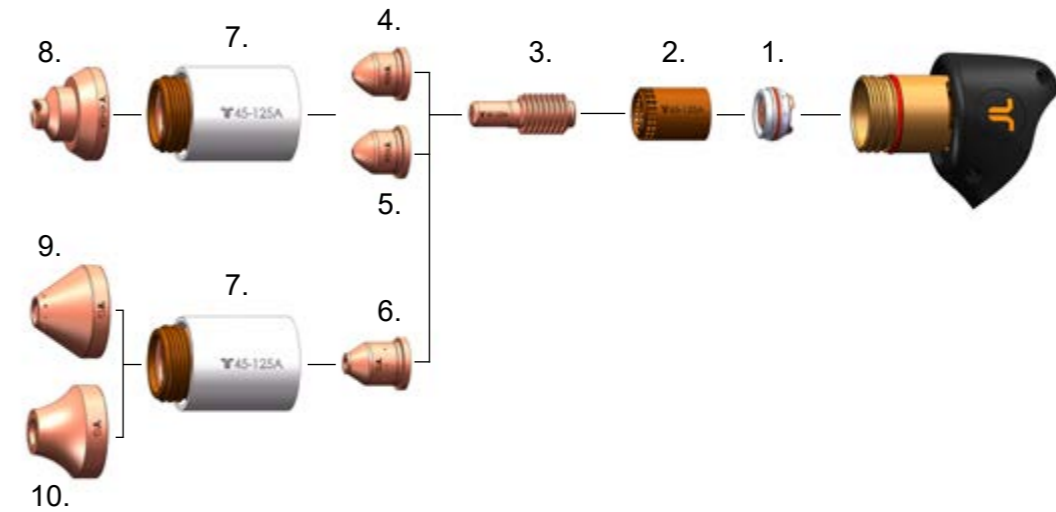


Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-374-001	FHT-EX®125TTH Hand Torch Lead Replacement 5m (16.5')/TCS13	1	8.	EX-0-325-005	Male Crimp Pin for TCS Plug	1
1.	EX-6-374-002	FHT-EX®125TTH Hand Torch Lead Replacement 8m (26.2')/TCS13	1	9.	EX-0-323-001	TCS13 Plug Body	1
1.	EX-6-374-003	FHT-EX®125TTH Hand Torch Lead Replacement 15m (49.2')/TCS13	1	10.	EX-6-302-001	Hand Torch Body	1
1.	EX-6-374-004	FHT-EX®125TTH Hand Torch Lead Replacement 23m (75')/TCS13	1	11.	EX-6-431-001	O-Ring (fitted on the torch body) - 2 pcs	1
2.	EX-6-306-004	TCS Plug Spring Strain Relief	1	12.	EX-6-314-001	Hand Torch Handle Replacement Kit	1
3.	EX-0-325-015	TCS Clam Shell Screw Kit (incl. 4 screws)	1	13.	EX-5-305-001	Cap-sensor Replacement Kit with Screws/ Hand Torch	1
4.	EX-0-325-002	TCS Clam Shell Upper	1	14.	EX-5-313-031	Safety Trigger	1
5.	EX-0-325-001	TCS Clam Shell Lower	1	15.	EX-6-308-001	Hand Torch Handle with Screws (6pcs)	1
6.	EX-0-325-010	Retaining Ring (Outer circlip ring)	1	16.	EX-5-313-030	Safety Trigger Micro-Switch	1
7.	EX-0-325-009	O-Ring (fitted in the TCS plug)	1	17.	EX-0-321-003	Latch w/Key Assembly	1

Last update of this page: 30.06.2023. See Revision history for details.

