TWECO®
AN ESAB® BRAND



MIG Guns, Welding Accessories & Consumables
2017 Catalog

U.S. Customer Care: 800-426-1888
Canada Customer Care: 905-827-4515
International Customer Care: 940-381-1212

esab.com



Tweco® - a world leader in welding for over 80 years.

In 1936, the Townsend Welding Equipment Company was born in the basement of Ray Townsend's Wichita, Kansas home. Since then, Tweco has grown to be a world leader in producing quality welding equipment and accessories. Tweco has produced more than two million MIG guns and is an industry leader in MIG guns and lead cables, manual arc welding electrode holders, consumables and accessories.

Still today, we strive to achieve what Ray Townsend began with a mission to provide our customers with quality, safe, and reliable products. Tweco products have been the reliable, dependable tools that everyone from the Do-It -Yourselfer to the expert welding professional has trusted. Tweco is the name you know you know and trust, for over 80 years.

ESAB® is a global manufacturer dedicated to developing innovative solutions for your cutting, gas control and specialty welding applications. With over a century of heritage of authenticity, innovation and a deep connection with end users, our brands include Victor®, Tweco®, Arcair®, Thermal Dynamics®, Stoody®, TurboTorch®, Firepower® and CIGWELD®.

EASY FIND GUIDE - Simplified Selection Guide

For your convenience and ease of use, we have incorporated a system in this catalog we call the **EASY FIND GUIDE**.
When you see this graphic symbol ...



EASY FIND GUIDE
See page # for details.

It will refer you to a page where additional details and specifications can be found regarding the product you are interested in. The **EASY FIND GUIDE** will also provide information for Optional Accessories & Replacement Parts to improve the performance of your equipment.

Icons

This catalog uses icons throughout to instantly identify features and basic product specifications. You might find it useful to familiarize yourself with the symbols below to assist in understanding each product quickly and easily.



MIG Welding
Gas Metal Arc Welding (GMAW)
also Flux Cored (FCAW)



STICK Welding
Shielded Metal Arc Welding (SMAW)



TIG Welding
Gas Tungsten Arc Welding (GTAW)
with Lift Start capability



High Frequency TIG Welding
Gas Tungsten Arc Welding (GTAW)



Carbon Arc Gouging
Carbon Arc Gouging
Carbon Arc Cutting - Air (CAC-A)



Plasma Welding
Plasma Arc Welding (PAW)



Type of Coolant
Either Air Cooled or Water Cooled MIG Guns



Application Usage
Light, Medium or Heavy Duty Fabrications



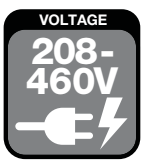
Current Range
Alternating Current (AC)
Direct Current (DC)
or Both (AC/DC)



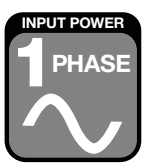
Current Output
Constant Current (CC)
Constant Voltage (CV)
or Both (CC/CV)



Maximum Output Power
Measured in Amps
10A up to 600A



Power Supply Voltage Range
Measured in Volts
208V up to 440V



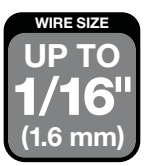
Input Power
Single Phase
Three Phase
or Both



Power Supply Frequency
50 or 60 Hertz
or Both



Duty Cycle
Amount of Time used before overheating occurs



Maximum Wire Size
used by MIG Guns

Table of Contents - MIG Guns. Welding Accessories & Consumables

MIG Guns & Accessories

EASY FIND GUIDE MIG Gun Selection Guide 6-7
Spray Master® MIG Gun Series (250/350/450) 8-15
Velocity™ Spray Master MIG Gun Series (V250/V350/V450) 16-21
Classic No. MIG Gun Series (180/200/300/400/500/600) . . 22-31
Velocity™ Classic No. MIG Gun Series (180/200/300/400/500) 32-41
Tweco Fusion® MIG Gun Series (140/180/220/250) 42-49
PulseMaster® Air-Cooled MIG Gun Series (350/450) . . . 50-55
Compact Eliminator® MIG Gun Series (250/450) 56-61
Standard Eliminator® MIG Gun Series (450) 56-61
Mini-MIG (160). 62
Mini-MIG Velocity (160) 63
Tuff-n-Lite™ MIG Gun (350) 64-65
Supra® XT SEHD MIG Gun (400) 66-67
Supra® XT SEL MIG Gun (400) 68-69
SmokeMaster® Fume Extraction MIG Gun Series (250/450) 70-72
Smoke Collector Fume Removal System 73
Flux Cored SEFC MIG Guns (350/450) 74-75
Tweco Spool Gun Series (160/200/300) 76-79
PullMaster® MIG Gun Series (Smart & Standard 300) . . . 80-81
Tweco Water-Cooled MIG Gun Series 82-91
PulseMaster™ Water-Cooled MIG Gun Series (400/500) 82-86
Tweco TC900 & TCV900 Water Coolers 87
Supra Water-Cooled MIG Gun (450). 88-89
Standard Water-Cooled MIG Gun (600). 90-91
Tweco MIG Gun Direct Plug & Control Wire Jumpers. . . 92-93

MIG Welding Consumables

Tweco Velocity™ Consumables 94-101
EASY FIND GUIDE Contact Tip Selection Guide 102
Contact Tips 103-105
EASY FIND GUIDE Nozzle Selection Guide 106
Nozzles & Nozzle Insulators 107-114
Gas Diffusers 115-116
EASY FIND GUIDE Conductor Tube Selection Guide . . . 117
Conductor Tubes 118-123
Universal Conduit Liners 124-125
Conduit Liners 126-127

Manual Welding Products & Accessories

Electrode Holders 128-131
EASY FIND GUIDE Electrode Holder Selection Guide . . . 129
Ground Clamps 132-139
EASY FIND GUIDE Ground Clamp Selection Guide 133
Switchable Magnetic Products 138-139
EASY FIND GUIDE Cable Lug Selection Guide 140
Cable Lugs & Cable Connectors 141-142
Splicers, Terminals & Accessories 143

WeldSkill® WM MIG Guns, Consumables & Accessories

WeldSkill WM MIG Gun Series 144-149
WeldSkill Consumables 150-154
WeldSkill Manual Welding Products & Accessories . . 155-156
Warranty Information. 157
Customer Care Contact Information 158

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

EASY FIND GUIDE - MIG Gun Selection Guide

Solid Wire – Mild Steel and Stainless Steel

Wire Diameter	Amperage Range	Recommended	Alternate
.023" - .030" (0.6 - 0.8 mm)	CO_2 / 75-25	Tweco Fusion® 140	Tweco® Classic® No.1, Velocity Classic No. 1
.035" (0.9 mm)	CO_2 / 75-25	Tweco Fusion 180, 220, 250 Tweco Classic No. 2, Velocity Classic No. 2	Spray Master® 250, Velocity Spray Master 250
.045" (1.2 mm)	CO_2 / Higher Argon Mixture	Spray Master 350, Tweco Classic No. 4, Velocity Classic No. 4, Velocity Spray Master 350	PulseMaster™ Air-Cooled 350, Supra® XT 400, Tuff-n-Lite 350, Smoke Master 450
.052" (1.3 mm)	Higher Argon Mixture	Spray Master 450, Tweco Classic No. 5, Velocity Classic No. 5	PulseMaster Air-Cooled 450, Supra XT 400, Smoke Master®450, Supra Water-Cooled 450
1/16" (1.6 mm)	Higher Argon Mixture	Spray Master 450, Velocity Spray Master 450, Tweco Classic No. 6	PulseMaster Air-Cooled 450, PulseMaster 500, Supra Water-Cooled 450, Standard Water-Cooled 600

Flux Cored Wire

Wire Diameter	Amperage Range	Recommended	Alternate
030" (0.8 mm)	Self-shielded	Tweco Fusion 140	Tweco Classic No. 1, Velocity Classic No. 1
.035" (0.9 mm)	Self-shielded / CO_2 or 75-25	Tweco Fusion 180, 220, 250	Tweco Classic No. 2, Velocity Classic No. 2
.045" (1.2 mm)	Self-shielded / CO_2 or 75-25	Tweco Fusion 220, 250, Spray Master 350, Velocity Spray Master 250	Tweco Classic No. 2, Velocity Classic No. 2, Supra XT 400
.052" (1.3 mm)	CO_2 or 75-25	Spray Master 450, Tweco Classic No. 4, Velocity Classic No. 4	Supra XT 400
1/16" - 5/64" (1.6 - 2.0 mm)	Self-shielded / CO_2 or 75-25	Spray Master 450, Tweco Classic No. 5, Velocity Classic No. 5, Velocity Spray Master 450	Supra XT 400
3/32" (2.4 mm)	Self-shielded / CO_2 or 75-25	Tweco Classic No.6	Tweco Classic No. 5, Velocity Classic No. 5

**Flux Cored SEFC Series MIG Guns are to be used only with Self-Shielded wire*

Solid Wire – Aluminum

Wire Diameter	Amperage Range	Recommended	Alternate
.030" (0.8 mm)	Argon	Spool Gun 160 & 200, Tweco Fusion 140	Tweco Classic No.1, Velocity Classic No. 1
.035" (0.9 mm)	Argon	Spool Gun 300	PulseMaster Air-Cooled 350, Tweco Classic No.2, Velocity Classic No. 2
3/64" (1.2 mm)	Argon	PulseMaster Air-Cooled 350, Tweco Fusion 250	PullMaster™ 300, Classic No. 3, Velocity Classic No. 3, Tuff-n-Lite 350
1/16" (1.6 mm)	Argon	PulseMaster Air-Cooled 450, Spray Master 350, Velocity Spray Master 350	PullMaster 300, Classic No.4, Tuff-n-Lite 350, Velocity Classic No. 4
3/32" (2.4 mm)	Argon	PulseMaster Air-Cooled 450, Spray Master 450, Velocity Spray Master 450	PullMaster 300, PulseMaster Water-Cooled 500, Tweco Classic No.4, Supra Water-Cooled 450, Velocity Classic No. 4

When welding with aluminum wire, standard MIG gun length of 12 ft should not be exceeded and conduit liners/contact tips made specifically for aluminum wires should be used.

EASY FIND GUIDE - MIG Gun Selection Guide

Tweco® MIG Gun	Amperage Range	Available Lengths ft (m)	Handle Design	Cablehoz® Connection	Rear End Connector Options	Air-Cooled/ Water-Cooled	Special Features	Catalog Page #
Spray Master® Series	250, 350, 450	10, 12 , 15, 20, 25 ft (3, 3.7, 4.6, 6.1, 7.6 m)	Small & Ergonomic	Crimped	Tweco, Miller®, Lincoln®, Euro-Kwik	Air	Heavy Duty Front End Consumables	8-15
Velocity™ Spray Master® Series	250, 350, 450	10, 12 , 15, 20, 25 ft (3, 3.7, 4.6, 6.1, 7.6 m)	Small & Ergonomic	Crimped	Tweco, Miller, Lincoln, Euro-Kwik	Air	Heavy Duty Front End Consumables	16-21
Classic® No. Series	160, 180, 200, 300, 400, 500, 600	10, 12 , 15, 20, 25 ft (3, 3.7, 4.6, 6.1, 7.6 m)	Oval/Paddle Contour	Mechanical	Tweco, Miller, Lincoln, Euro-Kwik	Air	Wide Range of Front End Consumables	22-31
Velocity™ Classic® No. Series	160, 180, 200, 300, 400, 500	10, 12 , 15, 20, 25 ft (3, 3.7, 4.6, 6.1, 7.6 m)	Oval/Paddle Contour	Mechanical	Tweco, Miller, Lincoln, Euro-Kwik	Air	Wide Range of Front End Consumables	32-41
Tweco Fusion® Series	140, 180, 220, 250	10, 12, 15 ft (3, 3.7, 4.6 m)	Small & Ergonomic	Crimped	Tweco, Miller, Lincoln, Euro- Kwik	Air	Longer life Velocity consumables	42-49
PulseMaster® Air-Cooled Series	350, 450	12, 15 ft (3.7, 4.6 m)	Small & Ergonomic	Crimped	Tweco, Euro-Kwik	Air	Smart Option or Standard	50-55
Compact Eliminator®	250, 450	10, 12 , 15, 20, 25 ft (3, 3.7, 4.6, 6.1, 7.6 m)	Small & Ergonomic	Crimped	Tweco, Miller, Euro-Kwik	Air	Ball & Socket design conductor tube & cam style locking contact tips	56-61
Eliminator®	450	15 ft (4.6 m)	Ergonomic	Crimped	Tweco, Miller, Lincoln, Euro-Kwik	Air	Ball & Socket design conductor tube & cam style locking contact tips	56-61
Mini-MIG	160	10, 12, 15 ft (3, 3.7, 4.6 m)	Straight	Mechanical	Tweco, Miller, Lincoln, Euro-Kwik	Air	Wide Selection of Front End Consumables Available	62
Velocity™ Mini-MIG	160	10, 12, 15 ft (3, 3.7, 4.6 m)	Straight	Mechanical	Tweco, Miller, Lincoln, Euro-Kwik	Air	Wide Selection of Front End Consumables Available	63
Tuff-n-Lite	350	15 ft (4.6 m)	Straight	Mechanical	Tweco, Miller	Air	Top Trigger Capability	64-65
Supra® XT	400	15 ft (4.6 m)	Straight	Mechanical	Tweco, Miller, Lincoln	Air	Top Trigger Capability	66-69
SmokeMaster® Series	250, 450	15 ft (4.6 m)	Ergonomic	Crimped	Tweco, Miller, Lincoln	Air	Fume Extraction Cam-Style Contact Tips	70-72
Flux Cored SEFC Series	350, 450	10, 15 ft (3, 4.6 m)	Straight	Crimped	Tweco, Miller, Lincoln	Air	Galvanized Steel Inner Core Tube Cablehoz Design	74-75
Tweco Spool Gun Series	160, 200, 300	12, 25 ft (3.7, 7.6 m)	Pistol Grip	Mechanical	Dinse Lug	Air	Accepts Standard 4" Spools Rotatable Wire Spool Housing	76-79
PullMaster® Series	300	33, 50 ft (10, 15.2 m)	Pistol Grip	Crimped	Tweco	Air	Smart Option or Standard	80-81
PulseMaster® Water-Cooled Series	400, 500	12, 25 ft (3.7, 7.6 m)	Ergonomic	Crimped	Tweco	Water	Smart Option or Standard	82-86
Supra	450	10, 12, 15 ft (3, 3.7, 4.6 m)	Oval/Paddle Contour	Crimped	Tweco, Miller	Water	Quick Water Connections	88-89
Standard Water-Cooled	600	10, 12, 15 ft (3, 3.7, 4.6 m)	Ergonomic	Crimped	Tweco	Water	Inert Gas Style Fitting	90-91

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Spray Master
MIG Gun Series

Spray Master®
MIG Gun Series

FEATURES

- **Extended Trigger** length (with optional mechanical locking trigger) keeps hands farther away from the arc to reduce radiated heat
- **Compact, Ergonomic Handle Design** is balanced to pivot at the center of the handle for ease of use, thereby reducing operator fatigue
- **Wide Welding Applications** both Spray Transfer Mode & Pulse Welding
- **Increased Productivity** with the use of patented, extended life Eliminator front end consumables, helps the shop floor lower usage cost
- **Split Handle Case** provides access for ease of repairs in the field
- **Durable, Metal-Jacketed, Three-Layer Conductor Tube** rotates easily for different welding positions and lowers heat in the front end
- **Heavy Duty, Thick-Walled Contact Tip and Diffuser** increases tip life, decreases downtime with fewer tip changes and improves performance in high heat applications
- **Front and Rear Steel Spring Strain Relief** provides support to the Cablehoz® coming out of the rear of the handle and minimizes wire feed issues
- **Crimped Front Cablehoz Connection** for improved electrical conductivity
- **Field Repairable** mechanical Cablehoz connections
- **Interchangeable Front End Consumables** between Tweco® Classic No. and Tweco Spray Master series

		Spray Master 250 Amp	Spray Master 350 Amp	Spray Master 450 Amp	Spray Master V250 Amp	Spray Master V350 Amp	Spray Master V450 Amp
Applications		Light - Medium Duty Fabrication	Medium - Heavy Duty Fabrication	Heavy Duty Fabrication	Light - Medium Duty Fabrication	Medium - Heavy Duty Fabrication	Heavy Duty Fabrication
Standard Options	**Dual Schedule**		■	■		■	■
	Locking Trigger			■			■
	Rear Connector	■	■	■	■	■	■
	Velocity Consumables				■	■	■
	Eliminator Consumables	■	■	■			
	Long Reach Conductor Tube			■			■
	Knucklehead™ Flexible Conductor Tube		■	■		■	■
Output Current		250 Amps	350 Amps	450 Amps	250 Amps	350 Amps	450 Amps
Duty Cycle - Mixed Gases		80%	80%	80%	80%	80%	80%
Wire Diameter		Up to .045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 1/16" (1.6 mm)	Up to .045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 1/16" (1.6 mm)
Process	**MIG**	■	■	■	■	■	■
	Aluminum	■	■	■	■	■	■
	Flux Cored Gas Shielded	■	■	■	■	■	■
	Flux Cored Self Shielded	■	■	■	■	■	■

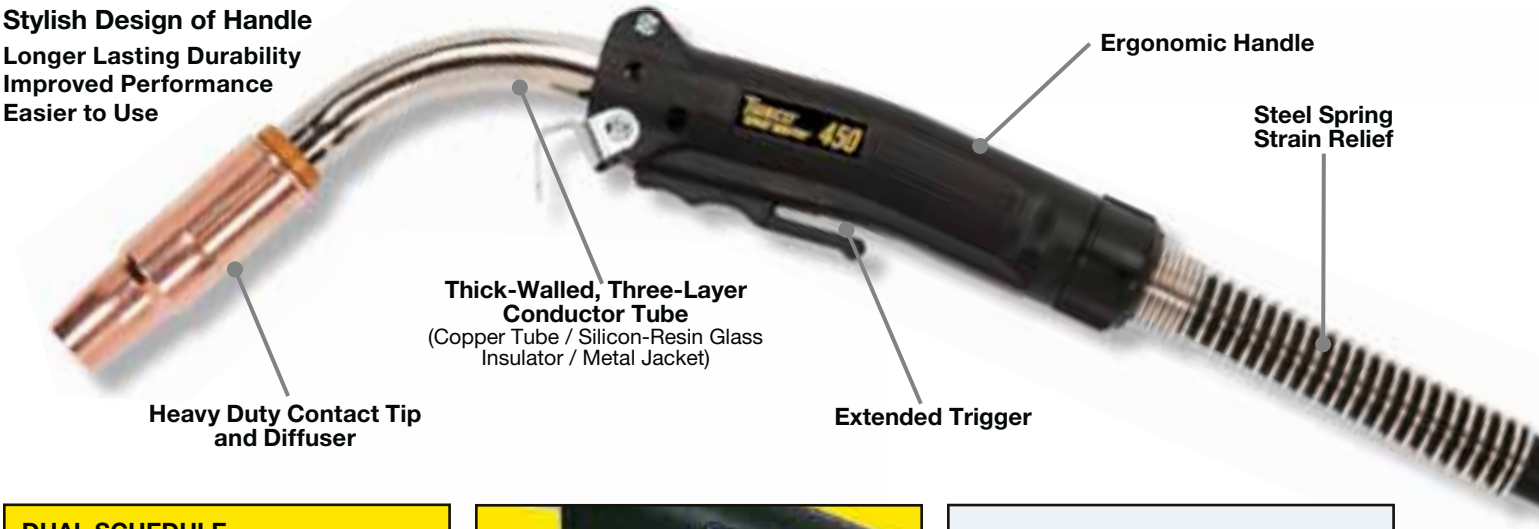
For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Spray Master® MIG Gun & Welding Consumables

Stylish Design of Handle
Longer Lasting Durability
Improved Performance
Easier to Use



DUAL SCHEDULE
Optional Dual Schedule On/Off control with your gloved thumb (350 and 450 Amp only) Identified with "DSRS" Part No. suffix





LOCKING TRIGGER
Optional mechanical locking trigger - Identified with "LC" Part No. suffix
"LC" = *Locking Control / Locking Trigger*

Enhanced Design of Front End Consumables

- **Eliminator® Contact Tips** increase productivity
- **Heavy Duty Contact Tip and Diffuser** for better electrical conductivity
- **Enhanced Gas Diffuser Design** designed for specific MIG gun series to improve gas coverage
- **Slip-On or Thread-On Nozzle Styles** with a choice of diameter bore sizes
- **Conduit Liners** made from either zinc-plated music wire with and without nylon coated wall or Teflon tubing – all having its benefits when running the various welding wire material
- **Contact Tips** manufactured from extruded copper alloy 122 in either threaded and/or twist lock Eliminator style



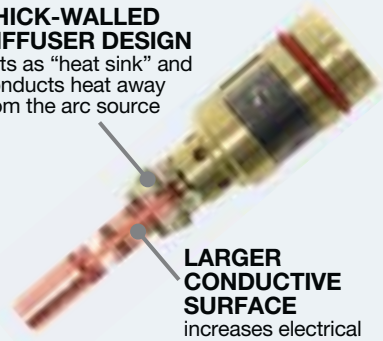
Tweco® offers a wide range of front end consumables for your MIG gun. With over 40 years of experience delivering dependable and durable MIG welding consumables, trust Tweco to fit all of your welding application needs.

TWIST-IT AND FORGET IT
locks in place, no threads to worry about and increases surface contact between contact tip and diffuser



DOUBLE TIP LIFE
by twisting tip to expose a new wear point

THICK-WALLED DIFFUSER DESIGN
acts as "heat sink" and conducts heat away from the arc source



LARGER CONDUCTIVE SURFACE
increases electrical conductivity



12 HOLES in the diffuser provides a more uniform gas flow over the welding wire and the weld pool for improved gas coverage

MIG/FLUX CORED | MAX OUTPUT 250 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

Spray Master® 250 Amp MIG Gun



80% Duty Cycle - Mixed Gases
Suitable for Light/Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. MS63-60 (Stock No. 1630-1189) on all guns up to 15 ft (4.6 m)
- Part No. MS63-45 (Stock No. 1630-1188) on all guns over 15 ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	MS210-3545	1023-1100
	12 ft (3.6 m)	MS212-3545	1023-1101
	15 ft (4.6 m)	MS215-3545	1023-1102
	20 ft (6.1 m)	MS220-3545	1023-1103
	25 ft (7.6 m)	MS225-3545	1023-1108

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	MS210M-3545	1023-1110
	12 ft (3.6 m)	MS212M-3545	1023-1111
	15 ft (4.6 m)	MS215M-3545	1023-1112
	15 ft (4.6 m)	MS215M-3545EL	1023-1121
	20 ft (6.1 m)	MS220M-3545	1023-1113
	25 ft (7.6 m)	MS225M-3545	1023-1118

Suffix "EL" = *Eliminator Front End Consumables*

Tweco® Style (8-pin) Rear Connector

8-pin Control Wire Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	MS212E-3545	1023-1140
	15 ft (4.6 m)	MS215E-3545	1023-1141

Lincoln® Style Rear Connector

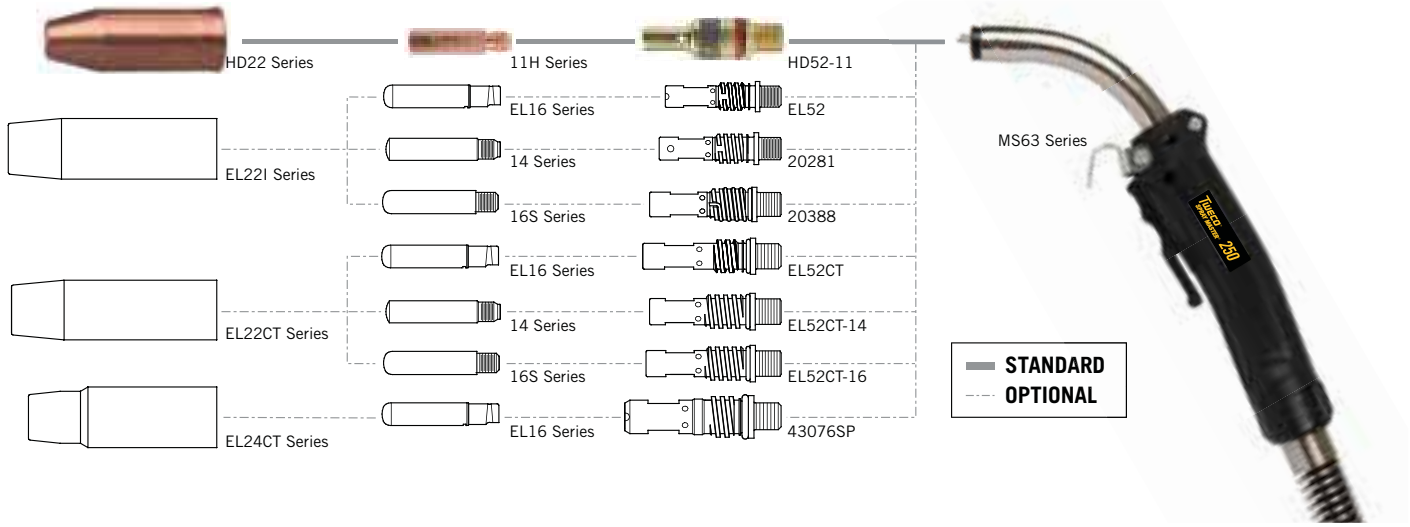
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	MS212L-3545	1023-1136

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	MS210X-3545	1023-1125
	12 ft (3.6 m)	MS212X-3545	1023-1126
	15 ft (4.6 m)	MS215X-3545	1023-1127
	25 ft (7.6 m)	MS225X-3545	1023-1133



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	80%	Mixed	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

EASY FIND GUIDE
See Page 14 & 15 for Replacement Parts & Optional Accessories

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MIG/FLUX CORED | MAX OUTPUT 350 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE MED. DUTY

Spray Master® 350 Amp MIG Gun



80% Duty Cycle - Mixed Gases

Suitable for Medium/Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. MS63-60 (Stock No. 1630-1189) on all guns up to 15 ft (4.6 m)
- Part No. MS63-45 (Stock No. 1630-1188) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	MS310-116	1036-1610
	12 ft (3.6 m)	MS312-116	1036-1613
	15 ft (4.6 m)	MS315-116	1036-1615
	15 ft (4.6 m)	MS315-116K4	1036-1715
	15 ft (4.6 m)	MS315-116DSRS	1036-1721
	15 ft (4.6 m)	MS315-116EL	1036-1725

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	MS310M-116	1036-1635
	12 ft (3.6 m)	MS312M-116	1036-1638
	15 ft (4.6 m)	MS315M-116	1036-1640
	15 ft (4.6 m)	MS315M-116K4	1036-1716
	15 ft (4.6 m)	MS315M-116EL	1036-1726
	25 ft (7.6 m)	MS325M-116	1036-1642

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

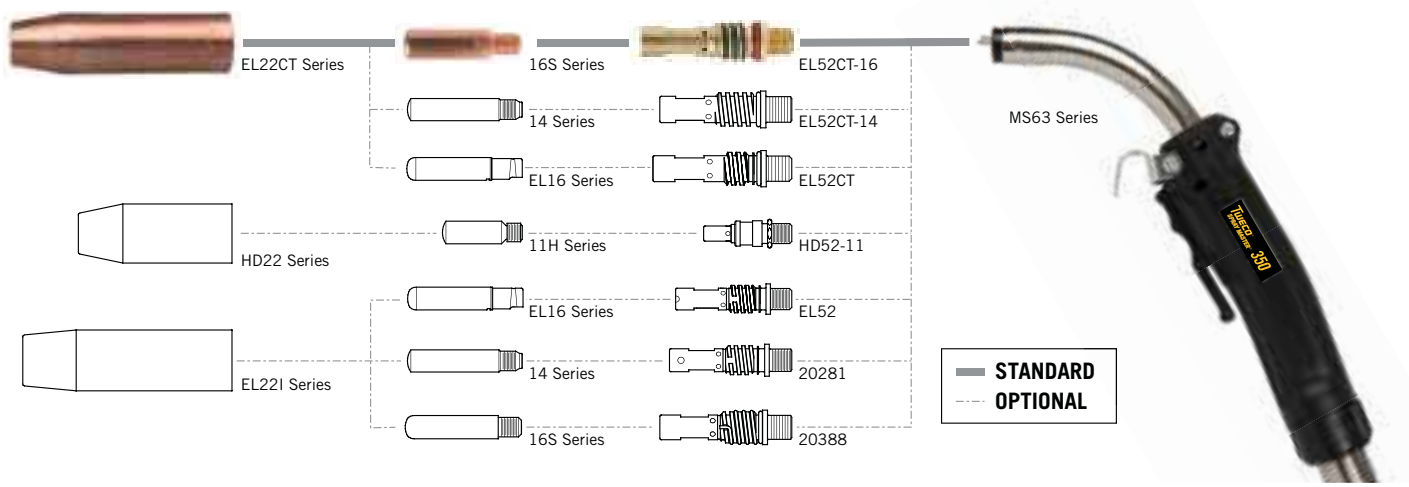
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	MS312L-116	1036-1646
	15 ft (4.6 m)	MS315L-116	1036-1647
	15 ft (4.6 m)	MS315L-116K4	1036-1717
	15 ft (4.6 m)	MS315L-116DSRS	1036-1722
	15 ft (4.6 m)	MS315L-116EL	1023-1727

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	MS315X-116	1036-1623
	15 ft (4.6 m)	MS315X-116EL	1036-1728

Suffix "K4" = *Kucklehead Conductor Tube – Part No. MS63SFLX4-80 (Stock No. 1630-1198);*
"DSRS" *= Dual Schedule Rocker Switch;*
Suffix "EL" *= Eliminator Front End Consumables*



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
350 Amps	80%	Mixed	Up To 1/16" (1.6 mm)	Air	Medium/Heavy Duty Fabrication

EASY FIND GUIDE
See Page 14 & 15 for Replacement Parts & Optional Accessories

Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco. Tweco is registered trademark of ESAB.

MIG/FLUX CORED | MAX OUTPUT 450 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Spray Master® 450 Amp MIG Gun



80% Duty Cycle - Mixed Gases
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Locking Trigger, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. MS64H-60 (Stock No. 1640-1319) on all guns up to 15 ft (4.6 m)
- Part No. MS64H-45 (Stock No. 1630-1318) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**MS410-116**	1040-1050
	12 ft (3.6 m)	**MS412-116**	1040-1051
	15 ft (4.6 m)	**MS415-116**	1040-1052
	15 ft (4.6 m)	**MS415-116K4**	1040-1530
	15 ft (4.6 m)	**MS415-116LM**	1040-1053
	15 ft (4.6 m)	**MS415-116EL**	1040-1541
	20 ft (6.1 m)	**MS420-116**	1040-1059
	25 ft (7.6 m)	**MS425-116**	1040-1058

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**MS410M-116**	1040-1060
	12 ft (3.6 m)	**MS412M-116**	1040-1061
	15 ft (4.6 m)	**MS415M-116**	1040-1062
	15 ft (4.6 m)	**MS415M-116K4**	1040-1531
	15 ft (4.6 m)	**MS415M-116DS**	1040-1097
	15 ft (4.6 m)	**MS415M-116DSRS**	1040-1536
	15 ft (4.6 m)	**MS415M-116LC**	1040-1092
	15 ft (4.6 m)	**MS415M-116LM**	1040-1063
	20 ft (6.1 m)	**MS420M-116**	1040-1064
	25 ft (7.6 m)	**MS425M-116**	1040-1068
	25 ft (7.6 m)	**MS425M-116DS**	1040-1099

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

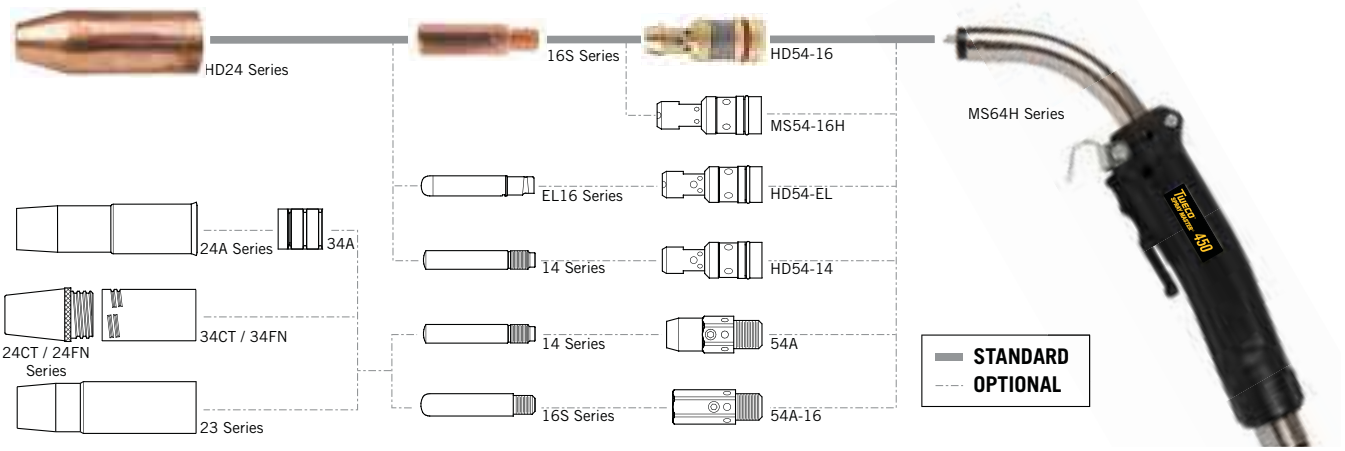
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**MS410L-116**	1040-1070
	15 ft (4.6 m)	**MS415L-116**	1040-1072
	15 ft (4.6 m)	**MS415L-116K4**	1040-1533
	15 ft (4.6 m)	**MS415L-116DSRS**	1040-1538
	15 ft (4.6 m)	**MS415L-116LC**	1040-1074
	15 ft (4.6 m)	**MS415L-116LM**	1040-1073
	15 ft (4.6 m)	**MS415L-116EL**	1040-1543
	25 ft (7.6 m)	**MS425L-116**	1040-1071

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**MS410X-116**	1040-1075
	12 ft (3.6 m)	**MS412X-116**	1040-1076
	15 ft (4.6 m)	**MS415X-116EL**	1040-1544
	15 ft (4.6 m)	**MS415X-116**	1040-1077

Suffix "K4" = *Knucklehead Conductor Tube – Part No. MS64SFLX4-80 (Stock No. 1640-1308);*
"DSRS" = *Dual Schedule Rocker Switch;* **"LC"** = *Locking Trigger;*
"LM" = *Long Reach Conductor Tube – Part No. MS64H-60LM (Stock No. 1640-1317);*
Suffix "EL" = *Eliminator Front End Consumables*



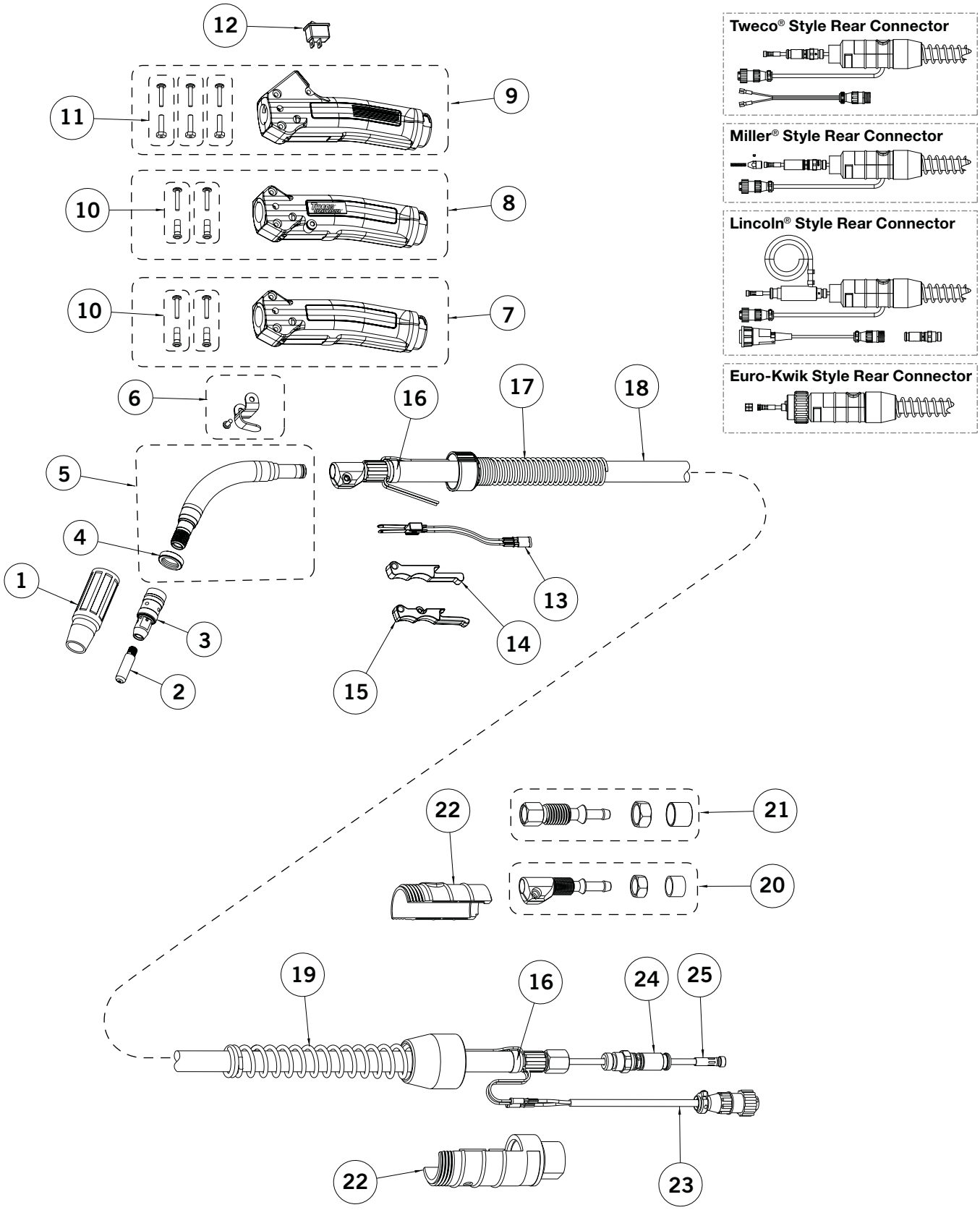
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	80%	Mixed	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 14 & 15 for Replacement Parts & Optional Accessories

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Spray Master® MIG Gun Replacement Parts



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Spray Master® MIG Gun Replacement Parts

#	Description	**Spray Master** 250 Amp		**Spray Master** 350 Amp		**Spray Master** 450 Amp	
		Part No.	**Stock No.**	**Part No.**	**Stock No.**	**Part No.**	**Stock No.**
1	Nozzle	**HD22 Series**		**EL22CT Series**		**HD24 Series**	
2	Contact Tip	**11H Series**		**16S Series**		**16S Series**	
3	Diffuser	**HD52-11**		**EL52CT-16**		**HD54-16**	
4	Nozzle Insulator	**63J-3**	1630-1121	**63J-3**	1630-1121	**66J-3**	1660-1836
5	Conductor Tube	**MS63 Series**		**MS63 Series**		**MS63 Series**	
6	Gun Hanger	**152**	2020-2152	**152**	2020-2152	**152**	2020-2152
7	Handle (Standard)	**MS84**	2060-2130	**MS84**	2060-2130	**MS84**	2060-2130
8	Handle (Locking Trigger)	**MS84LC**	2060-2127	**MS84LC**	2060-2127	**MS84LC**	2060-2127
9	Handle (Dual Schedule)	**MS84DSRS**	2060-2128	**MS84DSRS**	2060-2128	**MS84DSRS**	2060-2128
10	Binder Posts & Screws (Standard & Locking)	**ELC124FM**	2060-2646	**ELC124FM**	2060-2646	**ELC124FM**	2060-2646
11	Binder Posts & Screws (Dual Schedule)	**122FMS**	2020-2123	**122FMS**	2020-2123	**122FMS**	2020-2123
12	Rocker Switch (Dual Schedule)	**MS94RSW**	2060-2694	**MS94RSW**	2060-2694	**MS94RSW**	2060-2694
13	Trigger Blade Assembly	**ELC94-BL**	2060-2671	**ELC94-BL**	2060-2671	**ELC94-BL**	2060-2671
14	Trigger (Standard)	**ELC94**	2060-2647	**ELC94**	2060-2647	**ELC94**	2060-2647
15	Trigger (Locking)	**MS94LC**	2060-2693	**MS94LC**	2060-2693	**MS94LC**	2060-2693
16	Cable Clamp	**136**	2060-2690	**136**	2060-2690	**136**	2060-2690
17	Front Strain Relief Spring & Cap	**MS144**	2060-2131	**MS144**	2060-2131	**MS144**	2060-2131
18	10 ft (3 m) Cablehoz® Assembly (Direct Plug)	**MS210**	1720-2115	**MS310**	1730-2035	**--**	--
	12 ft (3.6 m) Cablehoz Assembly (Direct Plug)	**MS212**	1720-2116	**MS312**	1730-2036	**MS412**	1740-2116
	15 ft (4.6 m) Cablehoz Assembly (Direct Plug)	**MS215**	1720-2117	**MS315**	1730-2037	**MS415**	1740-2117
	25 ft (7.6 m) Cablehoz Assembly (Direct Plug)	**--**	--	**MS325**	1730-2038	**MS425**	1740-2118
	10 ft (3 m) Cablehoz Assembly (Euro)	**MS210X**	1720-2106	**MS310X**	1730-2010	**MS410X**	1740-2121
	12 ft (3.6 m) Cablehoz Assembly (Euro)	**MS212X**	1720-2107	**--**	--	**MS412X**	1740-2122
	15 ft (4.6 m) Cablehoz Assembly (Euro)	**MS215X**	1720-2108	**MS315X**	1730-2012	**MS415X**	1740-2123
	25 ft (7.6 m) Cablehoz Assembly (Euro)	**--**	--	**MS325X**	1730-2013	**MS425X**	1740-2124
19	Rear Strain Relief Spring & Cap	**235RSSR**	2060-2035	**235RSSR**	2060-2035	**235RSSR**	2060-2035
20	Front Cable Connector Repair Kit (Direct Plug & Euro)	**MS102-RK**	2060-2132	**MS104-RK**	2060-2133	**MS104-RK**	2060-2133
21	Rear Cable Connector Repair Kit (Direct Plug)	**EPG172-H**	2020-2191	**350-170HK**	2035-2169	**350-170HK**	2035-2169
	Rear Cable Connector Repair Kit (Euro)	**172X-M**	2020-2181	**174X-M**	2040-2181	**174X-M**	2040-2181
22	Rear Case (Direct Plug)	**C6RC**	2060-2041	**C6RC**	2060-2041	**C6RC**	2060-2041
	Rear Case (Euro)	**X6RC**	2060-2006	**X6RC**	2060-2006	**X6RC**	2060-2006
23	Miller® Control Wire	**MS354-DSM**	2060-2140	**MS354-DSM**	2060-2140	**MS354-DSM**	2060-2140
24	Connector Plug	**Refer to Pages 92-93**		**Refer to Pages 92-93**		**Refer to Pages 92-93**	
25	Conduit Assembly	**Refer to Pages 124-127**		**Refer to Pages 124-127**		**Refer to Pages 124-127**	
NS	Protective Cable Wrap, 50 ft (15.2 m) per box	**TCR50**	9900-1150	**TCR50**	9900-1150	**TCR50**	9900-1150

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 250 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

Spray Master® V250 Amp MIG Gun



80% Duty Cycle - Mixed Gases

Suitable for Light/Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. SMVCT-60 (Stock No.1240-1374) on all guns up to 15ft (4.6 m)
- Part No. SMVCT-45 (Stock No. 1240-1373) on all guns over 15ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**SMV210-3545**	1023-1290
	12 ft (3.6 m)	**SMV212-3545**	1023-1276
	15 ft (4.6 m)	**SMV215-3545**	1023-1277
	20 ft (6.1 m)	**SMV220-3545**	1023-1278
	25 ft (7.6 m)	**SMV225-3545**	1023-1279

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**SMV210M-3545**	1023-1280
	12 ft (3.6 m)	**SMV212M-3545**	1023-1281
	15 ft (4.6 m)	**SMV215M-3545**	1023-1282
	20 ft (6.1 m)	**SMV220M-3545**	1023-1283
	25 ft (7.6 m)	**SMV225M-3545**	1023-1289

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

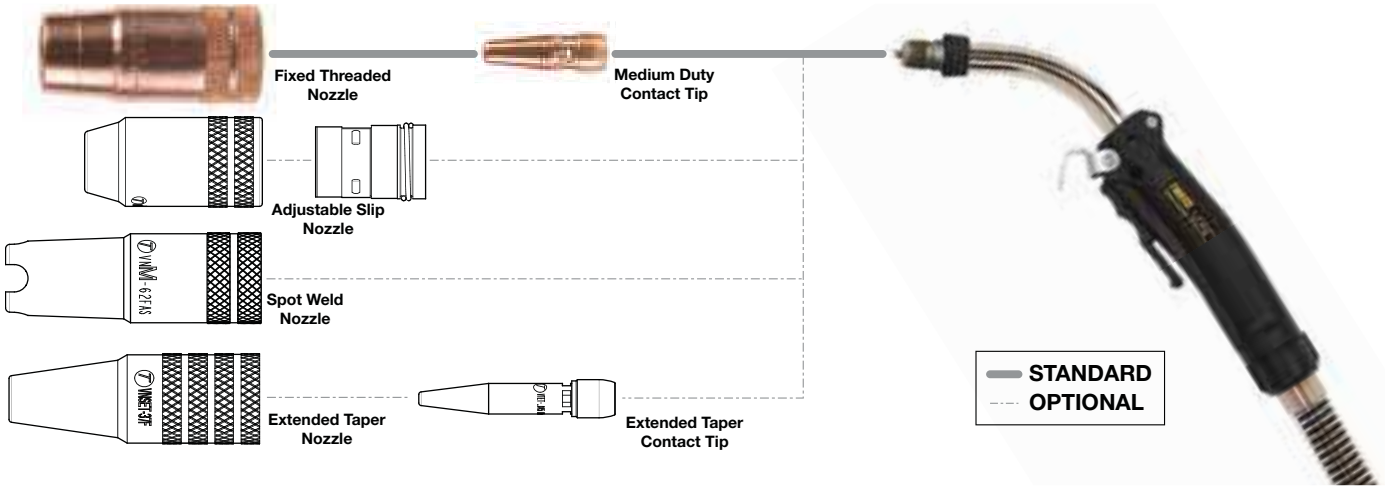
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**SMV210L-3545**	1023-1292
	12 ft (3.6 m)	**SMV212L-3545**	1023-1285
	15 ft (4.6 m)	**SMV215L-3545**	1023-1293
	20 ft (6.1 m)	**SMV220L-3545**	1023-1294
	25 ft (7.6 m)	**SMV225L-3545**	1023-1295

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**SMV210X-3545**	1023-1286
	12 ft (3.6 m)	**SMV212X-3545**	1023-1287
	15 ft (4.6 m)	**SMV215X-3545**	1023-1288
	20 ft (6.1 m)	**SMV220X-3545**	1023-1291
	25 ft (7.6 m)	**SMV225X-3545**	1023-1284

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	80%	Mixed	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

For more information refer to Tweco Spray Master V-Series MIG Gun flyer Form No. 64-1404

EASY FIND GUIDE
See Page 20 & 21 for Replacement Parts & Optional Accessories

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MIG/FLUX CORED | MAX OUTPUT 350 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE MED. DUTY

Spray Master® V350 Amp MIG Gun



80% Duty Cycle - Mixed Gases
Suitable for Medium/Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW),

Standard Options Include:

- Dual Schedule On/Off Control, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. SMVCT-60 (Stock No.1240-1374) on all guns up to 15ft (4.6 m)
- Part No. SMVCT-45 (Stock No. 1240-1373) on all guns over 15ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV310-116**	1036-1750
	12 ft (3.6 m)	**SMV312-116**	1036-1752
	15 ft (4.6 m)	**SMV315-116**	1036-1756
	15 ft (4.6 m)	**SMV315-116DSRS**	1036-1783
	15 ft (4.6 m)	**SMV315-116K4**	1036-1759
	20 ft (6.1 m)	**SMV320-116**	1036-1789
	25 ft (7.6 m)	**SMV325-116**	1036-1787

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV310M-116**	1036-1751
	12 ft (3.6 m)	**SMV312M-116**	1036-1754
	15 ft (4.6 m)	**SMV315M-116**	1036-1765
	15 ft (4.6 m)	**SMV315M-116K4**	1036-1768
	15 ft (4.6 m)	**SMV315M-332K4**	1036-1791
	15 ft (4.6 m)	**SMV315M-116CT180**	1036-1777
	20 ft (6.1 m)	**SMV320M-116**	1036-1780
	25 ft (7.6 m)	**SMV325M-116CT180**	1036-1778
	25 ft (7.6 m)	**SMV325M-116**	1036-1775

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV310L-116**	1036-1785
	12 ft (3.6 m)	**SMV312L-116**	1036-1753
	15 ft (4.6 m)	**SMV315L-116**	1036-1762
	15 ft (4.6 m)	**SMV315L-116DSRS**	1036-1788
	15 ft (4.6 m)	**SMV315L-116K4**	1036-1764
	20 ft (6.1 m)	**SMV320L-116**	1036-1781
	25 ft (7.6 m)	**SMV325L-116**	1036-1786

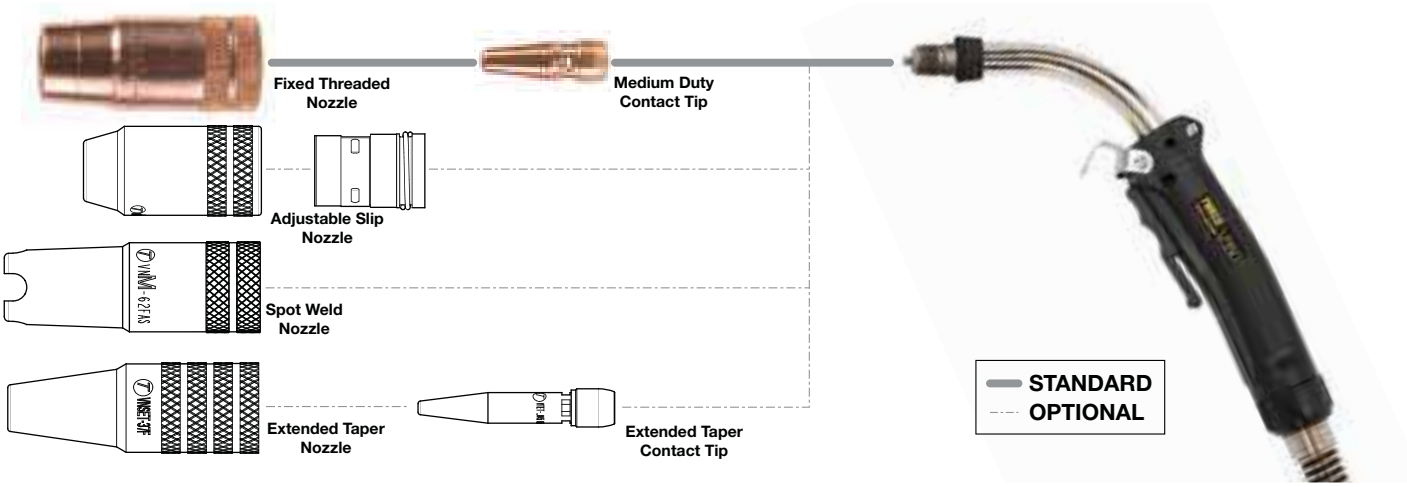
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV310X-116**	1036-1784
	12 ft (3.6 m)	**SMV312X-116**	1036-1779
	15 ft (4.6 m)	**SMV315X-116**	1036-1770
	20 ft (6.1 m)	**SMV320X-116**	1036-1782
	25 ft (7.6 m)	**SMV325X-116**	1036-1790

