

# CIGWELD

AN ESAB BRAND



DESIGNED  
& TESTED  
IN AUSTRALIA  
FOR OVER 100 YEARS

## BLUEJET™

## REGULATORS



OPERATING MANUAL

BLUEJET REGULATORS

AS4267  
STANDARD

5 YEAR  
WARRANTY

# CIGWELD

AN **ESAB** BRAND

## WE APPRECIATE YOUR BUSINESS!

Congratulations on your new CIGWELD product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network.

This Operating Manual has been designed to instruct you on the correct use and operation of your CIGWELD product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) while writing this manual. However errors do occur and we apologize if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

## YOU ARE IN GOOD COMPANY!

**The Brand of Choice for Contractors and Fabricators Worldwide.**

CIGWELD is a Market Leading Brand of Arc Welding Products for ESAB. We are a mainline supplier to major welding industry sectors in the Asia Pacific and emerging global markets including; Manufacturing, Construction, Mining, Automotive, Engineering, Rural and DIY.

We distinguish ourselves from our competition through market-leading, dependable products that have stood the test of time. We pride ourselves on technical innovation, competitive prices, excellent delivery, superior customer service and technical support, together with excellence in sales and marketing expertise.

Above all, we are committed to develop technologically advanced products to achieve a safer working environment for industry operators.



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FOR OVER 100 YEARS**

**WARNING**

Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment. While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use.

**CIGWELD BLUEJET  
OPERATING MANUAL  
NUMBER FOR:**

**PART NUMBER 201000, 201003,  
201008, 201021, 201019, 210222,  
210223, 210254, 208545, 210224**



**CIGWELD Pty Ltd**

**CIGWELD An ESAB Brand**

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**RECORD THE FOLLOWING INFORMATION  
FOR WARRANTY PURPOSES:**

**Where Purchased:**

**Purchase Date:**

**Equipment Serial #:**

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**Revision Date:**

## SAFETY PRECAUTIONS

This regulator is designed to reduce and control high pressure gas from a cylinder or pipeline to the working pressure required for the equipment using it.

If the equipment is improperly used, hazardous conditions are created that may cause accidents. It is the users responsibility to prevent such conditions. Before handling or using the equipment, understand and comply at all times with the safe practices prescribed in this instruction.

SPECIFIC PROCEDURES for the use of regulators are listed below.

- A.** NEVER subject the regulator to inlet pressures greater than its rated inlet pressure.
- B.** DO NOT allow oil, oil-bearing materials, or other combustibles that can ignite readily in the presence of oxygen.
- C.** Use oxygen regulators with equipment suitable for and used only for oxygen service.
- D.** NEVER use non-oxygen regulators in oxygen service.
- E.** NEVER pressurise a regulator that has loose or damaged parts or is in a questionable condition. Never loosen a connection or attempt to remove any part of a regulator until the gas pressure has been relieved. Under pressure, gas can dangerously propel a loose part.
- F.** DO NOT remove the regulator from a cylinder without first closing the cylinder valve and releasing gas in the regulator high and low pressure chambers
- G.** DO NOT use the regulator as a control valve. When downstream equipment is not in use for extended periods of time, shut off the gas at the cylinder valve and release the gas from the equipment.
- H.** NEVER use Acetylene at pressure in excess of 150kPa.
- I.** OPEN the cylinder valve SLOWLY. Close after use.
- J.** All oxygen - fuel systems MUST be fitted with minimum an AS4603 compliant flashback arrestor and a non-return valve for each gas line, taking into consideration any pressure drops experienced in all components of the assembled gas control system, at the rated flow capacity of the tip or nozzle in use.
- K.** All Regulators, Flashback Arrestors, Blowpipes, Attachments, Mixers and Cutting Torches MUST be refurbished or replaced after 5-Years of service as noted in AS4839-2001.

## USER RESPONSIBILITIES

This equipment will perform safely and reliably only when installed, operated and maintained, and repaired in accordance with the instructions provided. Equipment must be checked periodically and repaired, replaced, or reset as necessary for continued safe and reliable performance. Defective equipment should not be used. Parts that are broken, missing, obviously worn, distorted, or contaminated should be replaced immediately.

The user of this equipment will generally have the sole responsibility for any malfunction, which results from improper use, faulty maintenance, or by repair by anyone other than an accredited repairer.

## INSTALLATION

- 1.** Remove cylinder valve plastic dust seal. Clean the cylinder valve outlet of impurities that may clog orifices and damage seats before connecting the regulator, by cracking the valve (open then close) momentarily, pointing the outlet away from people and sources of ignition. Always crack a fuel gas valve in a well ventilated area and never near a source of ignition.
- 2.** Match regulator to cylinder. Before connecting, check that the regulator label and cylinder marking agree and that the regulator inlet and cylinder outlet match. NEVER CONNECT a regulator designed for a particular gas or gases to a cylinder containing any other gas
- 3.** Connect the regulator inlet connection to cylinder or pipeline and tighten it firmly but not excessively, with a suitable spanner.
- 4.** Connect and tighten the outlet hose firmly and attach down-stream equipment.
- 5.** To protect sensitive down-stream equipment a separate safety device may be necessary if the regulator is not fitted with a pressure relief device

## OPERATION

With the regulator connected to cylinder or pipeline, and the adjustment screw/knob fully disengaged, pressurise as follows:

1. Stand to one side of regulator and slowly open the cylinder valve. If opened quickly, a sudden pressure surge may damage internal regulator parts.
2. With valves on downstream equipment closed, adjust regulator to approximate working pressure. It is recommended that testing for leaks at the regulator connection points be carried out using a suitable leak detection solution or soapy water.
3. Purge air or other unwanted gas from equipment connected to the regulator by individually opening then closing the equipment control valves. Complete purging may take up to ten seconds or more, depending upon the length and size of the hose being purged.