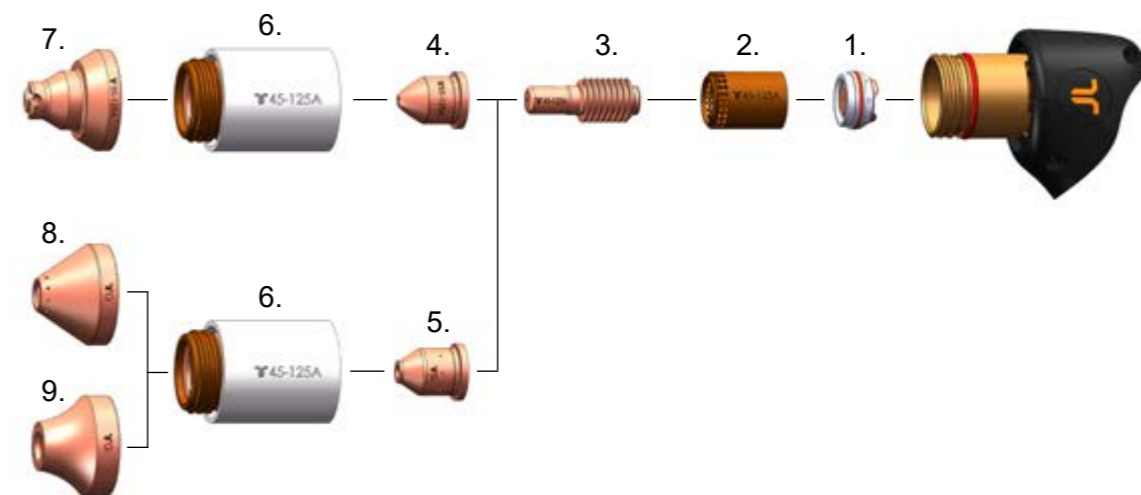
# CONSUMABLES

## HAND TORCH CONSUMABLES - 45-65 A



Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-446-001	Swirl Ring Holder	1	6.	EX-6-440-020	Gouging Nozzle	1
2.	EX-6-404-021	Swirl Ring 45-125A	1	7.	EX-6-415-021	Retaining Cap 45-125A	1
3.	EX-6-401-021	Electrode 45-125A (5pcs package)	1	8.	EX-6-419-022	Shield 45-65A, Hand	1
4.	EX-6-409-024	Nozzle 45A	1	9.	EX-6-440-023	Gouging Shield, Standard	1
5.	EX-6-409-023	Nozzle 65A	1	10.	EX-6-440-024	Gouging Shield, High Removal	1