"DSRS" = *Dual Schedule Rocker Switch;* **"K4"** = *Knucklehead Conductor Tube*

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
350 Amps	80%	Mixed	Up To 1/16" (1.6 mm)	Air	Medium/Heavy Duty Fabrication

EASY FIND GUIDE
See Page 20 & 21 for Replacement Parts & Optional Accessories

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 450 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Spray Master® V450 Amp MIG Gun



80% Duty Cycle - Mixed Gases
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Locking Trigger, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. SMVCT-60 (Stock No.1240-1374) on all guns up to 15ft (4.6 m)
- Part No. SMVCT-45 (Stock No. 1240-1373) on all guns over 15ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV410-116**	1040-1825
	12 ft (3.6 m)	**SMV412-116**	1040-1829
	15 ft (4.6 m)	**SMV415-116**	1040-1833
	15 ft (4.6 m)	**SMV415-116LM**	1040-1838
	15 ft (4.6 m)	**SMV425-116LMK4**	1040-1870
	20 ft (6.1 m)	**SMV420-116**	1040-1854
	25 ft (7.6 m)	**SMV425-116**	1040-1859

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV410M-116**	1040-1827
	12 ft (3.6 m)	**SMV412M-116**	1040-1830
	15 ft (4.6 m)	**SMV415M-116**	1040-1844
	15 ft (4.6 m)	**SMV415M-116DSRS**	1040-1846
	15 ft (4.6 m)	**SMV415M-116LC**	1040-1848
	15 ft (4.6 m)	**SMV415M-116LM**	1040-1849
	15 ft (4.6 m)	**SMV415M-116K4**	1040-1874
	20 ft (6.1 m)	**SMV420M-116**	1040-1855
	25 ft (7.6 m)	**SMV425M-116**	1040-1861
	25 ft (7.6 m)	**SMV425M-116LM**	1040-1872

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV410L-116**	1040-1826
	12 ft (3.6 m)	**SMV415L-116**	1040-1866
	15 ft (4.6 m)	**SMV415L-116**	1040-1839
	15 ft (4.6 m)	**SMV415L-116DSRS**	1040-1840
	15 ft (4.6 m)	**SMV415L-116LC**	1040-1842
	15 ft (4.6 m)	**SMV415L-116LM**	1040-1843
	15 ft (4.6 m)	**SMV415L-116K4**	1040-1875
	20 ft (6.1 m)	**SM420L-116**	1040-1869
	25 ft (7.6 m)	**SMV425L-116**	1040-1860
	25 ft (7.6 m)	**SMV425L-116LM**	1040-1871

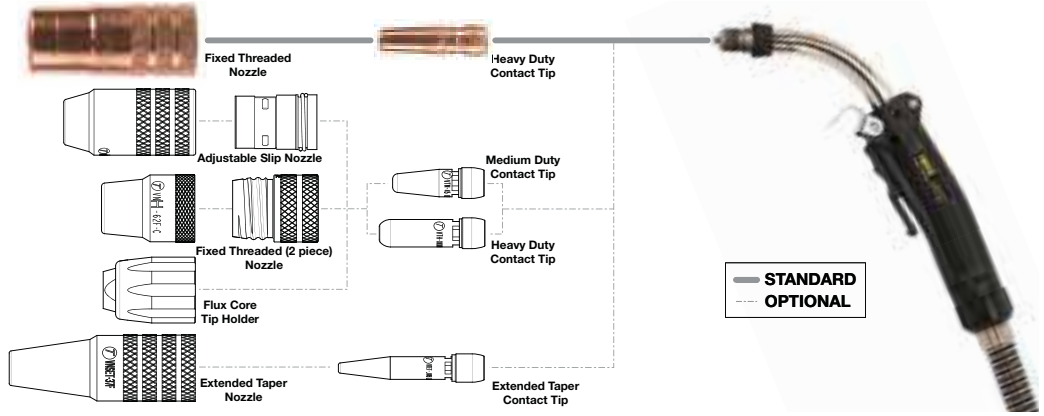
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SMV410X-116**	1040-1828
	12 ft (3.6 m)	**SMV412X-116**	1040-1832
	15 ft (4.6 m)	**SMV415X-116**	1040-1850
	20 ft (6.1 m)	**SMV420X-116**	1040-1867
	25 ft (7.6 m)	**SMV425X-116**	1040-1868
	25 ft (7.6 m)	**SMV425X-116LM**	1040-1873

"DSRS" = *Dual Schedule Rocker Switch;* **"LC"** = *Locking Trigger;*
"K4" = *Knucklehead Conductor Tube;* **"LM"** = *Long reach Conductor Tube*

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	80%	Mixed	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

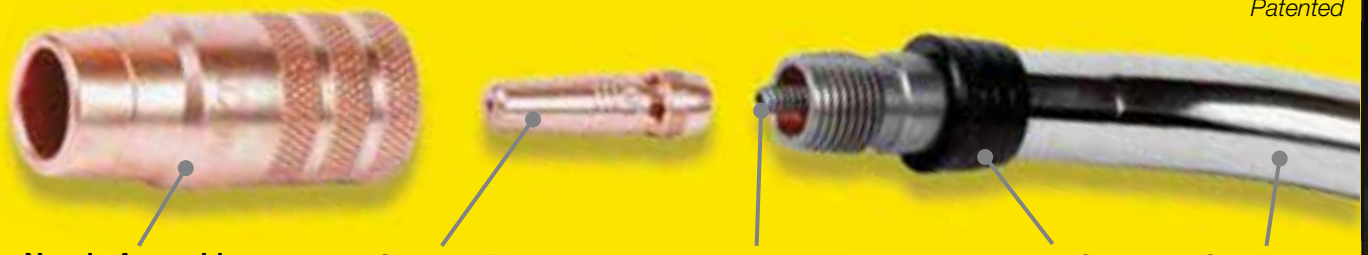
EASY FIND GUIDE
See Page 20 & 21 for Replacement Parts & Optional Accessories

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Spray Master®
V-Series MIG Guns with Velocity™ Consumables



Patented



Nozzle Assembly
Heavy Duty Copper

Contact Tip
with Gas Ports

Conduit Liner
Perfectly Centered inside Tip

Nozzle Collar
with index marks

Conductor Tube
Fully Insulated

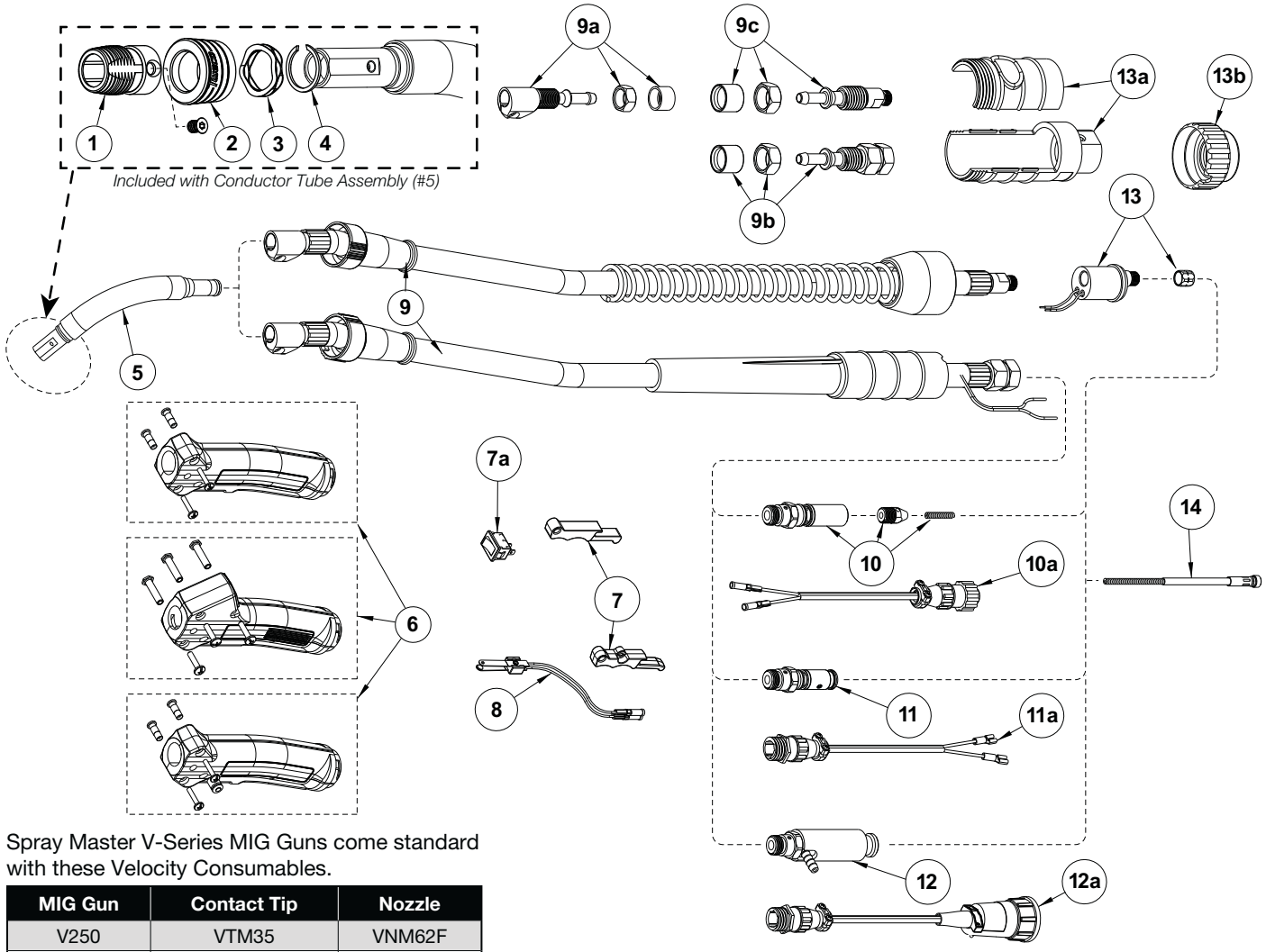
FEATURES

- **Velocity™ Consumables** with new ground-breaking innovation inspired by welders for welders
- **Solid Copper Conductor Path** with fewer connections for optimized electrical surface contact
- **Fewer Consumable Parts** mean less complexity and lower cost of ownership
- **Gas Ported Velocity Contact Tips** stay cooler and last longer
- **Extended Length Trigger** allows welders to adjust their grip for access, comfort and to avoid radiated heat
- **Easy to Use Velocity Tips** eliminates threads and requires no tools
- **Tips can be Rotated** to prolong life requiring fewer changes
- **Excellent Wire Feedability** with centered liner
- **Superior Welding Performance** from a smoother, more stable arc
- **Compact, Ergonomic Handle Design** is balanced to pivot at the center of the handle for ease of use, thereby reducing operator fatigue
- **Front and Rear Steel Spring Strain Relief** provides support to the Cablehoz® coming out of the rear of the handle and minimizes wire feed issues
- **Split Handle Case** provides access for ease of repairs in the field
- **Durable, Metal-Jacketed, Three-Layer Conductor Tube** rotates easily for different welding positions and lowers heat in the front end
- **Crimped Front Cablehoz Connection** for improved electrical conductivity
- **Designed for Spray and Pulse transfer modes,** maintains the copper needed for high duty cycle welding



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Spray Master® V-Series Replacement Parts



Spray Master V-Series MIG Guns come standard with these Velocity Consumables.

MIG Gun	Contact Tip	Nozzle
V250	VTM35	VNM62F
V350	VTM116	VNM62F
V450	VTH116	VNH62

Upgrade your Spray Master® MIG gun to Velocity™ by replacing the conductor tube.

For additional information on converting to Velocity consumables, refer to Tweco Conductor Tube Conversions and Diffuser Adaptors Flyer Form No. 64-1403



Spray Master Conductor Tube Upgrade

Description	Part No.	Stock No.
45° Conductor Tube Assembly	**SMVCT45**	1240-1373
45° Conductor Tube Long Reach Assembly	**SMVCT45LM**	1640-1373
60° Conductor Tube Assembly	**SMVCT60**	1240-1374
60° Conductor Tube Long Reach Assembly	**SMVCT60LM**	1640-1374

Upgrade Spray Master to Velocity™

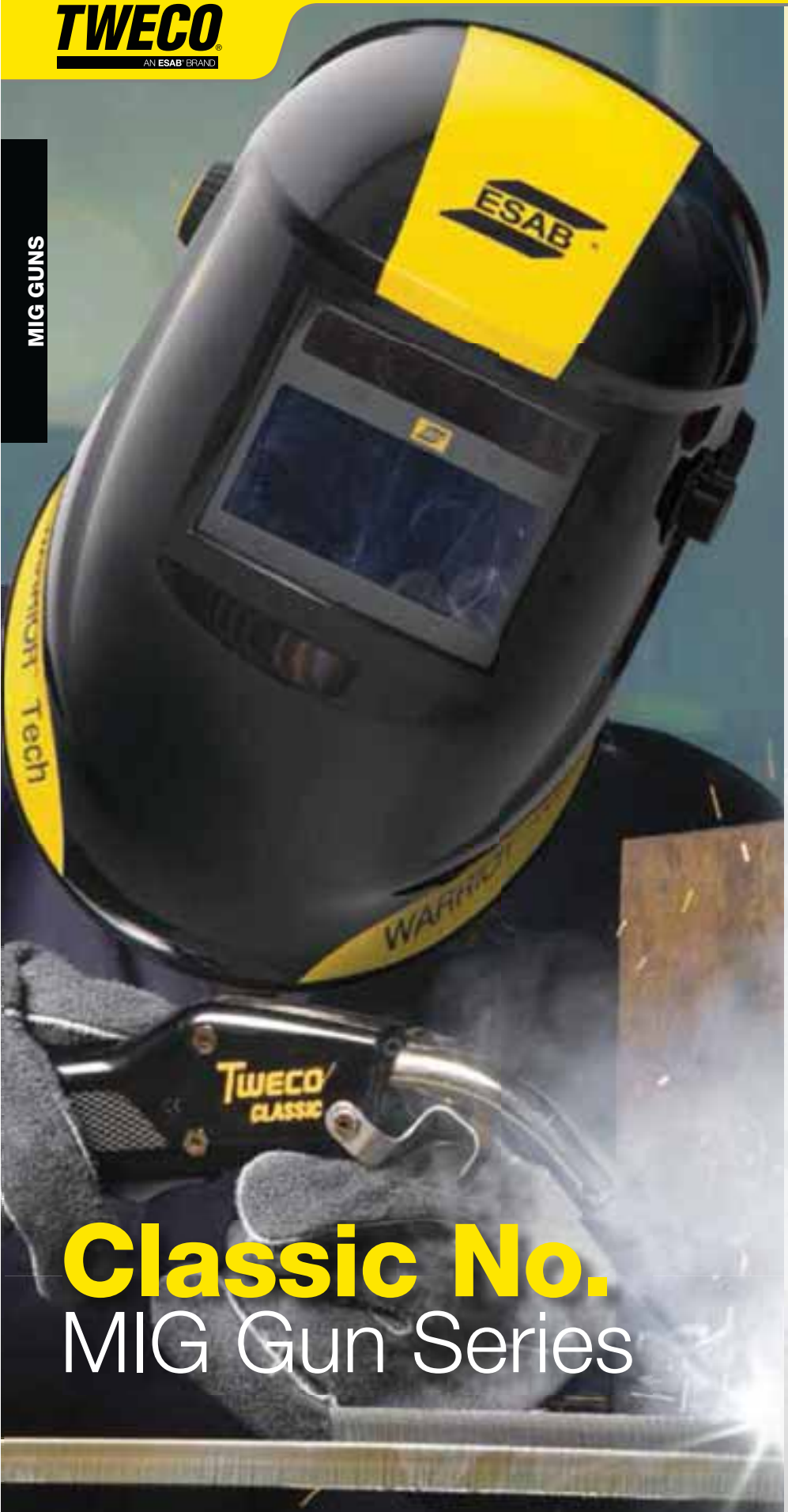
1) Order a Velocity conductor tube assembly from the table at left.
2) Order a new replacement liner.
3) Order Velocity consumables - contact tips and nozzles. See catalog page 94 or Velocity consumables range brochure *(Form No. 64-1403)*.
4) Visit our website or refer to your Tweco® owner's manual for specific step by step instructions to complete the modification.

Spray Master® V-Series Replacement Parts

#	Description	**Spray Master** V250 Amp		**Spray Master** V350 Amp		**Spray Master** V450 Amp	
		Part No.	**Stock No.**	**Part No.**	**Stock No.**	**Part No.**	**Stock No.**
1	Threaded Stainless Sleeve	**VCTLSL**	1640-1397	**VCTLSL**	1640-1397	**VCTLSL**	1640-1397
2	Nozzle Collar	**VCTLSLK**	1640-1398	**VCTHSLK**	1640-1398	**VCTHSLK**	1640-1398
3	Wave Spring	**VCTLSPR**	1640-1399	**VCTLSPR**	1640-1399	**VCTLSPR**	1640-1399
4	Wave Spring Retainer	**PMA64RS**	1640-1396	**PMA64RS**	1640-1396	**PMA64RS**	1640-1396
5	Conductor Tube Assembly	**SMVCT45**	1240-1373	**SMVCT60**	1240-1374	**SMVCT60**	1240-1374
6	Handle –Standard Spray Master	**SMV82**	2060-2082	**SMV83**	2060-2083	**SMV84**	2060-2084
	Handle –Dual Schedule (Rocker Switch)	**N/A**	N/A	**SMV83DS**	2060-2077	**SMV84DS**	2060-2078
	Handle –Locking Trigger	**SMV82LC**	2060-2079	**SMV83LC**	2060-2080	**SMV84LC**	2060-2081
7	Trigger–Standard & Dual Schedule	**ELC94**	2060-2647	**ELC94**	2060-2647	**ELC94**	2060-2647
	Trigger –Locking	**MS94-LC**	2060-2693	**MS94-LC**	2060-2693	**MS94-LC**	2060-2693
7b	Dual Schedule Rocker Switch	**N/A**	N/A	**MS94-RSW**	2060-2694	**MS94-RSW**	2060-2694
8	Trigger Blade Assembly	**ELC94-BL**	2060-2671	**ELC94-BL**	2060-2671	**ELC94-BL**	2060-2671
9	Cablehoz® Assembly - 10 ft (3 m)	**N/A**	N/A	**MS310**	1730-2035	**N/A**	N/A
	Cablehoz Assembly - 12 ft (4 m)	**MS212**	1720-2116	**MS312**	1730-2036	**MS512**	1750-2116
	Cablehoz Assembly - 15 ft (5 m)	**MS215**	1720-2117	**MS315**	1730-2037	**MS515**	1750-2117
	Cablehoz Assembly - 25 ft (8 m)	**MS225**	1720-2118	**MS325**	1730-2038	**MS525**	1750-2118
	Cablehoz Assembly, Euro-Kwik - 12 ft (4 m)	**MS212X**	1720-2107	**N/A**	N/A	**MS512X**	1750-2119
	Cablehoz Assembly, Euro-Kwik - 15 ft (5 m)	**MS215X**	1720-2108	**N/A**	N/A	**MS515X**	1750-2120
	Cablehoz Assembly, Euro-Kwik - 25 ft (8 m)	**MS225X**	1720-2109	**N/A**	N/A	**N/A**	N/A
9a	Cablehoz Front Mechanical Connector Replacement Kit	**MS102-RK**	2060-2132	**MS104-RK**	2060-2133	**EL106-RK**	2060-2620
9b	Cablehoz Rear Mechanical Connector Replacement Kit	**MS172-RK**	2060-2134	**MS174-RK**	2060-2135	**--**	--
9c	Cablehoz Rear Mechanical Connector Replacement Kit For Euro-Style	**172X-M**	2020-2181	**174X-M**	2040-2181	**--**	--
10a	Miller® Rear Connector	**350174MHFS**	2035-2118	**350174MHFS**	2035-2118	**350174MHFS**	2035-2118
10b	Miller Control Wire & Plug	**WM-354M**	2030-2075	**WM-354M**	2030-2075	**WM-354M**	2030-2075
NS	Miller Dual Schedule Control Wire & Plug	**N/A**	N/A	**194DS**	2040-2195	**194DS**	2040-2195
11a	Tweco® Rear Connector	**350174HFS**	2035-2119	**350174HFS**	2035-2119	**350174HFS**	2035-2119
11b	Tweco Control Wire	**MS354-TAJ**	2060-2139	**MS354-TAJ**	2060-2139	**MS354-TAJ**	2060-2139
NS	Tweco Dual Schedule Control Wire & Plug	**MS-354DS-TJ**	2060-2138	**MS-354DS-TJ**	2060-2138	**MS-354DS-TJ**	2060-2138
12a	Lincoln® Rear Connector	**350-174LH**	2035-2112	**350-174LH**	2035-2112	**350-174LH**	2035-2112
12b	Lincoln Control Wire & Plug	**MS-354DS-LJ**	2060-2137	**MS-354DS-LJ**	2060-2137	**MS-354DS-LJ**	2060-2137
13	Euro-Kwik Connection Assembly	**174EX-1**	2040-2276	**174EX-1**	2040-2276	**174EX-1**	2040-2276
13a	Euro-Kwik Nut	**174X-2**	2040-2177	**174X-2**	2040-2177	**174X-2**	2040-2177
13b	Euro-Kwik Connector Case	**X6RC**	2060-2006	**X6RC**	2060-2006	**X6RC**	2060-2006
14	Conduit – Refer to our catalog or visit esab.com	**--**	--	**--**	--	**--**	--
15	Sleeve Screw	**VCT41CS**	2040-2048	**VCT41CS**	2040-2048	**VCT41CS**	2040-2048

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Classic No.
MIG Gun Series

Classic® No.
MIG Gun Series

FEATURES

- **The Industry Standard** for over 40 years
- **Oval-Shaped Handle** reduces grip required to manipulate MIG gun and eases operator fatigue
- **High-Impact Crush-Resistant Handle** uses special plastic composition for long-lasting durability and dependability
- **Heavy Duty Handle** balanced to pivot at center for ease of use in different welding positions
- **Metal Jacketed Three-Layer Conductor Tube Construction** (copper tube/silicon-resin glass insulator/ metal jacket) for improved electrical conductivity
- **Trigger Contains Silver Plated Contacts** with self-cleaning action every time it is engaged or disengaged
- **Heavy Duty Design** for dependable industrial applications
- **Field Repairable Cablehoz®** requires no additional connectors
- **Gun Hanger** located at bottom for convenience of resting the gun when not in use
- **Split Handle Case** provides access for easy repairs
- **Improved Performance** with longer life consumables
- **Wide Selection** of front end consumables available
- **Front and Rear Steel Spring Strain Relief** provides support to the Cablehoz coming out of the rear of the handle and minimizes wire feed issues
- **Heavy Duty Contact Tips** in high heat applications offered
- **Interchangeable Front End Consumables** between Tweco® Classic No. and Tweco Spray Master® series

		Classic No. 1	Classic No. 2	Classic No. 3	Classic No. 4	Classic No. 5	Classic No. 6
Applications		Light Duty Fabrication	Medium Duty Fabrication	Med/Heavy Duty Fabrication	Med/Heavy Duty Fabrication	Heavy Duty Fabrication	Heavy Duty Fabrication
Standard Options	**Dual Schedule**				■		
	Rear Connector	■	■	■	■	■	■
	Knucklehead™ Flexible Conductor Tube		■		■		
Output Current		180 Amps	200 Amps	300 Amps	400 Amps	500 Amps	600 Amps
Duty Cycle - CO_2		60%	60%	60%	60%	60%	60%
Wire Diameter		Up to .045" (1.2 mm)	Up to . 045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 5/64" (2.0 mm)	Up to 3/32" (2.4 mm)	Up to 3/32" (2.4 mm)
Process	**MIG**	■	■	■	■	■	■
	Aluminum	■	■	■	■		
	Flux Cored Gas Shielded				■	■	■
	Flux Cored Self Shielded					■	■

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 180 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE LIGHT DUTY

Classic® No. 1 180 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector
- Standard Conductor Tube – Part No. 61-60 (Stock No. 1610-1102) on all guns up to 15 ft (4.6 m)
- Part No. 61-45 (Stock No. 1610-1101) on all guns over 15 ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**110-3035**	1010-1111
	12 ft (3.6 m)	**112-3035**	1010-1112
	15 ft (4.6 m)	**115-3035**	1010-1113
	20 ft (6.1 m)	**120-3035**	1010-1114
Up To .045" (1.2 mm)	10 ft (3 m)	**110-4045**	1010-1121
	12 ft (3.6 m)	**112-4045**	1010-1122
	15 ft (4.6 m)	**115-4045**	1010-1123
	20 ft (6.1 m)	**120-4045**	1010-1124

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**M110-3035**	1010-1131
	12 ft (3.6 m)	**M112-3035**	1010-1133
	15 ft (4.6 m)	**M115-3035**	1010-1135

Lincoln® Style Rear Connector

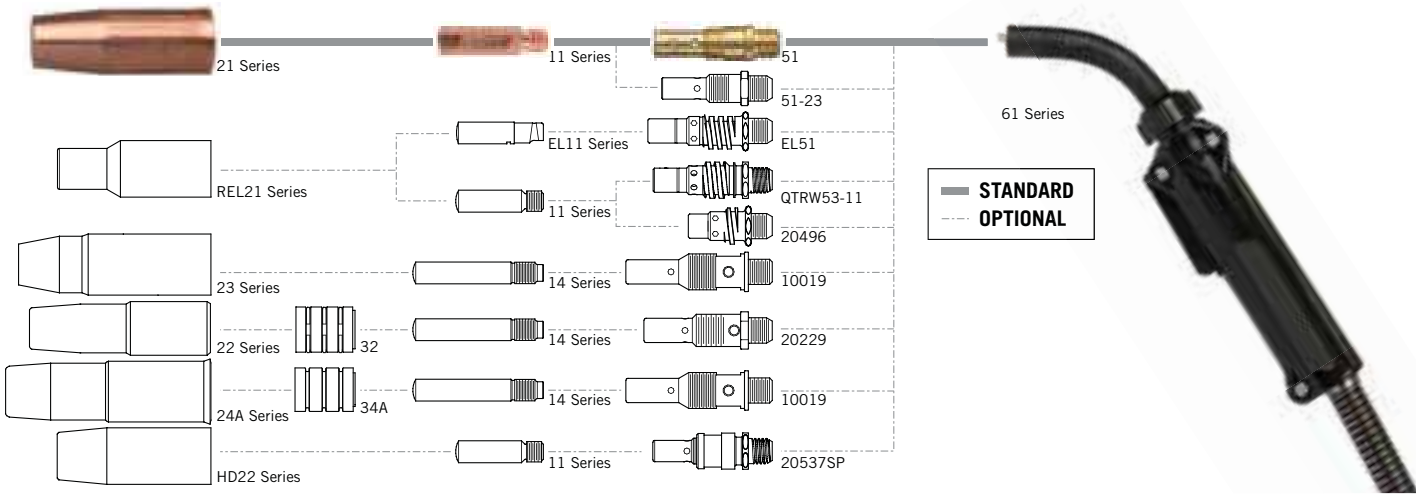
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	**L115-3035**	1010-1145

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**X110-4045**	1010-1621
	12 ft (3.6 m)	**X112-4045**	1010-1622
	15 ft (4.6 m)	**X115-4045**	1010-1623



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light Duty Fabrication

EASY FIND GUIDE
See Page 30 & 31 for Replacement Parts & Optional Accessories

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MIG | MAX OUTPUT 200 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

Classic® No. 2 200 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. 62J-60 (Stock No.1620-1301) on all guns up to 15ft (4.6 m)
- Part No. 62J-45 (Stock No. 1620-1300) on all guns over 15ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**210-3035**	1020-1111
	12 ft (3.6 m)	**212-3035**	1020-1112
	15 ft (4.6 m)	**215-3035**	1020-1113
	20 ft (6.1 m)	**220-3035**	1020-1114
	25 ft (7.6 m)	**225-3035**	1020-1115
Up To .045" (1.2 mm)	10 ft (3 m)	**210-4045**	1020-1121
	12 ft (3.6 m)	**212FN-4045**	1020-1322
	15 ft (4.6 m)	**215-4045**	1020-1123
	15 ft (4.6 m)	**215-4045K4****	1020-1660
	20 ft (6.1 m)	**225-4045**	1020-1125

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**M210-3035**	1020-1130
	12 ft (3.6 m)	**M212-3035**	1020-1132
	15 ft (4.6 m)	**M215-3035**	1020-1134
Up To .045" (1.2 mm)	10 ft (3 m)	**M210-4045**	1020-1131
	12 ft (3.6 m)	**M212-4045**	1020-1133
	15 ft (4.6 m)	**M215-4045**	1020-1135
	15 ft (4.6 m)	**M215-4045K4****	1020-1661

**** Suffix "K4"** = *Knucklehead Conductor Tube – Part No. 62SFLX4-80 (Stock No. 1620-1106)*

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

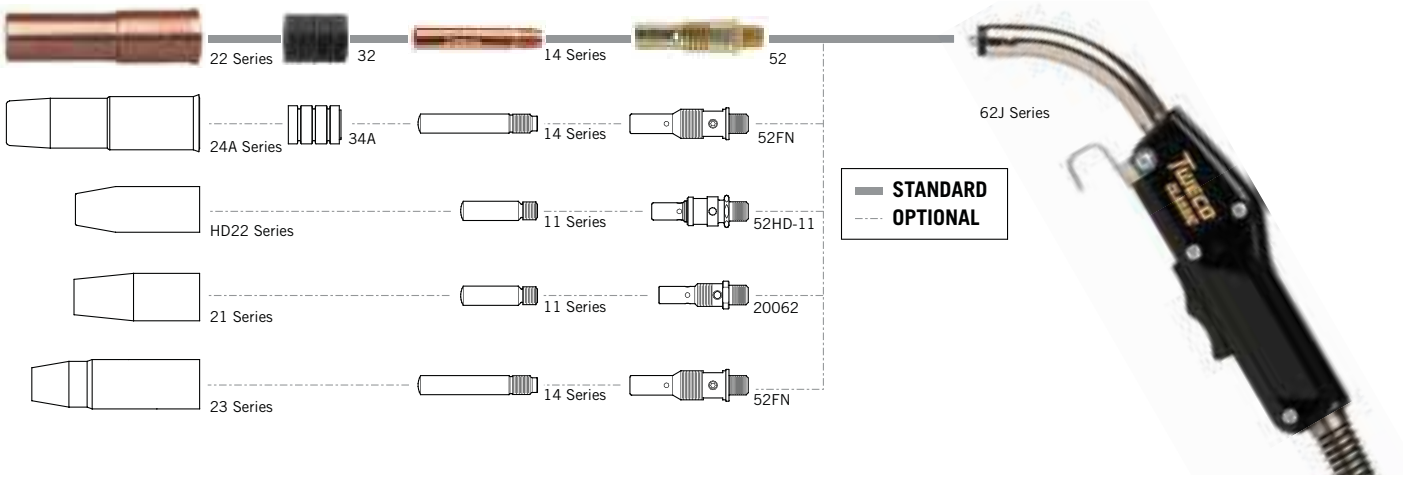
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**L210-3035**	1020-1140
	12 ft (3.6 m)	**L212-3035**	1020-1142
	15 ft (4.6 m)	**L215-3035**	1020-1144

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**X210-3035**	1020-1612
Up To .045" (1.2 mm)	10 ft (3 m)	**X210-4045**	1020-1621
	12 ft (3.6 m)	**X212-4045**	1020-1622
	12 ft (3.6 m)	**X212FN-4045†**	1020-1652
	15 ft (4.6 m)	**X215-4045**	1020-1623
	15 ft (4.6 m)	**X215FN-4045**	1020-1653

† FN guns are furnished with 24CT nozzles, 34CT insulators, 14H series contact tip, and fiber insulated conductor tube – Part No. 62A-60 (Stock No. 1620-1102).



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

EASY FIND GUIDE
See Page 30 & 31 for Replacement Parts & Optional Accessories

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 300 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE HEAVY DUTY

Classic® No. 3 300 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium/Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. 63J-60 (Stock No. 1630-1111) on all guns up to 15 ft (4.6 m)
- Part No. 63J-45 (Stock No. 1630-1110) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**310-3545**	1030-1101
	12 ft (3.6 m)	**312-3545**	1030-1102
	15 ft (4.6 m)	**315-3545**	1030-1103
	20 ft (6.1 m)	**320-3545**	1030-1104
	25 ft (7.6 m)	**325-3545**	1030-1105
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**315-116**	1030-1113
	25 ft (7.6 m)	**325-116**	1030-1115

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**M310-3545**	1030-1130
	12 ft (3.6 m)	**M312-3545**	1030-1133
	15 ft (4.6 m)	**M315-3545**	1030-1136
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**M315-116**	1030-1137

Lincoln® Style Rear Connector

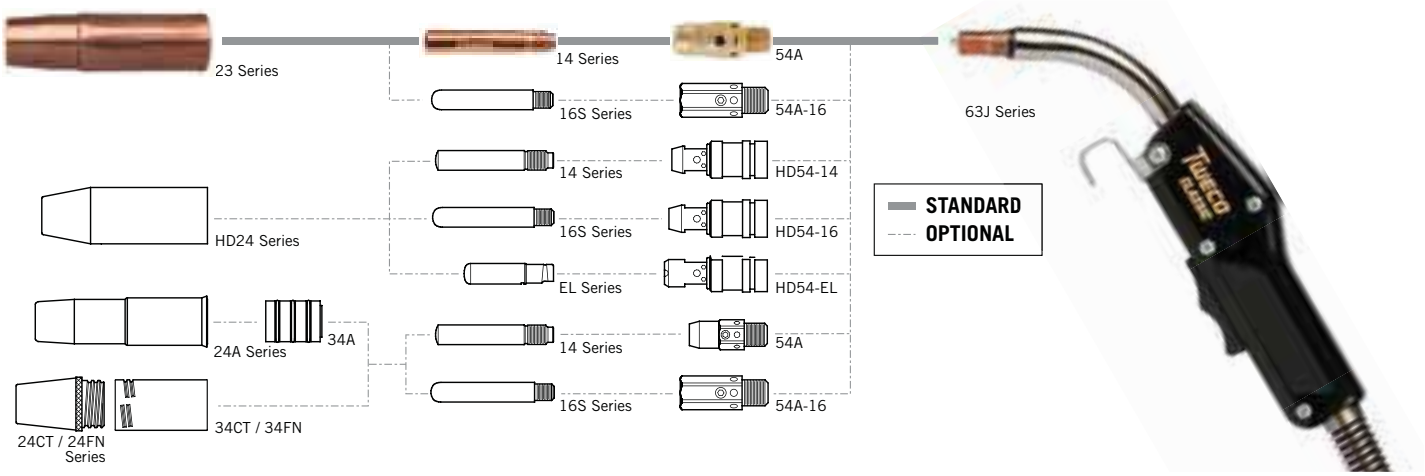
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**L310-3545**	1030-1140
	12 ft (3.6 m)	**L312-3545**	1030-1143
	15 ft (4.6 m)	**L315-3545**	1030-1146

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**X310-3545**	1030-1601
	12 ft (3.6 m)	**X312-3545**	1030-1602



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
300 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Medium/Heavy Duty Fabrication

EASY FIND GUIDE
See Page 30 & 31 for Replacement Parts & Optional Accessories

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MIG/FLUX CORED | MAX OUTPUT 400 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Classic® No. 4 400 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. 64J-60 (Stock No. 1640-1106) on all guns up to 15 ft (4.6 m)
- Part No. 64J-45 (Stock No. 1640-1105) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**410-3545**	1040-1101
	12 ft (3.6 m)	**412-3545**	1040-1102
	15 ft (4.6 m)	**415-3545**	1040-1103
	15 ft (4.6 m)	**DS415-3545**	1040-1503
	20 ft (6.1 m)	**420-3545**	1040-1104
	25 ft (7.6 m)	**425-3545**	1040-1105
Up To .045" (1.2 mm)	10 ft (3 m)	**410-116**	1040-1111
	12 ft (3.6 m)	**412-116**	1040-1112
	15 ft (4.6 m)	**415-116**	1040-1113
	20 ft (6.1 m)	**420-116**	1040-1114
	25 ft (7.6 m)	**425-116**	1040-1115
1/16" (1.6 mm)	15 ft (4.6 m)	**DS420-116**	1040-1514
5/64" (2.0 mm)	15 ft (4.6 m)	**415-564**	1040-1123

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**X410-3545**	1040-1601
	12 ft (3.6 m)	**X412-3545**	1040-1602
	15 ft (4.6 m)	**X415-3545**	1040-1603
	25 ft (7.6 m)	**X425-3545**	1040-1605
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**X412FN-116**	1040-1642
	15 ft (4.6 m)	**X415-116**	1040-1613

Suffix "K4" = *Knucklehead Conductor Tube – Part No. 64SFLX4-80 (Stock No. 1640-1113);*
Prefix "DS" = *Dual Schedule*

Lincoln® Style Rear Connector

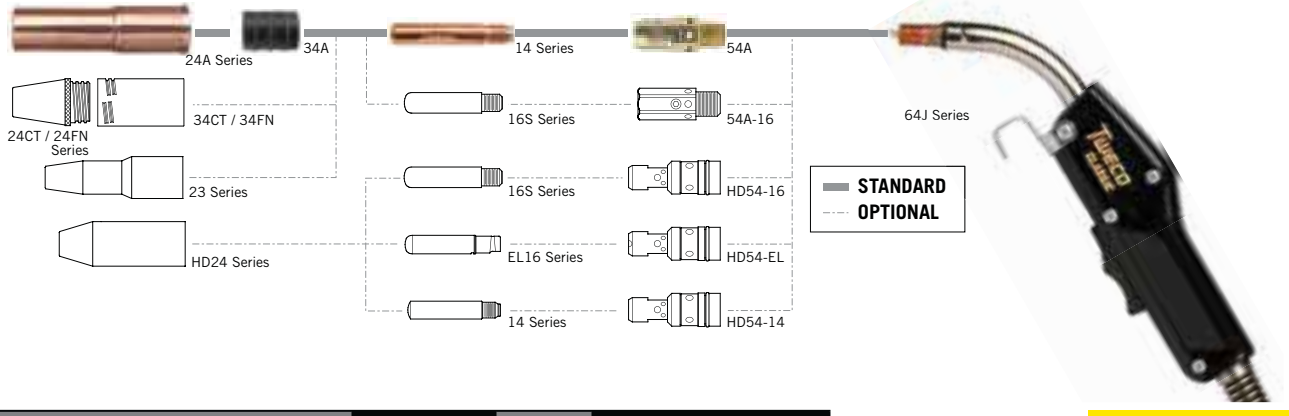
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**L410-3545**	1040-1140
	12 ft (3.6 m)	**L412-3545**	1040-1143
	15 ft (4.6 m)	**L415-3545**	1040-1146
	15 ft (4.6 m)	**L415-3545K4**	1040-1689
Up To 1/16" (1.6 mm)	10 ft (3 m)	**L410-116**	1040-1141
	12 ft (3.6 m)	**L412-116**	1040-1144
	15 ft (4.6 m)	**L415-116**	1040-1147

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**M410-3545**	1040-1130
	12 ft (3.6 m)	**M412-3545**	1040-1133
	15 ft (4.6 m)	**M415-3545**	1040-1136
	15 ft (4.6 m)	**M415-3545K4**	1040-1688
	20 ft (6.1 m)	**M420-3545**	1040-1126
	25 ft (7.6 m)	**M425-3545**	1040-1129
Up To .045" (1.2 mm)	10 ft (3 m)	**M410-116**	1040-1131
	12 ft (3.6 m)	**M412-116**	1040-1134
	15 ft (4.6 m)	**M415-116**	1040-1137
	20 ft (6.1 m)	**M420-116**	1040-1127
	25 ft (7.6 m)	**M425-116**	1040-1128
5/64" (2.0 mm)	15 ft (4.6 m)	**M415-564**	1040-1138



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 30 & 31 for Replacement Parts & Optional Accessories

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International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 500 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 3/32" (2.4 mm) | COOLED AIR | USAGE HEAVY DUTY

Classic® No. 5 500 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Locking Trigger & Rear Connector
- Standard Conductor Tube – Part No. 65J-60 (Stock No.1650-1111) on all guns up to 15ft (4.6 m)
- Part No. 65J-45 (Stock No. 1650-1110) on all guns over 15ft (4.6 m)
- Conduit Liner – 45 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**515-116**	1050-1113
	25 ft (7.6 m)	**525-116**	1050-1115
Up To 3/32" (2.4 mm)	10 ft (3 m)	**510-332**	1050-1131
	15 ft (4.6 m)	**515-332**	1050-1133

Lincoln® Style Rear Connector

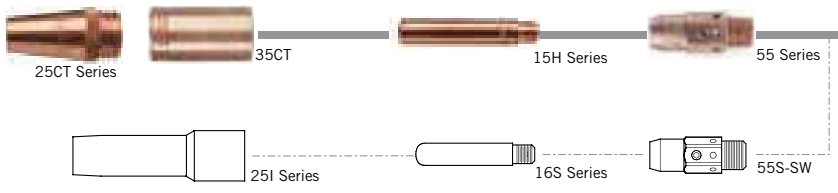
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**L515-332**	1050-1642

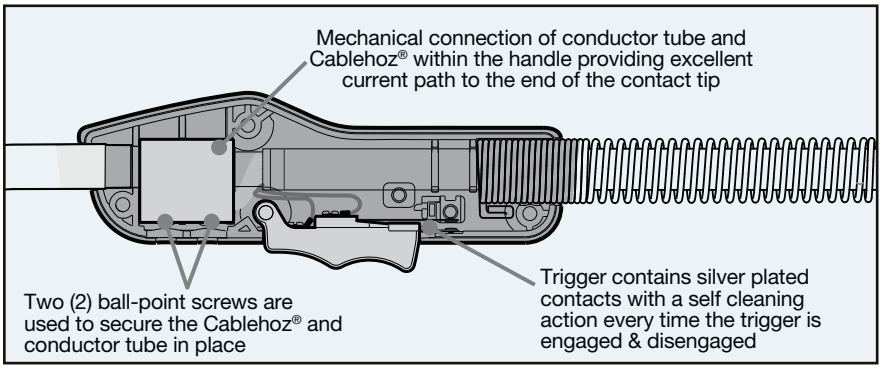
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**M515-116**	1050-1173
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**M515-332**	1050-1175







Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	60%	CO_2 Carbon Dioxide	Up To 3/32" (2.4 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 30 & 31 for Replacement Parts & Optional Accessories

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MIG/FLUX CORED | MAX OUTPUT 600 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 3/32" (2.4 mm) | COOLED AIR | USAGE HEAVY DUTY

Classic® No. 6 600 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. 66J-60 (Stock No. 1660-1826) on all guns
- Conduit Liner – 45 Series

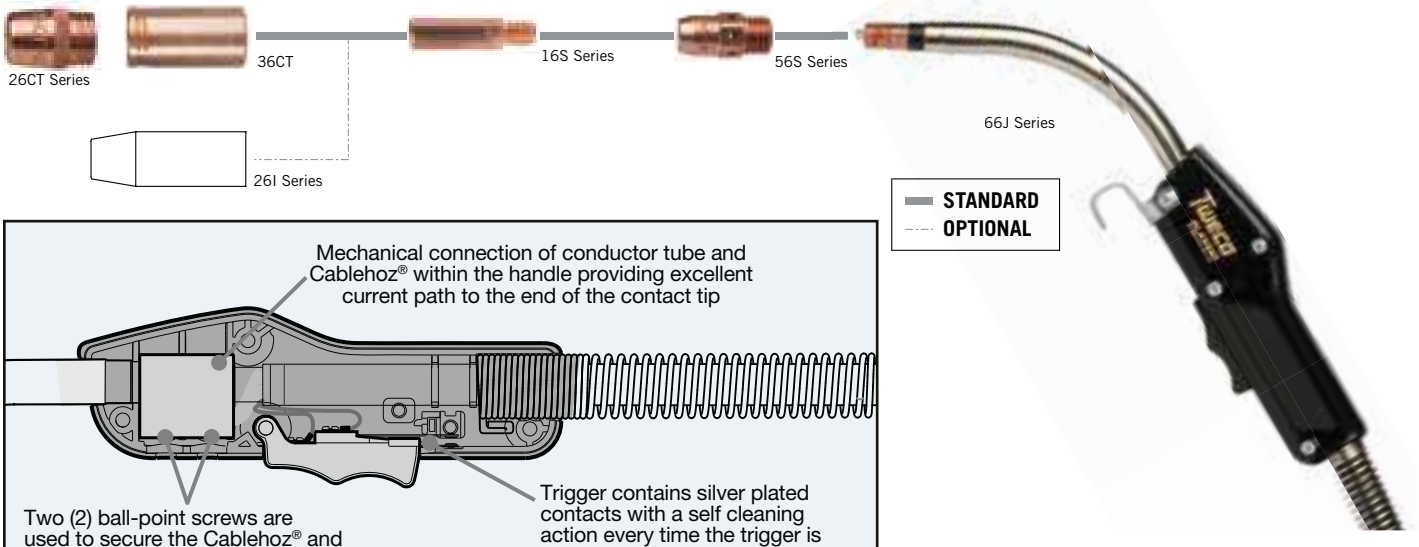
Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**615-332**	1060-1217

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**M615-332**	1060-1242



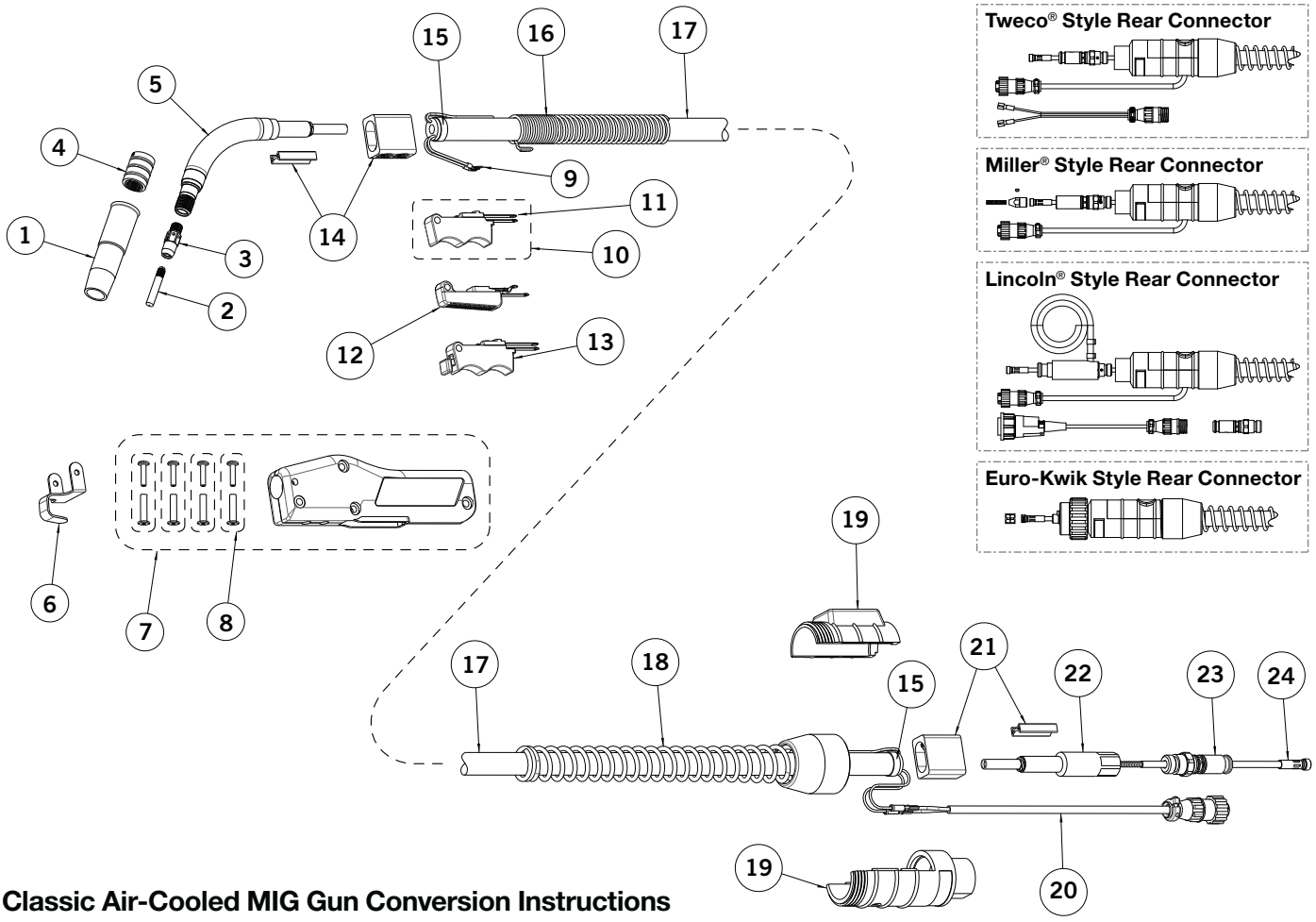
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
600 Amps	60%	CO_2 Carbon Dioxide	Up To 3/32" (2.4 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 30 & 31 for Replacement Parts & Optional Accessories

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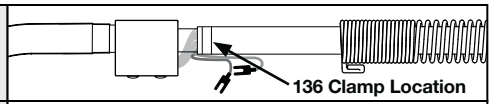
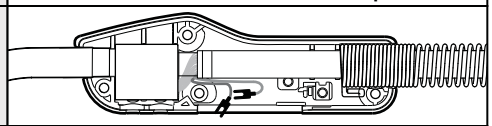
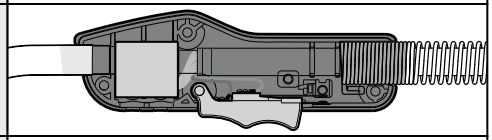
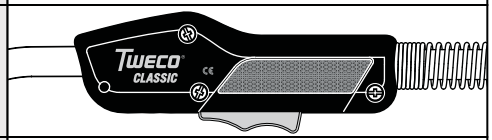
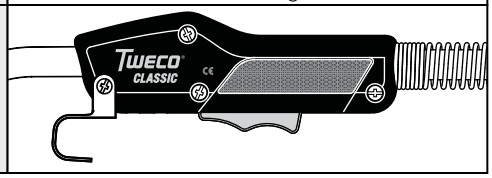
Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Classic® No. Series Replacement Parts



Classic Air-Cooled MIG Gun Conversion Instructions

These instructions convert a Tweco® Professional MIG Gun to a Tweco Classic Professional MIG Gun. Read and follow these instructions carefully.