## CAUTION

DO NOT purge oxidising or flammable gases in the presence of flame, lighted cigarettes, or other sources of ignition or in a confined space. Open each downstream valve in turn, if more than one regulator is used. Close one valve before opening the next one. This procedure will prevent explosive gas mixtures occurring in the welding hose between regulators and equipment.

Close equipment valve(s) after purging, and test all connections for leaks with a suitable leak detection solution or soapy water. Never use a flame when testing for leaks.

## ADJUSTING PRESSURE

With the regulator ready for operation, adjust working pressure as follows:

1. Slowly turn adjusting screw/knob in (clockwise) direction until the outlet gauge indicates the required pressure. All valves downstream of the regulator must be opened to obtain a true working pressure reading on the outlet gauge. Close the valves after the pressure has been set.
2. To reduce pressure, allow the gas to discharge from regulator by opening the downstream valve. Bleed gas into a well ventilated area and away from any ignition source. Turn adjusting screw counter clockwise, until the required pressure is indicated on the gauge. Close downstream valve.

## SHUTDOWN

Close cylinder valve whenever the regulator is not in use. To shut down for extended periods (more than 30 minutes)

1. Close cylinder or upstream valve tightly.
2. Open downstream equipment valves to drain the lines. Bleed gas into a well ventilated area and away from any ignition source.
3. After gas is drained completely, disengage adjusting screw and close downstream equipment valves.
4. Before transporting cylinders that are not secured on a cart designed for such purposes, remove regulators.

## NOTES FOR CARBON DIOXIDE (CO<sub>2</sub>) REGULATORS



### WARNING

**CO<sub>2</sub> IS ASPHYXIATING IN HIGH CONCENTRATION. LOCATE REGULATOR IN A WELL VENTILATED AREA.**

CO<sub>2</sub> regulators are fitted with pressure relief valves to protect the regulator against minor component failures. It cannot be considered a safety device for the protection of downstream attached equipment. The pressure relief valve is not intended to replace a primary pressure relief valve or bursting disc as may be required by local legislation. To reduce the risk of asphyxiation due to the concentration of CO<sub>2</sub> resulting from leaks or discharge through pressure relief valves, equipment should be located in a well ventilated area.



**READ AND UNDERSTAND THE OPERATING MANUAL BEFORE INSTALLING OR OPERATING. PROTECT YOURSELF AND OTHERS!**



AN ESAB BRAND

## LIMITED WARRANTY TERMS

**LIMITED WARRANTY:** CIGWELD Pty Ltd, An ESAB Brand, hereafter, "CIGWELD" warrants to customers of its authorized distributors hereafter "Purchaser" that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the CIGWELD products as stated below, CIGWELD shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with CIGWELD's specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at CIGWELD's sole option, of any components or parts of the product determined by CIGWELD to be defective.

CIGWELD MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.

**LIMITATION OF LIABILITY:** CIGWELD SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE FOR SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES, SUCH AS, BUT NOT LIMITED TO, LOST PROFITS AND BUSINESS INTERRUPTION. The remedies of the Purchaser set forth herein are exclusive and the liability of CIGWELD with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by CIGWELD whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty.

PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN CIGWELD'S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY CIGWELD PRODUCT. PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-AUTHORIZED PERSONS.

The warranty is effective for the time stated below beginning on the date that the authorized distributor delivers the products to the Purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date CIGWELD delivered the product to the authorized distributor.

Any claim under this warranty must be made within the warranty period which commences on the date of purchase of the product. To make a claim under the warranty, take the product (with proof of purchase from a CIGWELD Accredited Seller) to the store where you purchased the product or contact CIGWELD Customer Care 1300 654 674 for advice on your nearest Service Provider. CIGWELD reserves the right to request documented evidence of date of purchase. CIGWELD or our Accredited Distributor must be notified in writing of its claim within seven (7) days of becoming aware of the basis thereof, and at its own expense returning the goods which are the subject of the claim to CIGWELD or nominated Accredited Distributor/Accredited Service Provider

This warranty is given.

CIGWELD Pty Ltd A.B.N. 56007226815

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Website: www.cigweld.com.au

This warranty is provided in addition to other rights and remedies you have under law: Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

## WARRANTY PERIOD

<b>Gas Regulators</b> (excluding seat assembly, pressure gauges, Elastomer seals and "O" rings)	5 Years
<b>Regulator seat assemblies and pressure gauges</b>	6 months
<b>Elastomer seals and "O" rings used in the equipment</b>	3 months

Note: In the interest of continuous improvement, CIGWELD Pty Ltd reserves the right to change the specifications or designs of any of its products without prior notice.



**P/N: 201000**  
**OXYGEN,**  
**SIDE ENTRY**



**P/N: 210222**  
**OXYGEN,**  
**BOTTOM ENTRY**



**P/N: 210224**  
**ACETYLENE,**  
**SIDE ENTRY**



**P/N: 210223**  
**ACETYLENE,**  
**BOTTOM ENTRY**



**P/N: 201019**  
**ARGON,**  
**SIDE ENTRY**



**P/N: 201021**  
**ARGON, BOTTOM ENTRY -**  
**REQUIRES A FLOWMETER**



**P/N: 210254**  
**ARGON,**  
**BOTTOM ENTRY**



**P/N: 201008**  
**CARBON DIOXIDE/CO2,**  
**SIDE ENTRY**



**P/N: 201003**  
**LPG (5/8"-18 UNF LH),**  
**SIDE ENTRY**



**P/N: 208545**  
**LPG (3/8" BSP LH),**  
**SIDE ENTRY**



Instruction Part No: 213027-07-N24



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