## HAND TORCH CONSUMABLES - 85-125 A

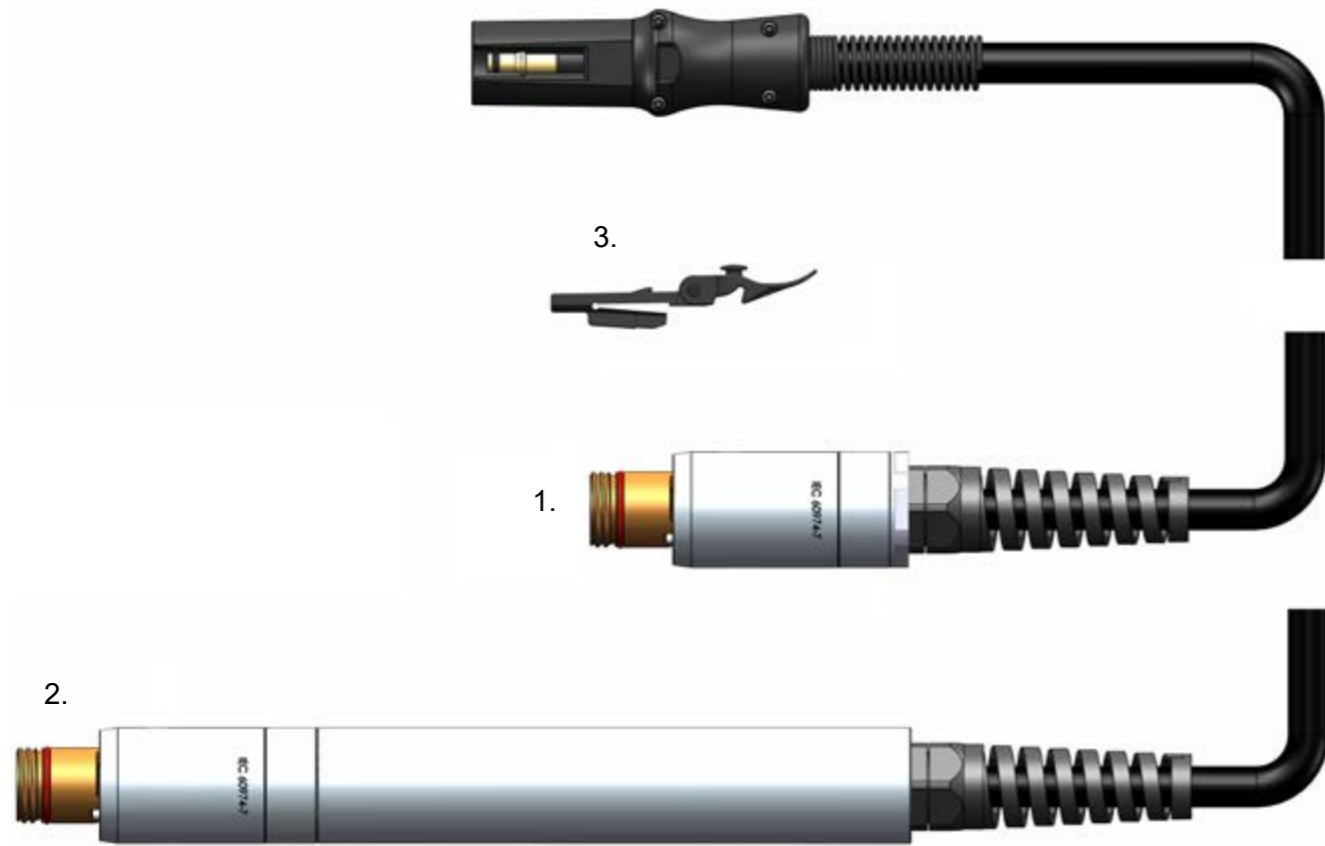


Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-446-001	Swirl Ring Holder	1	5.	EX-6-415-021	Retaining Cap 45-125A	1
2.	EX-6-404-021	Swirl Ring 45-125A	1	6.	EX-6-419-021	Shield 85-125A, Hand	1
3.	EX-6-401-021	Electrode 45-125A (5pcs package)	1	7.	EX-6-440-023	Gouging Shield, Standard	1
4.	EX-6-409-021	Nozzle 85-125A	1	8.	EX-6-440-024	Gouging Shield, High Removal	1
5.	EX-6-440-020	Gouging Nozzle	1				

Last update of this page: 30.06.2023. See Revision history for details.