1. Disconnect MIG Gun from machine. 2. Remove gun hanger, handle (both halves) and trigger.	
3. Place the MIG Gun assembly inside the bottom handle half and confirm that your strain relief is inside the handle half.	
4. Mount the wire connectors to the new trigger and place the trigger inside the handle half.	
5. Lay the top handle half in place on the bottom half and begin inserting screws.	
6. Place the MIG Gun hanger in position and tighten all screws. 7. MIG Gun is ready for use.	

Note: Do not remove **136 Cable Clamp** unless necessary. Replacement cable clamps **136** 2060-2690 are available. Also, a cable clamp installation tool is available - **136TOOL** 2060-2691 if you repair MIG Guns often.

Tweco Classic Professional Conversion Kit Parts List

Description	Qty
Tweco Classic Left Handle Half	1
Tweco Classic Right Handle Half	1
Binder Post	4
Binder Screw	4
Tweco Classic Standard Trigger Assembly	1

MIG Gun	Conversion Kit	
	Part No.	Stock No.
#2	**83R-CK**	2030-2085
#3	**83R-CK**	2030-2085
#4	**84R-CK**	2040-2089
#5	**85R-CK**	2050-2089
#6	**86R-CK**	2060-2033

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Classic® No. Series Replacement Parts

#	Description	Classic No. 1	Classic No. 2	Classic No. 3	Classic No. 4	Classic No. 5	Classic No. 6
		Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.
1	Nozzle	**21 Series**	**22 Series**	**23 Series**	**24A Series**	**25CT Series w/ 35CT Base**	**26CT Series w/ 36CT base**
2	Contact Tip	**11 Series**	**14 Series**	**14 Series**	**14 Series**	**15H Series**	**16 Series**
3	Diffuser	**51**	**52**	**54A**	**54A**	**55 Series**	**56S Series**
4	Nozzle Insulator	**--**	**32**	**--**	**34A**	**--**	**--**
5	Conductor Tube	**61 Series**	**62J Series**	**63J Series**	**64J Series**	**65J Series**	**66J Series**
6	Gun Hanger	**152** 2020-2152	**152** 2020-2152	**152** 2020-2152	**154B** 2040-2156	**154B** 2040-2156	**154B** 2040-2156
7	Handle (Standard)	**81** 2010-2081	**83RC** 2030-2084	**83RC** 2030-2084	**84RC** 2040-2087	**85RC** 2050-2088	**86RC** 2060-2032
	Handle (Dual Schedule)	--	--	--	**84RC-DS** 2040-2088	--	--
8	Binder Posts & Screws	**122FM** 2020-2122	**122FM** 2020-2122	**122FM** 2020-2122	**124FM** 2040-2124	**124FM** 2040-2124	**124FM** 2040-2124
9	Trigger Control Wire Terminal (Standard - 2 ea.)	**244DS** 2040-2245	**244** 2040-2224	**244** 2040-2224	**244** 2040-2224	**244** 2040-2224	**244** 2040-2224
	Trigger Control Wire Terminal (Dual Schedule - 4 ea.)	--	--	--	**244LK** 2040-2246	--	--
10	Trigger Assembly (Standard)	**91** 2010-2091	**92RR** 2020-2093	**92RR** 2020-2093	**94RR** 2040-2098	**94RR** 2040-2098	**94RR** 2040-2098
11	Trigger Blades	**91C** 2010-2093	**94RC** 2040-2100	**94RC** 2040-2100	**94RC** 2040-2100	**94RC** 2040-2100	**94RC** 2040-2100
12	Trigger Assembly (Dual Schedule)	--	--	--	**94RDS** 2040-2101	**94RDS** 2040-2101	**94RDS** 2040-2101
13	Trigger Assembly (Locking)	--	--	--	**94R-L** 2040-2102	**94R-L** 2040-2102	**94R-L** 2040-2102
14	Front Cable Connector	**101R** 2010-2103	**102** 2020-2102	**102** 2020-2102	**104** 2040-2104	**104** 2040-2104	**104** 2040-2104
15	Cable Clamp	**136** 2060-2690	**136** 2060-2690	**136** 2060-2690	**136** 2060-2690	**136** 2060-2690	**136** 2060-2690
16	Front Strain Relief Spring	**141-6-SPR** 2010-2143	**142-6-SPR** 2020-2144	**142-6-SPR** 2020-2144	**144-6-SPR** 2040-2146	**145-6-SPR** 2050-2147	**145-6-SPR** 2050-2147
17	Cablehoz®	**200** 1720-2100	**200** 1720-2100	**300** 1730-2100	**400** 1740-2100	**500** 1750-2100	**600S** 1760-2100
18	Rear Strain Relief Spring	**235RSSR** 2060-2035	**235RSSR** 2060-2035	**235RSSR** 2060-2035	**235RSSR** 2060-2035	**235RSSR** 2060-2035	**235RSSR** 2060-2035
19	Rear Case (Direct Plug)	**R6RC** 2060-2040	**R6RC** 2060-2040	**R6RC** 2060-2040	**R6RC** 2060-2040	**R6RC** 2060-2040	**R6RC** 2060-2040
	Rear Case (Euro)	**X6RC** 2060-2006	**X6RC** 2060-2006	**X6RC** 2060-2006	**X6RC** 2060-2006	**X6RC** 2060-2006	**X6RC** 2060-2006
20	Control Wire (Standard)	**MS354-DSM** 2060-2140	**MS354-DSM** 2060-2140	**MS354-DSM** 2060-2140	**MS354-DSM** 2060-2140	**MS354-DSM** 2060-2140	**MS354-DSM** 2060-2140
	Control Wire (Dual Schedule)	**194DS** 2040-2195	**194DS** 2040-2195	**194DS** 2040-2195	**194DS** 2040-2195	**194DS** 2040-2195	**194DS** 2040-2195
21	Rear Cable Connector (Direct Plug)	**104** 2040-2104	**104** 2040-2104	**104** 2040-2104	**104** 2040-2104	**104** 2040-2104	**104** 2040-2104
	Rear Cable Connector (Euro)	**172X-M** 2020-2181	**172X-M** 2020-2181	**174X-M** 2040-2181	**174X-M** 2040-2181	--	--
22	Adapter (Direct Plug)	**M170-2H** 2020-2165	**M170-2H** 2020-2165	**M170-4H** 2020-2166	**M170-4H** 2020-2166	**M170-5H** 2020-2167	**M170-5H** 2020-2167
NS	Repair/Conversion Kits	--	**83R-CK** 2030-2085	**83R-CK** 2030-2085	**84R-CK** 2040-2089	**85R-CK** 2050-2089	**86R-CK** 2060-2033
23	Connector Plug	**Refer to Pages 92-93**					
24	Conduit Assembly	**Refer to Pages 124-127**					
NS	Protective Cable Wrap, 50 ft (15.2 m) per box	**TCR50** 9900-1150					

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Classic No. Velocity
MIG Gun Series

Velocity Classic® No.
MIG Gun Series

FEATURES

- **The Industry Standard** for over 40 years
- **Incorporating Velocity™ Consumables** with new ground breaking innovation inspired by welders for welders
- **Solid Copper Conductor Path** with fewer connections for optimized electrical surface contact
- **Fewer Consumables Parts** means less complexity and lower cost of ownership
- **Gas Ported Velocity Contact Tips** stay cooler and last longer
- **Easy to Use Velocity Tips** eliminates threads and requires no tools
- **Tips can be Rotated** to prolong life requiring fewer changes
- **Excellent Wire Feed** ability with centered liner with the conduit liner fitting inside the tip
- **Superior Welding Performance** from a smoother, more stable arc
- **Large Copper to Copper** surface contact for superior thermal and electrical efficiency
- **Proven Contact Tip Life Improvements** with Short Arc Solid Wire 2 to 3 times life, Spray Transfer 4 to 5 times life and Gas Shielded Flux Core 8 to 10 times life

		Velocity Classic No. 1	Velocity Classic No. 2	Velocity Classic No. 3	Velocity Classic No. 4	Velocity Classic No. 5
Applications		Light Duty Fabrication	Medium Duty Fabrication	Med/Heavy Duty Fabrication	Med/Heavy Duty Fabrication	Heavy Duty Fabrication
Standard Options	**Dual Schedule**				■	
	Rear Connector	■	■	■	■	■
	Knucklehead™ Flexible Conductor Tube		■		■	
Output Current		180 Amps	200 Amps	300 Amps	400 Amps	500 Amps
Duty Cycle - CO_2		60%	60%	60%	60%	60%
Wire Diameter		Up to .045" (1.2 mm)	Up to . 045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 5/64" (2.0 mm)	Up to 3/32" (2.4 mm)
Process	**MIG**	■	■	■	■	■
	Aluminum	■	■	■	■	
	Flux Cored Gas Shielded				■	■
	Flux Cored Self Shielded					■

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 180 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE LIGHT DUTY

Velocity Classic® No. 1 180 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. VA61-60 (Stock No. 1010-1105) on all guns over 15 ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**V110-3035**	1010-1115
	15 ft (4.6 m)	**V115-3035**	1010-1116
	20 ft (6.1 m)	**V120-3035**	1010-1117
Up To .045" (1.2 mm)	12 ft (3.6 m)	**V112-4045**	1010-1118
	15 ft (4.6 m)	**V115-4045**	1010-1119
	20 ft (6.1 m)	**V120-4045**	1010-1120

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VM110-3035**	1010-1125
	12 ft (3.6 m)	**VM112-3035**	1010-1126
	15 ft (4.6 m)	**VM115-3035**	1010-1127

Lincoln® Style Rear Connector

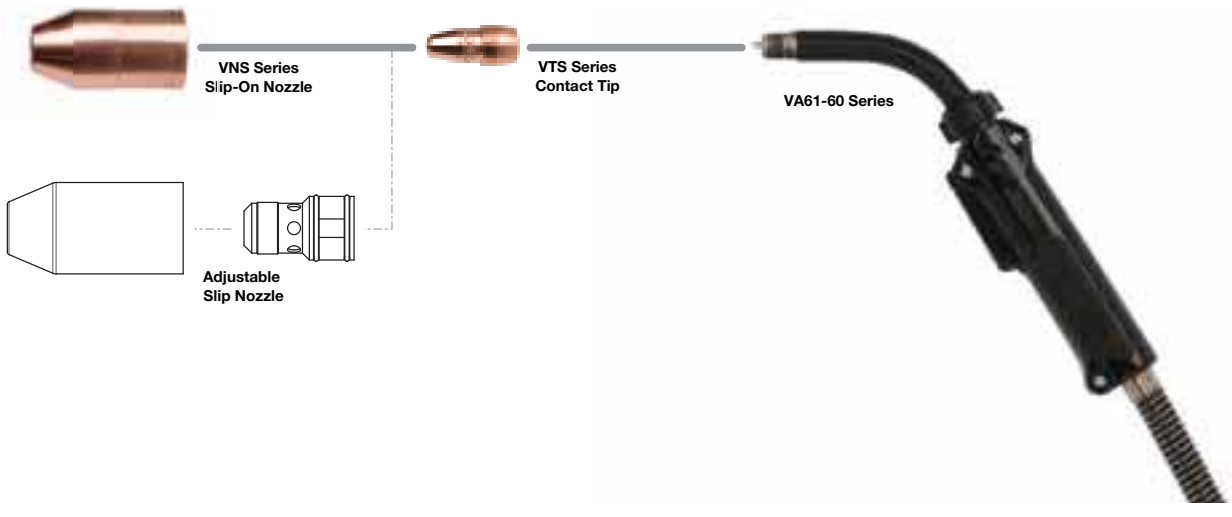
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	**VL115-3035**	1010-1138

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**VX110-4045**	1010-1147
	12 ft (3.6 m)	**VX112-4045**	1010-1148
	15 ft (4.6 m)	**VX115-4045**	1010-1149



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light Duty Fabrication

EASY FIND GUIDE
See Page 40 & 41 for Replacement Parts & Optional Accessories

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MIG | MAX OUTPUT 200 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

Velocity Classic® No. 2 200 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – VCTL62-60 (Stock No. 1620-1371) on all guns up to 15 ft (4.6 m)
- VCTL62-45 (Stock No. 1620-1372) on all guns over 15 ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**V210-3035**	1020-1105
	12 ft (3.6 m)	**V212-3035**	1020-1106
	15 ft (4.6 m)	**V215-3035**	1020-1107
	20 ft (6.1 m)	**V220-3035**	1020-1108
	25 ft (7.6 m)	**V225-3035**	1020-1109
Up To .045" (1.2 mm)	10 ft (3 m)	**V210-4045**	1020-1117
	15 ft (4.6 m)	**V215-4045**	1020-1118
	20 ft (6.1 m)	**V225-4045**	1020-1119

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VM210-3035**	1020-1128
	12 ft (3.6 m)	**VM212-3035**	1020-1129
	15 ft (4.6 m)	**VM215-3035**	1020-1136
Up To .045" (1.2 mm)	10 ft (3 m)	**VM210-4045**	1020-1137
	12 ft (3.6 m)	**VM212-4045**	1020-1138
	15 ft (4.6 m)	**VM215-4045**	1020-1139

Lincoln® Style Rear Connector

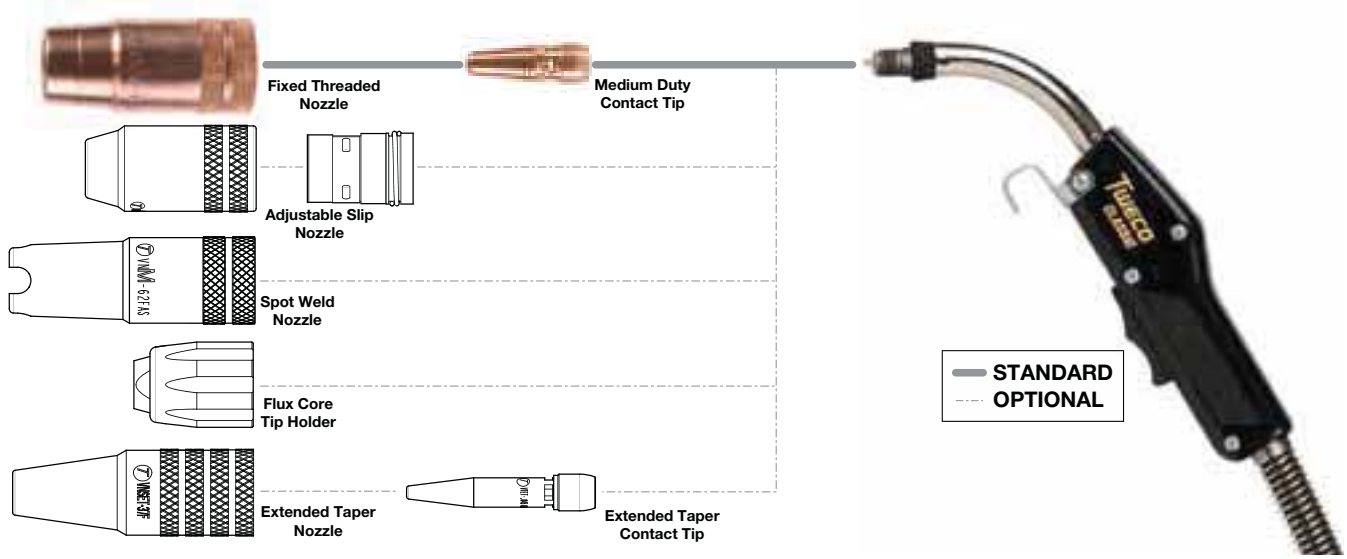
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VL210-3035**	1020-1147
	12 ft (3.6 m)	**VL212-3035**	1020-1148
	15 ft (4.6 m)	**VL215-3035**	1020-1149

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**VX210-3035**	1020-1305
Up To .045" (1.2 mm)	10 ft (3 m)	**VX210-4045**	1020-1306
	12 ft (3.6 m)	**VX212-4045**	1020-1307
	15 ft (4.6 m)	**VX215-4045**	1020-1308



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 300 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE HEAVY DUTY

Velocity Classic® No. 3 300 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium/Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – VCTL63-60 (Stock No. 1630-1225) on all guns up to 15 ft (4.6 m)
- VCTL63-45 (Stock No. 1630-1226) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**V310-3545**	1030-1003
	12 ft (3.6 m)	**V312-3545**	1030-1004
	15 ft (4.6 m)	**V315-3545**	1030-1005
	20 ft (6.1 m)	**V320-3545**	1030-1006
	25 ft (7.6 m)	**V325-3545**	1030-1007
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**V312-116**	1030-1008
	15 ft (4.6 m)	**V315-116**	1030-1009
	25 ft (7.6 m)	**V325-116**	1030-1010

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**VM310-3545**	1030-1013
	12 ft (3.6 m)	**VM312-3545**	1030-1014
	15 ft (4.6 m)	**VM315-3545**	1030-1015
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**VM315-116**	1030-1016

Lincoln® Style Rear Connector

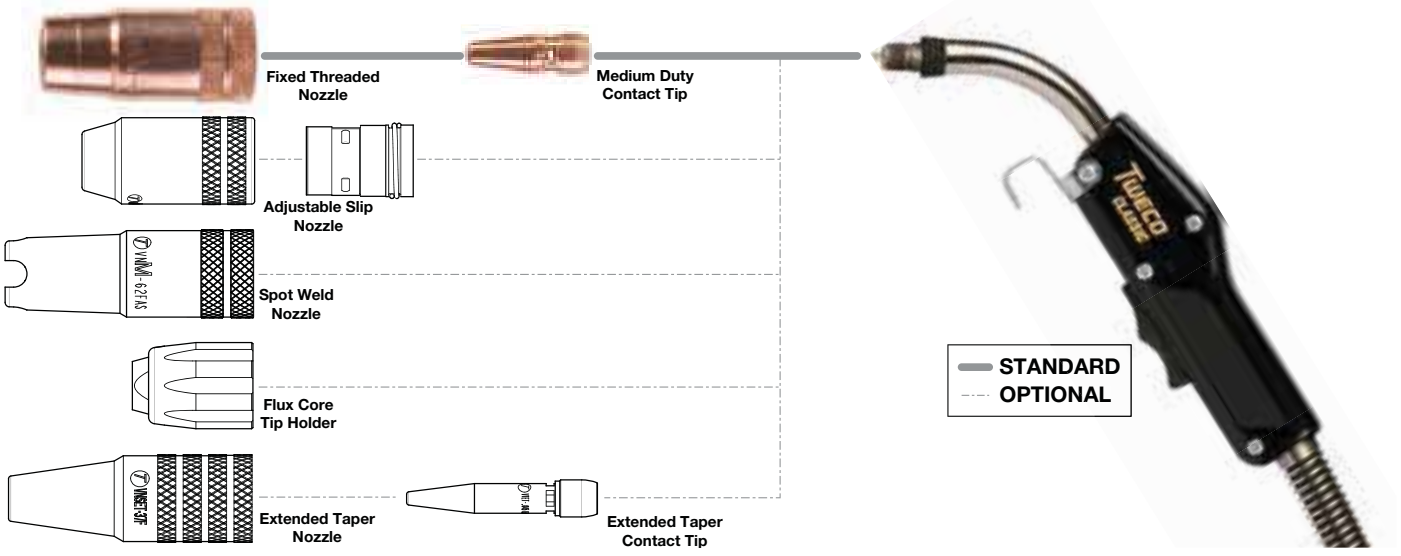
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**VL310-3545**	1030-1017
	12 ft (3.6 m)	**VL312-3545**	1030-1018
	15 ft (4.6 m)	**VL315-3545**	1030-1019

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**VX310-3545**	1030-1020
	12 ft (3.6 m)	**VX312-3545**	1030-1021
	15 ft (4.6 m)	**VX315-3545**	1030-1022
Up To 5/64" (2.0 mm)	15 ft (4.6 m)	**VX315-564**	1030-1023



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
300 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Medium/Heavy Duty Fabrication

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MIG/FLUX CORED | MAX OUTPUT 400 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Velocity Classic® No. 4 400 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:
- Dual Schedule On/Off Control, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – VCTL64-60 (Stock No. 1640-1391) on all guns up to 15 ft (4.6 m)
- VCTL64-45 (Stock No. 1640-1392) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**V410-3545**	1040-1901
	12 ft (3.6 m)	**V412-3545**	1040-1902
	15 ft (4.6 m)	**V415-3545**	1040-1903
	15 ft (4.6 m)	**VDS415-3545**	1040-1904
	15 ft (4.6 m)	**V415-3545K4****	1040-1905
	20 ft (6.1 m)	**V420-3545**	1040-1906
	20 ft (6.1 m)	**VDS420-3545**	1040-1911
	25 ft (7.6 m)	**V425-3545**	1040-1907
Up To 1/16" (1.6 mm)	10 ft (3 m)	**V410-116**	1040-1908
	12 ft (3.6 m)	**V412-116**	1040-1909
	15 ft (4.6 m)	**V415-116**	1040-1900
	20 ft (6.1 m)	**VDS420-116**	1040-1910
5/64" (2.0 mm)	15 ft (4.6 m)	**V415-564**	1040-1912

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**VX410-3545**	1040-1934
	12 ft (3.6 m)	**VX412-3545**	1040-1935
	15 ft (4.6 m)	**VX415-3545**	1040-1936
	25 ft (7.6 m)	**VX425-3545**	1040-1937
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**VX412-116**	1040-1938
	15 ft (4.6 m)	**VX415-116**	1040-1939
5/64" (2.0 mm)	15 ft (4.6 m)	**VX415-564**	1040-1940

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

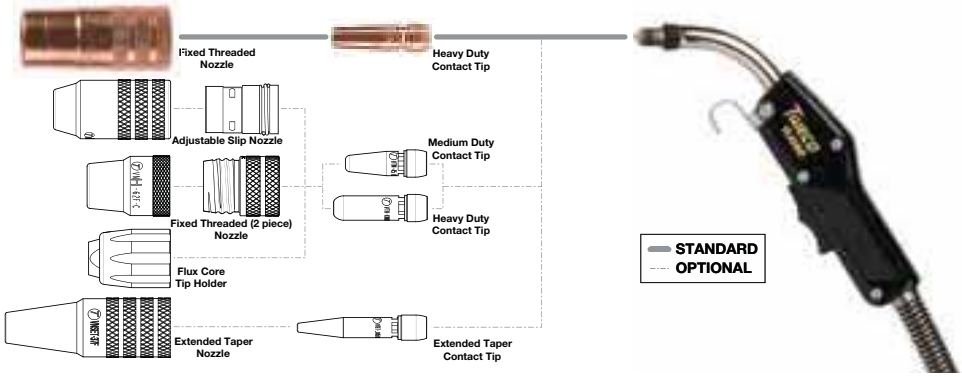
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VL410-3545**	1040-1927
	12 ft (3.6 m)	**VL412-3545**	1040-1928
	15 ft (4.6 m)	**VL415-3545**	1040-1929
	15 ft (4.6 m)	**VL415-3545K4****	1040-1930
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**VL412-116**	1040-1931
	15 ft (4.6 m)	**VL415-116**	1040-1932

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**VM410-3545**	1040-1914
	12 ft (3.6 m)	**VM412-3545**	1040-1915
	15 ft (4.6 m)	**VM415-3545**	1040-1916
	15 ft (4.6 m)	**VM415-3545K4****	1040-1917
	20 ft (6.1 m)	**VM420-3545**	1040-1918
	25 ft (7.6 m)	**VM425-3545**	1040-1919
Up To 1/16" (1.6 mm)	10 ft (3 m)	**VM410-116**	1040-1920
	12 ft (3.6 m)	**VM412-116**	1040-1921
	15 ft (4.6 m)	**VM415-116**	1040-1922
	20 ft (6.1 m)	**VM420-116**	1040-1923
	25 ft (7.6 m)	**VM425-116**	1040-1924
5/64" (2.0 mm)	15 ft (4.6 m)	**VM415-564**	1040-1925

Suffix "K4" = *Knucklehead Conductor Tube – Part No. 64SFLX4-80 (Stock No. 1640-1113);*
Prefix "DS" = *Dual Schedule*



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

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International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Velocity Classic® No. 5 500 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Locking Trigger & Rear Connector
- Standard Conductor Tube – VCTL66-60 (Stock No. 1660-1242) on all guns up to 15ft (4.6 m)
- VCTL66-45 (Stock No. 1660-1243) on all guns over 15ft (4.6 m)
- Conduit Liner – 45 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**V512-3545**	1050-1084
	15 ft (4.6 m)	**V515-3545**	1050-1085
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**V515-116**	1050-1086
	25 ft (7.6 m)	**V525-116**	1050-1087
Up To 3/32" (2.4 mm)	10 ft (3 m)	**V510-332**	1050-1088
	15 ft (4.6 m)	**V515-332**	1050-1089

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**VM515-116**	1050-1091
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**VM515-332**	1050-1092

Lincoln® Style Rear Connector

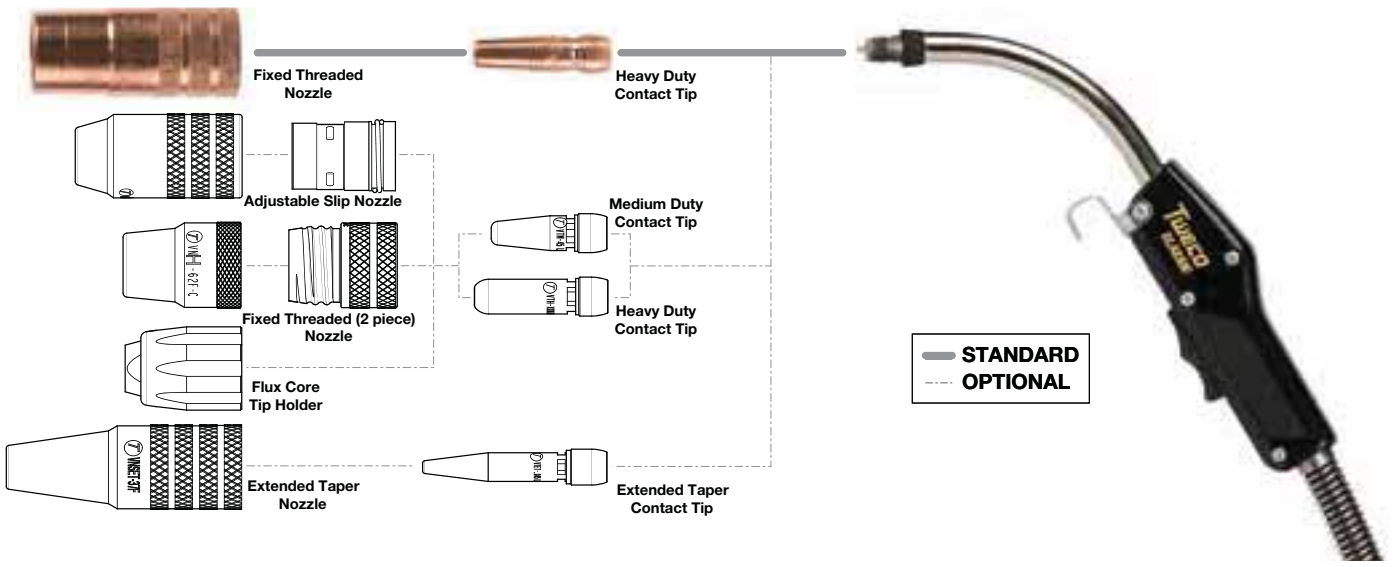
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**VL515-332**	1050-1094

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**VX515-116**	1050-1096



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	60%	CO_2 Carbon Dioxide	Up To 3/32" (2.4 mm)	Air	Heavy Duty Fabrication

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Velocity Classic No. Series MIG Guns with Velocity™ Consumables



Patented



Nozzle Assembly
Heavy Duty Copper

Contact Tip
with Gas Ports

Conduit Liner
Perfectly Centered inside Tip

Nozzle Collar
with index marks

Conductor Tube
Fully Insulated

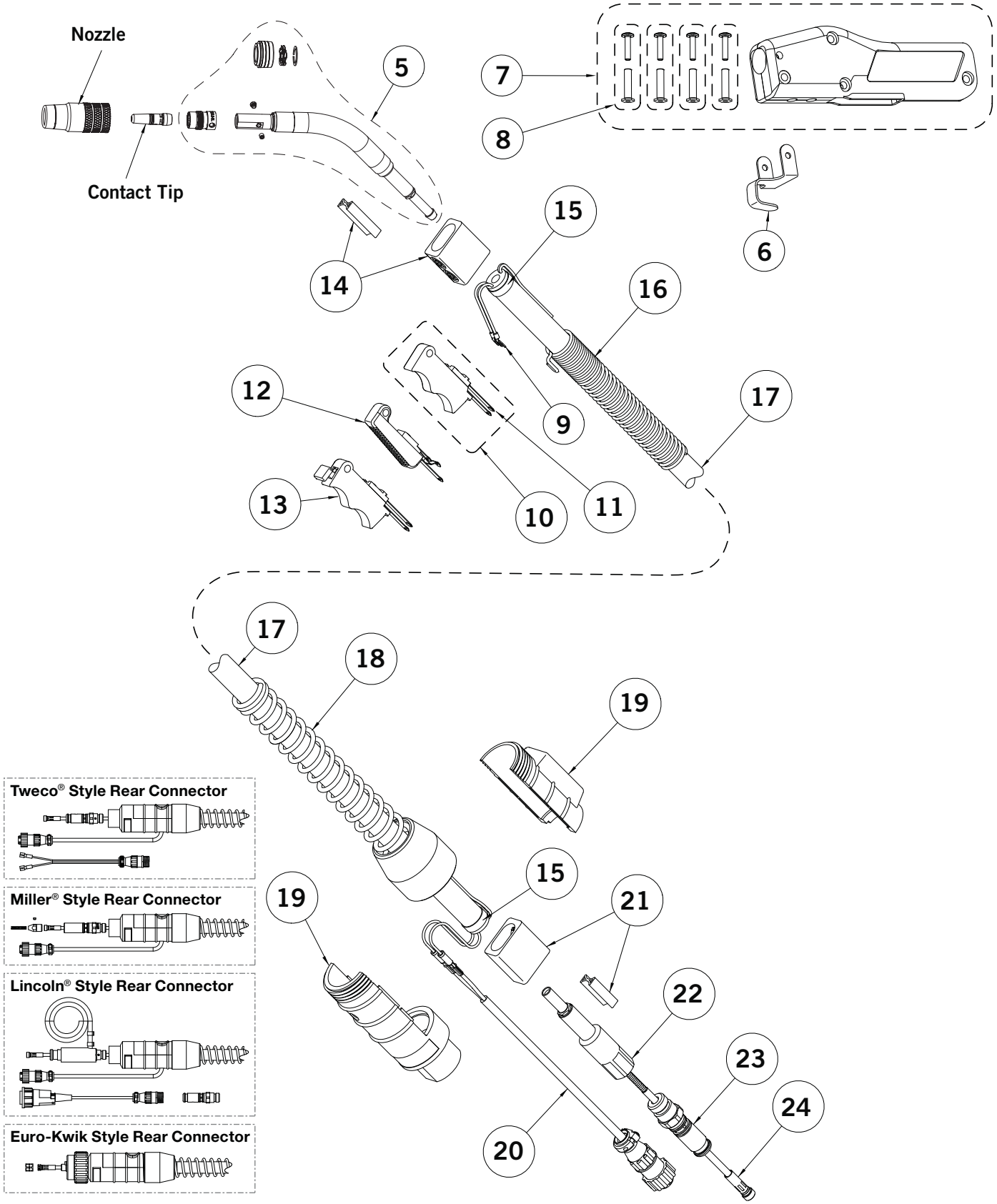
FEATURES

- **Velocity™ Consumables** with new ground-breaking innovation inspired by welders for welders
- **Solid Copper Conductor Path** with fewer connections for optimized electrical surface contact
- **Fewer Consumable Parts** mean less complexity and lower cost of ownership
- **Gas Ported Velocity Contact Tips** stay cooler and last longer
- **Extended Length Trigger** allows welders to adjust their grip for access, comfort and to avoid radiated heat
- **Easy to Use Velocity Tips** eliminates threads and requires no tools
- **Tips can be Rotated** to prolong life requiring fewer changes
- **Excellent Wire Feedability** with centered liner
- **Superior Welding Performance** from a smoother, more stable arc
- **Compact, Ergonomic Handle Design** is balanced to pivot at the center of the handle for ease of use, thereby reducing operator fatigue
- **Front and Rear Steel Spring Strain Relief** provides support to the Cablehoz® coming out of the rear of the handle and minimizes wire feed issues
- **Split Handle Case** provides access for ease of repairs in the field
- **Durable, Metal-Jacketed, Three-Layer Conductor Tube** rotates easily for different welding positions and lowers heat in the front end
- **Crimped Front Cablehoz Connection** for improved electrical conductivity
- **Designed for Spray and Pulse transfer modes,** maintains the copper needed for high duty cycle welding



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
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Velocity Classic® No. Series Replacement Parts



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Velocity Classic® No. Series Replacement Parts

#	Description	Velocity Classic No. 1	Velocity Classic No. 2	Velocity Classic No. 3	Velocity Classic No. 4	Velocity Classic No. 5
		Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.	Part No./ Stock No.
	Contact Tip	VTS Series	VTM Series	VTM Series	VTH Series	VTH Series
	Nozzle	VNS Series	VNM Series	VNM Series	VNH Series	VNH Series
5	60° Velocity Conductor Tube Assy.	VA61-60* 1010-1105	VCTL6260 1620-1371	VCTL6360 1630-1225	VCTL6460 1640-1391	VCTL6660 1660-1242
	45° Velocity Conductor Tube Assy.	VA61-60* 1010-1105	VCTL6245 1620-1372	VCTL6345 1630-1226	VCTL6445 1640-1392	VCTL6645 1660-1243
	80° Velocity Conductor Tube Assy.	–	VCTL6280 1620-1373	VCTL6380 1630-1227	VCTL6480 1640-1393	VCTL6680 1660-1241
	180° Velocity Conductor Tube Assy.	VA61-60* 1010-1105	VCTL62180 1620-1374	VCTL63180 1630-1228	VCTL64180 1640-1394	VCTL66180 1660-1244
6	Gun Hanger	152 2020-2152	152 2020-2152	152 2020-2152	154B 2040-2156	154B 2040-2156
7	Handle (Standard)	81 2010-2081	83RC 2030-2084	83RC 2030-2084	84RC 2040-2087	85RC 2050-2088
	Handle (Dual Schedule)	–	–	–	84RC-DS 2040-2088	–
8	Binder Posts & Screws	122FM 2020-2122	122FM 2020-2122	122FM 2020-2122	124FM 2040-2124	124FM 2040-2124
9	Trigger Control Wire Terminal (Standard - 2 ea.)	244DS 2040-2245	244 2040-2244	244 2040-2244	244 2040-2244	244 2040-2244
	Trigger Control Wire Terminal (Dual Schedule - 4 ea.)	–	–	–	244LK 2040-2246	–
10	Trigger Assembly (Standard)	91 2010-2091	92RR 2020-2093	92RR 2020-2093	94RR 2040-2098	94RR 2040-2098
11	Trigger Blades	91C 2010-2093	94RC 2040-2100	94RC 2040-2100	94RC 2040-2100	94RC 2040-2100
12	Trigger Assembly (Dual Schedule)	–	–	–	94RDS 2040-2101	94RDS 2040-2101
13	Trigger Assembly (Locking)	–	–	–	94R-L 2040-2102	94R-L 2040-2102
14	Front Cable Connector	101R 2010-2103	102 2020-2102	102 2020-2102	104 2040-2104	104 2040-2104
15	Cable Clamp	136 2060-2690	136 2060-2690	136 2060-2690	136 2060-2690	136 2060-2690
16	Front Strain Relief Spring	141-6-SPR 2010-2143	142-6-SPR 2020-2144	142-6-SPR 2020-2144	144-6-SPR 2040-2146	145-6-SPR 2050-2147
17	Cablehoz® (Sold by the Foot)	200 1720-2100	200 1720-2100	300 1730-2100	400 1740-2100	500 1750-2100
18	Rear Strain Relief Spring	235RSSR 2060-2035	235RSSR 2060-2035	235RSSR 2060-2035	235RSSR 2060-2035	235RSSR 2060-2035
19	Rear Case (Direct Plug)	R6RC 2060-2040	R6RC 2060-2040	R6RC 2060-2040	R6RC 2060-2040	R6RC 2060-2040
	Rear Case (Euro)	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006
20	Control Wire (Standard)	MS354-DSM 2060-2140	MS354-DSM 2060-2140	MS354-DSM 2060-2140	MS354-DSM 2060-2140	MS354-DSM 2060-2140
	Control Wire (Dual Schedule)	194DS 2040-2195	194DS 2040-2195	194DS 2040-2195	194DS 2040-2195	194DS 2040-2195
21	Rear Cable Connector (Direct Plug)	104 2040-2104	104 2040-2104	104 2040-2104	104 2040-2104	104 2040-2104
	Rear Cable Connector (Euro)	172X-M 2020-2181	172X-M 2020-2181	174X-M 2040-2181	174X-M 2040-2181	--
22	Adapter (Direct Plug)	M170-2H 2020-2165	M170-2H 2020-2165	M170-4H 2020-2166	M170-4H 2020-2166	M170-5H 2020-2167
NS	Repair/Conversion Kits	--	83R-CK 2030-2085	83R-CK 2030-2085	84R-CK 2040-2089	85R-CK 2050-2089
23	Connector Plug	Refer to Pages 92-93				
24	Conduit Assembly	Refer to Pages 124-127				
NS	Protective Cable Wrap, 50 ft (15.2 m) per box	TCR50 9900-1150				

** VA61-60 (Stock No. 1010-1105) is an adapter that threads into the standard Classic No. series conductor tube to allow the Velocity consumable to be used*

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Tweco Fusion
MIG Gun Series

Tweco Fusion®
MIG Gun Series

FEATURES
- **Easy to Maneuver** in various welding positions to reduce operator fatigue
- **Rugged Design** with steel spring strain relief – built tough to last
- **Ergonomic Handle Design** with diamond pattern for better grip and greater operator appeal
- **Impact-Resistant Handle and Components** for long-lasting durability
- **Microswitch Trigger** designed for dependability
- **Optimized Electrical Surface Contact** with improved arc stability
- **Velocity Consumables** for longer life and improved performance
- **Easy to Change Velocity Tips** – no threads, no tools needed
- **Fewer Consumables Parts** to replace resulting in lower cost of ownership
- **Contact Tips** can be rotated to optimize life requiring fewer changes thus reducing cost of usage
- **Solid Copper Conductor Path** with fewer connections
- **Smooth, Stable Arc** for a superior welding performance
- **Optimized Wire Feedability** with centered liner
- **Best in Class Performance**

250 FEATURES
- **Heavy Duty Chrome Plated Conductor Tube** for improved electrical conductivity
- **Gun Hook** on bottom for easy access

		Tweco Fusion 140	Tweco Fusion 180	Tweco Fusion 220	Tweco Fusion 250
Applications		Light Duty Fabrication	Light Duty Fabrication	Medium Duty Fabrication	Medium/Heavy Duty Fabrication
Standard Options	**Rear Connector**	■	■	■	■
Output Current		140 Amps	180 Amps	220 Amps	250 Amps
Duty Cycle - CO_2		40%	40%	40%	80%
Wire Diameter		Up to .035" (0.9 mm)	Up to .035" (0.9 mm)	Up to .035" (0.9 mm)	Up to .045" (1.2 mm)
Process	**MIG**	■	■	■	■
	Aluminum	■	■	■	■

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 140 AMPS | DUTY CYCLE 40% | WIRE SIZE UP TO .035" (0.9 mm) | COOLED AIR | USAGE LIGHT DUTY

Tweco Fusion® 140 Amp MIG Gun



40% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- High Performance Velocity™ Consumables and Rear Connector
- Conduit Liner – WS42 Series

Tweco® Style (4 Pin) Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F140T-10-3035**	1017-1320

Tweco® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F140TA-10-3035**	1017-1321

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F140M-10-3035**	1017-1319

Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F140L-10-3035**	1017-1318

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F140X-10-3035**	1017-1323
Conduit Liner – WS42 Series			

Note: Gun length is measured from the front case to the rear case +/-3".



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
120 Amps	20%	CO_2 Carbon Dioxide	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

EASY FIND GUIDE
See Page 48 & 49 for Replacement Parts & Optional Accessories

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MIG | MAX OUTPUT 180 AMPS | DUTY CYCLE 40% | WIRE SIZE UP TO .035" (0.9 mm) | COOLED AIR | USAGE LIGHT DUTY

Tweco Fusion® 180 Amp MIG Gun



40% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- High Performance Velocity™ Consumables and Rear Connector
- Conduit Liner – WS42 Series

Tweco® Style (4 Pin) Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**F180T-12-3035**	1017-1331

Tweco® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F180TA-10-3035**	1017-1338
	12 ft (3.6 m)	**F180TA-12-3035**	1017-1332

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**F180M-12-3035**	1017-1330

Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**F180L-12-3035**	1017-1329

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F180X-10-3035**	1017-1335
	12 ft (3.6 m)	**F180X-12-3035**	1017-1334
Conduit Liner – WS42 Series			

Note: Gun length is measured from the front case to the rear case +/-3".



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	40%	CO_2 Carbon Dioxide	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 220 AMPS | DUTY CYCLE 40% | WIRE SIZE UP TO .035" (0.9 mm) | COOLED AIR | USAGE MED. DUTY

Tweco Fusion® 220 Amp MIG Gun



40% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:

- High Performance Velocity™ Consumables and Rear Connector
- Conduit Liner – WS42 Series

Tweco® Style (4 Pin) Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	**F220T-15-3035**	1023-1260

Tweco® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**F220TA-12-3035**	1023-1261

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	**F220M-15-3035**	1023-1259

Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	**F220L-15-3035**	1023-1258

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**F220X-10-3035**	1023-1264
	12 ft (3.6 m)	**F220X-12-3035**	1023-1265
	15 ft (4.6 m)	**F220X-15-3035**	1023-1263
Conduit Liner – WS42 Series			

Note: Gun length is measured from the front case to the rear case +/-3".



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
220 Amps	40%	CO_2 Carbon Dioxide	Up To .035" (0.9 mm)	Air	Medium Duty Fabrication

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See Page 48 & 49 for Replacement Parts & Optional Accessories

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MIG | MAX OUTPUT 250 AMPS | DUTY CYCLE 80% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE LIGHT DUTY

Tweco Fusion® 250 Amp MIG Gun



80% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- High Performance Velocity™ Consumables and Rear Connector
- Conduit Liner – 42 Series
- Heavy Duty Chrome Plated Conductor Tube for improved electrical conductivity
- Gun Hook on bottom for easy access

Tweco® Style (4 Pin) Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**FV210-3545**	1023-1059
	12 ft (3.6 m)	**FV212-3545**	1023-1060
	15 ft (4.6 m)	**FV215-3545**	1023-1260
	20 ft (6.1 m)	**FV220-3545**	1023-1062
	25 ft (7.6 m)	**FV225-3545**	1023-1063

Tweco® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**FV215TA-3545**	1023-1261

Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**FV212L-3545**	1023-1084
	15 ft (4.6 m)	**FV215L-3545**	1023-1258

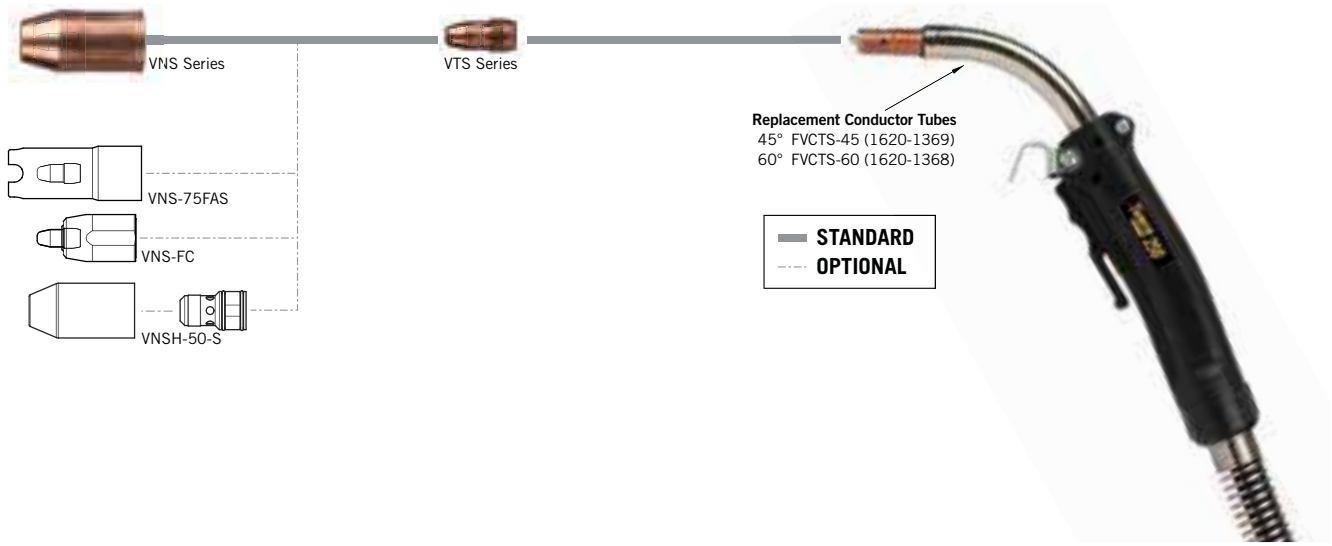
Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**FV210-3545**	1023-1059
	10 ft (3 m)	**FV210M-3545**	1023-1067
	12 ft (3.6 m)	**FV212M-3545**	1023-1068
	15 ft (4.6 m)	**FV215M-3545**	1023-1259
	20 ft (6.1 m)	**FV220M-3545**	1023-1070
	25 ft (7.6 m)	**FV225M-3545**	1023-1071

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**FV210X-3545**	1023-1089
	12 ft (3.6 m)	**FV212X-3545**	1023-1090
	15 ft (4.6 m)	**FV215X-3545**	1023-1263
	25 ft (7.6 m)	**FV225X-3545**	1023-1092

Note: Gun length is measured from the front case to the rear case +/-3".