# FHT-EX® 125TTM

## MACHINE TORCH ASSEMBLY



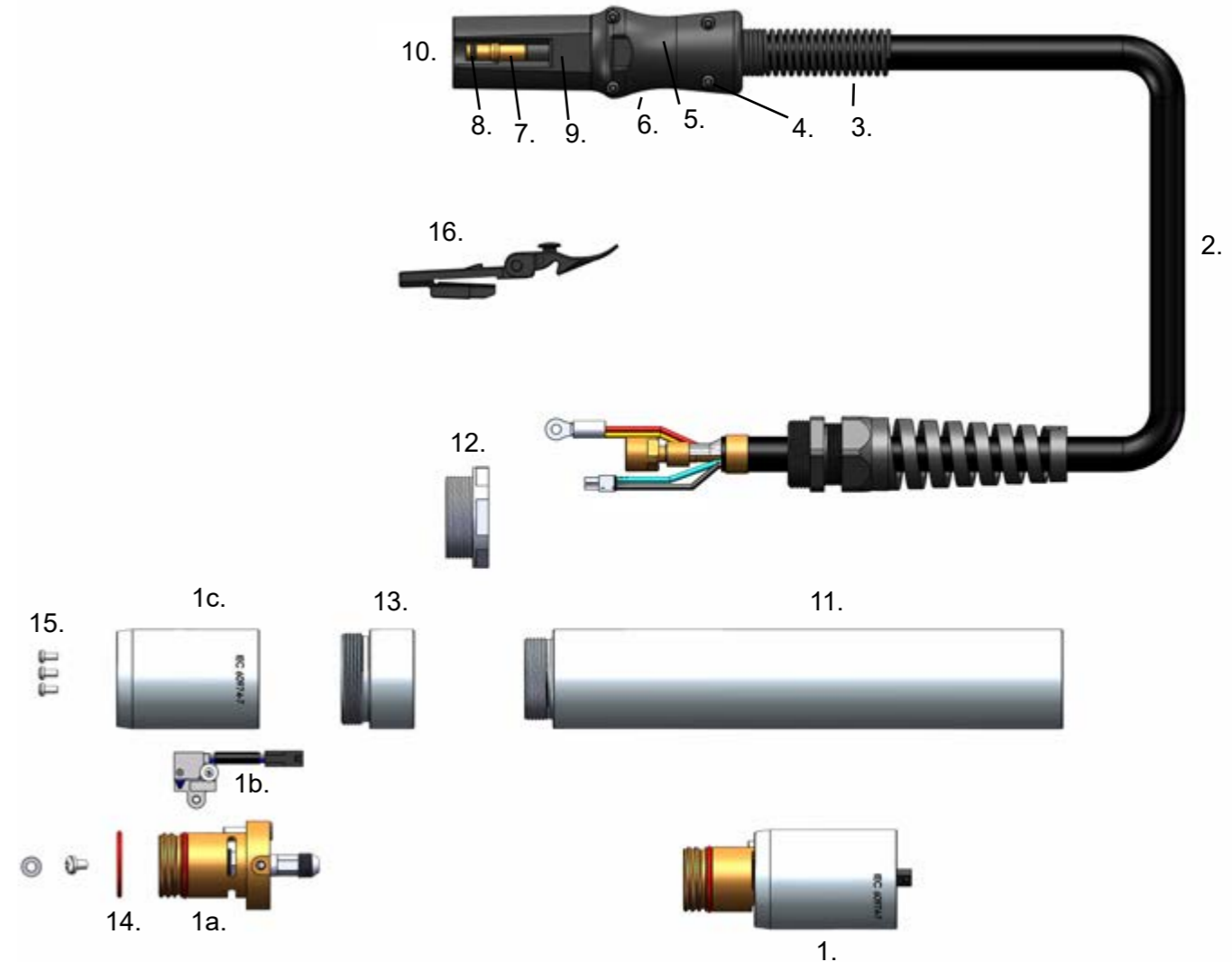
Item	Part No.	Description	Pcs
NS	EX-6-233-001	DEMO FHT-EX®125TTM Machine Torch Assembly/TCS13	1
NS	EX-6-234-001	DEMO FHT-EX®125TTSM Short Machine Torch Assembly/TCS13	1
1.	EX-6-272-001	FHT-EX®125TTSM Short Machine Torch Assembly-w/o consumables w/5m (16.5') Lead/TCS13	1
1.	EX-6-272-002	FHT-EX®125TTSM Short Machine Torch Assembly-w/o consumables w/8m (26.2') Lead/TCS13	1
1.	EX-6-272-003	FHT-EX®125TTSM Short Machine Torch Assembly-w/o consumables w/15m (49.2') Lead/TCS13	1
1.	EX-6-272-004	FHT-EX®125TTSM Short Machine Torch Assembly-w/o consumables w/23m (75.5') Lead/TCS13	1
2.	EX-6-270-001	FHT-EX®125TTM Machine Torch Assy w/o consumables w/5m (16.5')Lead/TCS13	1
2.	EX-6-270-002	FHT-EX®125TTM Machine Torch Assy w/o consumables w/8m (26.2') Lead/TCS13	1
2.	EX-6-270-003	FHT-EX®125TTM Machine Torch Assy w/o consumables w/15m (49.2') Lead/TCS13	1
2.	EX-6-270-004	FHT-EX®125TTM Machine Torch Assy w/o consumables w/23m (75.5') Lead/TCS13	1
3.	EX-0-321-003	Latch with Key Assembly	1