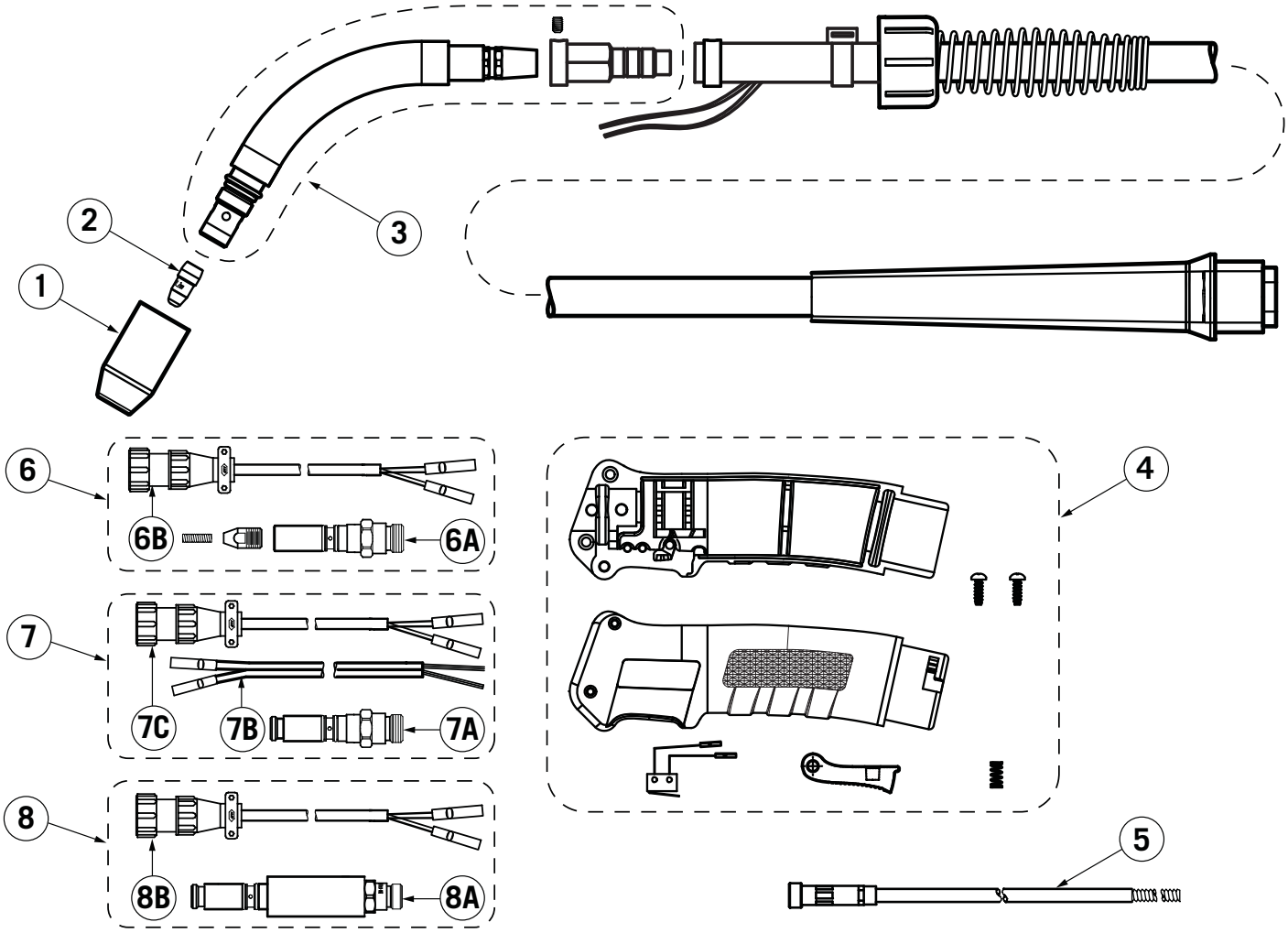
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	80%	CO_2 Carbon Dioxide	Up To .035" (0.9 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 48 & 49 for Replacement Parts & Optional Accessories

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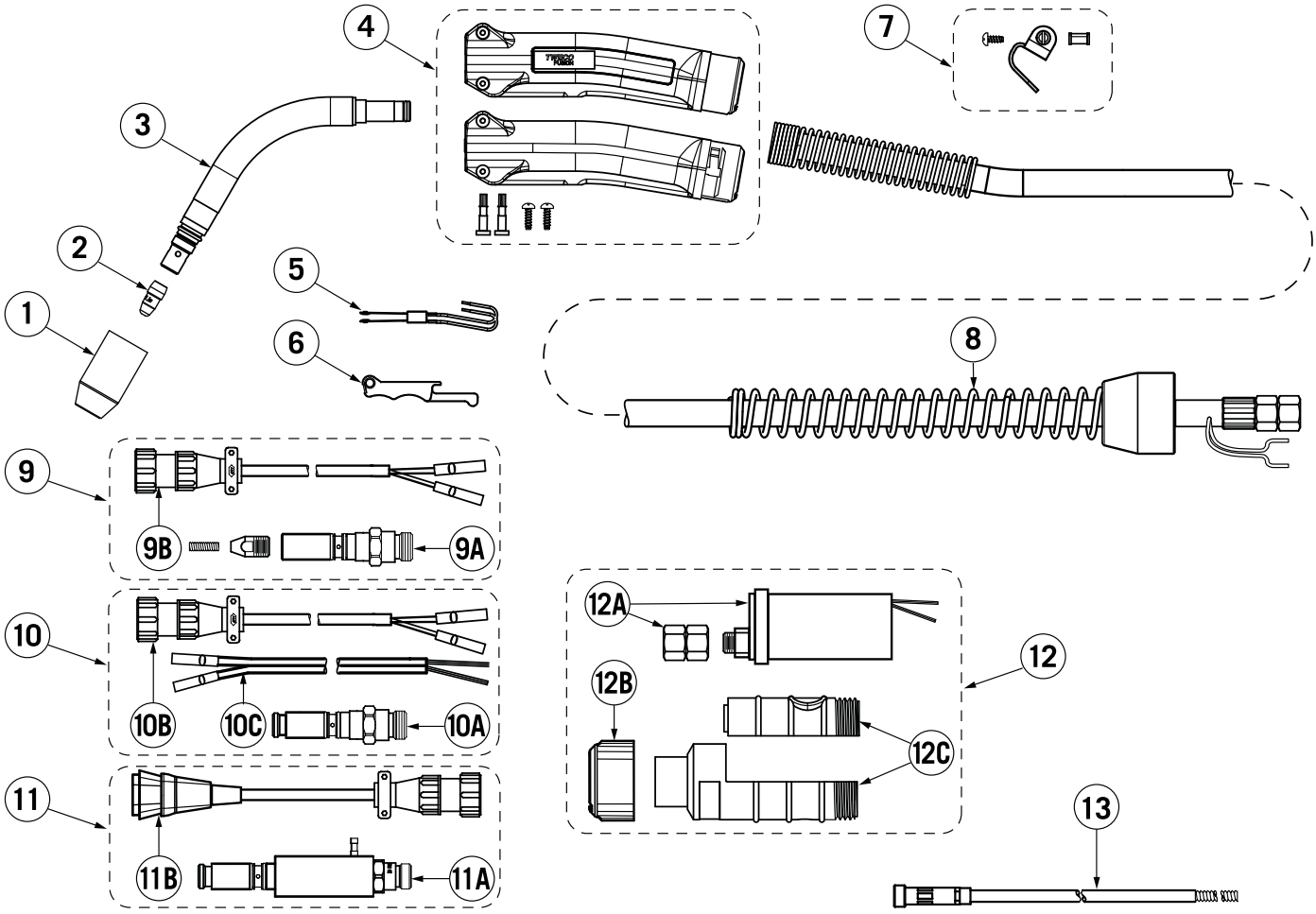
Tweco Fusion® 140, 180 & 220 Amp MIG Gun
Replacement Parts



#	Description	Part No.	Stock No.
1	Velocity™ Nozzle	**Refer to Page 100**	
2	Velocity Contact Tip	**Refer to Page 100**	
3	Conductor Tube Assembly	FVCTS-220-60	1620-1108
4	Handle / Trigger Repair Kit	F80	2020-2025
5	Conduit Assembly	WS42-3035-15	1420-1140
6A	Miller® Rear Connector	350-174MH	2035-2111
6B	Miller® & Lincoln® Control Wire & Plug	WM354-M	2030-2075
7A	Tweco® Rear Connector	350-174H	2035-2110
7B	Tweco® Control Wire & Plug	35K-350-1	2000-2352
7C	Thermal Arc® Control Wire	WS-354-TA-LC	2060-2141
8A	Lincoln® Rear Connector	350-174HXL	2035-2116
8B	Miller® & Lincoln® Control Wire & Plug	WM354-M	2030-2075

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Tweco Fusion® 250 Amp MIG Gun
Replacement Parts

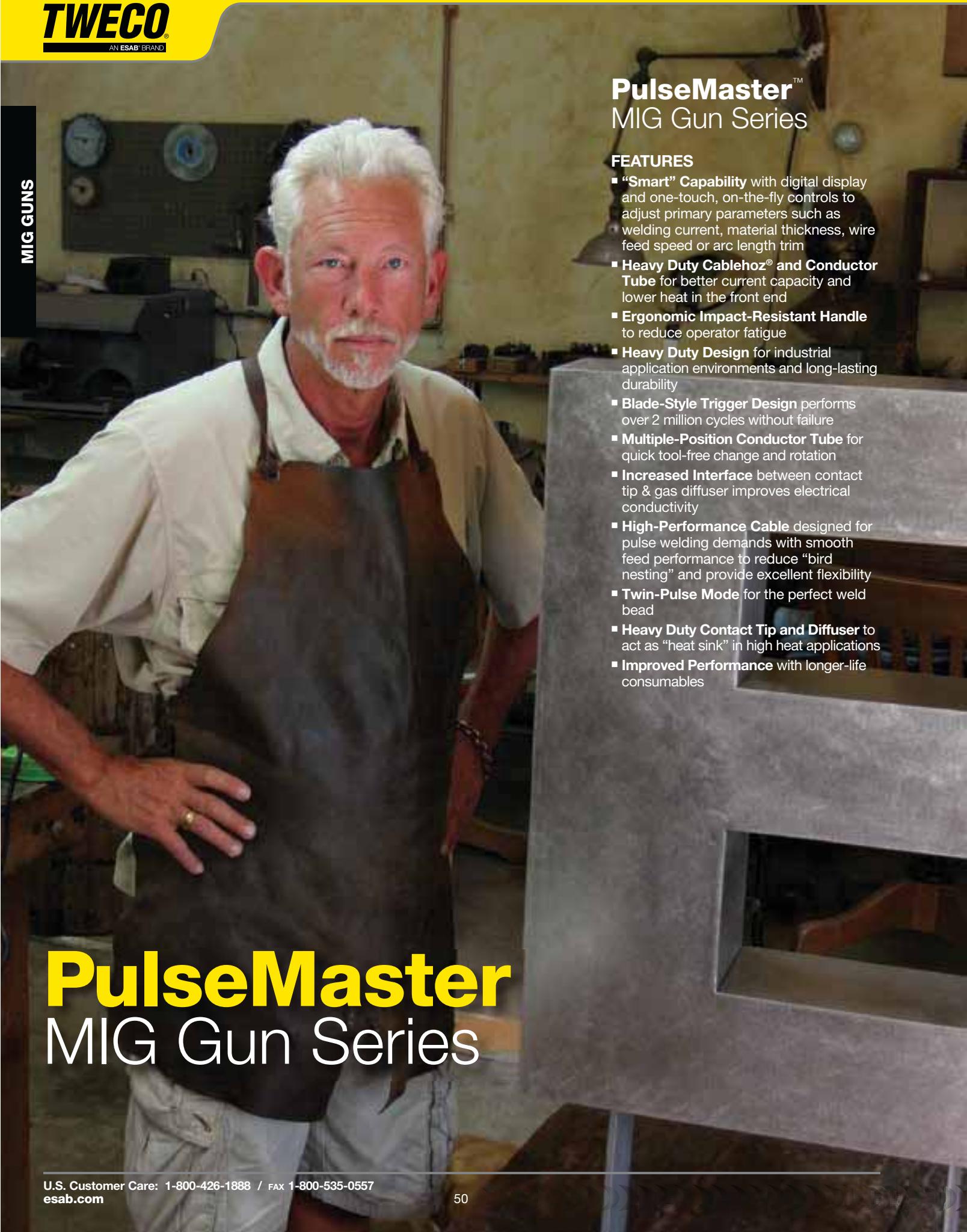


#		Description	Part No.	Stock No.
1		Velocity™ Nozzle	**Refer to Page 100**	
2		Velocity Contact Tip	**Refer to Page 100**	
3		Velocity 45˚ Conductor Tube	FVCT-S45	1620-1369
		Velocity 60˚ Conductor Tube	FVCT-S60	1620-1368
4		Handle Halves w/screws	F84	2060-2126
5		Trigger – Standard	ELC84	2060-2647
6		Trigger Blade Assembly	ELC94-BL	2060-2671
7		Gun Hanger	152	2020-2152
8	NS	Cablehoz Assembly – 10 ft (3 m)	MS210	1720-2115
	NS	Cablehoz Assembly – 12 ft (3.6 m)	MS212	1720-2116
	NS	Cablehoz Assembly – 15 ft (4.6 m)	MS225	1720-2117
	NS	Cablehoz Assembly – 25 ft (7.6 m)	MS225	1720-2118
	NS	Cablehoz Assembly, Euro-Kwik – 12 ft (3.6 m)	MS212X	1720-2107
	NS	Cablehoz Assembly, Euro-Kwik – 15 ft (4.6 m)	MS215X	1720-2108
	NS	Cablehoz Assembly, Euro-Kwik – 25 ft (7.6 m)	MS225X	1720-2109

#	Description	Part No.	Stock No.
8A	Cablehoz Front Mechanical Connector Replacement Kit	MS102-RK	2060-2132
8B	Cablehoz Rear Mechanical Connector Replacement Kit	MS172-RK	2060-2134
8C	Cablehoz Front Mechanical Connector Replacement Kit for Euro-Style	172X-M	2060-2181
9A	Miller® Rear Connector	350-174-MH	2035-2111
9B	Miller® Control Wire & Plug	WM-354M	2030-2075
10A	Tweco® Rear Connector	350-174H	2035-2110
10B	Tweco® Control Wire & Plug	MS354-TAJ	2060-2139
10C	Thermal Arc® Control Wire & Plug	WS-354-TA-LC	2060-2141
11A	Lincoln® Rear Connector	350-174LH	2035-2112
11B	Lincoln® Control Wire & Plug	MS-354DS-LJ	2060-2137
12A	Euro-Kwik Connection Assembly	174EX-1	2040-2276
12B	Euro-Kwik Nut	174X-2	2040-2177
12C	Euro-Kwik Connector Case	X6RC	2060-2006
13	Conduit Assembly	**Refer to Pages 124-127**	

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
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PulseMaster™
MIG Gun Series

FEATURES

- **"Smart" Capability** with digital display and one-touch, on-the-fly controls to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim
- **Heavy Duty Cablehoz® and Conductor Tube** for better current capacity and lower heat in the front end
- **Ergonomic Impact-Resistant Handle** to reduce operator fatigue
- **Heavy Duty Design** for industrial application environments and long-lasting durability
- **Blade-Style Trigger Design** performs over 2 million cycles without failure
- **Multiple-Position Conductor Tube** for quick tool-free change and rotation
- **Increased Interface** between contact tip & gas diffuser improves electrical conductivity
- **High-Performance Cable** designed for pulse welding demands with smooth feed performance to reduce "bird nesting" and provide excellent flexibility
- **Twin-Pulse Mode** for the perfect weld bead
- **Heavy Duty Contact Tip and Diffuser** to act as "heat sink" in high heat applications
- **Improved Performance** with longer-life consumables

PulseMaster
MIG Gun Series

		PulseMaster 350 Amp	**PulseMaster** 450 Amp
Applications		Light-Medium Duty Fabrication	Heavy Duty Fabrication
Standard Options	**Smart Capability**	■	■
	Standard without "Smart"Capability	■	■
	Rear Connector	■	■
Output Current		350 Amps	450 Amps
Duty Cycle - Mixed Gases		60%	60%
Wire Diameter		Up to .045" (1.2 mm)	Up to .045" (1.2 mm)
Process	**MIG**	■	■
	Aluminum	■	■

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.





PulseMaster with "Smart" Capability

- Digital Display Screen
- Selection Buttons
- **Menu Options**
  - Welding Current
  - Material Thickness
  - Wire Feed Speed
  - Arc Length Trim

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

PulseMaster™ 350 Amp MIG Gun



60% Duty Cycle - Mixed Gases
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard without "Smart" Capability but available with "Smart" Capability
- Standard Conductor Tube – Part No. PMA64EL-45 (Stock No. 1642-1130)
- Conduit Liner – 44 Series

Smart Gun
PulseMaster Smart MIG Guns are used only with Tweco® PowerMaster SP machines and are available with "Smart" Capability.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMAS312-3545**	1038-1152
	15 ft (4.6 m)	**PMAS315-3545**	1038-1157

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMAS312X-3545**	1038-1153
	15 ft (4.6 m)	**PMAS315X-3545**	1038-1158

Standard Gun
PulseMaster MIG Guns are Standard without "Smart" Capability.

Tweco® Style Rear Connector
Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA312-3545**	1038-1150
	15 ft (4.6 m)	**PMA315-3545**	1038-1155

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA312M-3545**	1038-1160
	15 ft (4.6 m)	**PMA315M-3545**	1038-1161

Lincoln® Style Rear Connector
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA312L-3545**	1038-1162
	15 ft (4.6 m)	**PMA315L-3545**	1038-1163

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA312X-3545**	1038-1151
	15 ft (4.6 m)	**PMA315X-3545**	1038-1156



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
350 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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See Page 54 & 55 for Replacement Parts & Optional Accessories

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MIG | MAX OUTPUT 450 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE HEAVY DUTY

PulseMaster™ 450 Amp MIG Gun



60% Duty Cycle - Mixed Gases
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard without "Smart" Capability but available with "Smart" Capability
- Standard Conductor Tube – Part No. PMA64EL-45 (Stock No. 1642-1130)
- Conduit Liner – 44 Series

Smart Gun
PulseMaster Smart MIG Guns are used only with Tweco® PowerMaster SP machines and are available with "Smart" Capability.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMAS412-3545**	1041-1510
	15 ft (4.6 m)	**PMAS415-3545**	1041-1511

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMAS412X-3545**	1041-1515
	15 ft (4.6 m)	**PMAS415X-3545**	1041-1516

Standard Gun
PulseMaster MIG Guns are Standard without "Smart" Capability.

Tweco® Style Rear Connector
Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA412-3545**	1041-1500
	15 ft (4.6 m)	**PMA415-3545**	1041-1501

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA412M-3545**	1041-1502
	15 ft (4.6 m)	**PMA415M-3545**	1041-1503

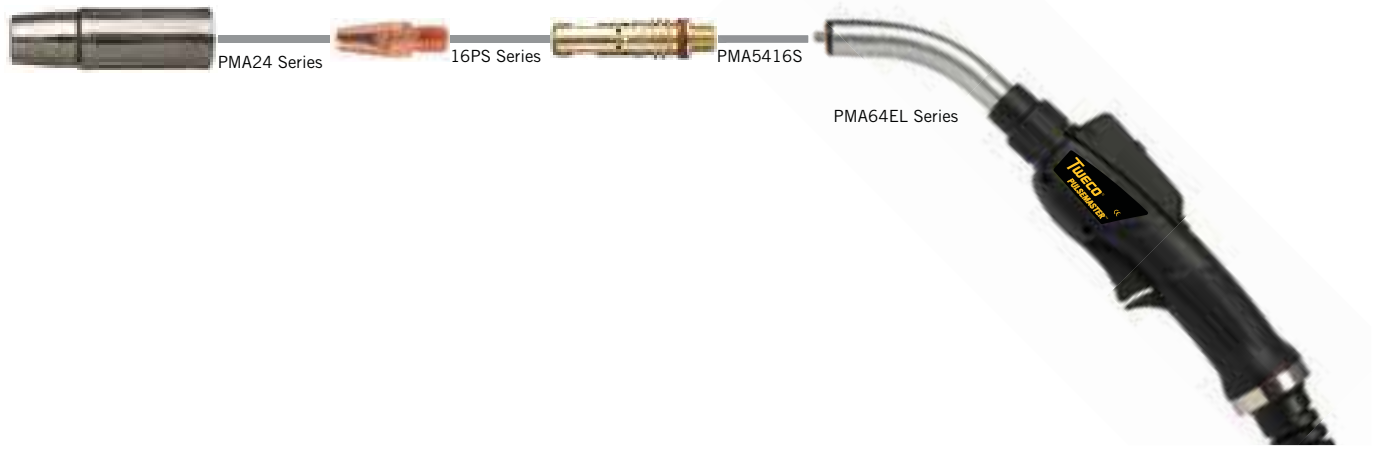
Lincoln® Style Rear Connector
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA412L-3545**	1041-1507
	15 ft (4.6 m)	**PMA415L-3545**	1041-1508

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMA412X-3545**	1041-1505
	15 ft (4.6 m)	**PMA415X-3545**	1041-1506



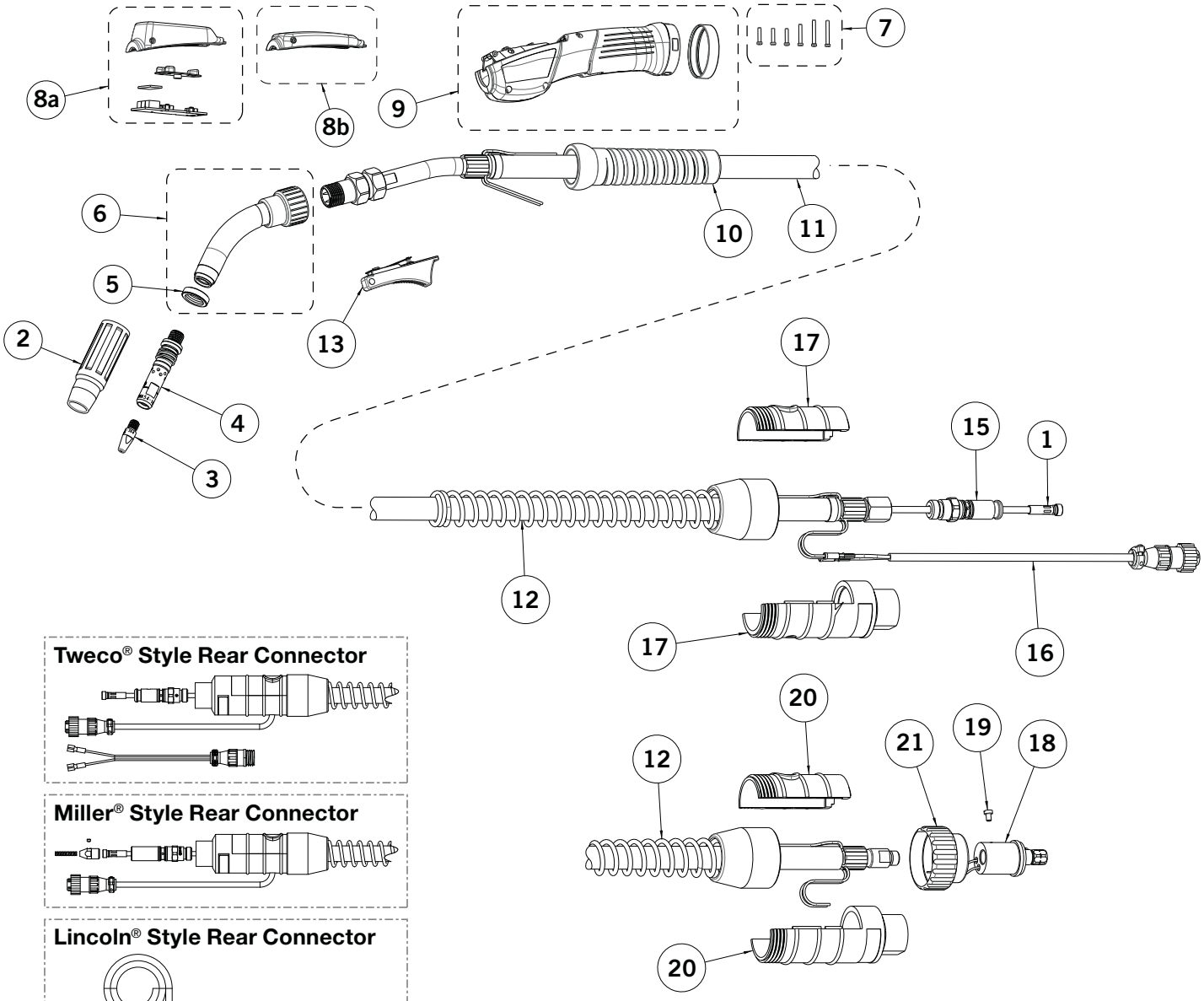
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 54 & 55 for Replacement Parts & Optional Accessories

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

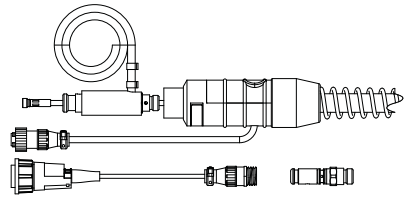
PulseMaster™ Series Replacement Parts



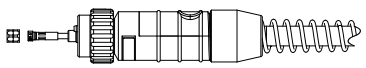
Tweco® Style Rear Connector

Miller® Style Rear Connector

Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



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PulseMaster™ Series Replacement Parts

#	Description	Part No.	Stock No.
1	Conduit Assembly	**Refer to Pages 124-127**	
2	Nozzle	**PMA24 Series**	
3	Contact Tip	**16PS Series**	
4	Gas Diffuser used w/ 16PS Series Contact Tips	**PMA54-16S**	1543-1106
5	Nozzle Insulator	**66J-3**	1660-1836
6	Conductor Tube	**PMA64EL Series**	
7	Handle Screws w/T9 Star Head (12 mm, 16 mm, & 20 mm LG)	**PMHSK**	2060-2705
8a	Handle Housing w/ Smart Control Assembly	**PM84-PCB-HK**	2060-2706
8b	Handle Housing (Blank)	**PM84-H**	2060-2707
9	Large Handle Assembly w/ Retaining Ring	**PM84**	2060-2708
	Small Handle Assembly w/ Retaining Ring	**PM83**	2060-2715
10	Front Cable Support	**--**	--
11	Cablehoz® Assembly	**--**	--
12	Rear Cable Support	**235RSSR**	2060-2035
13	Trigger	**PM94**	2060-2712
15	Connector Plug	**Refer to Pages 92-93**	
16	Control Wire Plug	**MS354-DSM**	2060-2140
17	Rear Case	**--**	--
18	Euro-Kwik Rear Connector	**174EX-1**	2040-2276
19	Screw (Euro Rear Connector)	**4M-S**	2011-2004
20	Rear Case & Strain Relief (Euro)	**X6RC**	2060-2006
21	Connector Nut (Euro)	**174X-2**	2040-2177
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Eliminator®
MIG Gun Series

Compact Eliminator® and Eliminator®
MIG Gun Series

FEATURES

- **Operator appeal** with ergonomic handle to reduce operator fatigue and extended trigger length to reduce radiated heat to welder's gloved hand
- **Field repairable** split-half handle case provides access for ease of repair with field repairable mechanical cable connections available and spare trigger leads in Cablehoz®
- **Improved performance patented contact tip** with no threads cam style interface between contact tip & gas diffuser for increased surface contact
- **Ball & socket conductor tube design** with articulating conductor tube and three layer conductor tube construction (Copper Tube/Silicon Resin Fiberglass Insulator/ Metal Jacket)
- **Wide welding applications** spray transfer & pulse welding modes straight CO_2 or mixed gases

		Compact Eliminator® 250	Compact Eliminator 450	Standard Eliminator 450
Applications		Light/Medium Duty Fabrication	Heavy Duty Fabrication	Heavy Duty Fabrication
Standard Options	**Rear Connector**	■	■	■
	Dual Schedule		■	■
	Knucklehead Flexible Conductor Tube	■	■	■
Output Current		250 Amps	450 Amps	450 Amps
Duty Cycle - CO_2		60%	60%	60%
Wire Diameter		Up to .045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 1/16" (1.6 mm)
Process	**MIG**	■	■	■
	Aluminum	■	■	■
	Flux-Cored Gas Shielded	■	■	■
	Flux-Cored Self Shielded	■	■	■

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.



Compact Eliminator®

Standard Eliminator®

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 250 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

Compact Eliminator® 250 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Light/Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW), Flux-Cored Gas Shielded, Flux-Cored Self Shielded

Standard Options Include:

- Rear Connector
- Standard Conductor Tube – Part No. EL63J-45 (Stock No. 1630-1136)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**ELC212-4045**	1028-1108
	15 ft (4.6 m)	**ELC215-4045**	1028-1112

Miller® Style Rear Connector

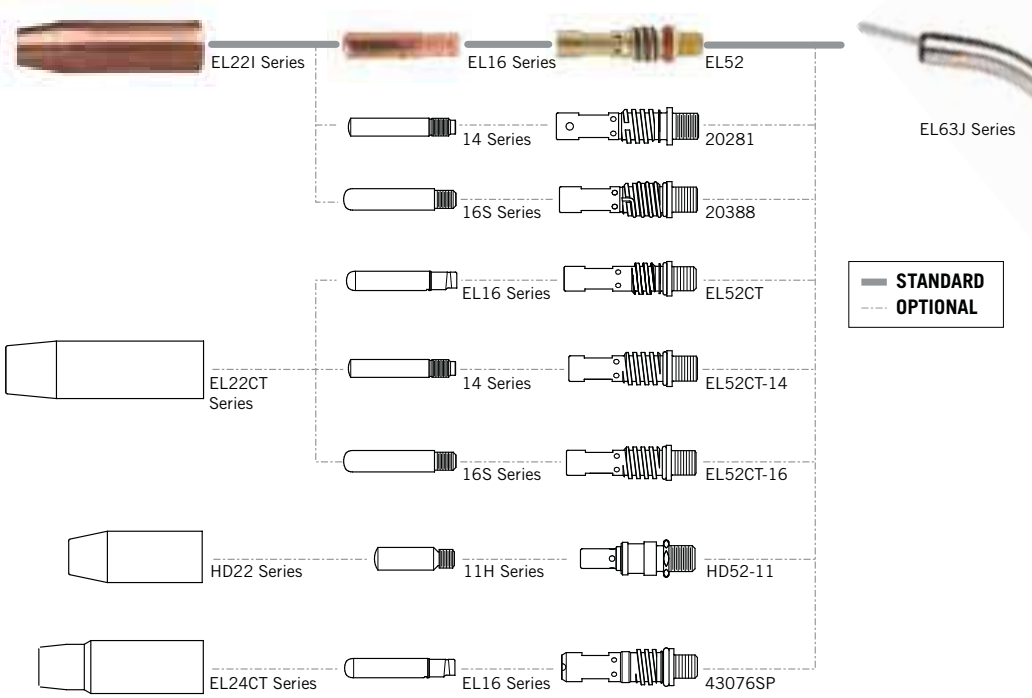
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**ELC212M-4045**	1028-1158
	15 ft (4.6 m)	**ELC215M-4045**	1028-1162
	25 ft (7.6 m)	**ELC225M-4045**	1028-1170

Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (1.0 mm)	15 ft (4.6 m)	**ELC215L-3035**	1028-1186

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**XELC215-4045**	1028-1137





Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

EASY FIND GUIDE
See Page 61 for Replacement Parts & Optional Accessories

Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco. Tweco is registered trademark of ESAB.

MIG | MAX OUTPUT 450 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Compact Eliminator®450 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW), Flux-Cored Gas Shielded, Flux-Cored Self Shielded

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. EL64J-60 (Stock No. 1640-1137)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2mm)	15 ft (4.6 m)	**ELC415-3545**	1048-1210
Up To 1/16" (1.6mm)	15 ft (4.6 m)	**ELC415-116**	1048-1211
	20 ft (6.1 m)	**ELC420-116**	1048-1216
	25 ft (7.6 m)	**ELC425-116**	1048-1221

Miller® Style Rear Connector

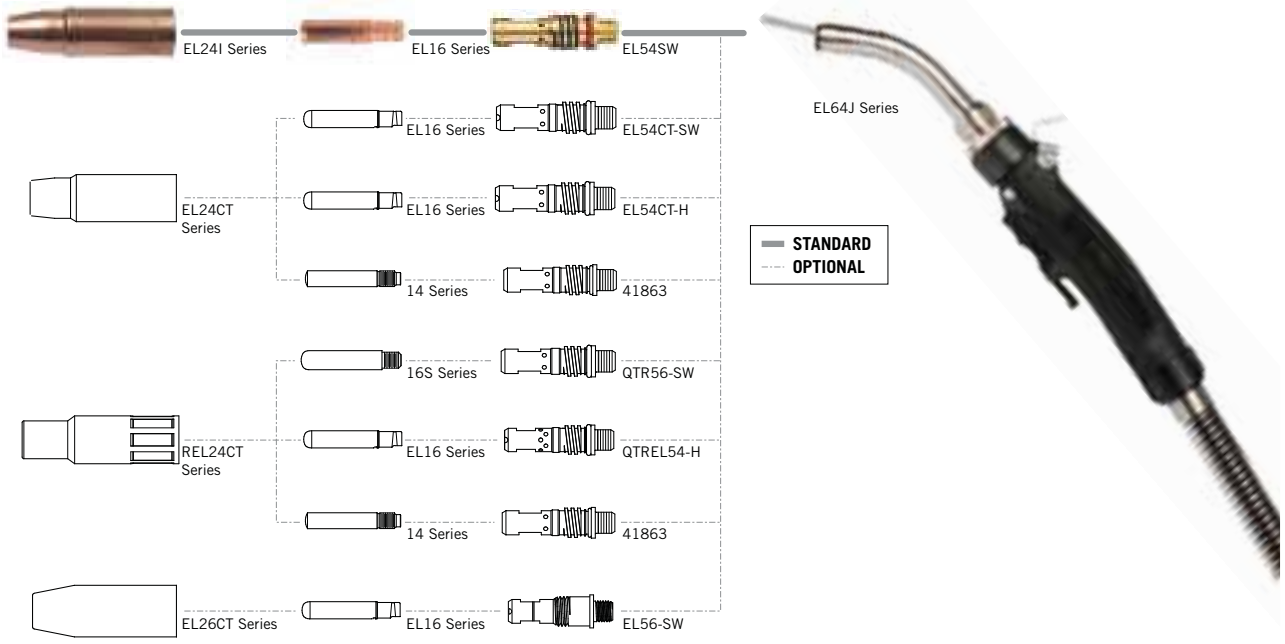
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2mm)	10 ft (3 m)	**ELC410M-3545**	1048-1250
	12 ft (3.6 m)	**ELC412M-3545**	1048-1255
	15 ft (4.6 m)	**ELC415M-3545**	1048-1260
Up To 1/16" (1.6mm)	15 ft (4.6 m)	**ELC415M-116**	1048-1261
	25 ft (7.6 m)	**ELC425M-116**	1048-1271

Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2mm)	15 ft (4.6 m)	**ELC415L-3545**	1048-1285
Up To 1/16" (1.6mm)	15 ft (4.6 m)	**ELC415L-116**	1048-1286

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2mm)	12 ft (3.6 m)	**XELC412-3545**	1048-1230
	15 ft (4.6 m)	**XELC415-3545**	1048-1235



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 61 for Replacement Parts & Optional Accessories

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Standard Eliminator® 450 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW), Flux-Cored Gas Shielded, Flux-Cored Self Shielded

Standard Options Include:

- Rear Connector
- Standard Conductor Tube – Part No. EL64J-60 (Stock No. 1640-1137)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**EL415-3545**	1048-1112

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**EL415M-3545**	1048-1162
Up To 1/16" (1.6mm)	15 ft (4.6 m)	**EL415M-116**	1048-1163

Lincoln® Style Rear Connector

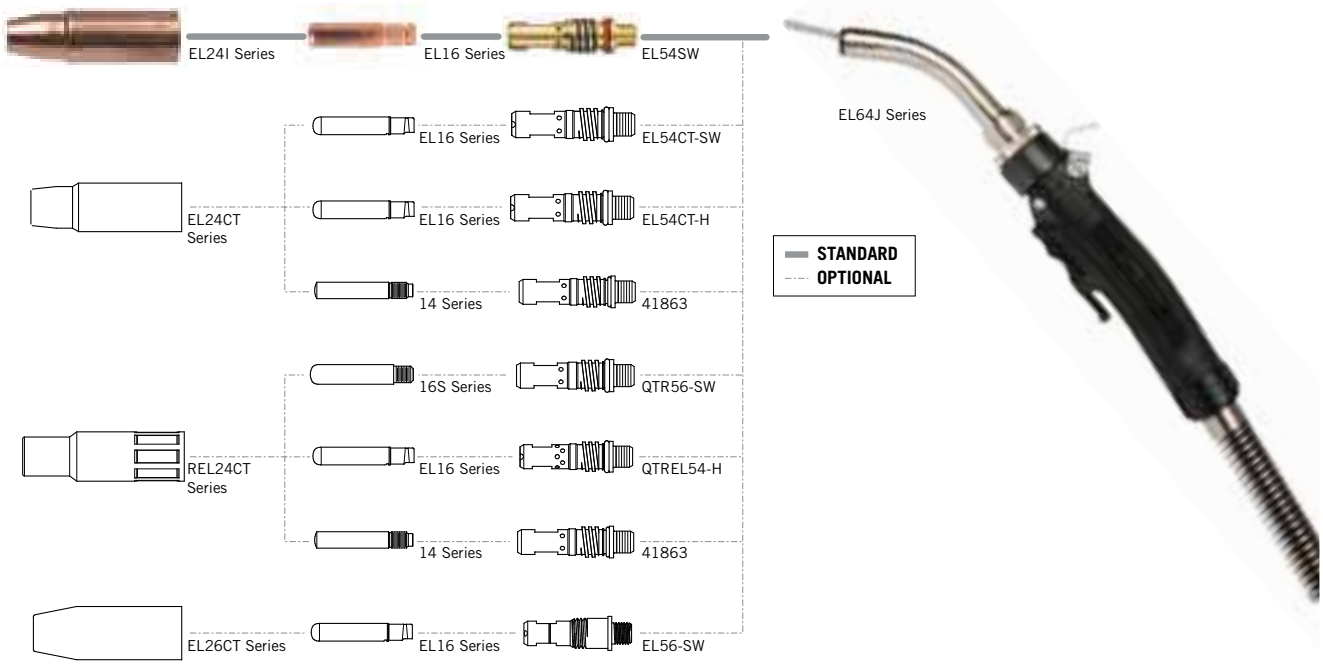
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**EL415L-3545**	1048-1190
Up To 1/16" (1.6mm)	15 ft (4.6 m)	**EL415L-116**	1048-1191

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**XEL415-3545**	1048-1140

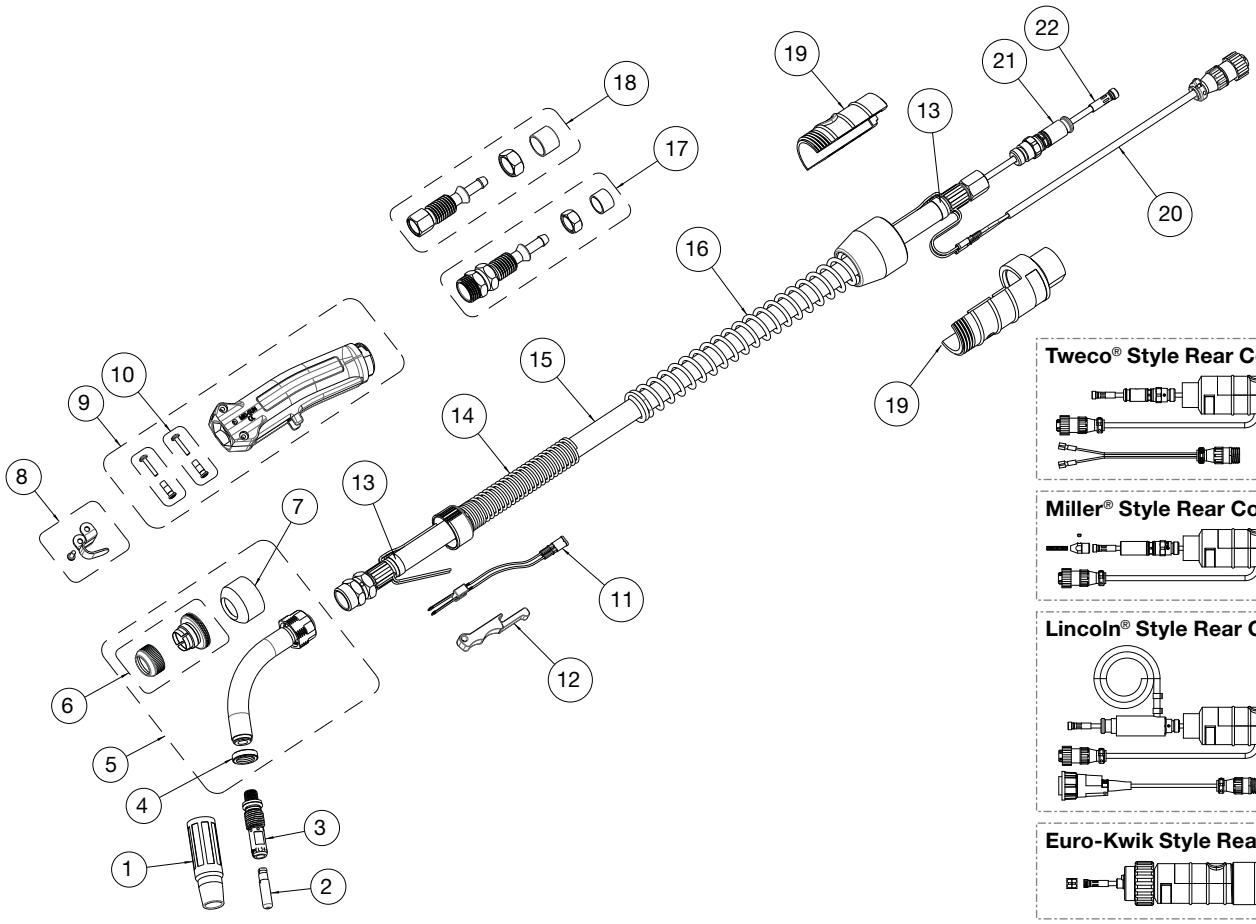


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 61 for Replacement Parts & Optional Accessories

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Eliminator® Series Replacement Parts



#	Description	Compact 250 Amp	Compact 450 Amp	Standard 450 Amp
		Part No. / Stock No.	**Part No. /** Stock No.	**Part No. /** Stock No.
1	Nozzle	**EL22I Series**	**EL24I Series**	**EL24I Series**
2	Contact Tip	**EL16 Series**	**EL16 Series**	**EL16 Series**
3	Diffuser	**EL52 Series**	**EL54 Series**	**EL54 Series**
4	Nozzle Insulator	**63J-3 /** 1630-1121	**63J-3 /** 1630-1121	**63J-3 /** 1630-1121
5	Conductor Tube	**EL63J Series**	**EL64J Series**	**EL64J Series**
6	Nut Cover Ring & Sleeve	**EL66-CR21** / 2060-2666	**EL66-CR21** / 2060-2666	**EL66-CR21** / 2060-2666
7	Nut Insulator	**EL66-CR** / 2060-2667	**EL66-CR** / 2060-2667	**EL66-CR** / 2060-2667
8	Gun Hanger	**152** / 2020-2152	**152** / 2020-2152	**152** / 2020-2152
9	Handle (Includes Items #10 & #12)	**ELC84-H** / 2060-2643	**ELC84-H** / 2060-2643	**EL86-H** / 2060-2653
10	Binder Posts & Screws (2 Required)	**ELC124FM** / 2060-2646	**ELC124FM** / 2060-2646	--
11	Trigger Blade Assembly	**ELC94-BL** / 2060-2671	**ELC94-BL** / 2060-2671	**EL96-B** / 2060-2606
12	Trigger	**ELC94** / 2060-2647	**ELC94** / 2060-2647	**EL96** / 2060-2605
13	Cable Clamp	**136** / 2060-2690	**136** / 2060-2690	**136** / 2060-2690
14	Front Strain Relief Spring & Cap	**MS144** / 2060-2131	**MS144** / 2060-2131	**EL146** / 2060-2686
15	Cablehoz Assembly, 15 ft (5 m) (Direct Plug)	**ELC215R** / 1720-2142	**ELC415R** / 1740-2527	**EL415R** / 1740-2537
	Cablehoz Assembly, 15 ft (5 m) (Euro)	--	**XELC415R** / 1740-2532	--
16	Rear Strain Relief Spring	**235RSSR** / 2060-2035	**235RSSR** / 2060-2035	**235RSSR** / 2060-2035
17	Front Cable Connector Repair Kit	**ELC100-2RK** / 2020-2182	**ELC100-4RK** / 2040-2187	**EL100-4RK** / 2040-2188
18	Rear Cable Connector Repair Kit (Direct Plug)	**--**	**350-170HK** / 2035-2169	**350-170HK** / 2035-2169
	Rear Cable Connector Repair Kit (Euro)	**172X-M** / 2020-2181	**174X-M** / 2040-2181	**174X-M** / 2040-2181
19	Rear Case (Direct Plug)	**C6RC** / 2060-2041	**C6RC** / 2060-2041	**C6RC** / 2060-2041
	Rear Case (Euro)	**X6RC** / 2060-2006	**X6RC** / 2060-2006	**X6RC** / 2060-2006
20	Control Wire (Direct Plug Only)	**MS354-DSM** / 2060-2140	**MS354-DSM** / 2060-2140	**MS354-DSM** / 2060-2140
21	Connector Plug	**Refer to Pages 92-93**	**Refer to Pages 92-93**	**Refer to Pages 92-93**
22	Conduit Assembly	**Refer to Pages 124-127**	**Refer to Pages 124-127**	**Refer to Pages 124-127**
NS	Protective Cable Wrap (50 ft/ 15 m per Box)	**TCR50** / 9900-1150	**TCR50** / 9900-1150	**TCR50** / 9900-1150

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 160 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .035" (0.9 mm) | COOLED AIR | USAGE LIGHT DUTY

Mini-MIG 160 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. 35-60-60 (Stock No. 1600-1102) on all guns
- Conduit Liner – 23 & 35 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**35-10**	1000-1131
	12 ft (3.6 m)	**35-12**	1000-1132
	15 ft (4.6 m)	**35-15**	1000-1133

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**M23-10**	1000-1210
	10 ft (3 m)	**M35-10**	1000-1211
	12 ft (3.6 m)	**M35-12**	1000-1213
	15 ft (4.6 m)	**M35-15**	1000-1215

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

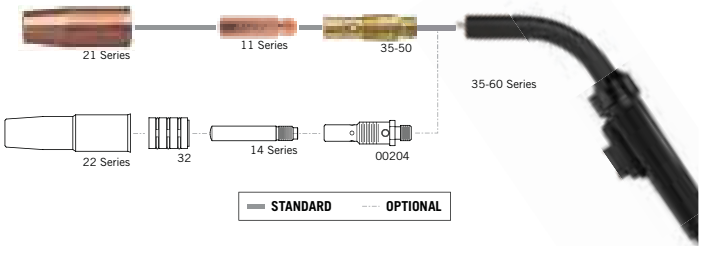
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**L35-10**	1000-1231
	10 ft (3 m)	**L35-10PM***	1000-1235
	12 ft (3.6 m)	**L35-12**	1000-1231
	15 ft (4.6 m)	**L35-15**	1000-1232
	15 ft (4.6 m)	**L35-15PM***	1000-1236

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.
**Fits Lincoln Power MIG 140/180 machines.*

Euro-Kwik Style Rear Connector

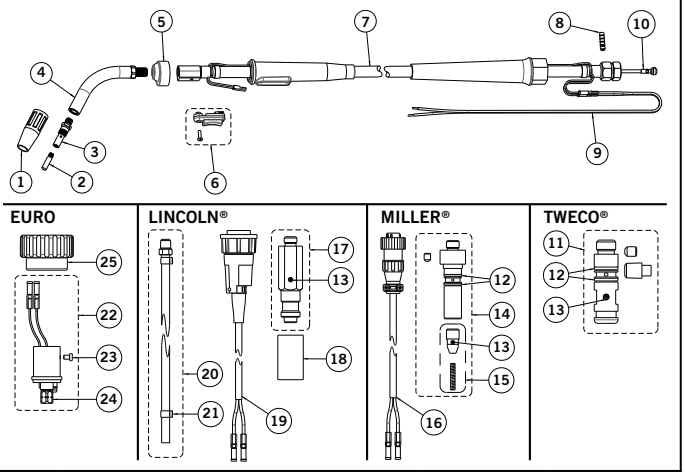
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**X23-10**	1000-1621
	10 ft (3 m)	**X35-10**	1000-1631
	12 ft (3.6 m)	**X35-12**	1000-1632
	15 ft (4.6 m)	**X35-15**	1000-1633

For additional information on adapter kits for other manufacturers' machines, refer to Form No. TAKL-97.



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
160 Amps	60%	CO_2 Carbon Dioxide	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

Mini-MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Nozzle	**21 Series**	
2	Contact Tip	**11 Series**	
3	Diffuser	**35-50**	
4	Conductor Tube	**35-60 Series**	
5	Handle Cap	**35-80-A1**	2000-2081
6	Trigger with Screw	**35-90**	2000-2090
7	Cablehoz® Assembly 10 ft (3 m) (Direct Plug)	**35-010A**	1700-2126
	Cablehoz Assembly 12 ft (3.6 m) (Direct Plug)	**35-012A**	1700-2127
	Cablehoz Assembly 15 ft (4.6 m) (Direct Plug)	**35-015A**	1700-2128
8	Gas Nipple	**35-170-5**	2000-2175
9	Control Wire	**35K350-1**	2000-2352
10	Conduit Assembly	**Refer to Pages 124-127**	
11	Tweco® Connector Plug	**35K-174C**	2000-2169
12	O-Ring (Package of 10)	**224S**	2064-2059
13	Set Screw (Package of 10)	**44CS**	2040-2046
14	Miller® Connector Plug	**170M**	2000-2810
15	Wire Guide Assembly Only	**174M-N**	2040-2184
16	Miller Control Wire	**WM-354M**	2030-2075
17	Lincoln® SP200 Connector Plug	**TLAK-352**	2641-2030
18	Lincoln Insulator	**LAK-352-1**	2642-2210
19	Lincoln Control Wire	**35SP-354**	2000-2354
20	Gas Hose Assembly with Clamp	**AK353**	2642-2300
21	Gas Hose Clamp Only	**AK-353-2A**	2642-2302
22	Euro-Kwik Body Assembly	**174EX-1**	2040-2276
23	Screw Only	**4-MS**	2011-2004
24	Euro-Kwik Conduit Cap Only	**174EX-1C**	2040-2279
25	Euro-Kwik Nut	**174X-2**	2040-2177
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

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MIG/FLUX CORED | MAX OUTPUT 160 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .035" (0.9 mm) | COOLED AIR | USAGE LIGHT DUTY

Velocity Mini-MIG 160 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. VCTS35-60-60 (Stock No. 1600-1106) on all guns
- Conduit Liner – 23 & 35 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**V35-10**	1000-1800
	12 ft (3.6 m)	**V35-12**	1000-1801
	15 ft (4.6 m)	**V35-15**	1000-1802

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VM23-10**	1000-1804
	10 ft (3 m)	**VM35-10**	1000-1805
	10 ft (3 m)	**VHB35M-10**	1000-1806
	12 ft (3.6 m)	**VM35-12**	1000-1807
	15 ft (4.6 m)	**VM35-15**	1000-1808

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

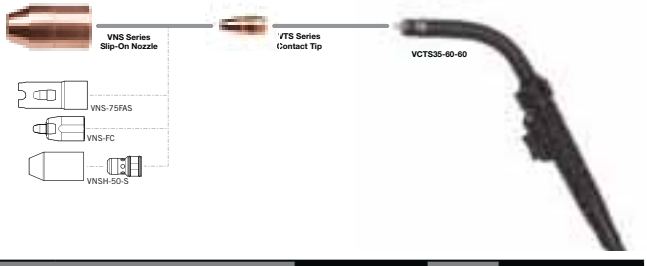
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VL35-10**	1000-1810
	10 ft (3 m)	**VHB35L-10**	1000-1811
	12 ft (3.6 m)	**VL-35-12**	1000-1812
	15 ft (4.6 m)	**VL35-15**	1000-1813
	15 ft (4.6 m)	**VL35-15PM**	1000-1814

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

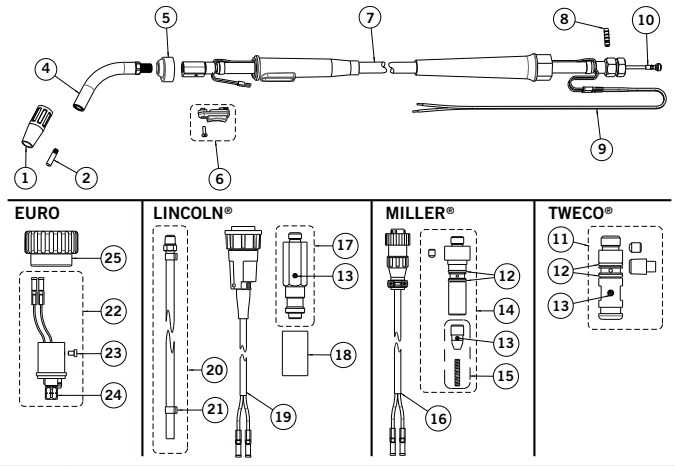
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	**VX23-10**	1000-1816
	10 ft (3 m)	**VX35-10**	1000-1817
	12 ft (3.6 m)	**VX35-12**	1000-1818
	15 ft (4.6 m)	**VX35-15**	1000-1819

For additional information on adapter kits for other manufacturers' machines, refer to Form No. TAKL-97.



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
160 Amps	60%	CO_2 Carbon Dioxide	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

V-Mini-MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Nozzle	**VNS Series**	
2	Contact Tip	**VTS Series**	
4	Conductor Tube	**VCTS35-60-60**	1600-1106
5	Handle Cap	**35-80-A1**	2000-2081
6	Trigger with Screw	**35-90**	2000-2090
7	Cablehoz® Assembly 10 ft (3 m) (Direct Plug)	**35-010A**	1700-2126
	Cablehoz Assembly 12 ft (3.6 m) (Direct Plug)	**35-012A**	1700-2127
	Cablehoz Assembly 15 ft (4.6 m) (Direct Plug)	**35-015A**	1700-2128
8	Gas Nipple	**35-170-5**	2000-2175
9	Control Wire	**35K350-1**	2000-2352
10	Conduit Assembly	**Refer to Pages 124-127**	
11	Tweco® Connector Plug	**35K-174C**	2000-2169
12	O-Ring (Package of 10)	**224S**	2064-2059
13	Set Screw (Package of 10)	**44CS**	2040-2046
14	Miller® Connector Plug	**170M**	2000-2810
15	Wire Guide Assembly Only	**174M-N**	2040-2184
16	Miller Control Wire	**WM-354M**	2030-2075
17	Lincoln® SP200 Connector Plug	**TLAK-352**	2641-2030
18	Lincoln Insulator	**LAK-352-1**	2642-2210
19	Lincoln Control Wire	**35SP-354**	2000-2354
20	Gas Hose Assembly with Clamp	**AK353**	2642-2300
21	Gas Hose Clamp Only	**AK-353-2A**	2642-2302
22	Euro-Kwik Body Assembly	**174EX-1**	2040-2276
23	Screw Only	**4-MS**	2011-2004
24	Euro-Kwik Conduit Cap Only	**174EX-1C**	2040-2279
25	Euro-Kwik Nut	**174X-2**	2040-2177
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 350 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Tuff-n-Lite 350 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Light to Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector
- Standard Conductor Tube – Part No. 64TL-60 (Stock No. 1635-1031) on all guns
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

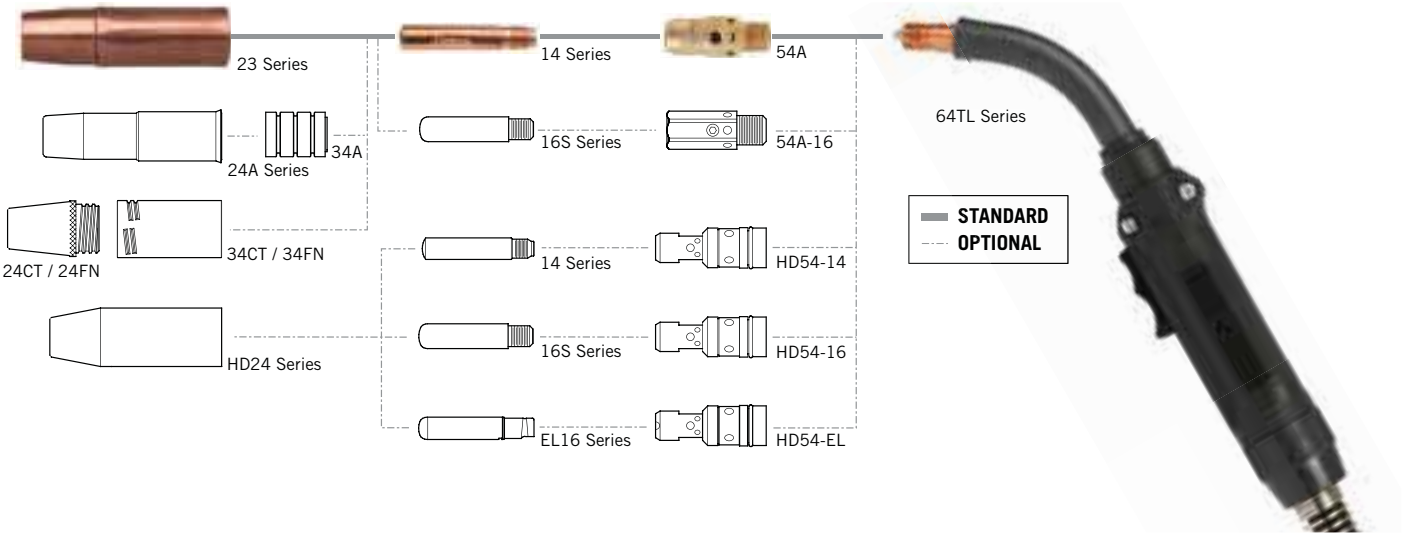
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**TL350-15-116**	1036-1037

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**TL350M-15-116**	1036-1237

FEATURES

- **Straight Handle** allows the welder to locate the trigger at the bottom or top of handle
- **Light-Weight Design** reduces operator fatigue and provides for ease of handling
- **Field Repairable Cablehoz®** for mechanical cable connections
- **Split Handle Case** provides access for easy repairs
- **Spray Transfer Mode and Pulse Welding**
- **Slim Design** for operator appeal
- **Spare Trigger Leads in Cablehoz**
- **Wide Variety of Welding Applications**
- **Straight CO_2 or Mixed Gases**

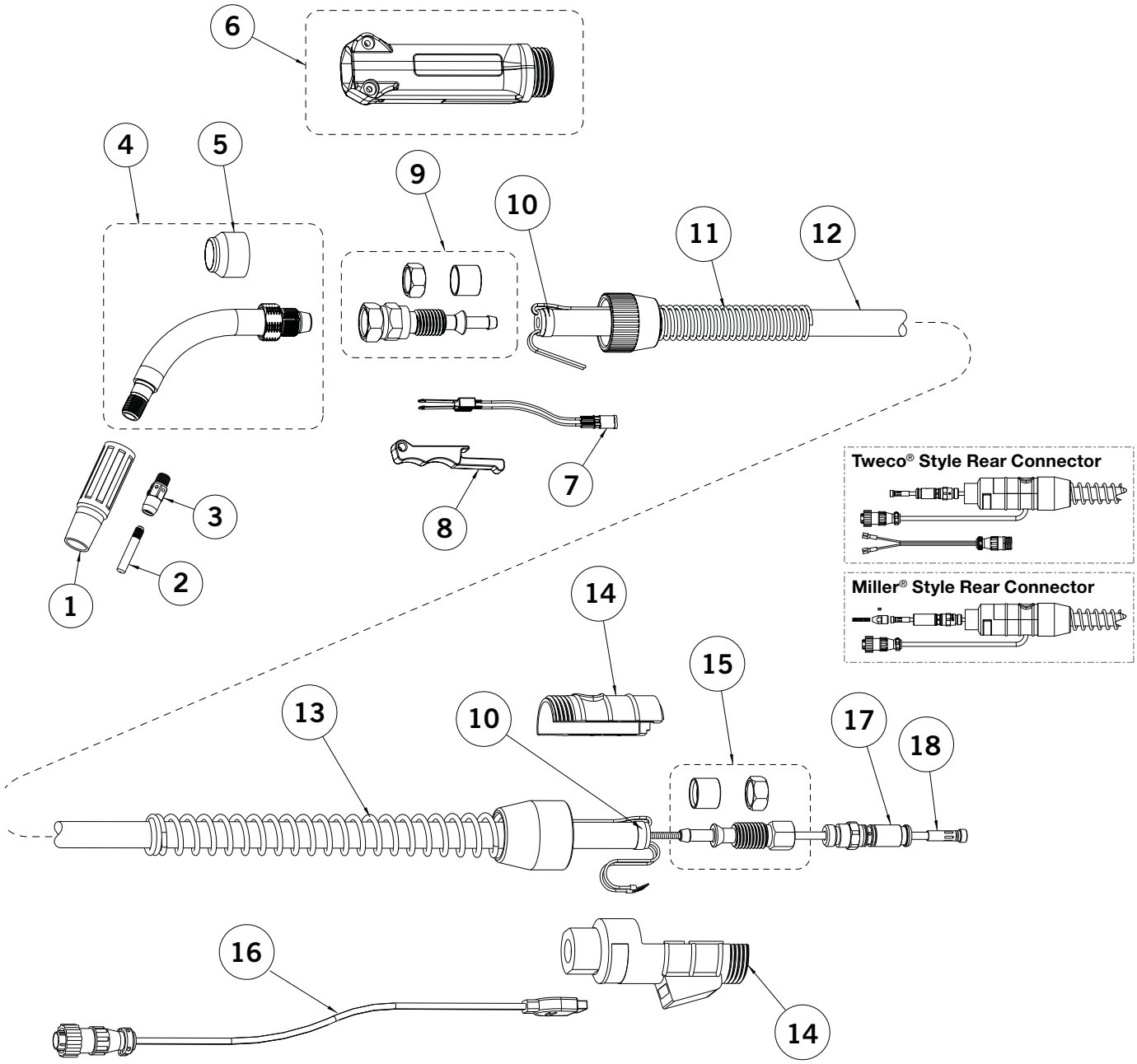


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
350 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 65 for Replacement Parts & Optional Accessories

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Tuff-n-Lite 350 Amp MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Nozzle	**23 Series**	
2	Contact Tip	**14 Series**	
3	Diffuser	**54A**	
4	Conductor Tube	**64TL Series**	
5	Nut Insulator	**64TL-NC**	2035-2128
6	Handle Assembly	**TL350-86R**	2035-2136
7	Trigger Blade Assembly	**EL96B**	2060-2606
8	Trigger	**EL96**	2060-2605
9	Front Cable Connector	**104TL**	2035-2130
10	Cable Clamp	**136**	2060-2690

#	Description	Part No.	Stock No.
11	Front Strain Relief Spring	**TL144**	2035-2138
12	Cablehoz®	**300**	1730-2100
13	Rear Strain Relief Spring	**235RSSR**	2060-2035
14	Rear Case	**M6RC**	2060-2018
15	Rear Cable Connector	**350-170HK**	2035-2169
16	Control Wire (Tweco®)	**MAK-354**	2642-2460
	Control Wire (Miller®)	**MSAK-354**	2642-2470
17	Connector Plug	**Refer to Pages 92-93**	
18	Conduit Assembly	**Refer to Pages 124-127**	
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 400 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Supra® XT SEHD 400 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Medium to Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector
- Available with Heavy Duty Front End Consumables
- Standard Conductor Tube – Part No. SE64J-60 (Stock No. 1640-1347) on all guns up to 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEHD400-5M16**	1040-1332

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEHD400M-5M16**	1040-1342

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEHD400L-5M16**	1040-1432

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

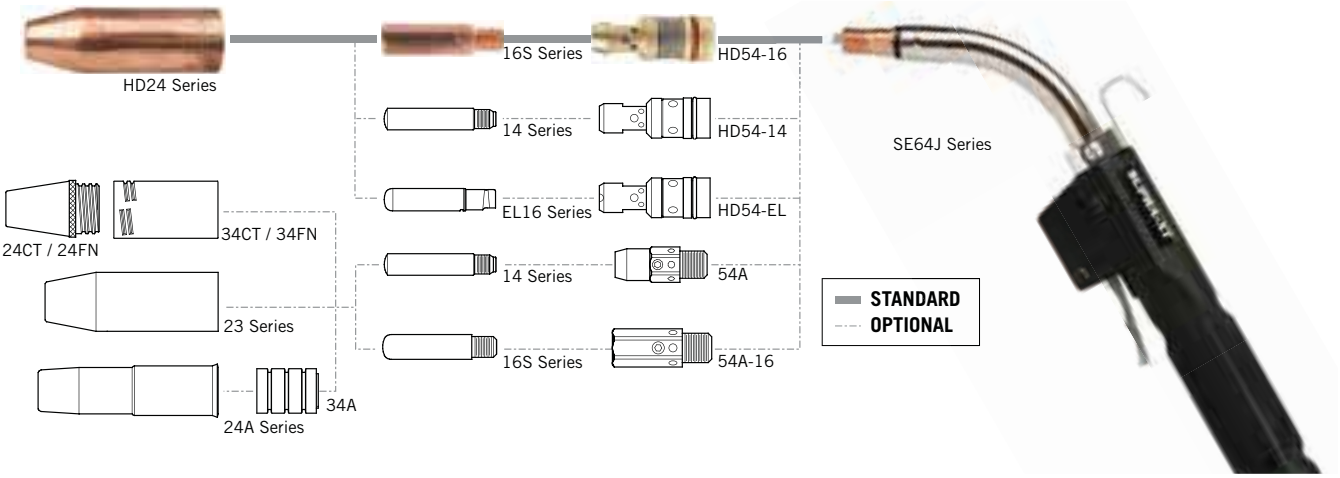
Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEHD400X-5M16**	1040-1442

For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.

FEATURES

- **High Impact-Resistant One-Piece "Straight" Handle** allows the welder to locate the trigger at the bottom or top of handle
- **Metal "Paddle" Style Trigger Lever**
- **Three-Layer Conductor Tube Construction** (copper tube/silicon-resin glass insulator/metal jacket) threads into front block for improved electrical conductivity
- **Front & Rear Spring Strain Relief** provides support to eliminate kinking
- **Micro-Switch Trigger Design** incorporates a button style switch for start/stop wire feed
- **Spray Transfer Mode and Pulse Welding**
- **Straight CO_2 or Mixed Gases**

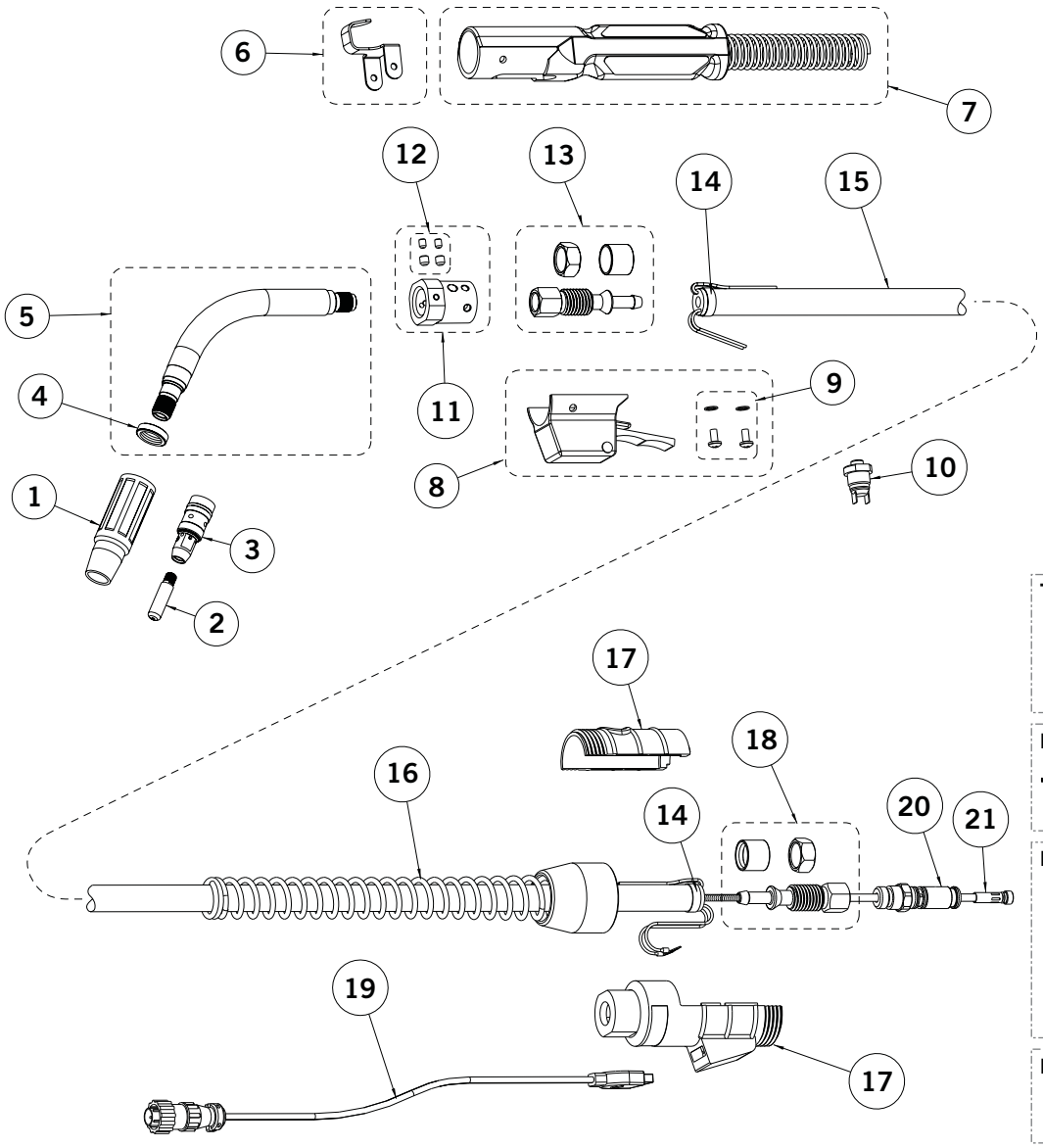


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

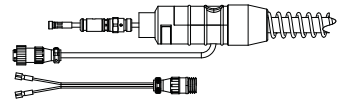
EASY FIND GUIDE
See Page 67 for Replacement Parts & Optional Accessories

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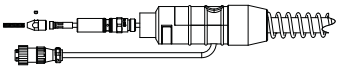
Supra® XT SEHD 400 Amp MIG Gun Replacement Parts



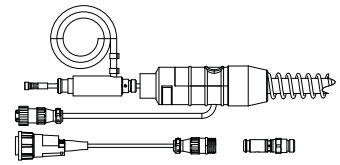
Tweco® Style Rear Connector



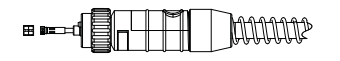
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



#	Description	Part No.	Stock No.
1	Nozzle	**HD24 Series**	
2	Contact Tip	**16S Series**	
3	Diffuser	**HD54-16**	
4	Nozzle Insulator	**66J-3**	1660-1836
5	Conductor Tube	**SE64J Series**	
6	Gun Hanger	**154**	2040-2154
7	Handle Assembly	**SE86-H**	2060-2052
8	Trigger Assembly	**SE96**	2060-2056
9	Trigger Housing Screws	**SE96-SW**	2060-2055
10	Trigger Switch	**SE96-B**	2060-2054
11	Front Pivot Block Assembly	**SE66**	2060-2051
12	Pivot Block Set Screw	**SE66-B**	2060-2050

#	Description	Part No.	Stock No.
13	Front Cable Connector	**SE104**	2060-2057
14	Cable Clamp	**136**	2060-2690
15	Cablehoz®	**400**	1740-2100
16	Rear Strain Relief Spring	**235RSSR**	2060-2035
17	Rear Case	**M6RC**	2660-2018
18	Rear Cable Connector	**350-170HK**	2035-2169
19	Control Wire (Tweco®)	**MAK-354**	2642-2460
	Control Wire (Miller®)	**MSAK-354**	2642-2470
	Control Wire (Lincoln®)	**LAK-354**	2642-2450
20	Connector Plug	**Refer to Pages 92-93**	
21	Conduit Assembly	**Refer to Pages 124-127**	
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 400 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Supra® XT SEL 400 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Medium to Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector
- Available with Eliminator Style Front End Consumables
- Standard Conductor Tube – Part No. SEL64J-60 (Stock No. 1640-1322) on all guns up to 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEL400-5M1,6**	1040-1207

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEL400M-5M1,6**	1040-1217

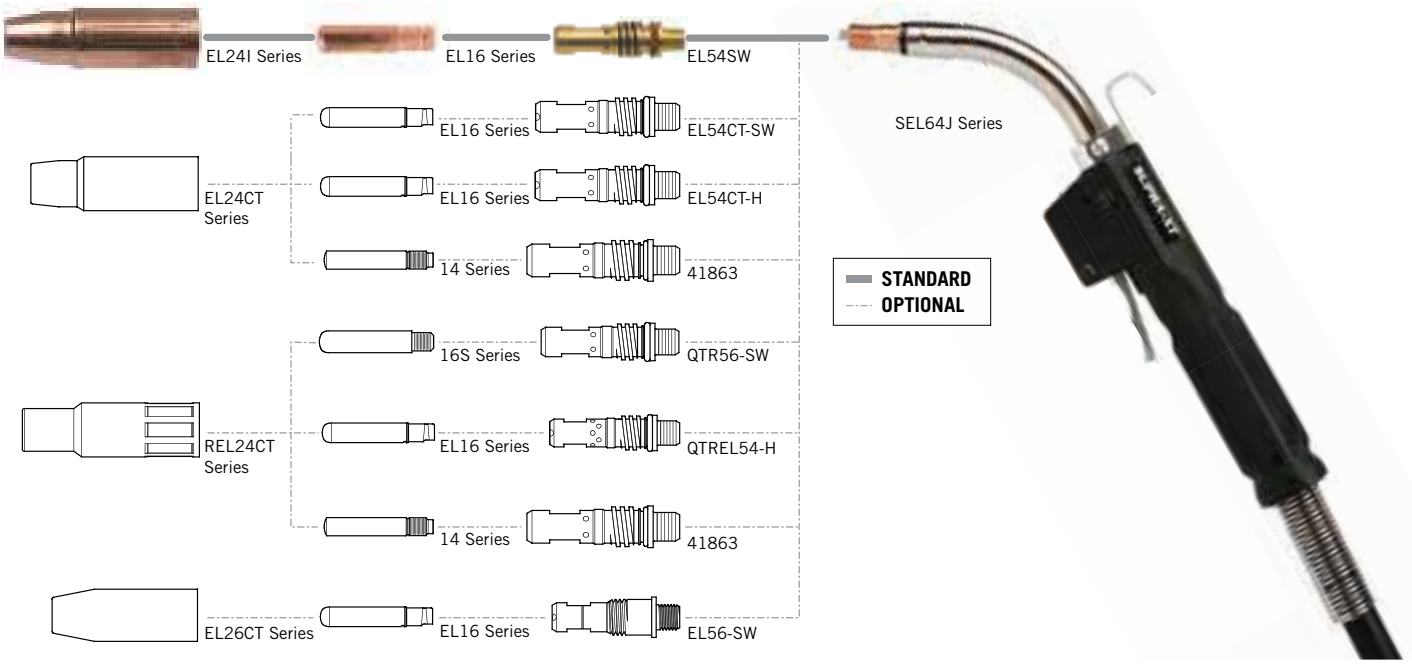
Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SEL400L-5M1,6**	1040-1242

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

MIG guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.
For Special MIG gun configurations, including special consumables, please contact Tech Service and Support.

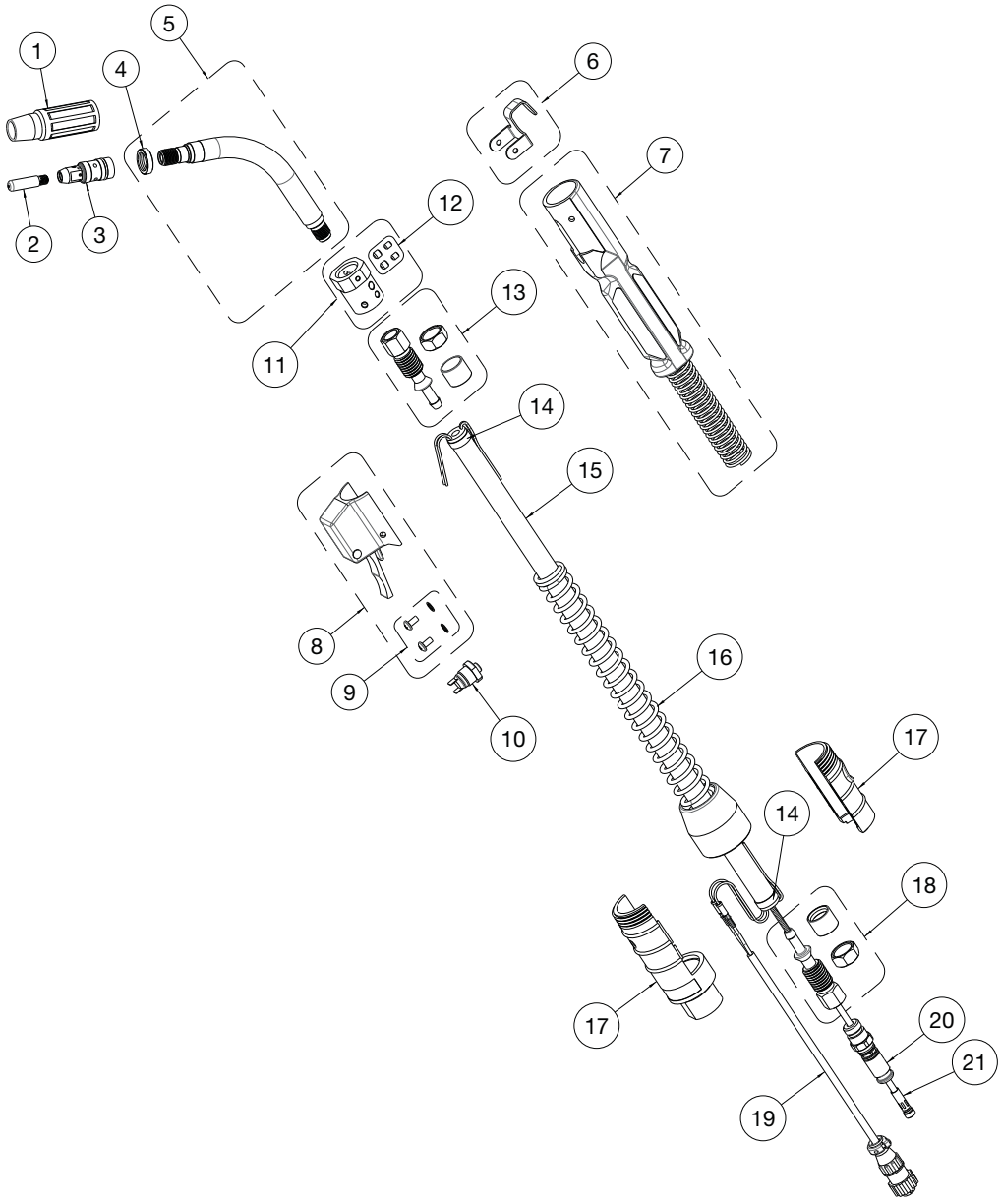


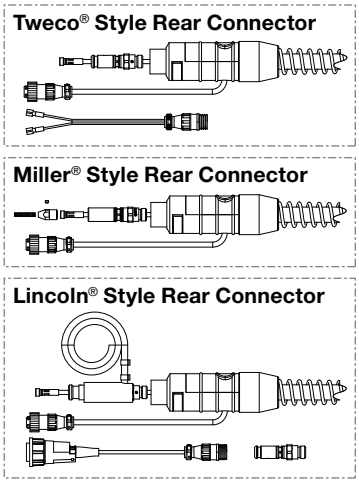
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 69 for Replacement Parts & Optional Accessories

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Supra® XT SEL 400 Amp MIG Gun Replacement Parts





#	Description	Part No.	Stock No.
1	Nozzle	**EL24I Series**	
2	Contact Tip	**EL16 Series**	
3	Diffuser	**EL54 Series**	
4	Nozzle Insulator	**66J-3**	1660-1836
5	Conductor Tube	**SEL64J Series**	
6	Gun Hanger	**154**	2040-2154
7	Handle Assembly	**SE86-H**	2060-2052
8	Trigger Assembly	**SE96**	2060-2056
9	Trigger Housing Screws	**SE96-SW**	2060-2055
10	Trigger Switch	**SE96-B**	2060-2054
11	Front Pivot Block Assembly	**SE66**	2060-2051
12	Pivot Block Set Screw	**SE66-B**	2060-2050

#	Description	Part No.	Stock No.
13	Front Cable Connector	**SE104**	2060-2057
14	Cable Clamp	**136**	2060-2690
15	Cablehoz®	**400**	1740-2100
16	Rear Strain Relief Spring	**235RSSR**	2060-2035
17	Rear Case	**M6RC**	2660-2018
18	Rear Cable Connector	**350-170HK**	2035-2169
19	Control Wire (Tweco®)	**MAK-354**	2642-2460
	Control Wire (Miller®)	**MSAK-354**	2642-2470
	Control Wire (Lincoln®)	**LAK-354**	2642-2450
20	Connector Plug	**Refer to Pages 92-93**	
21	Conduit Assembly	**Refer to Pages 124-127**	
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 250 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

Smoke Master® 250 Amp Fume Extraction Air-Cooled MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Light to Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. 62-60 (Stock No. 2020-2006) on all guns up to 15 ft (4.6 m)
- Conduit Liner – 42 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**S212-4045**	1026-1101
	15 ft (4.6 m)	**S215-4045**	1026-1102

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**S212M-4045**	1026-1106
	15 ft (4.6 m)	**S215M-4045**	1026-1107

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**S215L-4045**	1026-1132

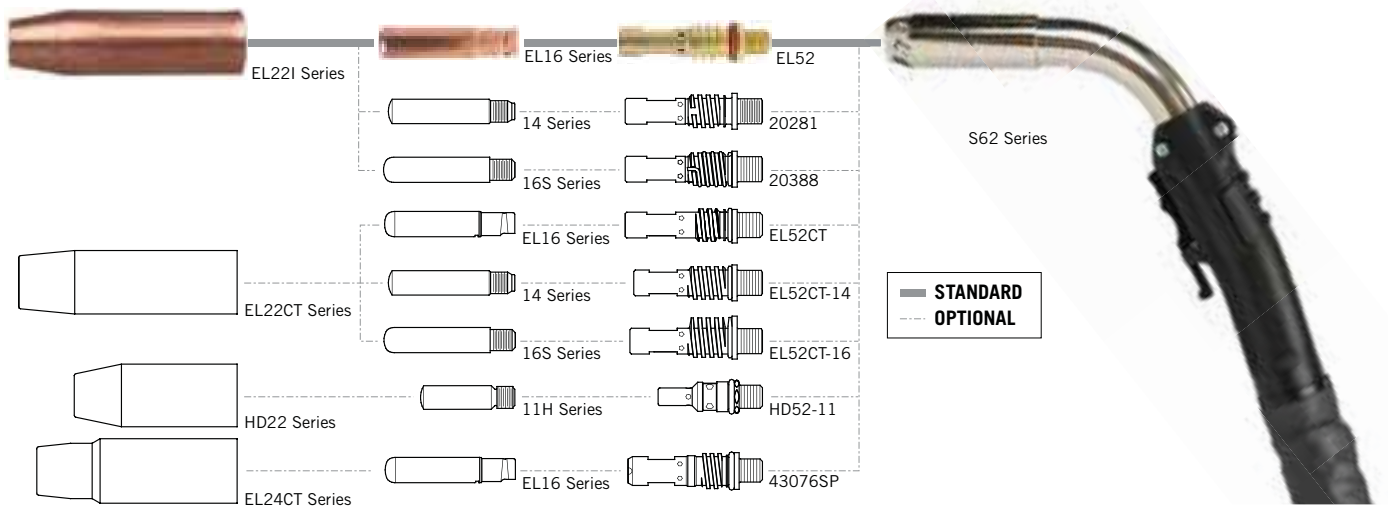
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**XS215-4045**	1026-1127

FEATURES

- **Handle Slide Valve** allows the operator to regulate vacuum on the MIG gun
- **Efficiently Removes 90% of Smoke** from the welding zone
- **Surrounding Air** is drawn over the front end consumables and conductor tube to keep cool
- **Tough Outer Jacket** made from leather protecting inner vacuum hose from weld spatter/abrasion
- **Low Bench Weight** for easy to handle MIG gun
- **Spare Trigger Leads in Cablehoz**
- **Rugged & Durable Power Cablehoz®** with proven abrasion & heat resistance
- **Outer Metal Plated Insulated Smoke Tube**
- **1-3/8" (334.9 mm) Inside Diameter PVC Reinforced Vacuum Hose**
- **Ergonomic Handle** to reduce operator fatigue
- **Extended Trigger Length** to reduce radiated heat



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

EASY FIND GUIDE
See Page 72 for Replacement Parts & Optional Accessories

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MIG/FLUX CORED | MAX OUTPUT 450 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

Smoke Master® 450 Amp Fume Extraction Air-Cooled MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide

Suitable for Medium to Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW), **Aluminum** (GMAW),

Standard Options Include:

- Rear Connector
- Standard Conductor Tube – Part No. S64-60 (Stock No. 1046-2258) on all guns up to 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**S412-116**	1046-1105
	15 ft (4.6 m)	**S415-116**	1046-1108

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**S412M-116**	1046-1125
	15 ft (4.6 m)	**S415M-116**	1046-1128

Lincoln® Style Rear Connector

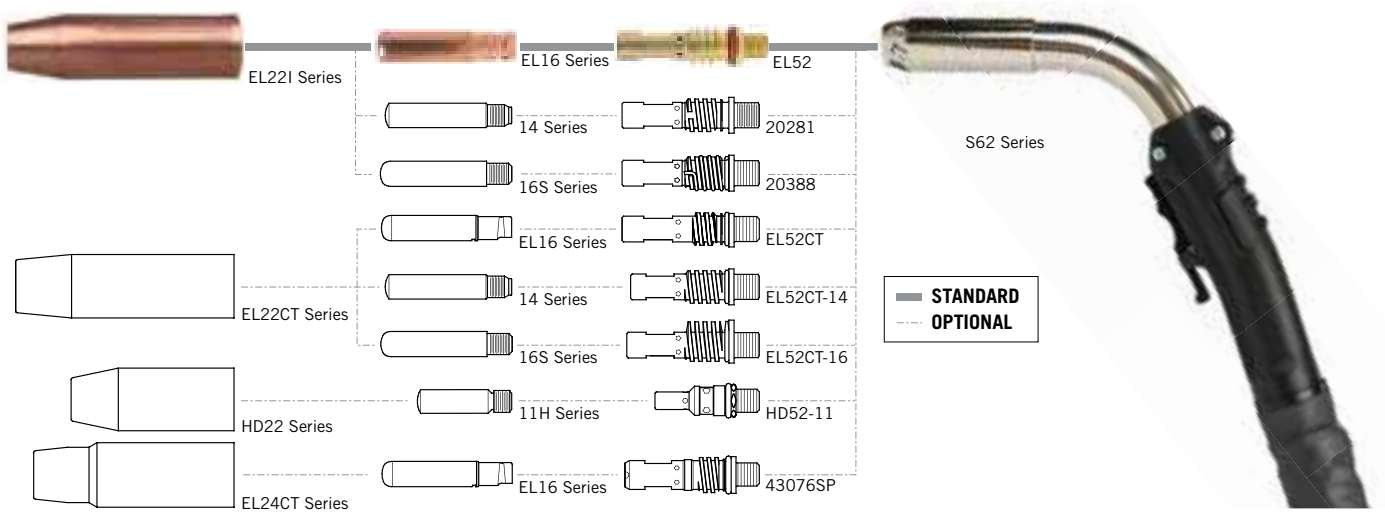
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**S415L-116**	1046-1138

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

FEATURES

- **Handle Slide Valve** allows the operator to regulate vacuum on the MIG gun
- **Efficiently Removes 90% of Smoke** from the welding zone
- **Surrounding Air** is drawn over the front end consumables and conductor tube to keep cool
- **Tough Outer Jacket** made from leather protecting inner vacuum hose from weld spatter/abrasion
- **Low Bench Weight** for easy to handle MIG gun
- **Spare Trigger Leads in Cablehoz**
- **Rugged & Durable Power Cablehoz®** with proven abrasion & heat resistance
- **Outer Metal Plated Insulated Smoke Tube**
- **1-3/8" (334.9 mm) Inside Diameter PVC Reinforced Vacuum Hose**
- **Ergonomic Handle** to reduce operator fatigue
- **Extended Trigger Length** to reduce radiated heat



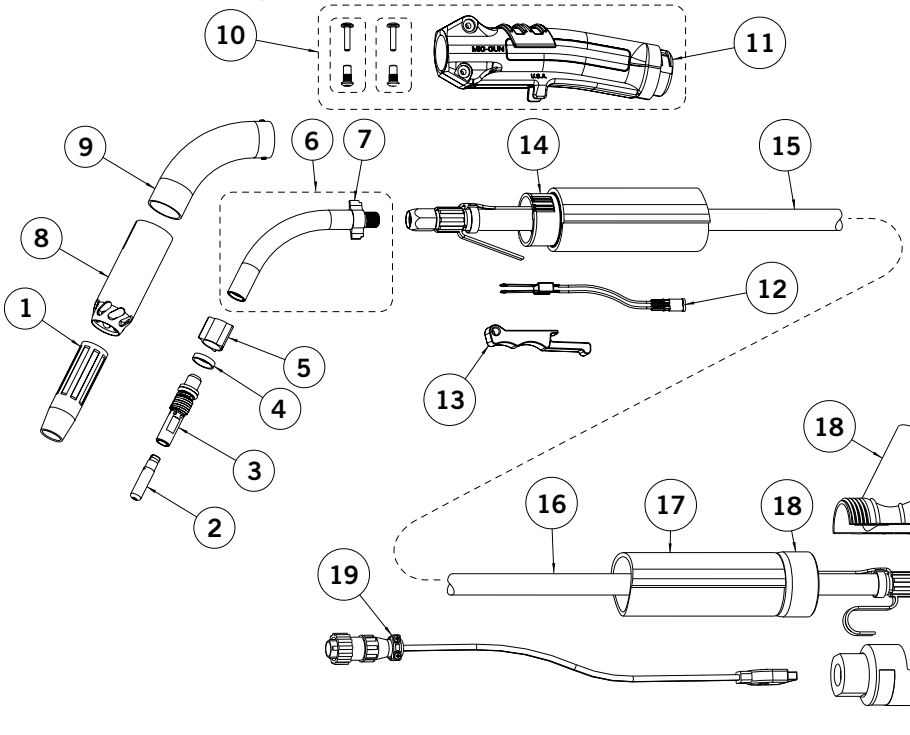
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 72 for Replacement Parts & Optional Accessories

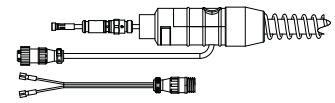
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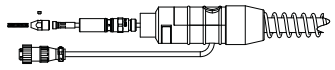
Smoke Master® Fume Extraction Air-Cooled MIG Gun Replacement Parts



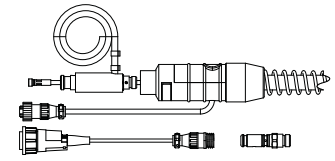
Tweco® Style Rear Connector



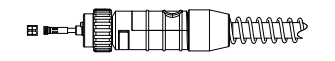
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



#	Description	250 Amp		450 Amp	
		Part No.	Stock No.	Part No.	Stock No.
1	Nozzle	EL22I Series		EL22I Series	
2	Contact Tip	EL16 Series		EL16 Series	
3	Diffuser (Slip-On)	EL52	1560-1110	EL52	1560-1110
	Diffuser (Coarse Thread)	EL52CT	1560-1109	EL52CT	1560-1109
4	Insulator Spacer	S62-60-2	2020-2013	S64-R	1046-2223
5	Smoke Tube Spacer	S62-60-2	2020-2013	S64-1	1046-2273
6	Conductor Tube (60 Degree, Standard)	S62-60	2020-2006	S64-60	1046-2258
	Conductor Tube (45 Degree, Standard)	S62-45	2020-2011	--	--
7	Handle Spacer	--	--	S64-2	1046-2271
8	Smoke Nozzle (Standard)	S22-62L	2020-2010	S24-62	1046-2225
	Smoke Nozzle (High Volume)	--	--	S24-62HV	1046-2226
9	Smoke Tube (60 Degree, Standard)	S62T-60	2020-2001	S64T-60	1046-2240
	Smoke Tube (45 Degree)	S62T-45	2020-2012	--	--
10	Handle Assembly	S82	2020-2003	S86	1046-2250
11	Handle Valve	S82-V	2020-2004	S86-V	1046-2252
12	Trigger Blade Assembly	ELC94-BL	2060-2671	ELC94-BL	2060-2671
13	Trigger	ELC94	2060-2647	EL96	2060-2605
14	Swivel Cap Assembly	S82-C	2020-2005	S86-C	1046-2254
15	Cablehoz® Assembly, 12 ft (4 m)	S212	2020-2008	S412	1046-2203
	Cablehoz Assembly, 15 ft (5 m)	S215	2020-2009	S415	1046-2206
16	Smoke Hose, 12 ft (4 m)	S412-H	1046-2214	S412-H	1046-2214
	Smoke Hose, 15 ft (5 m)	S415-H	1046-2217	S415-H	1046-2217
17	Leather Jacket, 12 ft (4 m)	SHP-12	1046-2267	SHP-12	1046-2267
	Leather Jacket, 15 ft (5 m)	SHP-15	1046-2268	SHP-15	1046-2268
18	Rear Case Assembly	M6RC	2060-2018	M6RC	2060-2018
19	Control Wire (Tweco®)	MAK-354	2642-2460	MAK-354	2642-2460
	Control Wire (Miller®)	MSAK-354	2642-2470	MSAK-354	2642-2470
	Control Wire (Lincoln®)	LAK-354	2642-2450	LAK-354	2642-2450
20	Connector Plug	Refer to Pages 90-91		Refer to Pages 92-93	
21	Conduit Assembly	Refer to Pages 122-125		Refer to Pages 124-127	

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Tweco® Smoke Collector Fume Removal System



FEATURES

- **Smoke Collector** is compatible with all Tweco Smoke Master MIG Guns
- **Efficiently Removes** welding fumes

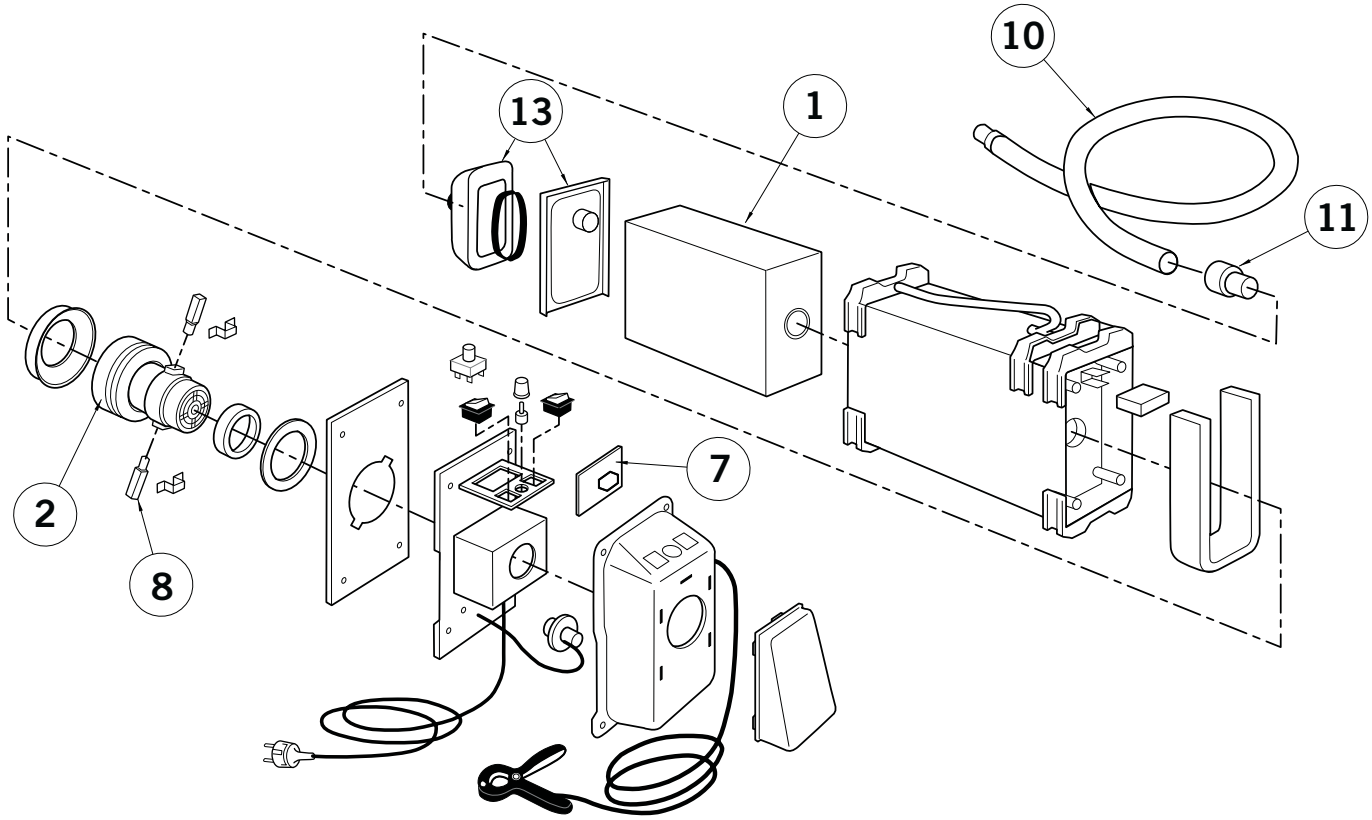
WELDING PROCESSES:
MIG (GMAW),

Standard Options Include:

- Automatic Start-Stop Function
- High-Efficiency Particle Filter
- Separately Air-Cooled Motor

Description	Part No.	Stock No.
120 Volt, 60 Hz	**TSC-96**	4500-1010

Tweco Smoke Collector Fume Removal System Replacement Parts



#	Description	Part No.	Stock No.
1	Filter - Particle	**TSC-F**	4500-2060
2	Motor 120 V	**TSC-M**	4500-2059
7	PCB, Sensor Tong & Potentiometer	**TSC580480**	4500-2088
8	Brushes Carbon - 2 pieces	**TSC-103**	4500-2078
10	Smoke Collector Hose,8 ft (2.44 m)	**TSC-H**	4500-2061
11	Hose Connector - 1.5" to 1.75" (3.81 cm to 4.45 cm)	**TSC-15**	4500-2063
13	Motor Cover	**TSC184100**	4500-2083
NS	Coarse Separator Complete	**TSC284230**	4500-2098

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG/FLUX CORED | MAX OUTPUT 350 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 3/32" (2.4 mm) | COOLED AIR | USAGE MED. DUTY

Flux Cored SEFC 350 Amp MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. 64FC-60 (Stock No. 1641-1127) on all guns up to 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	10 ft (3 m)	**SEFC350T-10**	1031-1642
	15 ft (4.6 m)	**SEFC350T-15**	1031-1643

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	10 ft (3 m)	**SEFC350-10**	1031-1632
	15 ft (4.6 m)	**SEFC350-15**	1031-1633

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 3/32" (2.4 mm)	10 ft (3 m)	**SEFC350M-10**	1031-1637
	15 ft (4.6 m)	**SEFC350M-15**	1031-1638

FEATURES

- **High Impact-Resistant One-Piece "Straight" Handle** allows the welder to locate the trigger at the bottom or top of handle
- **Metal "Paddle" Style Trigger Lever**
- **Micro-Switch Trigger Design** incorporates a button style switch for start/stop wire feed
- **Spare Trigger Leads in Cablehoz**
- **Durable & Dependable** for use with all gasless wires
- **Heavy Duty Design** for a wide variety of welding applications
- **Heavy Duty Front End Consumables**
- **Rugged & Durable Power Cablehoz** with proven abrasion & heat resistance

Flux Cored SEFC 450 Amp MIG Gun

MIG/FLUX CORED | MAX OUTPUT 450 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/8" (3.2 mm) | COOLED AIR | USAGE HEAVY DUTY



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Flux Cored** (FCAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. 66FC-60 (Stock No. 1661-1127) on all guns up to 15 ft (4.6 m)
- Conduit Liner – 44 Series

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/8" (3.2 mm)	15 ft (4.6 m)	**SEFC450T-15**	1041-1120

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/8" (3.2 mm)	15 ft (4.6 m)	**SEFC450-15**	1041-1113

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Miller® Style Rear Connector

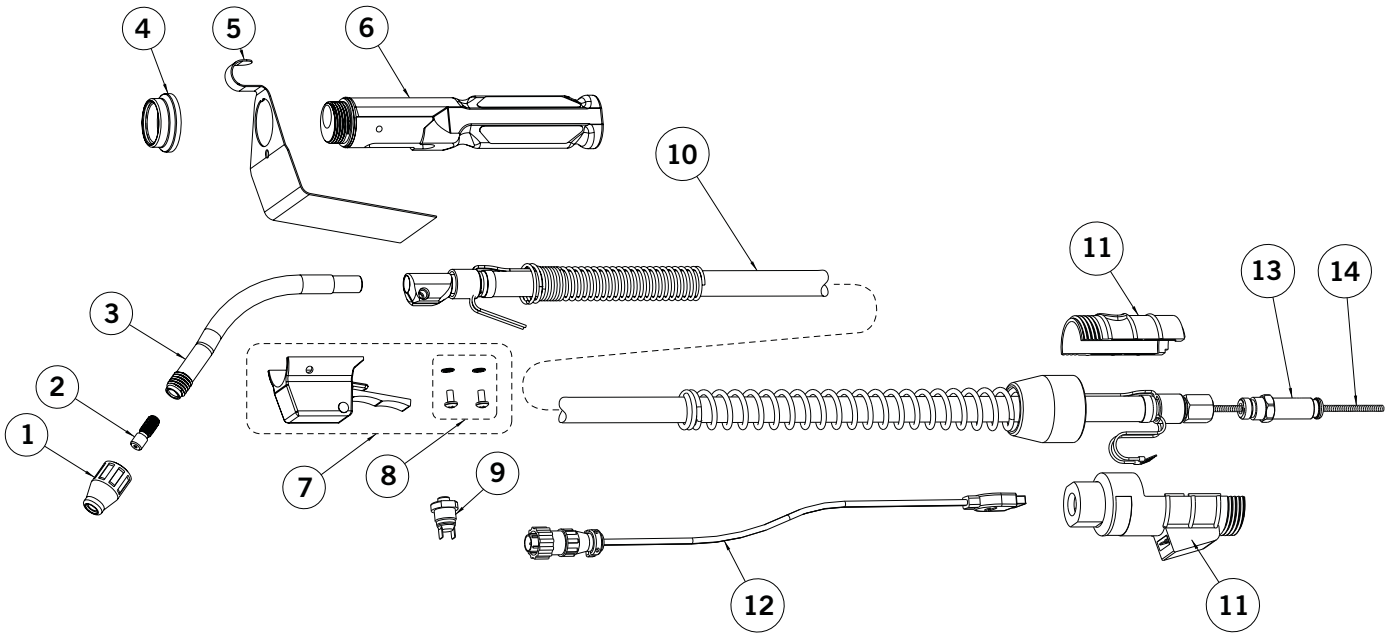
Wire Size	Length	Part No.	Stock No.
Up To 1/8" (3.2 mm)	15 ft (4.6 m)	**SEFC450M-15**	1041-1139

Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO_2 Carbon Dioxide	Up To 1/8" (3.2 mm)	Air	Heavy Duty Fabrication

EASY FIND **EASY FIND GUIDE**
See Page 75 for Replacement Parts & Optional Accessories

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Flux Cored SEFC Mig Gun Replacement Parts