3. LATCH WITH KEY IS NOT CONTENT OF TORCHES ABOVE. IF YOU NEED IT, YOU HAVE TO ORDER SEPARATELY.

Last update of this page: 30.06.2023. See Revision history for details.

# FHT-EX® 125TTM

## MACHINE TORCH COMPONENTS

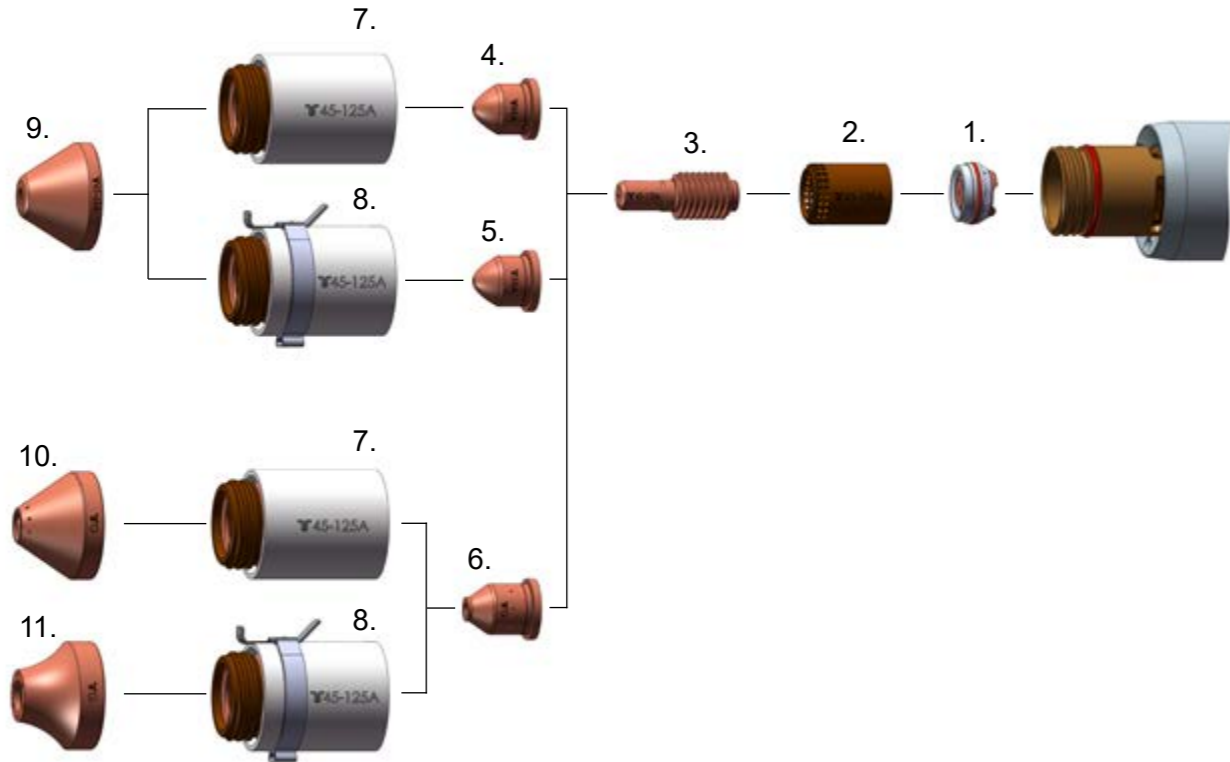


Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-303-001	FHT-EX125TTM/TTSM Machine Torch Body Replacement Kit	1	6.	EX-0-325-001	TCS Clam Shell Lower	1
1a.	EX-6-303-002	FHT-EX®125TTM/TTSM Machine Torch Body Assembly	1	7.	EX-0-325-010	Retaining Ring (Outer circlip ring)	1
1b.	EX-5-304-030	Cap Sensor Replacement Kit with Screws/Machine Torch	1	8.	EX-0-325-009	O-Ring (fitted in the TCS plug)	1
1c.	EX-6-306-001	Torch Mounting Sleeve (incl. 3 screws)	1	9.	EX-0-325-005	Male Crimp Pin for TCS Plug	1
2.	EX-6-375-001	FHT-EX®125TT Machine Torch Lead Replacement 5m (16.5')/TCS13	1	10.	EX-0-323-001	TCS13 Plug Body	1
2.	EX-6-375-002	FHT-EX®125TT Machine Torch Lead Replacement 8m (26.2')/TCS13	1	11.	EX-6-306-002	Mounting Tube ( dia 44.5mm, length 241mm)	1
2.	EX-6-375-003	FHT-EX®125TT Machine Torch Lead Replacement 15m (49.2')/TCS13	1	12.	EX-6-306-004	Strain Relief Thread Adaptor	1
2.	EX-6-375-004	FHT-EX®125TT Machine Torch Lead Replacement 23m (75')/TCS13	1	13.	EX-6-306-003	Reduction Nut	1
3.	EX-6-306-004	TCS Plug Spring Strain Relief	1	14.	EX-6-431-001	O-Ring (fitted on the torch body)	1
4.	EX-0-325-015	TCS Clam Shell Screw Kit (incl. 4 screws)	1	15.	EX-5-372-005	Torch Mounting Screws Kit (incl. 3 screws)	1
5.	EX-0-325-002	TCS Clam Shell Upper	1	16.	EX-0-321-003	Latch w/Key Assembly	1

Last update of this page: 30.06.2023. See Revision history for details.

# CONSUMABLES

## MACHINE TORCH CONSUMABLES - 45-65 A

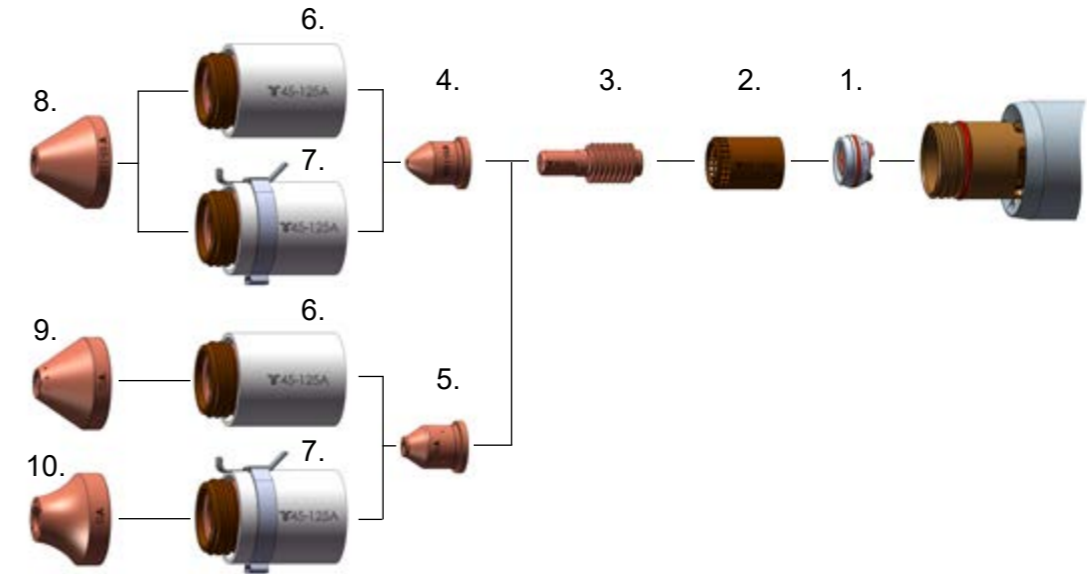


Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-446-001	Swirl Ring Holder	1	7.	EX-6-415-021	Retaining Cap 45-125A	1
2.	EX-6-404-021	Swirl Ring 45-125A	1	8.	EX-6-415-022	Retaining Cap 45-125A, IHS Tab	1
3.	EX-6-401-021	Electrode 45-125A (5pcs package)	1	9.	EX-6-421-022	Shield 45-65A, Machine	1
4.	EX-6-409-024	Nozzle 45A	1	10.	EX-6-440-023	Gouging Shield, Standard	1
5.	EX-6-409-023	Nozzle 65A	1	11.	EX-6-440-024	Gouging Shield, High Removal	1
6.	EX-6-440-020	Gouging Nozzle	1				

Last update of this page: 30.06.2023. See Revision history for details.

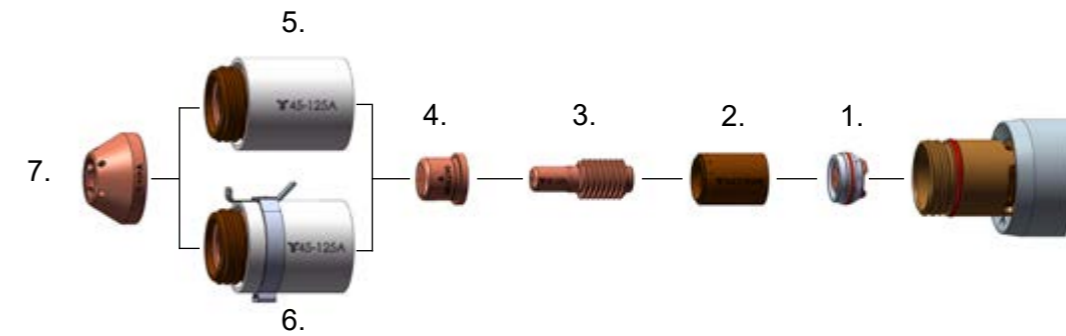
# CONSUMABLES

## MACHINE TORCH CONSUMABLES - 85-125 A



Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-446-001	Swirl Ring Holder	1	6.	EX-6-415-021	Retaining Cap 45-125A	1
2.	EX-6-404-021	Swirl Ring 45-125A	1	7.	EX-6-415-022	Retaining Cap 45-125A, IHS Tab	1
3.	EX-6-401-021	Electrode 45-125A (5pcs package)	1	8.	EX-6-421-021	Shield 85-125A, Machine	1
4.	EX-6-409-021	Nozzle 85-125A	1	9.	EX-6-440-023	Gouging Shield, Standard	1
5.	EX-6-440-020	Gouging Nozzle	1	10.	EX-6-440-024	Gouging Shield, High Removal	1

## MACHINE TORCH CONSUMABLES - SMOOTHLINE



Item	Part No.	Description	Pcs	Item	Part No.	Description	Pcs
1.	EX-6-446-001	Swirl Ring Holder	1	5.	EX-6-415-021	Retaining Cap 45-125A	1
2.	EX-6-440-021	Swirl Ring SmoothLine	1	6.	EX-6-415-022	Retaining Cap 45-125A, IHS Tab	1
3.	EX-6-401-021	Electrode 45-125A (5pcs package)	1	7.	EX-6-414-022	SmoothLine Shield	1
4.	EX-6-414-021	SmoothLine Nozzle	1				

Last update of this page: 30.06.2023. See Revision history for details.