#	Description	350 Amp		450 Amp	
		Part No.	Stock No.	Part No.	Stock No.
1	Insulated Guide Nozzle, 3/4" (19 mm) Stickout	**24FC-150**	1241-1027	**26FC-150**	1261-1026
	Insulated Guide Nozzle, 1-1/2" (38 mm) Stickout	**24FC-275**	1241-1026	**26FC-275**	1261-1027
	Thread Protector	**24FC-P**	1241-1025	**26FC-P**	1261-1025
2	Contact Tip, .045" (1.2 mm)	**14FC-045**	1140-1125	N/A	
	Contact Tip, .068" (1.72 mm)	**14FC-068**	1140-1126	N/A	
	Contact Tip, 5/64" (2.0 mm)	**14FC-564**	1140-1127	**16FC-564**	1160-1125
	Contact Tip, 3/32" (2.4 mm)	**14FC-332**	1140-1128	N/A	
	Contact Tip, 7/64" (2.8 mm)	N/A		**16FC-764**	1160-1127
	Contact Tip, 1/8" (3.2 mm)	N/A		**16FC-120**	1160-1128
3	Conductor Tube (60 Degree, Standard)	**64FC-60**	1641-1127	**66FC-60**	1661-1127
	Conductor Tube (45 Degree)	**64FC-45**	1641-1126	**66FC-45**	1661-1126
	Conductor Tube (180 Degree, Straight)	N/A		**66FC-180**	1661-1129
4	Heat Shield Nut	**SE86FC-R2**	2060-2065	**SE86FC-R2**	2060-2065
5	Heat Shield	**156W-HS**	2062-2157	**156W-HS**	2062-2157
6	Handle	**SE86FC-H**	2060-2063	**SE86FC-H**	2060-2063
7	Trigger Assembly	**SE96**	2060-2056	**SE96**	2060-2056
8	Trigger Housing Screw	**SE96-SW**	2060-2055	**SE96-SW**	2060-2055
9	Trigger Switch	**SE96-B**	2060-2054	**SE96-B**	2060-2054
10	Cablehoz® Assembly, 10 ft (3 m)	N/A		**SEFC450-10C**	1741-2125
	Cablehoz Assembly, 15 ft (4.6 m)	**SEFC350-15C**	1730-2043	**SEFC450-15C**	1741-2126
11	Rear Case	**M6RC**	2660-2018	**M6RC**	2660-2018
12	Control Wire (Tweco®)	**MAK-354**	2642-2460	**MAK-354**	2642-2460
	Control Wire (Miller®)	**MSAK-354**	2642-2470	**MSAK-354**	2642-2470
	Control Wire (Lincoln®)	**LAK-354**	2642-2450	**LAK-354**	2642-2450
13	Connector Plug (Tweco)	**FC350-174H**	2061-2115	**FC450-174H**	2061-2116
	Connector Plug (Miller)	**FC350-174MH**	2061-2117	**FC450-174MH**	2061-2118
	Connector Plug (Lincoln)	**173FCH**	2041-2131	**176FCH**	2041-2132
14	Conduit, 10 ft (3 m) 3/32" (2.4 mm)	**43FC-332-10**	1440-1030	N/A	
	Conduit, 15 ft (4.6 m) 3/32" (2.4 mm)	**43FC-332-15**	1440-1031	**44FC-332-15**	1440-1034
	Conduit, 10 ft (3 m) 1/8" (3.2 mm)	N/A		**44FC-18-10**	1440-1035
	Conduit, 15 ft (4.6 m) 1/8" (3.2 mm)	N/A		**44FC-18-15**	1440-1036
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150	**TCR50**	9900-1150

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Tweco® Spool Gun 160 Amp



MIG | MAX OUTPUT 160 AMPS | DUTY CYCLE 20% | WIRE SIZE UP TO .035" (0.9 mm) | COOLED AIR | USAGE LIGHT DUTY

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- 8-pin Amphenol Style Connector
- Standard Straight (180°) Conductor Tube
- Holds standard 4" (102 mm) diameter spools
- Optional 30° Rigid Conductor Tube or Knucklehead™ Flexible Conductor Tube

20% Duty Cycle - Mixed Gases

Suitable for Light Duty Fabrication.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	**SG160TA-12-3035**	1027-1390
	12 ft (3.6 m)	**SG160REB-12-3035**	1027-1397

Use on Tweco Fabricator 141i, 181i and 211i power supplies only

Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	20%	Mixed	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

EASY FIND GUIDE
See Page 77 for Replacement Parts & Optional Accessories

FEATURES

- **Ideal for a Variety of Applications** including aluminum, stainless steel and mild steel welding
- **Long Cables** allow operator to access hard to weld areas
- **Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) with quick disconnect
- **Tweco 160 Amp and 200 Amp Spool Guns** are designed to work with Tweco new inverter technology on the Fabricator® series of welding systems
- **Comfortable Pistol-Grip Handle Design** with outer spool tension control for ease of operation
- **Tweco 200 Amp Spool Guns** include **3-turn Potentiometer** for fine wire feed speed control
- **Tweco 200 Amp Spool Guns** adapt to most welding machines with the use of **ESG-1 Control Box**
- **ESG-1 Control Box** provides the gas solenoid with pre/post purge control and run-in control for arc starting (See page 60 for ordering information)

Tweco® Spool Gun 200 Amp



MIG | MAX OUTPUT 200 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- 10-pin Amphenol Style Connector
- Standard Straight (180°) Conductor Tube
- Holds standard 4" (102 mm) diameter spools
- Optional 30° Rigid Conductor Tube or Knucklehead™ Flexible Conductor Tube

60% Duty Cycle - Mixed Gases

Suitable for Medium Duty Fabrication.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**SG200REB-12-3545**	1027-1398
	25 ft (7.6 m)	**SG200REB-25-3545**	1027-1399
	25 ft (7.6 m)	**SG200-25-3545**	1027-1392
	25 ft (7.6 m)	**SG200TA-25-3545***	1027-1391

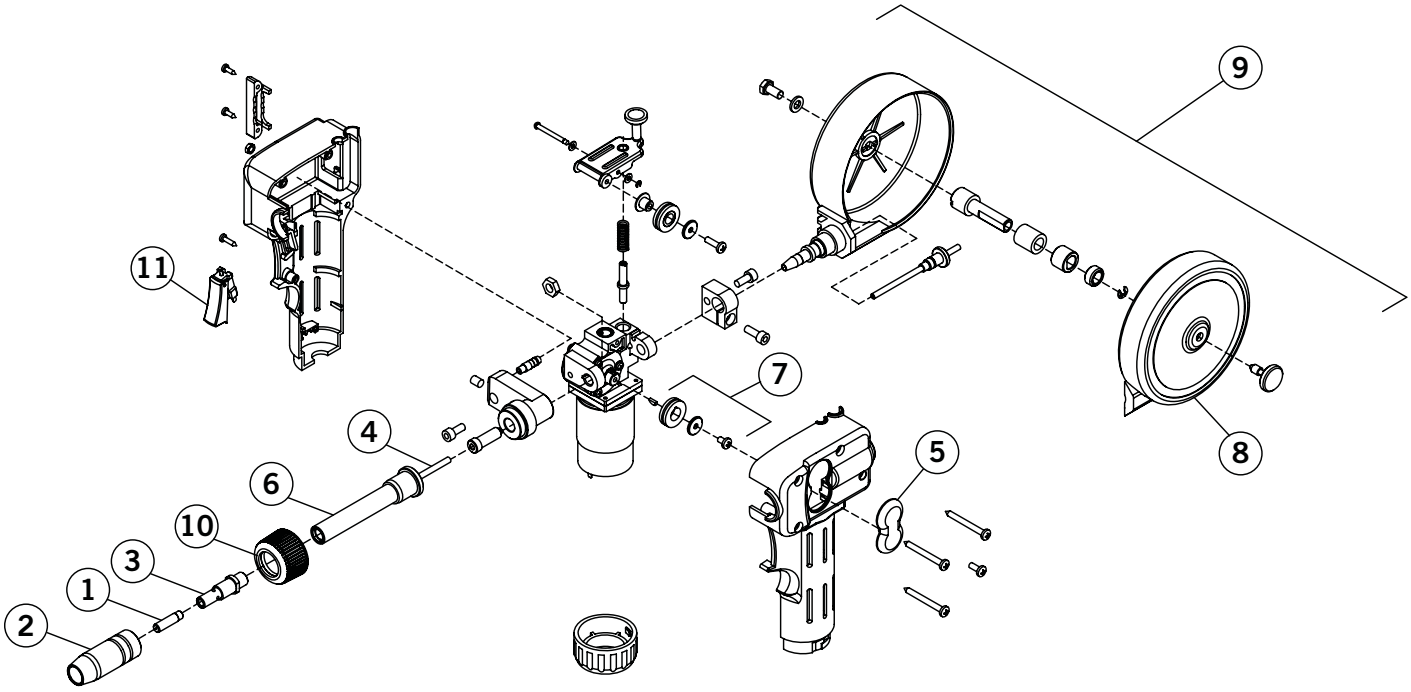
**Use on Tweco Fabricator 220i and 252i power supplies only*

Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

EASY FIND GUIDE
See Page 77 for Replacement Parts & Optional Accessories

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Tweco® Spool Gun 160 & 250 Amp Replacement Parts



#	Description	Part No.	Stock No.
1	Contact Tip .023 (0.6 mm)	**11-23**	1110-1100
	Contact Tip .030 (10.8 mm)	**11-30**	1110-1101
	Contact Tip .035 (10.9 mm)	**11-35**	1110-1102
2	Nozzle 3/8" (9.5 mm)	**21T-37**	1210-1300
	Nozzle 3/8" (9.5 mm)	**21-37**	1210-1100
	Nozzle 1/2" (12.7 mm)	**21-50**	1210-1110
	Nozzle 1/2" (12.7 mm)	**21-50F**	1210-1112
	Nozzle 5/8" (15.9 mm)	**21-62**	1210-1120
3	Gas Diffuser	**51**	1510-1101
4	Conduit	**SPG66065**	2031-2107
5	Drive Roll Cover	**WSPDRC**	2031-2227
6	Conductor Tube	**WSP62180**	2031-2225

#	Description	Part No.	Stock No.
7	.023 Drive Roll - V-Shaped	**WSPDRV023**	2031-2228
	.023 Guide Roll - V-Shaped	**WSPGRV023**	2031-2234
	.030 & .035 Drive Roll - V-Shaped	**WSPDRV030035**	2031-2257
	.030 & .035 Guide Roll - V-Shaped	**WSPGRV030035**	2031-2258
	.045 Drive Roll - V-Shaped	**WSPDRV047**	2031-2230
	.045 Guide Roll - V-Shaped	**WSPGRV047**	2031-2236
	.023 Drive Roll - U-Shaped	**WSPDRU023**	2031-2250
	.030 & .035 Guide Roll - U-Shaped	**WSPDRU030035**	2031-2252
	.045 Drive Roll - U-Shaped	**WSPDRU047**	2031-2254
	Smooth Guide Roll (for use with U-Shaped Drive Rolls, not grooved)	**WSPGR**	2031-2256
8	Spool Case Cover	**WSPSCC**	2031-2233
9	Complete Spool Case	**WSPSC**	2031-2232
10	Conductor Tube Nut	**WSP62N**	2031-2226
11	Trigger Assembly	**WSP92**	2031-2231
NS	Replacement Motor	**WSPMOTOR**	2031-2237
NS	Key Stock for Drive Roll	**WSPKEY**	2031-2239

Control Wire Jumper Cords

Use with Tweco Spool Gun 200 Amp - Part No. SG200-25-3545 (Stock No. 1027-1392)

Manufacturer	Machine	Part No.	Stock No.
Miller®	Millermatic® 210	**WSPMILL4PJC2**	2031-2246
Miller	Millermatic 212	**WSPMILL4PJC**	2031-2245
Lincoln®	Power MIG® 255C	**WSPLIN7PJC**	2031-2247
Hobart®	Ironman™ 210, 250	**WSPMILL4PJC**	2031-2245
ESAB®	MigMaster® 203	**WSPESAB7PJC**	2031-2248
ESAB	MigMaster 253	**WSPESAB7PJC**	2031-2248
ESAB	MigMaster 250	**WSPESAB7PJC**	2031-2248

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International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 300 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE MED. DUTY

Tweco® Spool Gun 300 Amp



60% Duty Cycle - Mixed Gases
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Standard Conductor Tube – Part No. PMP64EL-180 (Stock No. 1642-1140)
- Requires the use of the ESG-1 (Stock No. 1028-1295) Control Box for most welding machines

FEATURES

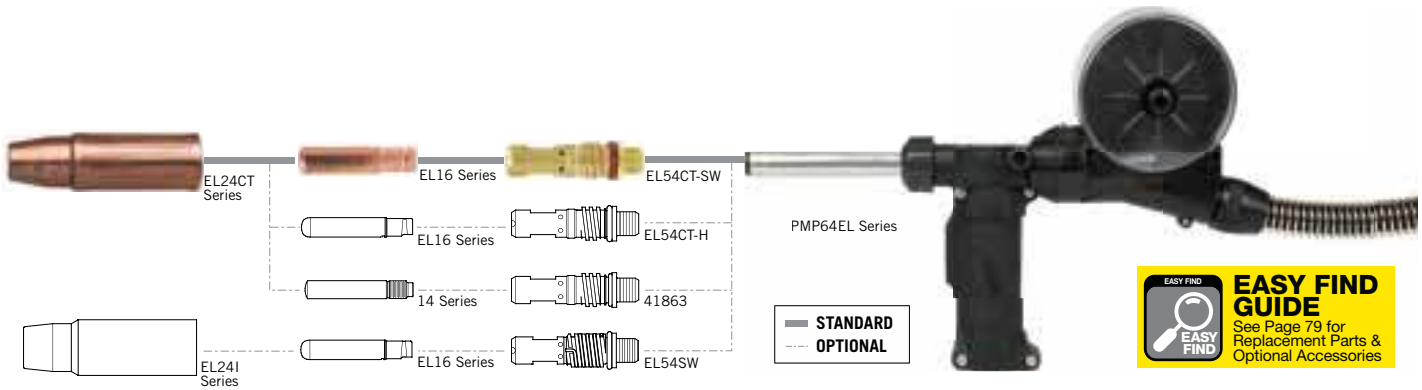
- **Tweco 300 Amp Spool Guns** are designed to work with Tweco new inverter technology on the ArcMaster® MST series of welding systems
- **Ideal for a Variety of Applications** including aluminum, stainless steel and mild steel welding
- **Tweco 300 Amp Spool Guns** adapt to most welding machines with the use of **ESG-1 Control Box** that provides the gas solenoid with pre/post purge control and run-in control for arc starting
- **Comfortable Pistol-Grip Handle Design** with outer spool tension control for ease of operation
- **Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) with quick disconnect
- **Tweco® 300 Amp Spool Guns** include **3-turn Potentiometer** for fine wire feed speed control

RATED OUTPUT			WIRE SIZE	COOLED	APPLICATION USAGE
AMPS	DUTY CYCLE	GAS			
300 Amps	60%	Mixed	Up To 1/16" (1.6 mm)	Air	Medium Duty Fabrication

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	25 ft (7.6 m)	**SSG225-3545**	1027-1370
	50 ft (15.2 m)	**SSG250-3545**	1027-1371
	100 ft (30.5 m)	**SSG2100-3545**	1027-1372

When using the 300 Amp Spool Gun with Tweco® ArcMaster® MST Series machines, use Tweco SGI100 Spool Gun Interface Box, Part No. W4009115



EASY FIND GUIDE
See Page 79 for Replacement Parts & Optional Accessories

Tweco® ESG-1 Control Box



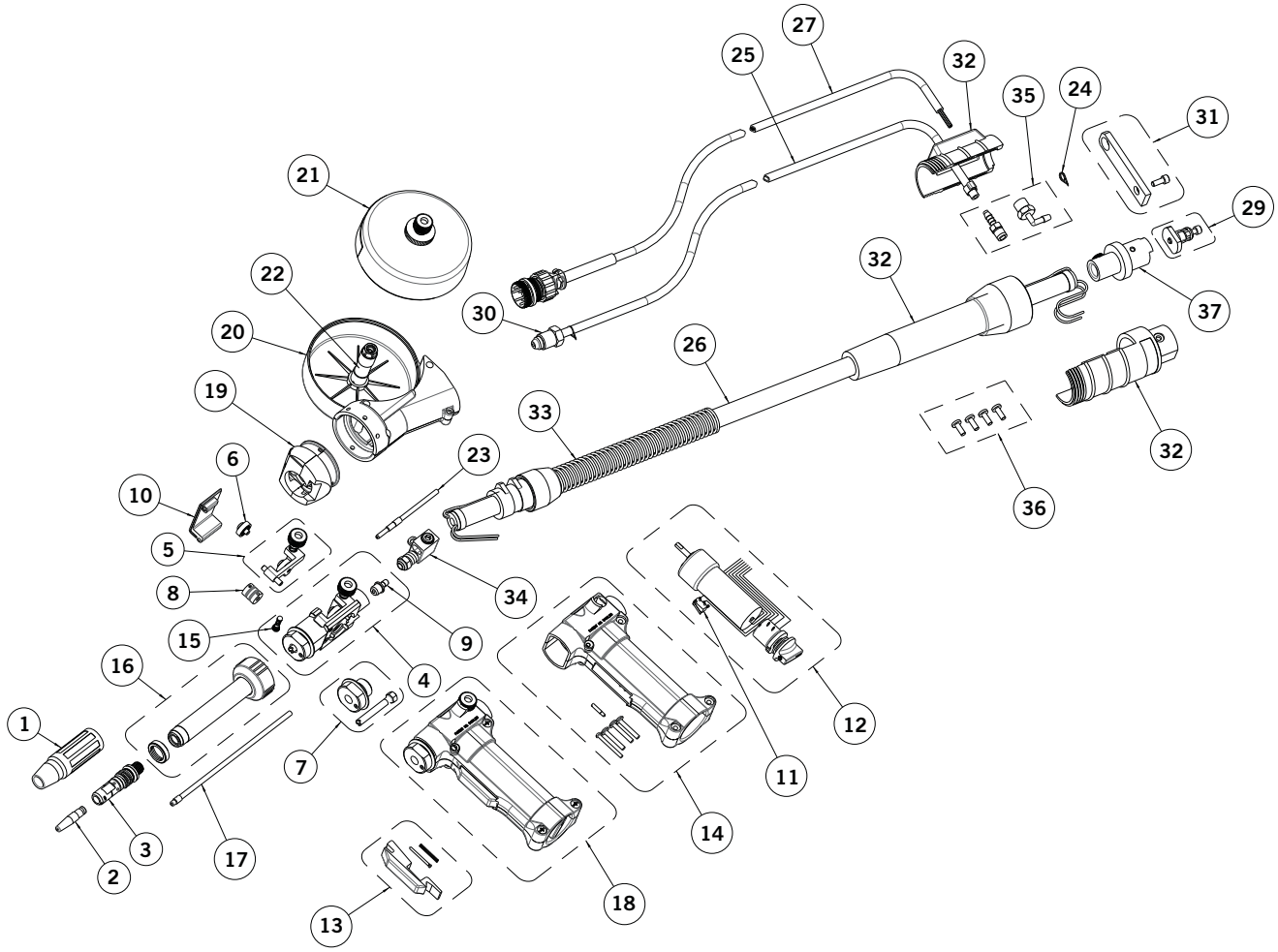
Part No. ESG-1
(Stock No. 1028-1295)

115 Volt, Single Phase, 60 Hz
used with Eliminator Spool Guns

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Standard Power Cord 6 ft (2 m)
- Requires Jumper Cord, Part No. SSG300-106JC (Stock No. 2031-2150)

Tweco® Spool Gun 300 Amp Replacement Parts



#	Description	Part No.	Stock No.
1	Nozzle	**EL24CT Series**	
2	Contact Tip	**EL16 Series**	
3	Diffuser	**EL54CT-SW**	
4	Head Block Assembly	**SPG103**	2031-2100
5	Pressure Arm Assembly	**SPG103-1**	2060-1727
6	Idler Bearing Assembly	**--**	--
7	Adapter Nut & Wire Guide	**EPG66-N**	2031-2096
8	Drive Roll 0.030" (0.8 mm)	**EPG103-2-08**	2031-2091
	Drive Roll 0.035" (0.9 mm)	**EPG103-2-09**	2031-2077
	Drive Roll 0.040" (1.0 mm)	**EPG103-2-10**	2031-2023
	Drive Roll 3/64" (1.2 mm) Standard	**EPG103-2-12**	2031-2003
	Drive Roll 1/16" (1.6 mm)	**EPG103-2-16**	2031-2022
9	Gas Nipple & Wire Tie	**--**	--
10	Handle Cover Assembly	**EPG86-2**	2031-2013
11	Trigger Switch	**ESG90**	2025-2399
12	Motor Assembly (24VAC)	**SSGM24**	2031-2101
13	Trigger Lever	**SPG-96TL**	2060-2733
14	Handle Sub-Assembly	**SSG86**	2060-2739
15	Poppet Valve Assembly	**PMP-PV**	2060-2737
16	Conductor Tube 30 Degree	**PMP64EL30**	1642-1141
	Conductor Tube 180 Degree	**PMP64EL180**	1642-1140
	Flexible Conductor Tube	**PMP64SFLX360**	1642-1142

#	Description	Part No.	Stock No.
17	Jump Liner	**PMP44PTF116**	1644-1096
	Jump Liner Teflon	**PMP-44FLX-116**	1644-1095
	Jump Liner Copper	**PMP-44-116**	1644-1097
18	Spool Gun Assembly w/o Cable & Support	**SSG300G**	2031-2117
19	Pivot Assembly	**ESG186**	2025-2397
20	Spool Canister Assembly	**ESG186S**	2025-1392
21	Spool Cover Assembly	**ESG186C**	2025-2393
22	Friction Tube Replacement (5 PC)	**ESG186S-3**	2025-2385
23	Conduit Assembly	**--**	--
24	Wire Tie	**BG-53N04**	8040-1998
25	Gas Hose Assembly F/SSG Spool Gun	**SSG3003GH**	2060-2741
26	Extruded Spool Gun Cablehoz, 25 ft (8 m) Long	**SSG30025**	2060-2742
27	10 Pin Control Cable Assembly F/SSG Spool Gun	**SSG300CW**	2060-2744
28	Hex Wrench Set	**--**	--
29	25 mm Dinse Connector	**SSG-DINS25**	2035-2186
30	Rear Gas Nipple	**EPG-RGN**	2031-2083
31	Straight Lug	**ESG-172SL**	2031-2110
32	Rear Case Sub-Assembly	**SSGT6RC**	2031-2111
33	Front Strain Relief Assembly	**SPG146R**	2031-2112
34	Cable Connector Assembly	**SPG102**	2031-2113
35	Hose Barb Connector	**ESG6RCUGN**	2031-2114
36	10-24 X 1/2" BH Plastic Screw	**SSG172PS**	2031-2115
37	Rear Power Connector	**ESG172**	2031-2116
NS	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 300 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE HEAVY DUTY

PullMaster™ 300 Amp MIG Gun



Tweco PullMaster Standard MIG Gun

Tweco PullMaster Smart MIG Gun with digital display

60% Duty Cycle - Mixed Gases

Suitable for Light - Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:

- Rear Connector
- Standard without "Smart" capability, Available with Smart Capability
- Standard Conductor Tube – Part No. PMP64EL-180 (Stock No. 1642-1140)
- Available with Optional 30° Rigid or Knucklehead™ Flexible Conductor Tube

EASY FIND **EASY FIND GUIDE**
See Page 81 for Replacement Parts & Optional Accessories

FEATURES

- **"Smart" Capability** with digital display and one-touch controls to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim
- **Comfortable Pistol-Grip Handle Design** for ease of operation
- **Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) with quick disconnect
- **Incorporates the Cablehoz®** used on other Tweco MIG guns
- **Improved Performance** with longer-life consumables
- **Heavy Duty Contact Tip and Diffuser** to act as "heat sink" in high heat applications

Standard Gun *PulseMaster MIG Guns are Standard without "Smart" Capability.*

Tweco® Style Rear Connector

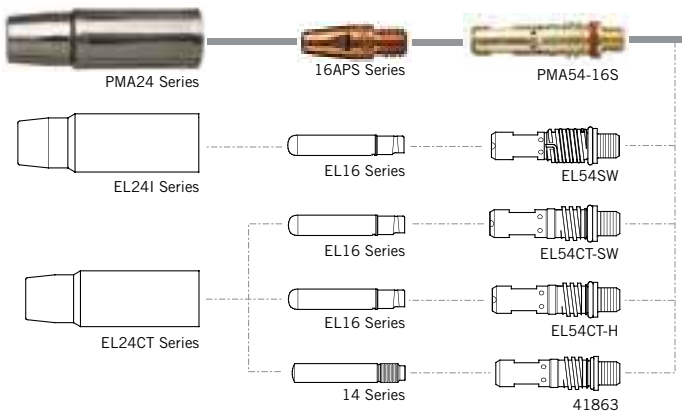
Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	33 ft (10.1 m)	**PMP333-3545**	1027-1401
	50 ft (15.2 m)	**PMP350-3545**	1027-1402

Smart Gun *PullMaster Smart MIG Guns are used only with Tweco® PowerMaster SP machines and are available with "Smart" Capability.*

Tweco Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	33 ft (10.1 m)	**PMPS333-3545**	1027-1407
	50 ft (15.2 m)	**PMPS350-3545**	1027-1408





Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

Tweco® EPG-CR2 Control Box



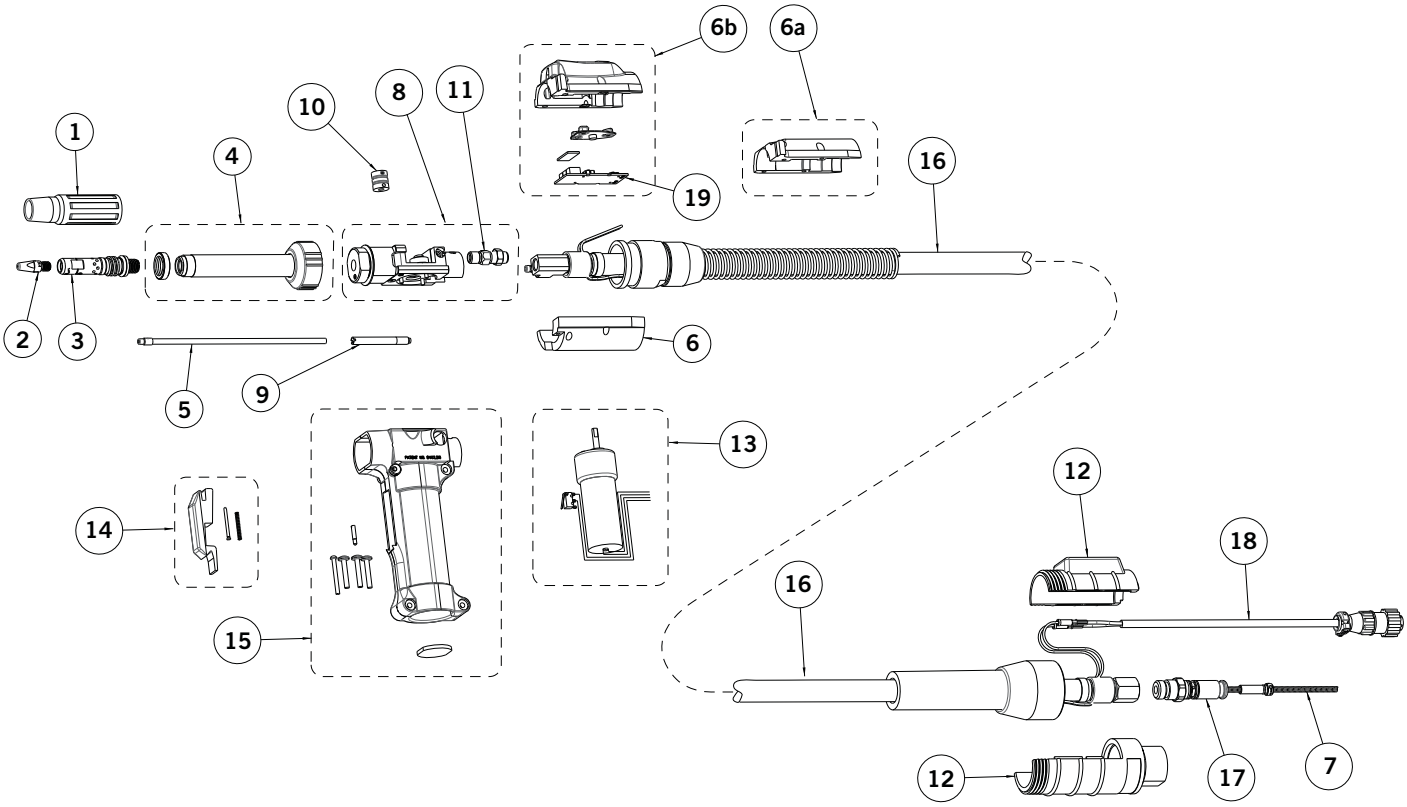
Part No. EPG-CR2
(Stock No. 1028-1291)
Used to connect standard PullMaster to most welding machines.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:

- Standard Power Cord 6 ft (2 m)
- Requires Jumper Cord - Part No. PMP354T (Stock No. 2031-2145)

PullMaster™ 300 Amp MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Nozzle	**PMA24 Series**	
2	Contact Tip	**16APS Series**	
3	Diffuser	**PMA54-16S**	1543-1106
4	Conductor Tube	**PMP64EL Series**	
5	Teflon Jump Liner, Flex Tube	**PMP-44FLX-116**	1644-1095
	Teflon Jump Liner, Rigid Tubes	**PMP-44PTF-116**	1644-1096
	Bronze Jump Liner for Steel Wires, Rigid Tubes	**PMP-44-116**	1644-1097
6a	Support Assembly Front (Std.)	**EPG186**	2031-2046
6b	Support Assembly Front (Including Smart Cover, PCB Membrane, Lens & Lower Support)	**PMPS186**	2060-2725
7	33 ft (10 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Wire	**PMP 44-116-33**	1441-1125
	50 ft (15 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Wire	**PMP 44-116-50**	1441-1126
	33 ft (10 m) Conduit Assembly, .035" - .045" (0.9 mm - 1.1 mm) Wire	**PMP 44-3545-33**	1441-1127
	33 ft (10 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Steel Wire	**PMPS 44-116-33**	1441-1129
	33 ft (10 m) Conduit Assembly, .035" - .045" (0.9 mm - 1.1 mm) Steel Wire	**PMPS 44-3545-33**	1441-1131
8	Head Block Assembly	**PMP103**	2060-1726
NS	Pressure Arm Assembly	**SPG103-1**	2060-1727
9	Front Wire Guide Assembly	**PMPS-106TA**	2060-1729

#	Description	Part No.	Stock No.
10	Drive Roll .030" (0.8 mm) Wire	**EPG103-2-0.8**	2031-2091
	Drive Roll .035" (0.9 mm) Wire	**EPG103-2-0.9**	2031-2077
	Drive Roll .040" (1.0 mm) Wire	**EPG103-2-1.0**	2031-2023
	Drive Roll 3/64" (1.2 mm) Wire	**EPG103-2-1.2**	2031-2003
	Drive Roll 1/16" (1.6 mm) Wire	**EPG103-2-1.6**	2031-2022
	Drive Roll V-Groove 1/16" (1.6 mm) Steel Wire	**EPG103-2-1.6V**	2031-2134
	Drive Roll V-Groove 3/64" (1.2 mm) Steel Wire	**EPG103-2-1.2V**	2031-2135
	Drive Roll V-Groove .035" (0.9 mm) Steel Wire	**EPG103-2-0.9V**	2031-2136
11	Power Cable Connector Assembly	**--**	--
NS	Handle Cover Assembly	**EPG86-2**	2031-2013
12	Rear Case Assembly	**PMP-T6RC**	2060-2731
13	Motor Assembly (24VDC)	**PMP-M24**	2060-2732
14	Trigger Lever	**SPG-96TL**	2060-2733
15	Handle Assembly	**SPG86**	2060-2734
16	Cablehoz® Assembly 33 ft (10 m) Standard	**PMP300-33**	2060-2750
	Cablehoz Assembly 50 ft (15 m) Standard	**PMP300-50**	2060-2751
17	Connector Plug	**Refer to Pages 92-93**	
18	Control Wire (Standard)	**MS354-DSM**	2060-2140
19	Replacement PCB	**PM85-PCB**	2060-2738
NS	Hose Clamp (Package of 5)	**BG-53N04**	2031-2088
	Poppet Valve Assembly	**PMP-PV**	2060-2737
	Miller® Control Wire	**EPG354M**	2031-2086
	EPG-CR2 Jumper Wire	**PMP354T**	2031-2145
	Protective Cable Wrap, 50 ft (15 m) per box	**TCR50**	9900-1150

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Water-Cooled MIG Gun Series

Features & Benefits

- **Heavy Duty Design** for industrial application environments
- **Ergonomic Handle** for operator comfort and appeal
- **Low Bench Weight** for easy to handle gun reduces operator fatigue
- **Increased Interface** between contact tip & gas diffuser improves performance and electrical conductivity
- **Provides Cooling Benefits** for the front end consumables for maximum efficiency and comfort
- **Heavy Duty Contact Tip and Diffuser** to act as "heat sink" in high heat applications
- **Improved Performance** with longer-life front end consumables
- **Operates @ 100% Duty Cycle** at high amperage applications

		PulseMaster 400 Amp	**PulseMaster** 500 Amp	**Supra** 450 Amp	**Standard** 600 Amp
Applications		Light-Medium Duty Fabrication	Heavy Duty Fabrication	Medium-Heavy Duty Fabrication	Medium-Heavy Duty Fabrication
Standard Options	**Rear Connector**	■	■	■	■
	Standard without "Smart" Capability	■	■		
	"Smart" Capability	■	■		
Output Current		400 Amps	500 Amps	450 Amps	600 Amps
Duty Cycle - Mixed Gases		100%	100%	100%	100%
Wire Diameter		Up to .045" (1.2 mm)	Up to .045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 3/32" (2.4 mm)
Process	**MIG**	■	■	■	■
	Aluminum	■	■	■	■



PulseMaster™ 500 Amp
Water-Cooled Smart MIG Gun



Supra® 450 Amp
Water-Cooled MIG Gun



Standard 600 Amp
Water-Cooled MIG Gun

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 400 AMPS | DUTY CYCLE 100% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED WATER | USAGE HEAVY DUTY

PulseMaster™ 400 Amp Water-Cooled MIG Gun



100% Duty Cycle - Mixed Gases
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard without "Smart" Capability but available with "Smart" Capability
- Standard Conductor Tube – Part No. PMP64EL-180 (Stock No. 1642-1140);
- Conduit Liner – 44 Series

FEATURES

- **"Smart" Capability** with digital display and one-touch, on-the-fly controls to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim
- **Heavy Duty Design** for industrial application environments and long-lasting durability
- **Heavy Duty Cablehoz®** designed for pulse welding demands with smooth feed performance to reduce "bird nesting" and provide excellent flexibility for better current capacity
- **Ergonomic Impact-Resistant Handle** to reduce operator fatigue
- **Blade-Style Trigger Design** performs over 2 million cycles without failure
- **Multiple-Position Conductor Tube** for quick tool-free change, rotation and lower heat in the front end
- **Increased Interface** between contact tip & gas diffuser improves electrical conductivity
- **Heavy Duty Contact Tip and Diffuser** to act as "heat sink" in high heat applications

Smart Gun

PulseMaster Smart MIG Guns are used only with Tweco® PowerMaster SP machines and are available with "Smart" Capability.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMWS412-3545**	1042-1510
	15 ft (4.6 m)	**PMWS415-3545**	1042-1511

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMWS412X-3545**	1042-1515

Standard Gun

PulseMaster MIG Guns are Standard without "Smart" Capability.

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW412-3545**	1042-1500
	15 ft (4.6 m)	**PMW415-3545**	1042-1501

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**PMW415M-3545**	1042-1502

Lincoln® Style Rear Connector

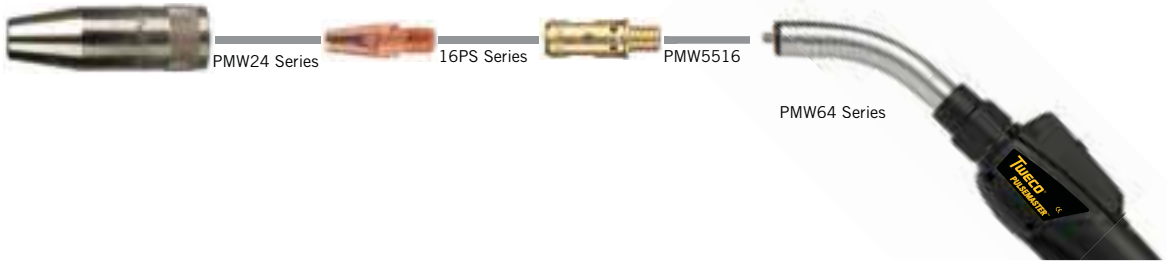
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW412L-3545**	1042-1503

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW412X-3545**	1042-1505
	15 ft (4.6 m)	**PMW415X-3545**	1042-1506



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	100%	Mixed	Up To .045" (1.2 mm)	Water	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 86 for Replacement Parts & Optional Accessories

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MIG | MAX OUTPUT 500 AMPS | DUTY CYCLE 100% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED WATER | USAGE HEAVY DUTY

PulseMaster™ 500 Amp Water-Cooled MIG Gun



100% Duty Cycle - Mixed Gases
Suitable for Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard without "Smart" Capability but available with "Smart" Capability
- Standard Conductor Tube – Part No. PMP64EL-180 (Stock No. 1642-1140)
- Conduit Liner – 44 Series

FEATURES

- **"Smart" Capability** with digital display and one-touch, on-the-fly controls to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim
- **Heavy Duty Design** for industrial application environments and long-lasting durability
- **Heavy Duty Cablehoz®** designed for pulse welding demands with smooth feed performance to reduce "bird nesting" and provide excellent flexibility for better current capacity
- **Improved Performance** with longer-life consumables
- **Twin-Pulse Mode** for the perfect weld bead
- **Multiple-Position Conductor Tube** for quick tool-free change, rotation and lower heat in the front end
- **Increased Interface** between contact tip & gas diffuser improves electrical conductivity

Smart Gun

PulseMaster Smart MIG Guns are used only with Tweco® PowerMaster SP machines and are available with "Smart" Capability.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMWS512-3545**	1042-1535

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMWS512X-3545**	1042-1540

Standard Gun

PulseMaster MIG Guns are Standard without "Smart" Capability.

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW512-3545**	1042-1525
	15 ft (4.6 m)	**PMW515-3545**	1042-1526

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW512M-3545**	1042-1527

Lincoln® Style Rear Connector

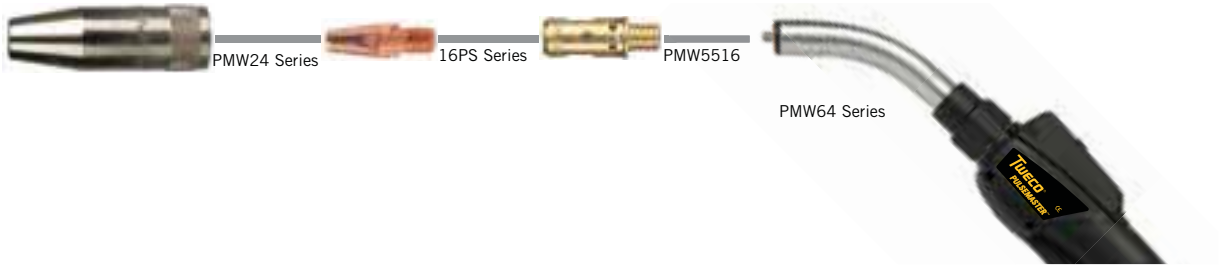
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW512L-3545**	1042-1528

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**PMW512X-3545**	1042-1530
	15 ft (4.6 m)	**PMW515X-3545**	1042-1531



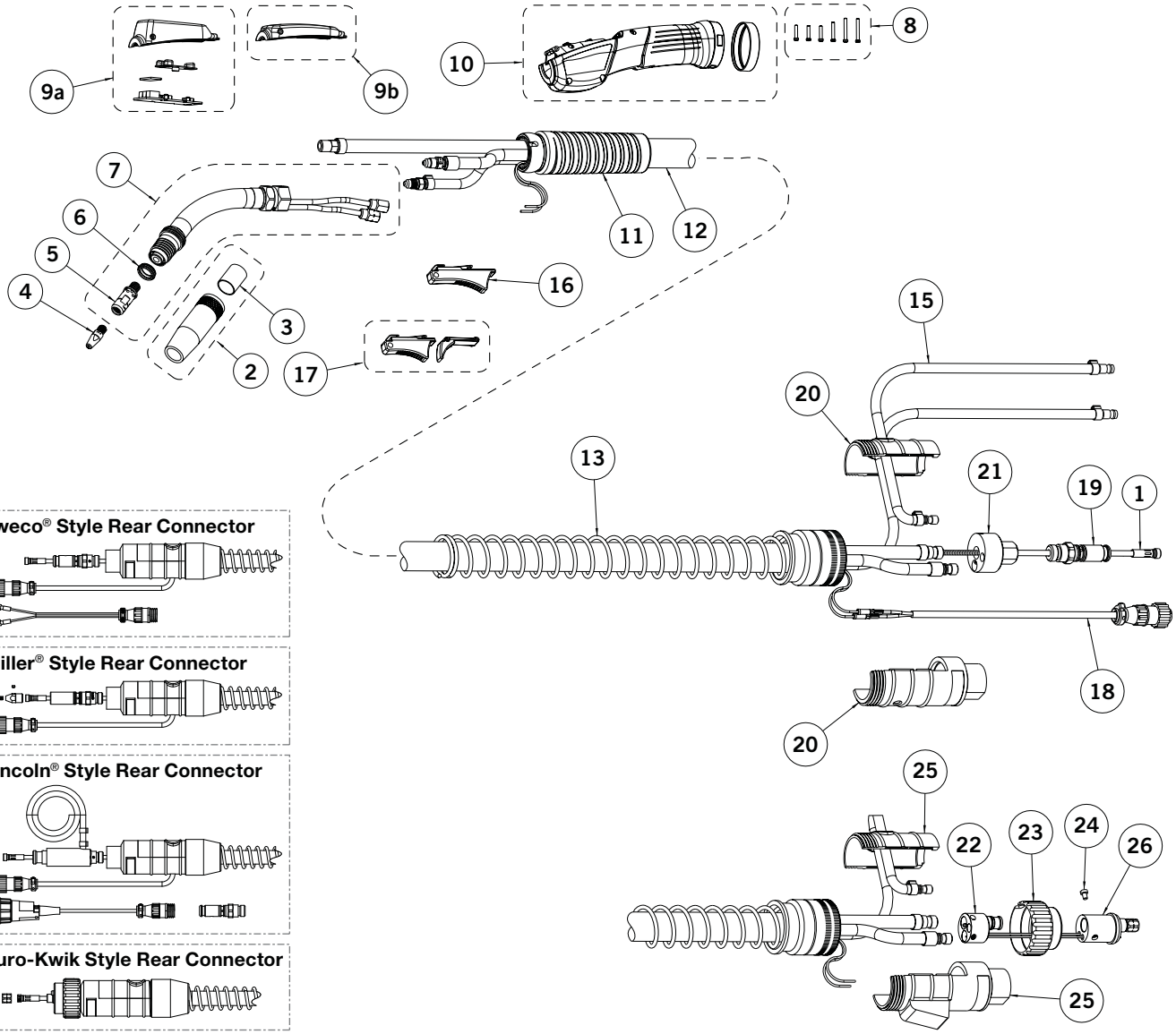
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	100%	Mixed	Up To .045" (1.2 mm)	Water	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 86 for Replacement Parts & Optional Accessories

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PulseMaster™ Water-Cooled MIG Gun
Replacement Parts



Tweco® Style Rear Connector

Miller® Style Rear Connector

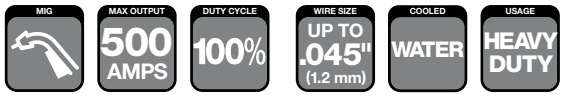
Lincoln® Style Rear Connector

Euro-Kwik Style Rear Connector

#	Description	Part No.	Stock No.
1	Conduit Assembly	**Refer to Pages 124-127**	
2	Nozzle	**PMW24 Series**	
3	Nozzle Insulator / Spatter Shield	**WC23-1**	1230-1084
4	Contact Tip	**16PS Series**	
5	Gas Diffuser used w/16P & 16PS Series Contact Tips	**PMW5516**	1550-1105
6	Pressure Ring	**PMW64-3**	1644-2900
7	Conductor Tube	**PMW64 Series**	
8	Handle Screws w/ T9 Star Head (12 mm, 16 mm, & 20 mm LG)	**PMHSK**	2060-2705
9a	Handle Housing w/ Smart Control Assembly	**PM84-PCB-HK**	2060-2706
9b	Handle Housing (Blank)	**PM84-H**	2060-2707
10	Large Handle Assembly w/ Retaining Ring	**PM84**	2060-2708
	Small Handle Assembly w/ Retaining Ring	**PM83**	2060-2715
11	Front Cable Support	**PMW-SPS**	2060-2720

#	Description	Part No.	Stock No.
12	12 ft (3.6 m) Cable and Hose Assembly	**PMW512**	2060-2721
13	Strain Relief Spring	**QR-SPR**	3045-1177
14	Strain Relief Cap	**QR-RC**	3045-1238
15	Water Hose Assembly	**--**	--
16	Trigger	**PM94**	2060-2712
17	Trigger & Guard Assembly	**--**	-
18	Control Wire Plug	**MS354-DSM**	2060-2140
19	Heavy Duty Connector Plug Assembly	**350-174H**	2035-2110
20	Rear Case	**--**	--
21	Rear Connector Block (Direct Plug)	**WC6-170H**	2064-2171
22	Rear Connector Block (Euro)	**WC174X-B**	2044-2182
23	Euro-Kwik Connector Nut	**174X-2**	2040-2177
24	Euro-Kwik Connector Screw	**4M-S**	2011-2004
25	Euro-Kwik Rear Case	**X6RC**	2060-2006
26	Euro-Kwik Connector Assembly	**WC174X**	2044-2181

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Tweco® TC900 & TCV900 Water Coolers



Tweco TCV900 Water Cooler

Tweco TC900 Water Cooler

FEATURES

- **Designed for MIG Guns & TIG Torches** up to 500 Amps
- **12,000 BTU @ 75 degree differential** between ambient and return water temperature
- **1 GPM @ 50 psi** (Gear Pump)
- **Stainless Steel Construction** eliminates coolant contamination due to electrolyte and chemical reactions
- **High Efficiency Radiator Design** pulls outside air through radiator
- **Vertical Model** has molded seamless plastic water tank; virtually eliminates leakage
- **Pump Bypass** to tank on rotary gear pump - keeps pump from overheating
- **Vane Pumps** are equipped with a bypass to eliminate excessive pump wear

WELDING PROCESSES:
MIG (GMAW), **TIG** (GTAW)

Standard Options Include:

- Stainless Steel Construction
- 2 Gallon Reservoir
- Vertical or Horizontal Models Available
- Available options include either Gear Pump or Vane Pump

TC900 Water Cooler

Description	Part No.	Stock No.
Cooler w/ Gear Pump 110V - 50/60 Hz	**TC900-G**	4010-1010
Cooler w/ Vane Pump 110V - 50/60 Hz	**TC900-V**	4010-1011

TCV900 Water Cooler

Description	Part No.	Stock No.
Cooler w/ Gear Pump 110V - 50/60 Hz	**TCV900-G**	4010-1035
Cooler w/ Vane Pump 110V - 50/60 Hz	**TCV900-V**	4010-1036

Rated Output			Wire Size	Cooled	Application Usage
Amps	Gear Pump	Temperature			
500 Amps	1 GPM @ 50 psi	12,000 BTU @ 75° differential	2 Gal. (7.6 L)	Water	Heavy Duty Fabrication

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 450 AMPS | DUTY CYCLE 100% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED WATER | USAGE HEAVY DUTY

Supra® 450 Amp Water-Cooled MIG Gun



100% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium - Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. SW64-60 (Stock No. 1644-1125)
- Conduit Liner – 44 Series

FEATURES

- **Ergonomic Handle** to reduce operator fatigue
- **Low Bench Weight** for easy to handle gun
- **Provides Cooling Benefits** to increase "weld" life of front end consumables
- **Cool Running** for maximum efficiency and comfort
- **Large Water Lines** for maximum cooling
- **High Water Flow Rates**
- **Increased Duty Cycle** at high amperage applications
- **Color Coded Water Lines** for easy identification to water-in & water-out
- **Outer Cover** protects components from weld spatter/abrasion
- **Replacement Cable Assemblies Available** – field-repairable power cable, water-lines and gas hose
- **Quick Water Line Connections** making hook-up easy (Euro style)
- **Simplified Direct Rear Plug Connections**
- **Adapts Easily** to Miller® and Lincoln® style machines

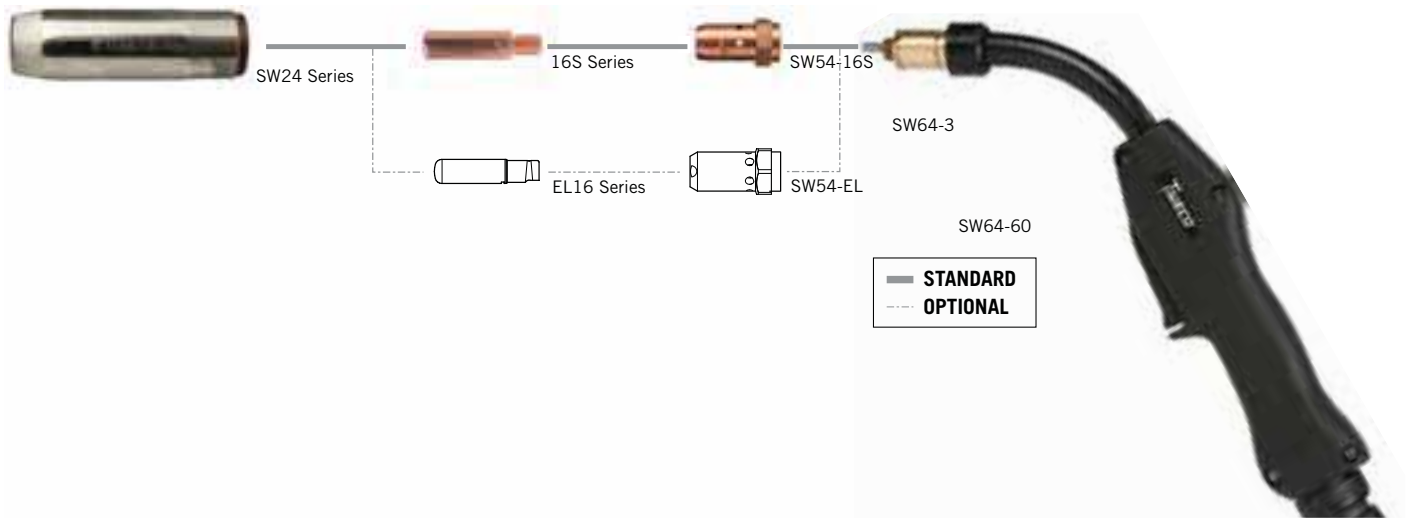
Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**SW410-116**	1044-1155
	15 ft (4.6 m)	**SW415-3545**	1044-1152
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**SW415-116**	1044-1157

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**SW410M-116**	1044-1180
	15 ft (4.6 m)	**SW415M-116**	1044-1182

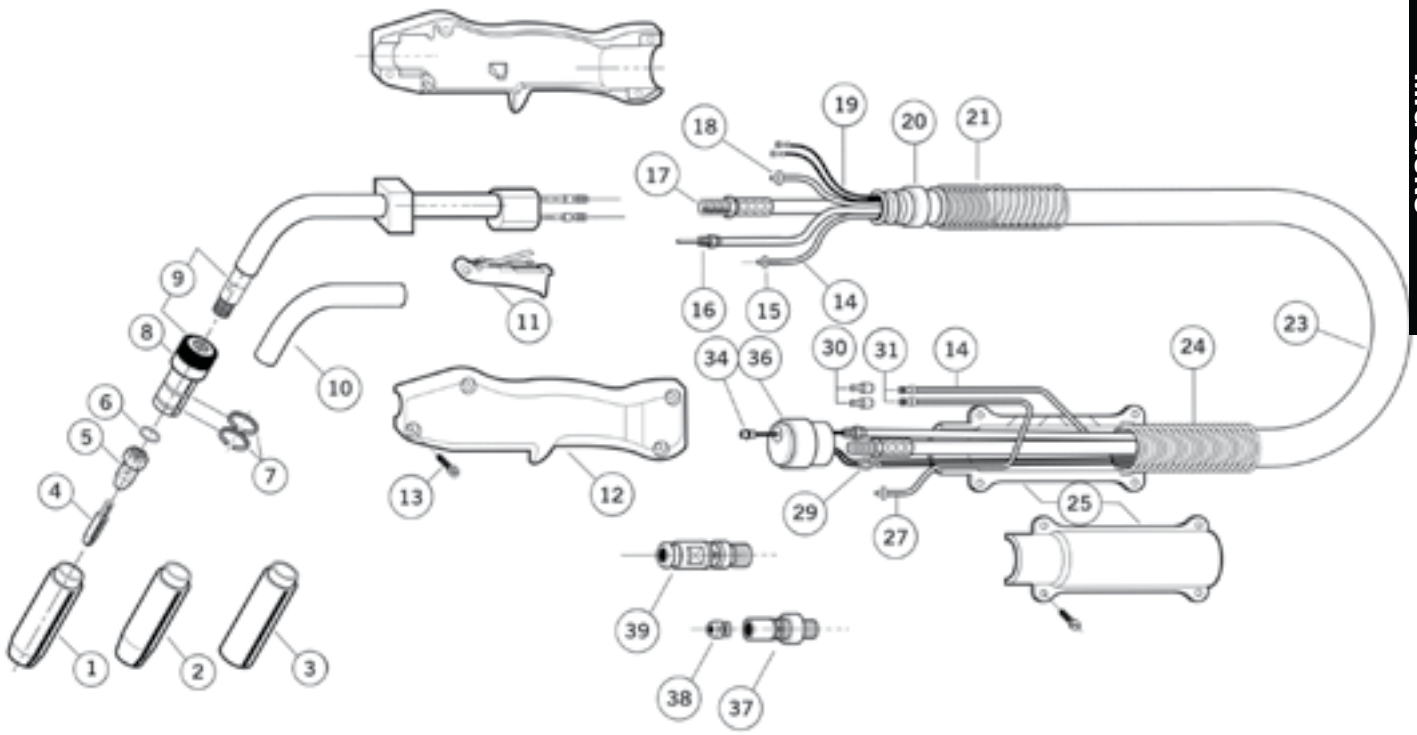


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	100%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Water	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 89 for Replacement Parts & Optional Accessories

Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco. Tweco is registered trademark of ESAB.

Supra® 450 Amp Water-Cooled MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Nozzle 11/16" (17 mm) Bore	**SW24-17**	1244-1025
2	Nozzle 5/8" (15.5 mm) Bore	**SW24-15**	1244-1026
3	Nozzle 13/16" (21 mm) Bore	**SW24-21**	1244-1027
4	EL16 Series Contact Tip	**Refer to Page 105**	
	16S Series Contact Tip	**Refer to Page 104**	
5	Diffuser for 16S Series Tips	**SW54-16S**	1540-1115
	Diffuser for EL16 Series Tips	**SW54-EL**	1540-1116
6	Insulating Ring	**SW64-2**	2044-1020
7	Nozzle Retaining Ring	**SW64-R**	2044-1025
8	Nozzle Holder	**SW64-3**	2044-1019
9	60° Conductor Tube	**SW64-60**	1644-1125
10	Conductor Tube Insulation	**SW64-1**	2044-1021
11	Trigger	**SW94**	2044-1018
12	Handle Assembly w/ Screws	**SW84**	2044-1023
13	Handle Screw	**SW84-S**	2044-1026
14	Water Inlet Hose (sold per foot)	**SW400-WHI**	1742-2240
15	Water Hose Clamp (9.5 mm)	**SW134-W**	2044-1002
16	10 ft (3 m) Conduit Housing	**SW410-CC**	1742-2235
	12 ft (4 m) Conduit Housing	**SW412-CC**	1742-2236
	15 ft (5 m) Conduit Housing	**SW415-CC**	1742-2237

#	Description		
17	10 ft (3 m) Power Cable	**SW410-PC**	1742-2230
	12 ft (4 m) Power Cable	**SW412-PC**	1742-2231
	15 ft (5 m) Power Cable	**SW415-PC**	1742-2232
18	Gas Hose Clamp (8.7 mm)	**SW134-G**	2044-1022
19	Control Wire (sold per foot)	**SW400-CW**	1742-2242
20	Front Knuckle Strain Relief	**Included with item 12**	
21	Front Handle Strain Relief	**SW144-F**	2044-1030
23	10 ft (3 m) Complete Cable	**SW410**	1742-2225
	12 ft (4 m) Complete Cable	**SW412**	1742-2226
	15 ft (5 m) Complete Cable	**SW415**	1742-2227
24	Rear Spring Support	**SW144**	2044-1000
25	Connector Case Cover w/Screws	**SW184**	2044-1011
27	Water Outlet Hose (sold per foot)	**SW400-WHO**	1742-2243
29	Female Wire Terminal Rear	**SW194-F**	2044-1004
30	Male Water Quick Connect	**SW-QCM**	2044-1005
31	Female Water Quick Connect	**SW-QCF**	2044-1006
34	44 Series Conduit	**Refer to Page 124**	
36	Connector Block (Tweco® & Miller® Rear Connections)	**SW174-T**	2044-1010
37	Connector Plug - Miller	**174TL-M**	2035-2131
38	Nipple Assembly - Miller	**174M-N**	2040-2184
39	Tweco Connector Plug & O-Rings	**350-174**	2035-2174

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 600 AMPS | DUTY CYCLE 100% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED WATER | USAGE HEAVY DUTY

Standard 600 Amp Water-Cooled MIG Gun



100% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium - Heavy Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. WCS66-60 (Stock No. 1664-1106)
- Conduit Liner – 45 Series

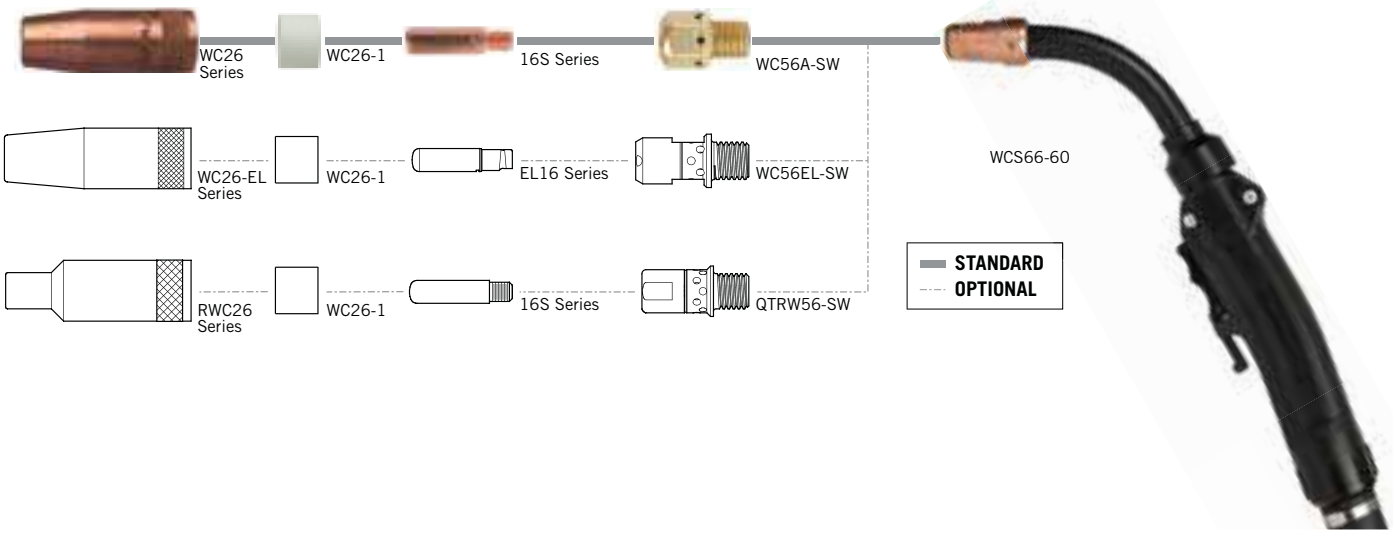
FEATURES

- **Ergonomic Handle** to reduce operator fatigue
- **Low Bench Weight** for easy to handle gun
- **Provides Cooling Benefits** to increase "weld" life of front end consumables
- **Cool Running** for maximum efficiency and comfort
- **High Water Flow Rates**
- **Large Water Lines** for maximum cooling
- **Threaded Water Line Connections** making hook-up easy (LH CGA)
- **Increased Duty Cycle** at high amperage applications
- **Large Diameter Wire Capacity** up to 7/64" (2.8 mm)
- **Outer Cover** protects components from weld spatter/abrasion
- **Simplified Direct Rear Plug Connections**
- **Replacement Cable Assemblies Available** – field-repairable power cable, water-lines and gas hose
- **Color Coded Water Lines** for easy identification to water-in & water-out
- **Adapts Easily** to Miller® and Lincoln® style machines

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	**WCS610-116**	1064-1114
	12 ft (3.6 m)	**WCS612-116**	1064-1115
.045" (1.2 mm)	15 ft (4.6 m)	**WCS615-3545**	1064-1106
1/16" (1.6 mm)	15 ft (4.6 m)	**WCS615-116**	1064-1116
3/32" (2.4 mm)	15 ft (4.6 m)	**WCS615-332**	1064-1136
7/64" (2.8 mm)	15 ft (4.6 m)	**WCS615-764**	1064-1146

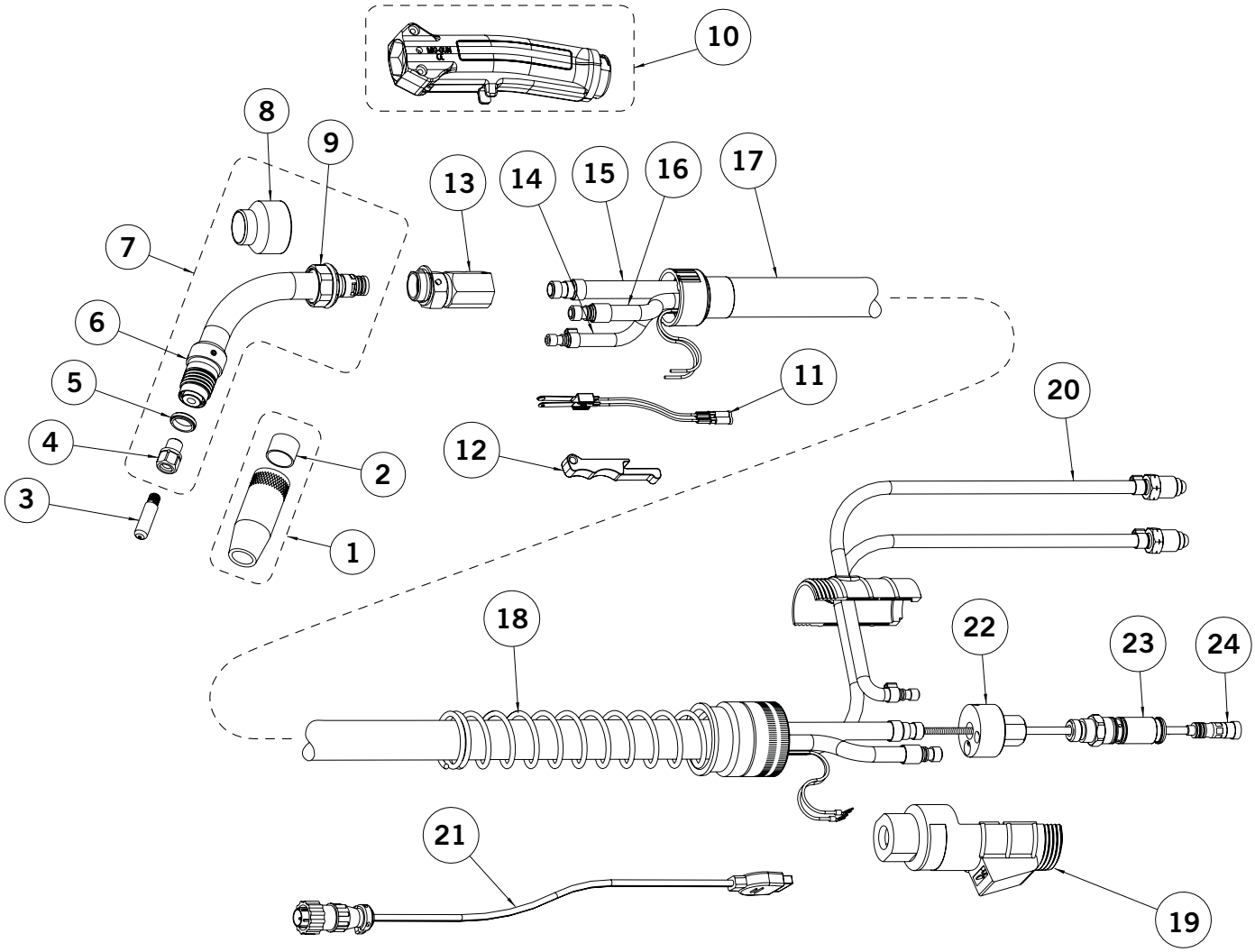


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
600 Amps	100%	CO_2 Carbon Dioxide	Up To 1/16" (1.1 mm)	Water	Heavy Duty Fabrication

EASY FIND GUIDE
See Page 91 for Replacement Parts & Optional Accessories

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Standard 600 Amp Water-Cooled MIG Gun Replacement Parts



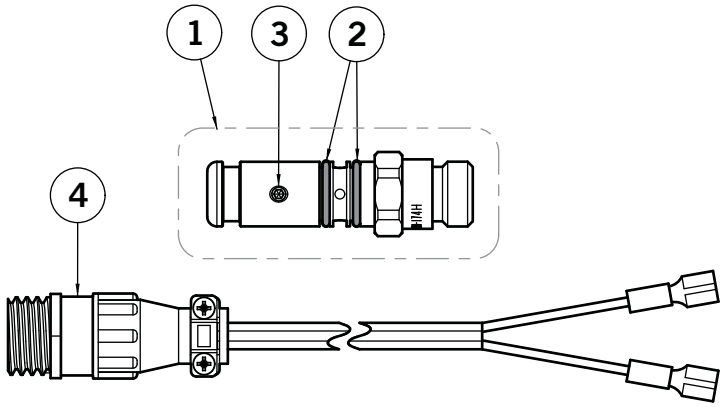
#	Description	Part No.	Stock No.
1	Nozzle	**WC26 Series**	
2	Spatter Shield	**WC26-1**	1264-1009
3	Contact Tip	**16S Series**	
4	Diffuser	**WC56A-SW**	
5	Pressure Ring Insulator	**WC36-R**	2064-1036
6	Conductor Tube Housing	**WCS36-H**	1344-1145
7	Conductor Tube	**WCS66-60**	
8	Nut Cover Insulation	**--**	--
9	Locking Nut	**WC66-N**	2064-2067
10	Handle Assembly	**W6R-H**	2064-2031
11	Trigger Blade Assembly	**EL96-B**	2060-2606
12	Trigger	**EL96**	2060-2605
13	Front Connector Block	**WC106**	2064-2106
14	Water Hose IN, 10 ft (3 m)	**WC610-WH**	1764-2131
	Water Hose IN, 12 ft (4 m)	**WC612-WH**	1764-2132
	Water Hose IN, 15 ft (5 m)	**WC615-WH**	1764-2133
15	Gas Hose, 10 ft (3 m)	**WC610-GH**	1764-2121
	Gas Hose, 12 ft (4 m)	**WC612-GH**	1764-2122
	Gas Hose, 15 ft (5 m)	**WC615-GH**	1764-2123

#	Description	Part No.	Stock No.
16	Power Cable, 10 ft (3 m)	**WC610-PC**	1764-2111
	Power Cable, 12 ft (4 m)	**WC612-PC**	1764-2112
	Power Cable, 15 ft (5 m)	**WC615-PC**	1764-2113
17	Complete Cable Assembly, 10 ft (3 m)	**WC600-10**	1764-2101
	Complete Cable Assembly, 12 ft (4 m)	**WC600-12**	1764-2102
	Complete Cable Assembly, 15 ft (5 m)	**WC600-15**	1764-2103
18	Rear Strain Relief Spring	**QR-SPHD**	3045-1178
19	Rear Case	**W6RC**	2064-2600
20	Water Hose Out	**WC603-WH**	1764-2130
21	Control Wire (Tweco®)	**MAK-354**	2642-2460
	Control Wire (Miller®)	**MSAK-354**	2642-2470
	Control Wire (Lincoln®)	**LAK-354**	2642-2450
22	Rear Connector Block (Direct Plug)	**WC6-170H**	2064-2171
	Rear Connector Block (Euro Plug)	**WC174X-B**	2044-2182
23	Connector Plug	**Refer to Pages 92-93**	
24	Conduit Assembly	**Refer to Pages 124-127**	

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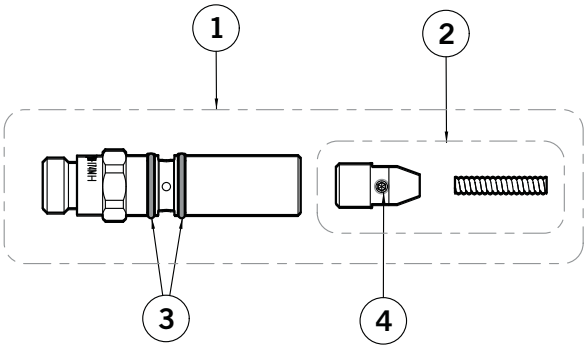
Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Tweco® MIG Gun Direct Plug & Control Wire Jumpers



Tweco® Style

#	Description	100 - 450 Amps		500 - 600 Amps	
		Part No.	Stock No.	Part No.	Stock No.
1	Connector Plug	**350-174H**	2035-2110	**176SH**	2060-2177
	Connector Plug (Extra Long)	**350-174HXL**	2035-2116	**--**	--
2	O-Ring Only (Package of 10)	**224S**	2064-2059	**225S**	2050-2226
3	Set Screw Only (Package of 10)	**44CS**	2040-2046	**2040-2046**	2040-2046
4	Thermal Arc® Control Jumper Cord	**MS-354-TAJ**	2060-2139	**MS-354-TAJ**	2060-2139
NS	Additional Adapter Kits	**See Adapter Kit Catalog - Form No. TAKL-97**			

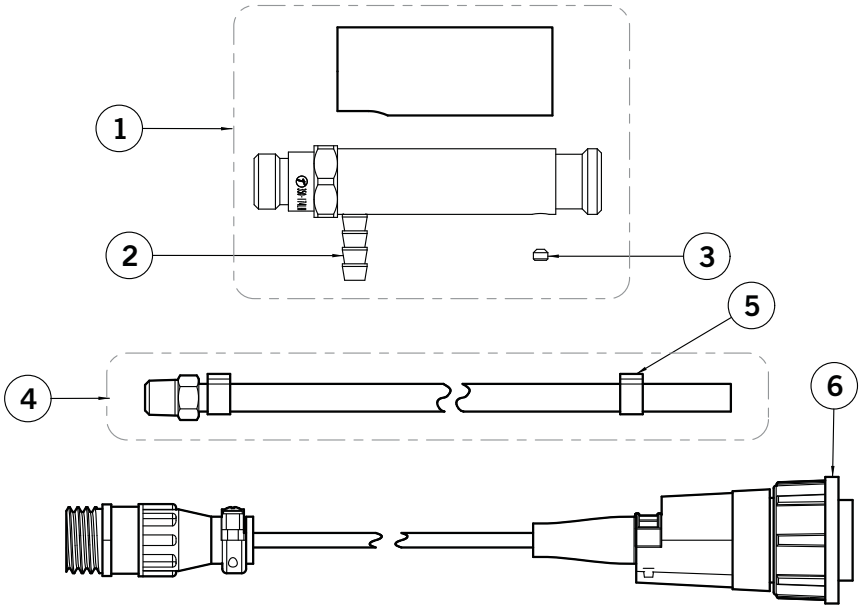


Miller® Style

#	Description	100 - 450 Amps		500 - 600 Amps	
		Part No.	Stock No.	Part No.	Stock No.
1	Connector Plug	**350-174MH**	2035-2111	**EL176MH**	2060-2178
	Connector Plug (Extra Long)	**350-174MHXL**	2035-2114	**--**	--
2	Wire Guide Assembly Only	**174M-N**	2040-2184	**175M-N**	2050-2178
3	O-Ring Only (Package of 10)	**224S**	2064-2059	**224S**	2064-2059
4	Set Screw Only (Package of 10)	**44CS**	2040-2046	**44CS**	2040-2046

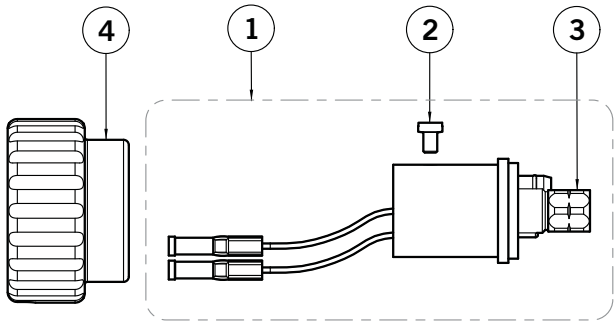
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Tweco® MIG Gun Direct Plug & Control Wire Jumpers



Lincoln® Style

#	Description	100 - 450 Amps		500 - 600 Amps	
		Part No.	Stock No.	Part No.	Stock No.
1	Connector Plug	**350-174LH**	2035-2112	**EL176LH**	2060-2680
2	Gas Nipple	**35-170-5**	2000-2175	**35-170-5**	2000-2175
3	Set Screw Only (Package of 10)	**44CS**	2040-2046	**44CS**	2040-2046
4	Gas Hose With Clamp	**AK353**	2642-2300	**AK353**	2642-2300
5	Gas Hose Clamp Only	**AK-353-2A**	2642-2302	**AK-353-2A**	2642-2302
6	Lincoln Control Jumper Cord	**MS354DS-LJ**	2060-2137	**MS354DS-LJ**	2060-2137



Euro-Kwik Style

#	Description	100 - 450 Amps		500 - 600 Amps	
		Part No.	Stock No.	Part No.	Stock No.
1	Euro-Kwik Body Assembly	**174EX-1**	2040-2276	**174EX-1**	2040-2276
	Euro-Kwik Body Assembly (Water-Cooled)	**WC174X**	2044-2181	**WC174X**	2044-2181
2	Screw Only	**4-MS**	2011-2004	**4-MS**	2011-2004
3	Euro-Kwik Conduit Cap Only	**174EX-1C**	2040-2279	**174EX-1C**	2040-2279
4	Euro-Kwik Nut	**174X-2**	2040-2177	**174X-2**	2040-2177

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Velocity™ MIG Welding Consumables

Tweco® has been an industry standard for over 75 years. Tweco is the name behind the most widely accepted standard of MIG welding consumables in use today.

We challenged ourselves again by leading in innovation with the introduction of Velocity™ MIG welding consumables.

They have been designed by welders for welders to provide prolonged tip life and improved performance and are featured on the Tweco Fusion® MIG guns and the new Spray Master® V-Series MIG guns.

- Velocity consumables have fewer parts – leads to less complexity
- The Velocity design eliminates the need for a gas diffuser – results in fewer parts
- The design optimizes surface contact for better electrical conductivity – provides smoother arc and improved performance
- Conduit liner fits inside the tip – provides superior feedability and minimizes wire feed issues

All in all, Velocity MIG welding consumables help improved productivity, reduced total cost of usage, less hassles for the operator. Available in a wide variety of sizes to meet your needs and with the same quality welders have come to expect from all Tweco products. They get it done faster, easier and more conveniently.

For additional information on Tweco Velocity MIG welding consumables refer to Technical Service Bulletin Form No. 64-1208

Ground Breaking Innovation - Inspired by Welders for Welders

Tweco is the name behind the most widely accepted standard in the industry today. We design our products with direct input from welders – voice of the customer. Velocity consumables are a direct reflection of their input.

Once you try Velocity tips, we are confident you will extend the Tweco legacy by choosing the welding consumables that outperform anything else available.

The best just got better. Tweco Velocity.



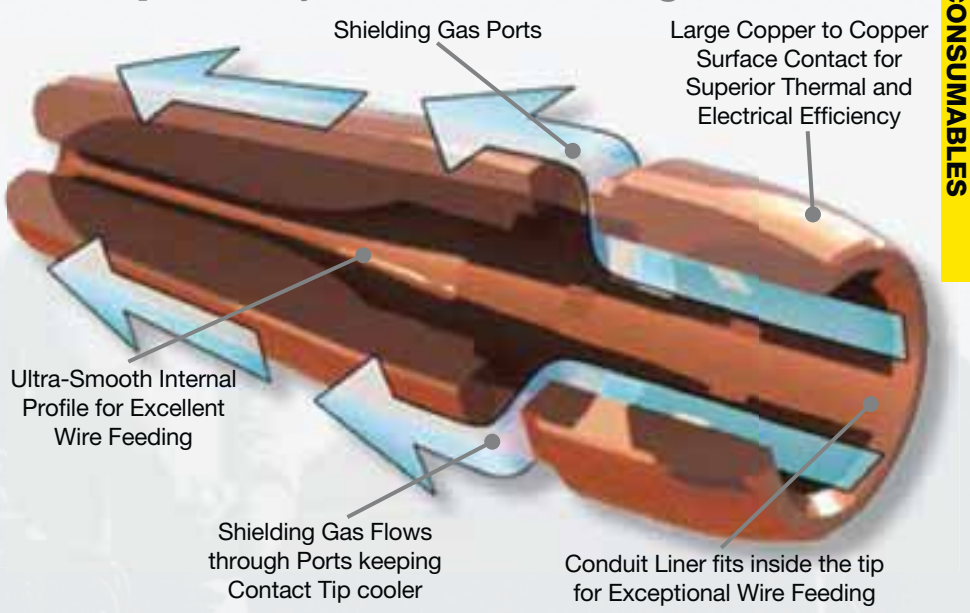
Tweco Velocity Contact Tips - Stay Cooler, Last Longer

Several features, inspired by welders, are built into the Velocity design.

- Addition of gas ports in the tip channels the shielding gas through the tip
- Greater contact surface area
- Fewer connections in the system
- Conduit liner fits inside the tip for improved wire feedability

The Velocity contact tip remains cooler. A cooler tip extends the life of the tip resulting in fewer tip changes, and les tip usage, and increase productivity and lowers total cost of usage, with up to 8x extended tip life.

Velocity is the MIG welding consumable of choice.



Fewer Consumable Parts - Less Complexity, Fewer Connections

We listened to shop-owners and welders alike and they all told us they prefer less complexity. The Velocity design is simpler with fewer connection points, requires no tools, and virtually eliminates problems with threads.

Welders needing smooth arc performance told us, 'reduce the number of connections, each connection is a chance for poor conductivity' … and we did. The result is a more stable arc that provides more precision for the discerning welder.



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Velocity™ Light Duty MIG Welding Consumables Reference

Light Duty Range Overview

Wire sizes .023" (0.6 mm) → 5/64" (2.0 mm)
Optimized for .035" (0.9 mm) & .045" (1.2 mm)
140 – 300 Amps @ 60% Duty Cycle

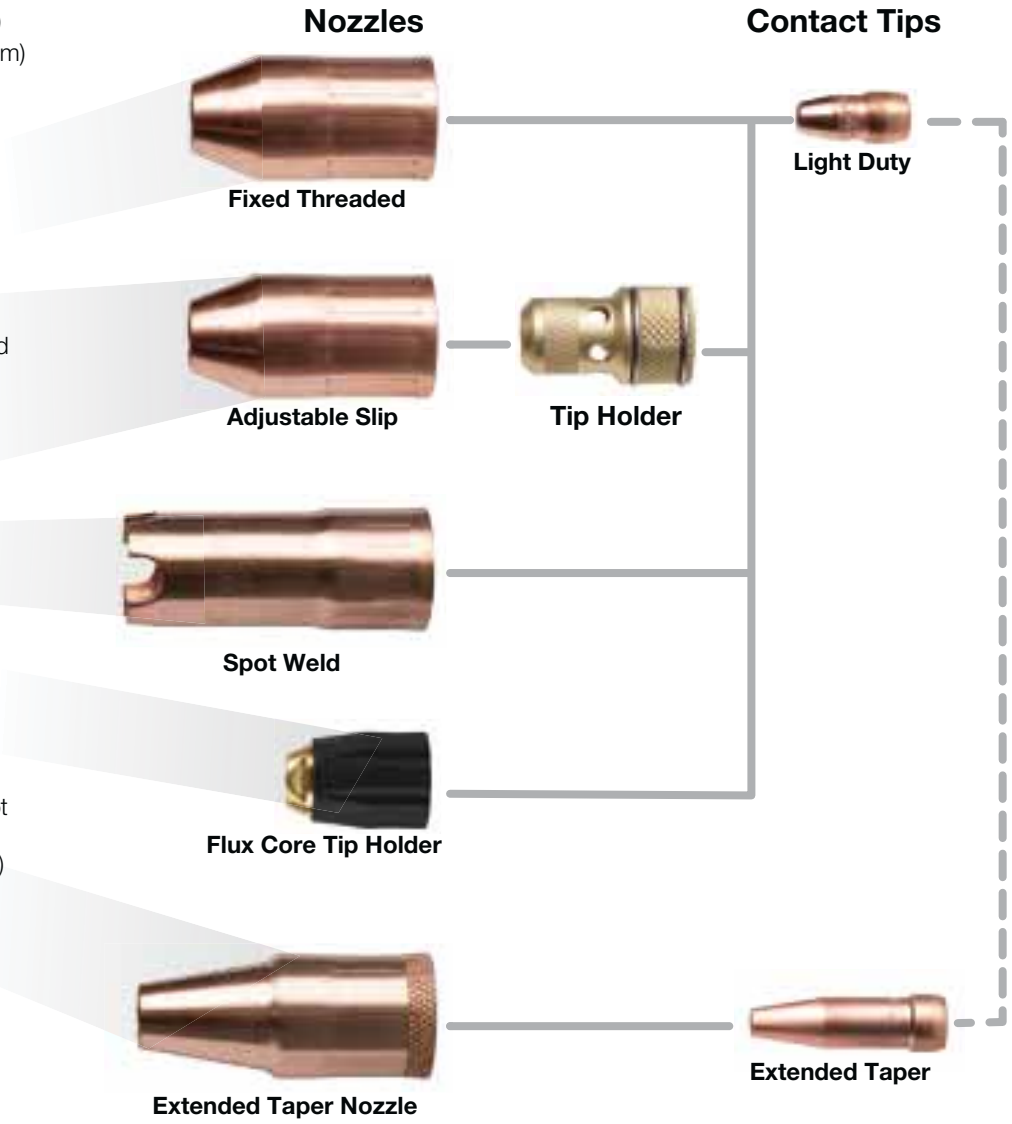
Fixed Threaded maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

Adjustable Slip allows welder to adjust the flushness relationship and provides improved access for cleaning. Adjustable slip nozzle cones and tip holder sold separately. These items must be used together to have a working nozzle assembly..

Spot Weld provides a solution for tack and spot welding with MIG.

Flux Core Tip Holder provides open sight line and the best solution for gasless flux core welding.

Extended Taper provides a solution for root pass and confined access MIG welding.
Wire sizes .030" (0.8 mm) → 1/16" (1.6 mm)
Optimized for .045" (1.2 mm)



Velocity Nozzle Identification

S=Small
M=Medium
H=Heavy
ET=Extended Taper

Blank=Fixed Threaded
S=Adjustable Slip

V N S 5 0 F S

Velocity Nozzle

Orifice Opening Size:
37=3/8" 62=5/8"
50=1/2" 75=3/4"

Blank=Standard Recess
F=Flush
2PC=Two Piece
R=Recess 1/4" (6.35 mm)
FAS=Spot Weld
FC=Flux Core

Velocity Contact Tip Identification

S=Small
M=Medium
H=Heavy
ET=Extended Taper

A=Aluminum
Blank=Other

V T S A 3 0

Velocity Tip

Wire Size:
23=0.023" 364=3/64"
30=0.030" 116=1/16"
35=0.035" 564=5/64"
40=0.040" 332=3/32"
45=0.045" 764=7/64"
18=1/8"

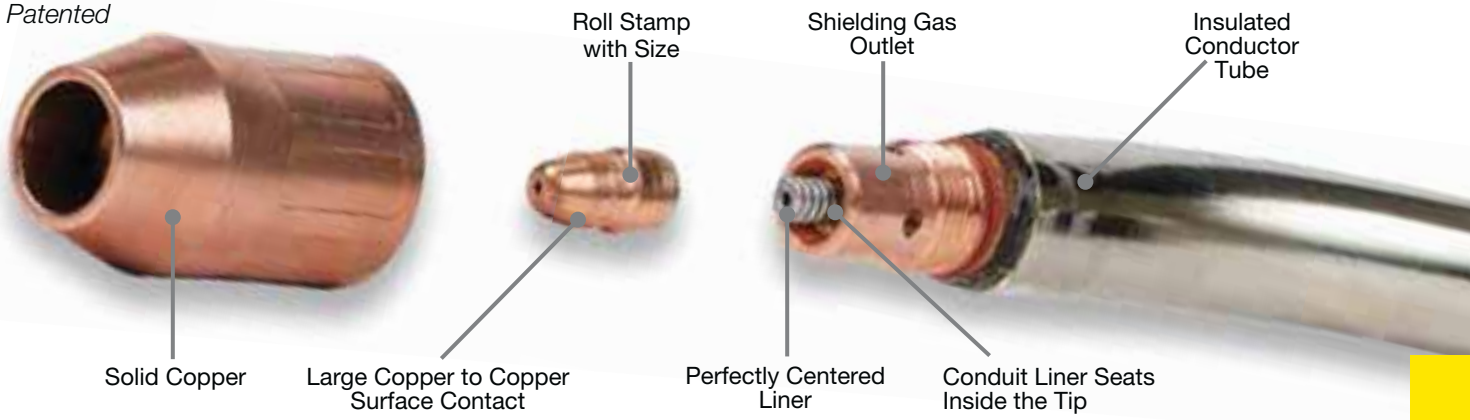
Note: Light Duty Velocity was released in 2013, please reference our website or call customer service for information.

Velocity™ Light Duty Consumables Reference

Velocity light duty consumables are used exclusively on Tweco Fusion® MIG Guns.

Velocity™ Nozzle | **Velocity Contact Tip** | **Conductor Tube**

Patented

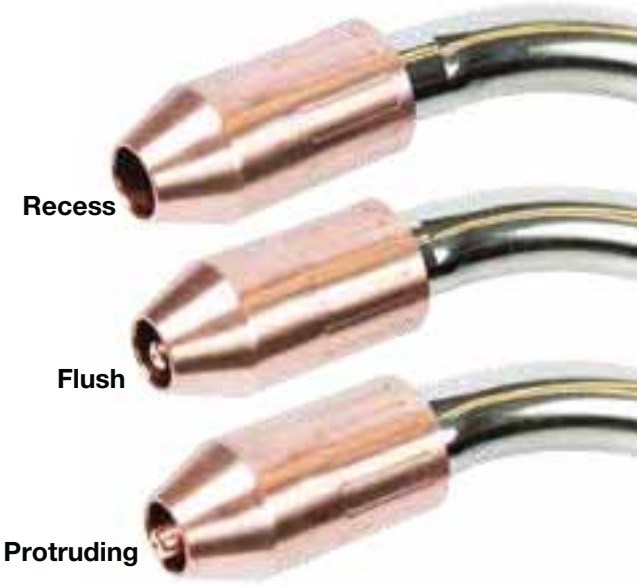


Velocity Adjustable Slip Nozzles - Flushness Relationship



- **Increased Versatility** – Able to conveniently achieve Recess, Flush, and Protruding tip flushness relationship.
- **Easy to Adjust** – Provides positive indexing to all positions.
- **Stays Where You Need It** – Clicks into place just by sliding to the preset 1/8" index marks on the tip holder.
- **Convenient** – Clean nozzle with tip secured to conductor tube.





Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Velocity™ Medium & Heavy Duty Welding Consumables Reference

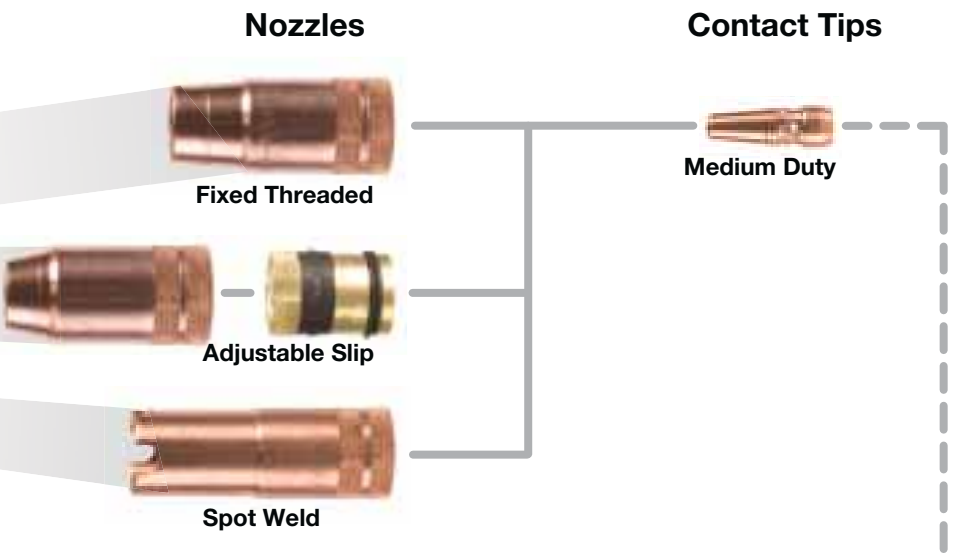
Medium Duty Range Overview

Wire sizes .023" (0.6 mm) → 1/16" (1.6 mm)
Optimized for .035" (0.9 mm) & .045" (1.2 mm)
200 – 350 Amps @ 60% Duty Cycle

Fixed Threaded maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

Adjustable Slip allows welder to adjust the flushness relationship and provides improved access for cleaning.

Spot Weld provides a solution for tack and spot welding with MIG.



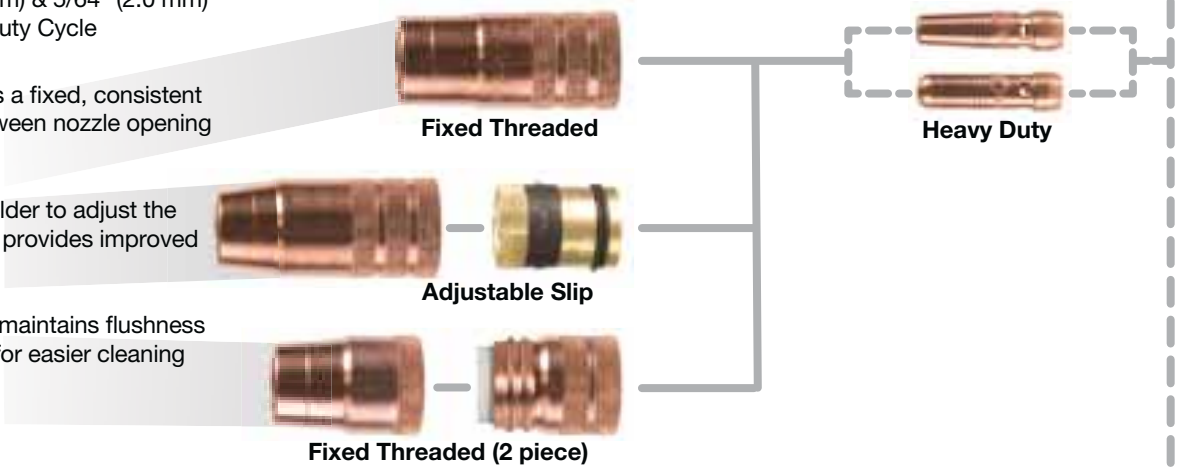
Heavy Duty Range Overview

Wire sizes .030" (0.8 mm) → 1/8" (3.2 mm)
Optimized for .045" (1.2 mm) & 5/64" (2.0 mm)
300 – 600 Amps @ 80% Duty Cycle

Fixed Threaded maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

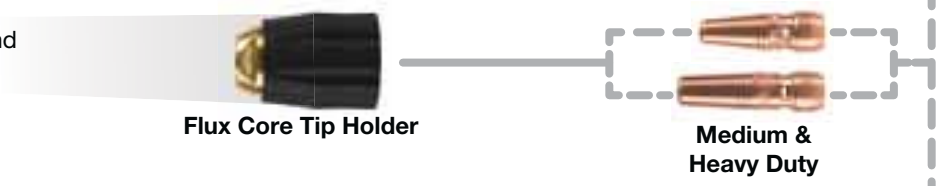
Adjustable Slip allows welder to adjust the flushness relationship and provides improved access for cleaning.

Fixed Threaded (2 piece) maintains flushness relationship and provides for easier cleaning and maintenance.



Flux Core Overview

Flux Core Tip Holder provides open sight line and the best solution for gasless flux core welding.



Extended Taper Range Overview

For Root Pass and Confined Access

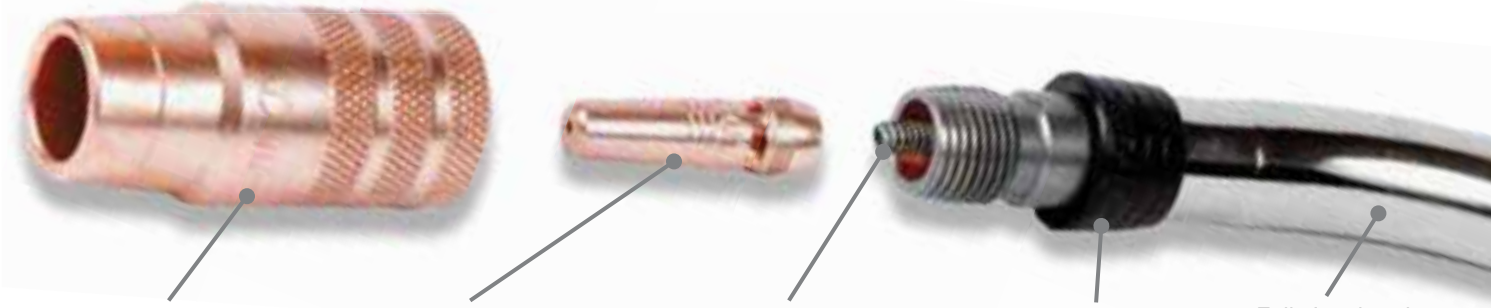
Wire sizes .030" (0.8 mm) → 1/16" (1.6 mm)
Optimized for .045" (1.2 mm)
200 – 350 Amps @ 60% Duty Cycle



Velocity™ Medium & Heavy Duty Consumables

Velocity medium and heavy duty consumables are used on Tweco Classic No. Series and Spray Master Series MIG Guns.

Velocity Nozzle | **Velocity Contact Tip** | **Conductor Tube**



Long Lasting, Heavy Duty Solid Copper Nozzle Assembly

Solid Copper Alloy Roll Stamp with Size

Perfectly Centered Conduit Liner Seats Inside the Tip for Superior Feedability

Nozzle Collar with index marks

Fully Insulated Gooseneck Conductor Tube

Easy To Identify Velocity Consumables - No More Guesswork

Velocity medium and heavy duty consumables are different from what you may be accustomed. Nozzles have a specific number of knurled bands and contact tips have rings to indicate their compatibility and correct usage.



Medium Duty
has two knurled bands on the nozzles and two rings on the contact tips.

Heavy Duty
has three knurled bands on the nozzles and three rings on the contact tips.

Extended Taper
has four knurled bands on the nozzles and four rings on the contact tips.

Velocity Adjustable Slip Nozzles - Flushness Relationship



Adjustable Slip Nozzle

Click to Index Mark

Index Marks



Recessed



Flush



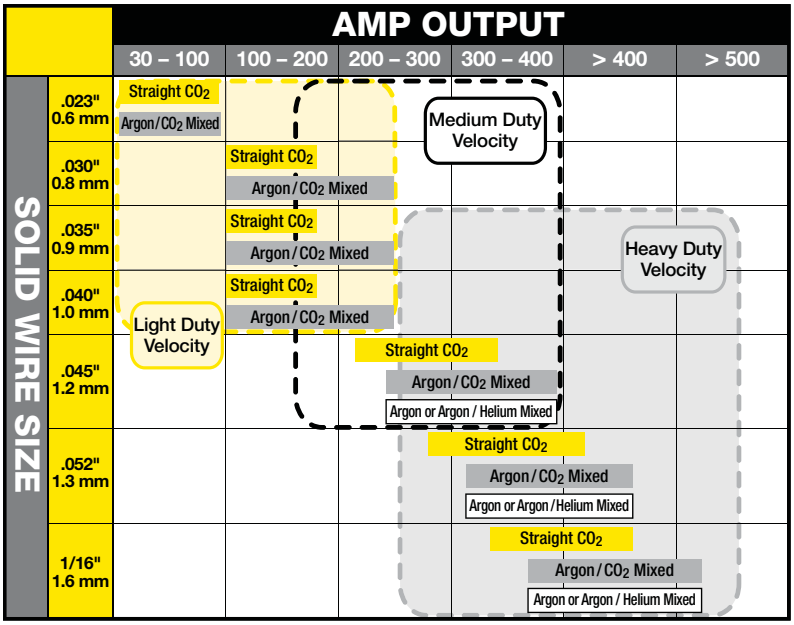
Protruding

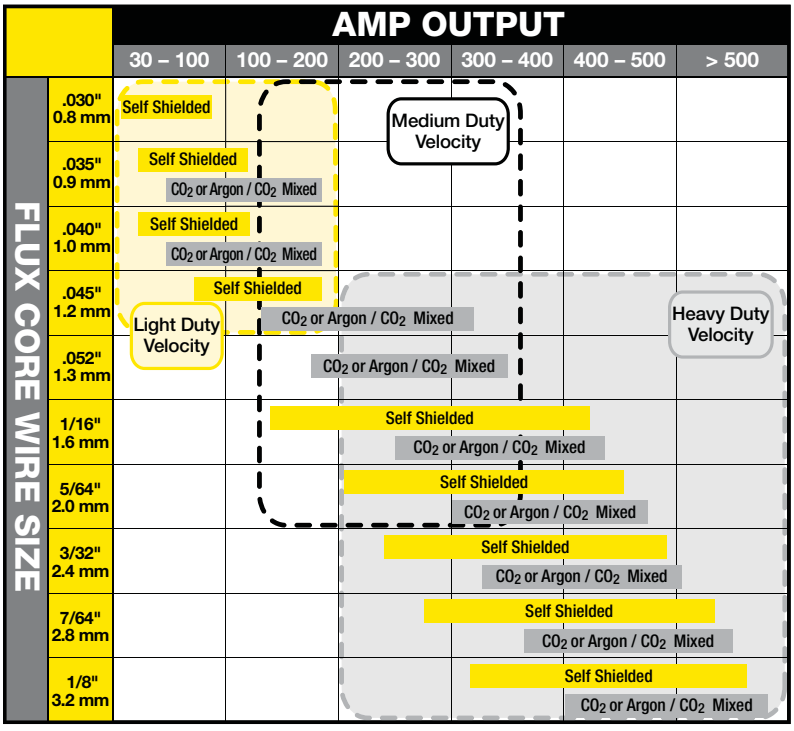
One of the Velocity consumable offerings is the Adjustable Slip Nozzle that provides positive indexing to all positions whether you require recessed, flush or protruding tips. The nozzle clicks into place just by sliding to the index marks on the collar of the conductor tube. Each index mark allows the operator to adjust the tip by 1/8" increments.



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International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Velocity™ Wire Process Charts





POWER SUPPLY COMPATIBILITY

Thermal Arc® Connector (8 Pin)	Tweco® Connector (4 Pin)	Miller® Connector	Lincoln® Connector	Euro-Kwik Connector
Thermal Arc Fabricator 141i, 181i, 211i & 252i	**Thermal Arc Fabricator** 190, 210, 251 & 281 **Lincoln** SP100, SP100T, SP125 Plus, SP130, SP170T & SP170 Plus **Hobart®** Beta Mig 170	**Millermatic®** 130, 130 XP, 135, 140, 150, 155, 175, 180, 185, 200, 210, 211, 212 **Hobart® Handler** 130XL, 210, Trek 180, Ironman™ 210	**Lincoln** SP140T, SP180T, PowerMIG® 140C & 180C, Easy-Core™ 125, Pro-Core™ 125, Easy-MIG® 140, Weld-Pak 125HD, 140HD & 180HD, MIG-Pak™ 140 & 180, Easy-MIG® 180, Pro-MIG™ 140 & 180	**ESAB®** MigMaster® 160 & 173

Velocity - Light Duty MIG Welding Consumables

Light Duty Contact Tips

Description	Part No.	Stock No.
.023" (0.6 mm) Standard	**VTS23**	1110-1308
.030" (0.8 mm) Standard	**VTS30**	1110-1309
.035" (0.9 mm) Standard	**VTS35**	1110-1310
.040" (1.0 mm) Standard	**VTS40**	1110-1311
.045" (1.2 mm) Standard	**VTS45**	1110-1312
3/64" (1.2 mm) Standard*	**VTSA364***	1110-1313
.052" (1.3 mm) Standard	**VTS52**	1110-1314
1/16" (1.6 mm) Standard	**VTS116**	1110-1315
1/16" (1.6 mm) Standard*	**VTSA116***	1110-1317
5/64" (2.0 mm) Standard	**VTS564**	1110-1316
.023" (0.6 mm) Extended Taper	**VTSET23**	1110-1330
.030" (0.8 mm) Extended Taper	**VTSET30**	1110-1331
.035" (0.9 mm) Extended Taper	**VTSET35**	1110-1332
.040" (1.0 mm) Extended Taper	**VTSET40**	1110-1333
.045" (1.2 mm) Extended Taper	**VTSET45**	1110-1334
3/64" (1.2 mm) Extended Taper	**VTSETA364***	1110-1335
.052" (1.3 mm) Extended Taper	**VTSET52**	1110-1336
1/16" (1.6 mm) Extended Taper	**VTSET116**	1110-1337
1/16" (1.6 mm) Extended Taper	**VTSETA116***	1110-1338
** For Aluminum Wire*		

Light Duty Nozzles

Self Insulated Nozzles. 2 per pack

Description	Part No.	Stock No.
1/2" Fixed Threaded - Flush	**VNS50F**	1220-1200
1/2" Fixed Threaded - Recess	**VNS50**	1220-1201
5/8" Fixed Threaded - Flush	**VNS62F**	1220-1202
5/8" Fixed Threaded - Recess	**VNS62**	1220-1203
3/8" Fixed Threaded - Flush	**VNS37F**	1220-1204
3/8" Fixed Threaded - Recess	**VNS37**	1220-1206
1/2" Adj. Slip - Heavy Cone	**VNSH50S**	1220-1229
Adj. Slip - Tip Holder	**VNSSINS**	1340-1132
3/8" Extended Taper Nozzle	**VNSET37F**	1220-1235
3/4" Spot Nozzle Assembly	**VNS75FAS**	1220-1205
FC Tip Holder - Insulator	**VNSFCI**	1220-1208

Velocity Conductor Tubes

Fully Insulated Gooseneck. 1 per pack

Description	Part No.	Stock No.
60 Degree Conductor Tube	**FVCTS60**	1620-1368
45 Degree Conductor Tube	**FVCTS45**	1620-1369

NOTE: All Contact Tips are packaged in quantities of ten (10) per bag and all Nozzles are packaged in quantities of two (2) per bag.

Velocity™ Medium & Heavy Duty MIG Welding Consumables

Medium Duty Contact Tips

Description	Part No.	Stock No.
.023" (0.6 mm)	**VTM23**	1160-1750
.030" (0.8 mm)	**VTM30**	1160-1751
.035" (0.9 mm)	**VTM35**	1160-1752
.040" (1.0 mm)	**VTM40**	1160-1753
.045" (1.2 mm)	**VTM45**	1160-1754
3/64" (1.2 mm)*	**VTMA364***	1160-1755
.052" (1.3 mm)	**VTM52**	1160-1756
1/16" (1.6 mm)	**VTM116**	1160-1757
1/16" (1.6 mm)*	**VTMA116***	1160-1758
5/64" (2.0 mm)	**VTM564**	1160-1759

Note: All Contact Tips are packaged in quantities of ten (10) per bag and all Nozzles are packaged in quantities of two (2) per bag.

Heavy Duty Contact Tips

Description	Part No.	Stock No.
.030" (0.8 mm)	**VTH30**	1160-1760
.035" (0.9 mm)	**VTH35**	1160-1761
.040" (1.0 mm)	**VTH40**	1160-1762
.045" (1.2 mm)	**VTH45**	1160-1763
3/64" (1.2 mm)*	**VTHA364***	1160-1764
.052" (1.3 mm)	**VTH52**	1160-1765
1/16" (1.6 mm)	**VTH116**	1160-1766
1/16" (1.6 mm)*	**VTHA116***	1160-1767
5/64" (2.0 mm)	**VTH564**	1160-1768
3/32" (2.4 mm)	**VTH332**	1160-1769
7/64" (2.8 mm)	**VTH764**	1160-1770
1/8" (3.2 mm)	**VTH18**	1160-1771

Extended Taper Contact Tips

Description	Part No.	Stock No.
.030" (0.8 mm)	**VTET30**	1160-1772
.035" (0.9 mm)	**VTET35**	1160-1773
.040" (1.0 mm)	**VTET40**	1160-1774
.045" (1.2 mm)	**VTET45**	1160-1775
3/64" (1.2 mm)*	**VTETA364***	1160-1776
.052" (1.3 mm)	**VTET52**	1160-1777
1/16" (1.6 mm)	**VTET116**	1160-1778

Extended HD Taper Contact Tips

Description	Part No.	Stock No.
.035" (0.9 mm)	**VTHET35**	1160-1780
.045" (1.2 mm)	**VTHET45**	1160-1782
.052" (1.3 mm)	**VTHET52**	1160-1784
1/16" (1.6 mm)	**VTHET116**	1160-1785

Medium Duty Nozzles

Self Insulated Nozzles. 2 per pack

Description	Part No.	Stock No.
1/2" (12.7 mm) Threaded Nozzle Recess	**VNM50**	1240-1857
1/2" (12.7 mm) Threaded Nozzle Flush	**VNM50F**	1240-1856
5/8" (15.9 mm) Threaded Nozzle Recess	**VNM62**	1240-1854
5/8" (15.9 mm) Threaded Nozzle Flush	**VNM62F**	1240-1855
3/4" (19.1 mm) Threaded Nozzle Recess	**VNM75**	1240-1852
3/4" (19.1 mm) Threaded Nozzle Flush	**VNM75F**	1240-1853
1/2" (12.7 mm) Slip Nozzle	**VNM50S**	1240-1859
5/8" (15.9 mm) Slip Nozzle	**VNM62S**	1240-1860
3/4" (19.1 mm) Slip Nozzle	**VNM75S**	1240-1863
Slip Nozzle Base	**VNS**	1240-1864
1/2" (12.7 mm) Slip Nozzle Cone Only	**VNM50SC**	1240-1861
5/8" (15.9 mm) Slip Nozzle Cone Only	**VNM62SC**	1240-1862
3/4" (19.1 mm) Slip Nozzle Cone Only	**VNM75SC**	1240-1865
Flux Core Nozzle	**VNLFC**	1240-1892
5/8" (15.9 mm) Spot Nozzle	**VNM62FAS**	1240-1866
3/4" (19.1 mm) Spot Nozzle	**VNM75FAS**	1240-1868

Extended Taper Nozzle

Extended Taper Nozzle	**VNET37F**	1240-1897

Heavy Duty Nozzles

Self Insulated Nozzles. 2 per pack

Description	Part No.	Stock No.
5/8" (15.9 mm) Threaded Nozzle Recess	**VNH62**	1240-1877
5/8" (15.9 mm) Threaded Nozzle Flush	**VNH62F**	1240-1878
3/4" (19.1 mm) Threaded Nozzle Recess	**VNH75**	1240-1875
3/4" (19.1 mm) Threaded Nozzle Flush	**VNH75F**	1240-1876
5/8" (15.9 mm) Slip Nozzle	**VNH62S**	1240-1893
3/4" (19.1 mm) Slip Nozzle	**VNH75S**	1240-1894
Slip Nozzle Base	**VNS**	1240-1864
5/8" (15.9 mm) Slip Nozzle Cone Only	**VNH62SC**	1240-1895
3/4" (19.1 mm) Slip Nozzle Cone Only	**VNH75SC**	1240-1896
5/8" (15.9 mm) 2 Piece Nozzle Assembly Recess	**VNH622PC**	1240-1880
5/8" (15.9 mm) 2 Piece Nozzle Cone Only Recess	**VNH62C**	1240-1884
5/8" (15.9 mm) 2 Piece Nozzle Assembly Flush	**VNH62F2PC**	1240-1881
5/8" (15.9 mm) 2 Piece Nozzle Cone Only Flush	**VNH62FC**	1240-1885
3/4" (19.1 mm) 2 Piece Nozzle Assembly Recess	**VNH752PC**	1240-1882
3/4" (19.1 mm) 2 Piece Nozzle Cone Only Recess	**VNH75C**	1240-1886
3/4" (19.1 mm) 2 Piece Nozzle Assembly Flush	**VNH75F2PC**	1240-1883
3/4" (19.1 mm) 2 Piece Nozzle Cone Only Flush	**VNH75FC**	1240-1887
Nozzle Retainer	**VNH2PC**	1240-1879
Flux Core Tip Holder & Insulator	**VNSFC**	1220-1207

Note: Velocity medium and heavy duty contact tips and nozzles are for use with Tweco Classic® No. series and Spray Master® series MIG Guns.

Velocity conductor tubes or 'goosenecks' include these components, held in place and protected by a heat-treated, super-hardened, threaded stainless sleeve. You will not need to replace these parts as often, they typically last far longer than the contact tip or nozzle.



Miscellaneous Components and Service Parts

Description	Part No.	Stock No.	Description	Part No.	Stock No.	Description	Part No.	Stock No.
Threaded Stainless Sleeve	**VCTLSL**	1640-1397	Retaining Ring	**PMA64RS**	1640-1396	45° Conductor Tube	**SMVCT45**	1240-1373
Nozzle Collar	**VCTLSLK**	1640-1398	Sleeve Screw	**VCT41CS**	2040-2048	60° Conductor Tube	**SMVCT60**	1240-1374
Wave Spring	**VCTLSPR**	1640-1399	Liner Set Screw	**41CS**	2040-2047	O-Ring Seal	**94-710-036**	9471-0036

For additional information visit us online at Tweco.com or call customer service.

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EASY FIND GUIDE - Contact Tip Selection Guide

Contact Tip Series	Output Current (Amps)	Contact Tip Size			Material	Style Option			Page
		Wire Size Min. & Max. Range (In / Mm)	Tip Inside Diameter Min. & Max. Range (In / Mm)	Outside Diameter (In / Mm)		Standard	Heavy Duty	Tapered	
11, 11H & 11T Series	100	Min: .023" (0.6 mm) Max: .045" (1.2 mm)	Min.: .031" (0.79 mm) Max.: .059" (1.50 mm)	0.25" (6.35 mm)	122 DHP Copper Alloy	■	■	■	103
14, 14H & 14T Series	400	Min: .023" (0.6 mm) Max.: .5/64" (2.0 mm)	Min.: .031" (0.79 mm) Max.: .090" (2.29 mm)	0.25" (6.35 mm)	122 DHP Copper Alloy	■	■	■	103
14RZ & 14RZT Series	400	Min.: .035" (0.9 mm) Max.: .052" (1.3. mm)	Min.: .041" (1.04 mm) Max.: .058" (1.47 mm)	0.25" (6.35 mm)	CDA 1815 Alloy	■		■	104
15H & 15HFC Series	500	Min.: .035" (0.9 mm) Max.: 1/8" (3.2 mm)	Min.: .044" (1.12 mm) Max.: .144" (3.66 mm)	0.345" (8.8 mm)	122 DHP Copper Alloy	■	■		103
16S & 16ST Series	600	Min.: .035" (0.9 mm) Max.: 7/64" (2.8 mm)	Min.: .044" (1.12 mm) Max.: .120" (3.05 mm)	0.375" (9.5 mm)	122 DHP Copper Alloy	■		■	104
16RZ & 16RZT Series	600	Min.: .035" (0.9 mm) Max.: .052" (1.3. mm)	Min.: .041" (1.04 mm) Max.: .058" (1.47 mm)	0.312" (7.9 mm)	CDA 1815 Alloy	■		■	104
16PS Series	600	Min.: .030" (0.8 mm) Max.: .052" (1.3. mm)	Min.: .038" (0.97 mm) Max.: .058" (1.50 mm)	0.375" (9.5 mm)	CDA 1815 Alloy	■			105
EL16 & EL16T Series	600	Min.: .030" (0.8 mm) Max.: 3/32" (2.4 mm)	Min.: .038" (0.97 mm) Max.: .106" (2.67 mm)	0.345" (8.8 mm)	122 DHP Copper Alloy	■		■	105
EL16RZ & EL16RZT Series	600	Min.: .035" (0.9 mm) Max.: .052" (1.3. mm)	Min.: .041" (1.04 mm) Max.: .058" (1.47 mm)	0.375" (9.5 mm)	CDA 1815 Alloy	■		■	105



Contact Tips - Standard Threaded Style

11, 11H & 11T Series

0.25" (6.35 mm) Outside Diameter - M6 x 1.0 Threads - 1.00" (25.4 mm) Overall Length

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.023" (0.6 mm)	.031" (0.79 mm)	**11-23**	1110-1100	**--**	--	**11T-23**	1110-1300
.030" (0.8 mm)	.038" (0.97 mm)	**11-30**	1110-1101	**11H-30**	1110-1201	**11T-30**	1110-1301
.035" (0.9 mm)	.044" (1.12 mm)	**11-35**	1110-1102	**11H-35**	1110-1202	**11T-35**	1110-1302
.040" (1.0 mm)	.048" (1.22 mm)	**11-40**	1110-1103	**11H-40**	1110-1203	**--**	--
.045" (1.2 mm)	.054" (1.37 mm)	**11-45**	1110-1104	**11H-45**	1110-1204	**11T-45**	1110-1304
3/64" AL (1.2 mm)	.059" (1.50 mm)	**--**	--	**11AH-364**	1110-1213	**--**	--

14, 14H, & 14T Series

0.25" (6.35 mm) Outside Diameter - .250-28 UNF Threads - 1.50" (38.1 mm) Overall Length

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.023" (0.6 mm)	.031" (0.79 mm)	**14-23**	1140-1100	**--**	--	**14T-23**	1140-1300
.030" (0.8 mm)	.038" (0.97 mm)	**14-30**	1140-1101	**--**	--	**14T-30**	1140-1301
.035" (0.9 mm)	.044" (1.12 mm)	**14-35**	1140-1102	**14H-35**	1140-1202	**14T-35**	1140-1302
.040" (1.0 mm)	.048" (1.22 mm)	**14-40**	1140-1103	**14H-40**	1140-1203	**--**	--
.045" (1.2 mm)	.054" (1.37 mm)	**14-45**	1140-1104	**14H-45**	1140-1204	**14T-45**	1140-1304
.052" (1.3 mm)	.064" (1.65 mm)	**14-52**	1140-1105	**14H-52**	1140-1205	**14T-52**	1140-1305
1/16" (1.6 mm)	.073" (1.85 mm)	**14-116**	1140-1106	**14H-116**	1140-1206	**14T-116**	1140-1306
5/64" (2.0 mm)	.090" (2.29 mm)	**14-564**	1140-1109	**14H-564**	1140-1209	**--**	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	**14A364**	1140-1113	**14AH-364**	1140-1213	**--**	--
1/16" AL (1.6 mm)	.082" (2.08 mm)	**--**	--	**14AH-116**	1140-1214	**--**	--

15H & 15HFC Series

0.345" (8.8 mm) Outside Diameter - .3125-24 UNF Threads, 15H & 15AH Series - 1.970" Overall Length; 15HFC - 1.590" Overall Length

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.044" (1.12 mm)	**15H-35**	1150-1202	**--**	--	**--**	--
.045" (1.2 mm)	.054" (1.37 mm)	**15H-45**	1150-1204	**15HFC-45**	1150-1254	**--**	--
.052" (1.3 mm)	.064" (1.65 mm)	**15H-52**	1150-1205	**15HFC-52**	1150-1255	**--**	--
1/16" (1.6 mm)	.073" (1.85 mm)	**15H-116**	1150-1206	**15HFC-116**	1150-1256	**--**	--
5/64" (2.0 mm)	.090" (2.29 mm)	**15H-564**	1150-1209	**15HFC-564**	1150-1259	**--**	--
3/32" (2.4 mm)	.106" (2.67 mm)	**15H-332**	1150-1210	**15HFC-332**	1150-1260	**--**	--
7/64" (2.8 mm)	.120" (3.05 mm)	**15H-764**	1150-1211	**15HFC-764**	1150-1261	**--**	--
1/8" (3.2 mm)	.144" (3.66 mm)	**15H-18**	1150-1212	**15HFC-18**	1150-1262	**--**	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	**15AH-364**	1150-1213	**--**	--	**--**	--
1/16" AL (1.6 mm)	.082" (2.08 mm)	**15AH-116**	1150-1214	**--**	--	**--**	--

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
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Contact Tips - Standard Threaded Style

16S & 16ST Series

0.375" (9.5 mm) Outside Diameter - M8 x 1.25 Threads - 1.50" (38.1 mm) Overall Length

25 per pack





Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Tapered	
		Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.044" (1.12 mm)	**16S-35**	1160-1102	**16ST-35**	1160-1135
.040" (1.0 mm)	.048" (1.22 mm)	**16S-40**	1160-1103	--	--
.045" (1.2 mm)	.054" (1.37 mm)	**16S-45**	1160-1104	**16ST-45**	1160-1137
.052" (1.3 mm)	.064" (1.65 mm)	**16S-52**	1160-1105	**16ST-52**	1160-1138
1/16" (1.6 mm)	.073" (1.85 mm)	**16S-116**	1160-1106	**16ST-116**	1160-1139
5/64" (2.0 mm)	.090" (2.29 mm)	**16S-564**	1160-1109	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	**16S-332**	1160-1110	--	--
7/64" (2.8 mm)	.120" (3.05 mm)	**16S-764**	1160-1111	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	**16AS-364**	1160-1113	--	--
1/16" AL (1.6 mm)	.082" (2.08 mm)	**16AS-116**	1160-1114	--	--

Contact Tips - Long Life Threaded

14RZ & 14RZT Series

.25" (6.35 mm) Outside Diameter - .250-28 UNF Threads - 1.50" (38.1 mm) Overall Length

25 per pack





Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Tapered	
		Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.041" (1.04 mm)	**14RZ-35**	1140-1430	**14RZT-35**	1140-1440
.045" (1.2 mm)	.051" (1.30 mm)	**14RZ-45**	1140-1432	**14RZT-45**	1140-1442
.052" (1.3 mm)	.058" (1.47 mm)	**14RZ-52**	1140-1433	**14RZT-52**	1140-1443

16RZ & 16RZT Series

0.312" (7.9 mm) Outside Diameter - M8 x 1.25 Threads - 1.50" (38.1 mm) Overall Length

25 per pack





Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Tapered	
		Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.041" (1.04 mm)	**16RZ-35**	1160-1180	**16RZT-35**	1160-1190
.045" (1.2 mm)	.051" (1.30 mm)	**16RZ-45**	1160-1182	**16RZT-45**	1160-1192
.052" (1.3 mm)	.058" (1.47 mm)	**16RZ-52**	1160-1183	**16RZT-52**	1160-1193

Contact Tips - Long Life PulseMaster® Threaded Style

16PS Series

0.375" (69.5 mm) Outside Diameter - M8 x 1.25 Threads - 1.81" (30 mm) Overall Length

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard	
		Part No.	Stock No.
.030" (0.8 mm)	.038" (0.97 mm)	**16PS-30**	1160-1543
.035" (0.9 mm)	.041" (1.04 mm)	**16PS-35**	1160-1535
.045" (1.2 mm)	.051" (1.30 mm)	**16PS-45**	1160-1537
.047" (1.2 mm)	.064" (1.63. mm)	**16APS-364**	1160-1538
.054" (1.3 mm)	.058" (1.50 mm)	**16PS-52**	1160-1541

Note: Gas Diffuser – Part No. PMA54-16S (Stock No. 1543-1106) or PMW55-16 (Stock No. 1550-1105) must be used with the 16PS series contact tips to maintain standard nozzle/contact tip relationship.

Contact Tips - Eliminator® Style

EL16 & EL16T Series

0.345" (6.35 mm) Outside Diameter - 1.50" (38.1 mm) Overall Length

25 per pack





Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Tapered	
		Part No.	Stock No.	Part No.	Stock No.
.030" (0.8 mm)	.038" (0.97 mm)	**EL16-30**	1160-1610	**EL16T-30**	1160-1601
.035" (0.9 mm)	.044" (1.12 mm)	**EL16-35**	1160-1611	**EL16T-35**	1160-1602
.040" (1.0 mm)	.048" (1.22 mm)	**EL16-40**	1160-1612	**EL16T-40**	1160-1603
.045" (1.2 mm)	.054" (1.37 mm)	**EL16-45**	1160-1613	**EL16T-45**	1160-1604
.052" (1.3 mm)	.064" (1.65 mm)	**EL16-52**	1160-1615	**EL16T-52**	1160-1605
1/16" (1.6 mm)	.073" (1.85 mm)	**EL16-116**	1160-1616	**EL16T-116**	1160-1606
5/64" (2.0 mm)	.090" (2.29 mm)	**EL16-564**	1160-1618	**--**	--
3/32" (2.4 mm)	.106" (2.67 mm)	**EL16-332**	1160-1619	**--**	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	**EL16A-364**	1160-1614	**EL16AT-364**	1160-1607

Contact Tips - Long Life Eliminator® Style

EL16RZ & EL16RZT Series

0.375" (9.5 mm) Outside Diameter - 1.50" (38.1 mm) Overall Length

25 per pack





Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Tapered	
		Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.041" (1.04 mm)	**--**	--	**EL16RZT-35**	1160-1705
.045" (1.2 mm)	.051" (1.30 mm)	**EL16RZ-45**	1160-1732	**EL16RZT-45**	1160-1707
.052" (1.3 mm)	.058" (1.47 mm)	**EL16RZ-52**	1160-1733	**EL16RZT-52**	1160-1708

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EASY FIND GUIDE - Nozzle Selection Guide

Nozzle Series	Output Current (Amps)	Nozzle Style	Bore Diameter Range (In / Mm)	Nozzle Design Options					Nozzle/Tip Relationship			Page
				Standard	Short Stop	Straight	Tapered	Heavy Duty	Flush	Recessed	Protruding	
21 Series	100	Thread-On	3/8" (9.5 mm) – 5/8" (15.9 mm)	■			■		■	■		107
REL 21 Series	100	Thread-On	1/2" (12.7 mm)			■			■	■	■	107
22 Series	200	Slip-On	3/8" (9.5 mm) – 5/8" (15.9 mm)	■	■				■	■	■	107
HD22 Series	200	Slip-On	3/8" (9.5 mm) – 5/8" (15.9 mm)	■					■	■		107
23 Series	300	Thread-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■					■	■		108
23T Series	300	Thread-On	3/8” (9.5 mm)				■		■	■		108
23H Series	300	Thread-On	1/2” (12.7 mm) – 3/4” (19.5 mm)					■	■	■		108
24A Series	400	Slip-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■	■			■	■	■	■	108
24CT Series	400	Thread-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■	■		■			■		109
24FN Series	400	Thread-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■	■		■			■		109
HD24 Series	400	Slip-On	1/2” (12.7 mm) – 3/4” (19.5 mm)	■			■		■	■		109
PMA24 Series	400	Thread-On	1/2” (12.7 mm) – 3/4” (19.5 mm)			■			■	■		110
25CT Series	500	Thread-On	1/2” (12.7 mm) – 3/4” (19.5 mm)	■						■		110
25I Series	500	Thread-On	5/8” (15.9 mm) – 3/4” (19.5 mm)	■						■		110
26CT Series	600	Thread-On	5/8” (15.9 mm) – 3/4” (19.5 mm)	■						■		110
26I Series	600	Thread-On	5/8” (15.9 mm) – 3/4” (19.5 mm)	■						■		110
FAS Series	--	Thread/Slip-On	1/2” (12.7 mm) – 1-5/8” (41.3 mm)									111
EL221 Series	400	Slip-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■						■	■	111
EL22CT Series	200	Thread-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■				■	■	■	■	111
EL24I Series	400	Slip-On	3/8” (9.5 mm) – 3/4” (19.5 mm)				■	■	■	■		112
EL24CT Series	400	Thread-On	3/8” (9.5 mm) – 3/4” (19.5 mm)	■				■	■	■	■	112
REL24 Series	400	Thread-On	1/2” (12.7 mm) – 3/4” (19.5 mm)			■			■	■	■	112
SW24 Series	400	Slip-On	5/8” (15.9 mm) – 13/16” (21 mm)	■						■		113
WC26 Series	600	Thread-On	1/2” (12.7 mm) – 3/4” (19.5 mm)	■					■	■	■	113
RWC26 Series	600	Thread-On	1/2” (12.7 mm) – 5/8” (15.9 mm)	■						■		114
PMW24 Series	400	Thread-On	1/2” (12.7 mm) – 3/4” (19.5 mm)	■					■	■		114

MIG Gun Nozzle to Tip Relationship - It’s More Than Just Welder’s Preference

Selecting the right nozzle for a welder’s preferred ‘nozzle to tip relationship’ on a MIG gun is generally based on the application and the welder’s daily welding routine.

Recessed Tips

are generally used for higher heat applications where longer electrical stick-out is required, or in cases where the nozzle may touch the work piece (tack, spot, and stitch).



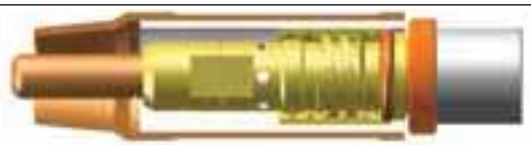
Flush Tips

are generally used where a shorter electrical stick-out is used sometimes resulting in shorter/tighter arc lengths. This brings the tip closer to the work piece.



Protruding Tips

are generally used when welding open root pipe or any joint that requires the welder to get into a tight weld joint. However the down side to this is the chance of arcing the tip to the work piece, which could damage front end parts resulting in downtime needed to replace.



Nozzles & Nozzle Insulators - Air-Cooled

21 Series

3-Piece Nozzle Design - 0.750" (19.05 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack


21 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**21-37F**	1210-1102	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	3/8" (9.5 mm)	**21-37**	1210-1100	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	**21T-37**	1210-1300	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	**21T-37F**	1210-1302	**Tapered**	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	**21-50F**	1210-1112	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	**21-50**	1210-1110	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**21-62**	1210-1120	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

REL 21 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack


REL 21 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	1/2" (12.7 mm)	**REL21-50F**	1210-1316	**Straight**	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	**REL21-50P**	1210-1321	**Straight**	5/32" (3.97 mm) Tip Protruding

22 Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter
Use with Nozzle Insulator Part No. 32 (Stock No. 1320-1100).
2 per pack


22 Series


32 Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	**22-37SS**	1220-1101	**Standard Short Stop**	Flush to 1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	**22T-37SS**	1220-1301	**Standard Short Stop**	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	**22-50**	1220-1110	**Standard**	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	**22-50SS**	1220-1111	**Standard Short Stop**	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**22-62**	1220-1120	**Standard**	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	**22-62SS**	1220-1121	**Standard Short Stop**	Flush to 1/8" (3.2 mm) Tip Recess

HD22 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack


HD22 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	**HD22-37**	1220-1305	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**HD22-50**	1220-1306	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**HD22-50F**	1220-1311	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**HD22-62**	1220-1307	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**HD22-62F**	1220-1312	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess

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Nozzles & Nozzle Insulators - Air-Cooled

23 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack



23 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**23-37**	1230-1100	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**23-50**	1230-1110	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**23-50F**	1230-1112	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**23-62**	1230-1120	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**23-62F**	1230-1122	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**23-75**	1230-1130	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**23-75F**	1230-1132	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

23T Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack



23T Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**23T-37**	1230-1300	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	**23T-37F**	1230-1302	**Tapered**	Flush To 1/16" (1.6 mm) Tip Recess

23H Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack



23H Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**23H-50**	1230-1210	**Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**23H-62**	1230-1220	**Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**23H-62F**	1230-1222	**Heavy Duty**	Flush To 1/16" (1.6 mm) Tip Recess
	3/4" (19.5 mm)	**23H-75**	1230-1230	**Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

24A Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter
Use with Nozzle Insulator Part No. 34A (Stock No. 1340-1100).
2 per pack



24A Series



34A Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	**24A-37SS**	1240-1101	**Standard Short Stop**	1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	**24AT-37SS**	1240-1301	**Standard Short Stop**	1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	**24A-50**	1240-1110	**Standard**	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	**24A-50SS**	1240-1111	**Standard Short Stop**	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**24A-62**	1240-1120	**Standard**	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	**24A-62SS**	1240-1121	**Standard Short Stop**	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**24AH-62**	1240-1220	**Standard Heavy Duty**	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	**24AH-62SS**	1240-1221	**Standard Short Stop**	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**24A-75**	1240-1130	**Standard**	Adjustable Tip Recess - Tip Protruding
	3/4" (19.5 mm)	**24AH-75**	1240-1230	**Standard Heavy Duty**	Adjustable Tip Recess - Tip Protruding
	3/4" (19.5 mm)	**24AH-75SS**	1240-1231	**Standard Short Stop**	1/8" (3.2 mm) Tip Recess

Nozzles & Nozzle Insulators - Air-Cooled

24CT Series

Coarse Thread Nozzle - 1.070" (27.2 mm) Outside Diameter
at the knurled flat section
Use with Nozzle Insulator Part No. 34CT (Stock No. 1340-1400).
2 per pack


24CT Series


34CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**24CT-37S**	1240-1404	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess
	1/2" (12.7 mm)	**24CT-50S**	1240-1414	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**24CT-62S**	1240-1424	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**24CT-62F**	1240-1422	**Tapered**	1/16" (1.59 mm) Tip Recess
	5/8" (15.9 mm)	**24CT-62R**	1240-1423	**Tapered**	1/2" (12.7 mm) Tip Recess
	3/4" (19.5 mm)	**24CT-75S**	1240-1434	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess

24FN Series

Fine Thread Nozzle - 1.070" (27.2 mm) Outside Diameter
at the knurled flat section
Use with Nozzle Insulator Part No. 34FN (Stock No. 1340-1401).
2 per pack


24FN Series


34FN Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**24FN-37S**	1240-1704	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**24FN-62S**	1240-1724	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**24FN-62R**	1240-1723	**Tapered**	1/16" (1.59 mm) Tip Recess
	3/4" (19.5 mm)	**24FN-75S**	1240-1734	**Standard Short Stop**	5/32" (3.97 mm) Tip Recess

HD24 Series

3-Piece Nozzle Design - 1.117" (28.4 mm) Outside Diameter
Self Insulated Nozzles. Use with HD54 Series Gas Diffusers.
2 per pack


HD24 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	1/2" (12.7 mm)	**HD24L-50**	1240-1200	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**HD24-50**	1240-1240	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**HD24L-62**	1240-1201	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**HD24L-62F**	1240-1205	**Tapered**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**HD24-62**	1240-1241	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**HD24-62F**	1240-1236	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	3/4" (19.5 mm)	**HD24L-75**	1240-1202	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**HD24-75**	1240-1242	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**HD24-75F**	1240-1237	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**HD24LB-62**	1240-1216	**Standard †**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**HD24LB-62F**	1240-1219	**Tapered †**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**HD26B-62**	1260-1285	**Standard †**	5/32" (3.97 mm) Tip Recess
	3/4" (19.5 mm)	**HD26B-75**	1260-1286	**Standard †**	5/32" (3.97 mm) Tip Recess

†Outer shell made from red brass Alloy 230

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Nozzles & Nozzle Insulators - Air-Cooled

PMA24 Series PulseMaster® and PullMaster™ Air-Cooled Nozzles



PMA24 Series

3-Piece Nozzle Design - 1.000" (25.4 mm) Outside Diameter
Self Insulated Nozzles. Nozzles are nickel plated.
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**PMA24-50F**	1260-1710	**Straight**	Flush To 1/16" (1.6 mm)
	1/2" (12.7 mm)	**PMA24-50**	1260-1711	**Straight**	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	**PMA24-62F**	1260-1712	**Straight**	Flush to 1/16" (1.6 mm)
	5/8" (15.9 mm)	**PMA24-62**	1260-1713	**Straight**	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	**PMA24H-62**	1260-1720	**Straight**	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	**PMA24-75F**	1260-1714	**Straight**	Flush To 1/16" (1.6 mm)
	3/4" (19.5 mm)	**PMA24-75**	1260-1715	**Straight**	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	**PMA24H-75**	1260-1721	**Straight**	0.156" (3.9 mm) Tip Recess

25CT Series



25CT Series



35CT Insulator
(sold separately)

Coarse Thread Nozzle - 1.080" (27.4 mm) Outside Diameter
at the knurled flat section
Use with Nozzle Insulator Part No. 35CT (Stock No. 1350-1400).
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**25CT-50**	1250-1410	**Standard**	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**25CT-62**	1250-1420	**Standard**	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**25CT-75**	1250-1430	**Standard**	1/8" (3.2 mm) Tip Recess

25I Series



25I Series

3-Piece Nozzle Design - 0.970" (24.6 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	5/8" (15.9 mm)	**25I-62**	1250-1120	**Standard**	5/32" (3.97 mm) Tip Recess
	3/4" (19.5 mm)	**25I-75**	1250-1130	**Standard**	5/32" (3.97 mm) Tip Recess

26CT Series



26CT Series



36CT Insulator
(sold separately)

Coarse Thread Nozzle - 1.080" (27.4 mm) Outside Diameter
at the knurled flat section
Use with Nozzle Insulator Part No. 36CT (Stock No. 1360-1400).
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	5/8" (15.9 mm)	**26CT-62**	1260-1420	**Standard**	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**26CT-75**	1260-1430	**Standard**	1/8" (3.2 mm) Tip Recess

26I Series



26I Series

3-Piece Nozzle Design - 0.970" (24.6 mm) Outside Diameter
Self Insulated Nozzles.
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	5/8" (15.9 mm)	**26I-62**	1260-1120	**Standard**	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**26I-75**	1260-1130	**Standard**	1/8" (3.2 mm) Tip Recess

Nozzles & Nozzle Insulators - Flat Arc Spot Style Air-Cooled

FAS Series

Self Insulated Nozzles.
2 per pack


21-62FAS

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**21-62FAS**	1210-1520	--	--

FAS Series

Use with Nozzle Insulator Part No. 34A (Stock No. 1340-1100).
2 per pack


24A-100FAS


34A Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/4" (19.5 mm)	**24A-100FAS**	1240-1550	--	--

FAS Series

Use with Nozzle Insulator Part No. 35CT (Stock No. 1350-1400).
2 per pack


25CT-162FAS


35CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1-5/8" (41.3 mm)	**25CT-162FAS**	1250-1570	--	--

Nozzles - Eliminator® Style Air-Cooled

EL22I Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles. Use with Part No. EL52 (Stock No. 1560-1110) Gas Diffuser.
2 per pack


EL21I Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	**EL22I-37**	1260-1601	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**EL22I-50**	1260-1602	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**EL22I-50P**	1260-1686	**Standard**	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	**EL22I-62**	1260-1603	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**EL22I-75**	1260-1604	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

EL22CT Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles. Use with Part No. EL52CT Series Gas Diffuser.
2 per pack


EL22CT Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**EL22CT-37**	1260-1625	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	**EL22CT-37F**	1260-1635	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	**EL22CT-50**	1260-1626	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**EL22CT-50F**	1260-1636	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**EL22CT-62**	1260-1627	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**EL22CT-62F**	1260-1637	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**EL22CT-62P**	1260-1692	**Standard**	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	**EL22CT-62H**	1260-1629	**Standard, Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**EL22CT-75**	1260-1628	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

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Nozzles - Eliminator® Style Air-Cooled

EL24I Series



EL24I Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles. Use with Part No. EL54 Series Gas Diffusers.
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	**EL24I-37**	1260-1606	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**EL24I-50**	1260-1607	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**EL24I-62**	1260-1608	**Tapered**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**EL24I-62R**	1260-1677	**Tapered**	3/8" (9.5 mm) Tip Recess
	5/8" (15.9 mm)	**EL24I-62H**	1260-1631	**Tapered, Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**EL24I-75**	1260-1609	**Tapered**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**EL24I-75H**	1260-1632	**Tapered, Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

EL24CT Series



EL24CT Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Self Insulated Nozzles. Use with Part No. EL52CT Series Gas Diffusers.
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**EL24CT-37**	1260-1650	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**EL24CT-50**	1260-1651	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**EL24CT-50P**	1260-1701	**Standard**	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	**EL24CT-62**	1260-1652	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**EL24CT-62F**	1260-1667	**Standard**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**EL24CT-62R**	1260-1682	**Standard**	3/8" (9.5 mm) Tip Recess
	5/8" (15.9 mm)	**EL24CT-62H**	1260-1657	**Standard, Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**EL24CT-75**	1260-1653	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**EL24CT-75H**	1260-1658	**Standard, Heavy Duty**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

REL24 Series



REL24 Series

3-Piece Nozzle Design - 1.000" (25.4 mm) Outside Diameter
Self Insulated Nozzles. Nickel plated nozzle. Use with Part No. QTR56-SW Gas Diffuser.
2 per pack

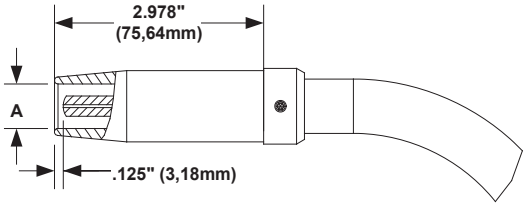
Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**REL24CT-50**	1240-1305	**Straight**	5/32" (3.97 mm) Tip Recess
	1/2" (12.7 mm)	**REL24CT-50F**	1240-1315	**Straight**	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	**REL24CT-50P**	1240-1310	**Straight**	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	**REL24CT-62**	1240-1306	**Straight**	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**REL24CT-62F**	1240-1316	**Straight**	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**REL24CT-62P**	1240-1311	**Straight**	5/32" (3.97 mm) Tip Recess
	3/4" (19.5 mm)	**REL24CT-75F**	1240-1317	**Straight**	Flush To 1/16" (1.6 mm) Tip Recess
	3/4" (19.5 mm)	**REL24CT-75P**	1240-1312	**Straight**	5/32" (3.97 mm) Tip Protruding

Nozzles & Nozzle Insulators - Water-Cooled

WC24 Series – Standard Tip Recess

Use with WC24-1 (Stock No. 1244-1009)
Nozzle Insulator .125" (3.18 mm)

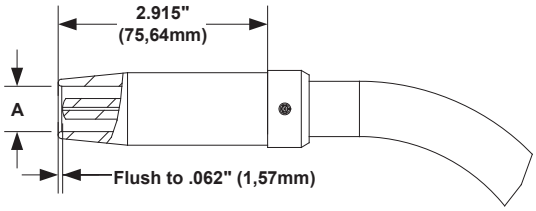
Bore Size "A"	Part No.	Stock No.
.500" (12.7mm)	**WC24-50**	1244-1110
.625" (15.9 mm)	**WC24-62**	1244-1120
.750" (19.1 mm)	**WC24-75**	1244-1130



WC24 Series – Flush Tip Recess

Use with WC24-1 (Stock No. 1244-1009)
Nozzle Insulator Flush to .062" (1.57 mm)

Bore Size "A"	Part No.	Stock No.
.500" (12.7 mm)	**WC24-50F**	1244-1112
.625" (15.9 mm)	**WC24-62F**	1244-1122



SW24 Series

Use with Insulator Ring Part No. SW64-3 (Stock No. 2044-1020).
2 per pack


SW24 Series


SW64-3
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	5/8" (15.9 mm)	**SW24-15**	1244-1026	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	11/16" (17 mm)	**SW24-17**	1244-1025	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	13/16" (21 mm)	**SW24-21**	1244-1027	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WC26 Series - Standard

3-Piece Nozzle Design - 1.062" (30 mm) Outside Diameter
Use with Spatter Shield Part No. WC26-1 (Stock No. 1264-1009).
2 per pack


WC26 Series


WC26-1
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On (Standard)	5/8" (15.9 mm)	**WC26-62**	1264-1120	**Standard**	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WC26-62R**	1264-1123	**Standard**	1/4" (6.4 mm) Tip Recess
	3/4" (19.5 mm)	**WC26-75**	1264-1130	**Standard**	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**WC26-75F**	1264-1132	**Standard**	Tip Flush
	3/4" (19.5 mm)	**WC26-75R**	1264-1133	**Standard**	1/4" (6.4 mm) Tip Recess
Thread-On* (Eliminator®)	1/2" (12.7 mm)	**WC26-50EL***	1262-1031	**Standard**	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WC26-62EL***	1262-1032	**Standard**	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WC26-62ELF***	1262-1037	**Standard**	Tip Flush
	3/4" (19.5 mm)	**WC26-75EL***	1262-1033	**Standard**	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**WC26-75ELF***	1262-1038	**Standard**	5/32" (3.97 mm) Tip Protruding
	3/4" (19.5 mm)	**WC26-75ELR***	1262-1042	**Standard**	Tip Flush

**Use with Eliminator style contact tips*

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Nozzles & Nozzle Insulators - Water-Cooled

RWC26 Series



RWC26 Series

Nickel plated nozzles.
Use with Spatter Shield Part No. WC26EL-1 (Stock No. 1262-1049).
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**RWC26-50**	1264-1430	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**RWC26-62**	1264-1431	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**RWC26-75**	1264-1432	**Standard**	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

PMW24 Series PulseMaster™ Water-Cooled Nozzles



PMW24 Series

Nickel plated nozzles.
2 per pack

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**PMW24-50F**	1260-1735	**Standard**	Flush To 1/2" (12.5 mm)
	1/2" (12.7 mm)	**PMW24-50**	1260-1736	**Standard**	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	**PMW24-62F**	1260-1737	**Standard**	Flush to 5/8" (16 mm)
	5/8" (15.9 mm)	**PMW24-62**	1260-1738	**Standard**	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	**PMW24-75F**	1260-1739	**Standard**	Flush To 3/4" (19 mm)
	3/4" (19.5 mm)	**PMW24-75**	1260-1740	**Standard**	0.156" (3.9 mm) Tip Recess

Gas Diffusers - Standard Air-Cooled

Mini-MIG Series 160 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
35-50	1500-1100	Brass	11 Series	21 Series

51 Series 100 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
51	1510-1101	Brass	11 Series	21 Series
51-23	1510-1100	Brass	11-23	21 Series
EL51	1510-1105	Brass	EL11 Series	REL21 Series
QTRW53-11	1525-1141	Brass	11 Series	REL21 Series

52 Series 200 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
52	1520-1101	Brass	14 Series	22 Series
52FN	1520-1102	Brass	14 Series	24A or 23 Series
MS52T-11	1520-1133	Brass	11 Series	22 Series

Gas Diffusers - Standard Air-Cooled

54 Series 400 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
54P	1540-1103	Copper	14 Series	24A, 24CT, & 23 Series
54A	1540-1100	Brass	14 Series	24A, 24CT, & 23 Series
54A-16	1540-1104	Brass	16S Series	24A, 24CT, & 23 Series
HD54-14	1540-1135	Brass	14 Series	HD24 Series
HD54-16	1540-1136	Brass	16S Series	HD24 Series
HD54-EL	1540-1137	Brass	EL16 Series	HD24 Series
PMA54-16S	1543-1106	Brass	16PS Series	PMA24 Series

55 Series 500 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
55SW *	1550-1101	Copper	15H Series	25CT Series
55 †	1550-1100	Copper	15H Series	25CT Series
55H §	1550-1102	Copper	15H Series	25CT Series
55S-SW *	1550-1110	Copper	16S Series	25I Series
55S-H † §	1550-1111	Copper	16S Series	25I Series
55S-SWL ‡	1550-1120	Copper	16S Series	25I Series
PMW55-16	1550-1105	Brass	16PS Series	PMW24 Series

** Use with 45-3545, 45-116, and 45N-3545 Conduit Liners*
† Use with 45-564, and 45N-116 Conduit Liners
§ Use with 45H-332, 45H-764, and 45-18 Conduit Liners
‡ Use with 45-3545, 45-116, and 45N-3545 Conduit Liners. Tip/Nozzle relationship will be 1/8" (3.2 mm) tip recess

56 Series 600 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
56S-SW	1560-1100	Copper	16S Series	26CT or 26I
56S-H	1560-1101	Copper	16S Series	26CT or 26I

EL52 Series 200 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
EL52	1560-1110	Brass	EL16 Series	EL22I Series
EL52CT	1560-1109	Brass	EL16 Series	EL22CT Series
EL52CT-14	1560-1106	Brass	14 Series	EL22CT Series
EL52CT-16	1560-1107	Brass	16S Series	EL22CT Series

Replacement O-ring for EL52 Series Gas Diffuser use Part No. EL52-1 (Stock No. 1560-1108)

HD52 Series 200 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
HD52-11	1520-1130	Brass	11 Series	HD22 Series

Replacement O-ring for HD52 Series Gas Diffuser use Part No. EL52-1 (Stock No. 1560-1108)

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Gas Diffusers - Eliminator® Style Air-Cooled

EL54 Series 400 Amp



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
EL54-SW *	1560-1114	Brass	EL16 Series	EL24I Series
EL54-H †	1560-1115	Brass	EL16 Series	EL24I Series
EL54CT-SW *	1560-1116	Brass	EL16 Series	EL24CT Series
EL54CT-H †	1560-1117	Brass	EL16 Series	EL24CT Series

Replacement O-ring for EL54 Series Gas Diffuser use Part No. EL54-10 (Stock No. 1560-1121)
** Use with 45-3545, 45-116, and 45N-3545 Conduit Liners*
† Use with 45-564, 45N-116, 45H-332, 45H-764, and 45-18 Conduit Liners

Gas Diffusers - Water-Cooled



WC54A



QTRW54-16

400 Amp

5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WC54A	1544-1141	Brass		
SW54-16S	1540-1115	Brass	16S Series	SW24 Series
SW54-EL	1540-1116	Brass	EL16 Series	SW24 Series
QTRW54	1544-1125	Brass	14H Series	RWC24 Series
QTRW54-16	1544-1126	Brass	16S Series	RWC24 Series



WC56A-SW



WC56EL-H

600 Amp

5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WC56A-SW	1564-1145	Brass	16S Series	WC26 or RWC26 Series
WC56A	1564-1143	Brass		
WC56A-H	1564-1144	Brass		
WC56EL-SW	1560-1146	Brass	EL16 Series	WC26EL or RWC26 Series
WC56EL-H	1560-1147	Brass	EL16 Series	WC26EL or RWC26 Series
QTRW56-SW	1560-1125	Brass	16S Series	WC26 or RWC26 Series

EASY FIND GUIDE - Conductor Tube Selection Guide

MIG Gun Series	Output Current (Amps)	Bend Angles (Degrees)	Threads		Outer Jacket Material	Page
			Back End	Front End		
Mini-MIG® Series	160	45 & 60 Degrees	■	■	Neoprene Rubber	119
Classic No. 1 Series	180	60 & 180 Degrees		■	Neoprene Rubber	119
Classic No. 2 Series	200	60, 80 & 180 Degrees	■	■	Metal or Fiber	119
Classic No. 3 Series	300	45, 60 & 180 Degrees	■	■	Metal	119
Classic No. 4 Series	400	45, 60, 80 & 180 Degrees	■	■	Metal	119
Classic No. 5 Series	500	45, 60 & 180 Degrees	■	■	Metal	119
Classic No. 6 Series	600	60 Degrees	■	■	Metal	119
Mini-MIG® V-Series	160	60 Degrees	■		Neoprene Rubber	120
Velocity™ Classic No. 1 Series	180	60 Degrees	■		Neoprene Rubber	120
Velocity Classic No. 2 Series	200	45, 60, 80 & 180 Degrees	■		Metal	120
Velocity Classic No. 3 Series	300	45, 60, 80 & 180 Degrees	■		Metal	120
Velocity Classic No. 4 Series	400	45, 60, 80 & 180 Degrees	■		Metal	120
Velocity Classic No. 5 Series	500	45, 60, 80 & 180 Degrees	■		Metal	120
Spray Master® 250 Series	250	60 Degrees		■	Metal	121
Spray Master 350 Series	350	45, 60 & 180 Degrees		■	Metal	121
Spray Master 450 Series	450	45 & 60 Degrees		■	Metal	121
Velocity™ Spray Master® 250 Series	250	45, 60, & 180 Degrees			Metal	121
Velocity Spray Master 350 Series	350	45, 60 & 180 Degrees			Metal	121
Velocity Spray Master 450 Series	450	45, 60, & 180 Degrees			Metal	121
Compact Eliminator® 250 Series	250	45 & 60 Degrees		■	Metal	121
Compact Eliminator 450 Series	450	45 & 60 Degrees		■	Metal or Fiber	121
Standard Eliminator 450 Series	450	45, 60 & 180 Degrees		■	Metal or Fiber	121
Tuff-n-Lite 350 Series	350	60 Degrees		■	Fiber	122
Supra® XT - SEHD Series	400	45 & 60 Degrees	■	■	Metal	122
Supra XT - SEL Series	400	45 Degrees	■	■	Metal	122
PulseMaster™ 350 & 450 Series	350 & 450	45 Degrees		■	Metal	122
SSG Spool Series	160 & 200	30 & 180 Degrees		■	Metal	122
PMP Push/Pull Series	300	30 & 180 Degrees		■	Metal	122
Smoke Master® 250 Series	250	45 & 60 Degrees	■	■	Powder Coat	122
Smoke Master 450 Series	450	60 Degrees	■	■	Teflon	122
Flux Cored 350 Series	350	60 Degrees		■	Thermo Flex	122
Flux Cored 450 Series	450	60 Degrees		■	Thermo Flex	122
PulseMaster 400 & 500 Series	400 & 500	45 Degrees		■	Metal	123
Supra 450 Series	450	60 Degrees		■	Neoprene Rubber	123
Standard 600 Series	600	60 Degrees		■	Neoprene Rubber	123
Traditional Series	400	60, 80 & 180 Degree Extensions				123

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Conductor Tubes - Flexible Knucklehead™

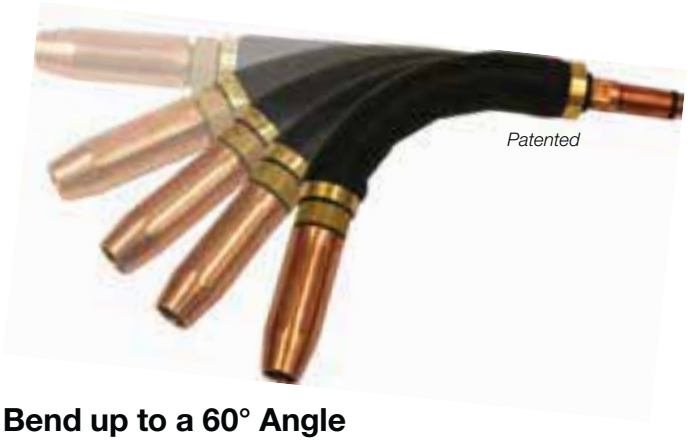
Engineered to Last Longer

Patent pending mechanical connections engineered to last 50 times longer than any other design on the market today. Proven in heavy duty field trials, the Knucklehead flexible conductor tube is rugged and flexible enough to be used everyday. It makes difficult welding applications easier.

- Improved weld quality
- Increased productivity
- Less welder fatigue
- Improves the ergonomics of any MIG Gun
- Lasts longer than any design on the market today
- Eliminates downtime caused by changing conductor tubes

Each connector allows for approximately 20° of bend. Two models are offered in 3 or 4 connector designs. Each three-connector design allows a maximum of 60° of bend and each four-connector design allows a maximum of 80° of bend. Extended reach Knucklehead conductor tubes are also available designated with "LR" on the end of the part number.

Heavy Duty performance even on your 80% Duty Cycle guns



Bend up to a 60° Angle

- Specially engineered to bend while minimizing restrictions on wire feeding
- Get that same consistent angle and firm feel that any comparable bent rigid tube offers
- Bend to the right feel and comfort. The engineers at Tweco® have designed the Knucklehead to work with the following Tweco MIG guns: Spray Master® Series, Classic No. Series, Eliminator® Series and Standard WeldSkill® Series

Spray Master® Series

Amp/ Model	Bend Angle	Stand. Cons.*	EL Cons.‡	Long Reach†	Part No.	Stock No.
250	60°	■			MS62SFLX3-60	1620-1341
	80°	■			MS62SFLX4-80	1620-1342
350	60°	■			MS63SFLX3-60	1630-1197
	80°	■			MS63SFLX4-80	1630-1198
450	60°	■			MS64SFLX3-60	1640-1307
	80°	■			MS64SFLX4-80	1640-1308
	60°	■		■	MS64SFLX3-60LR	1640-1309
	80°	■		■	MS64SFLX4-80LR	1640-1310
	60°		■		MS64SFLX3-60EL	1640-1370
	80°		■		MS64SFLX4-80EL	1640-1371

Classic No. Series

Amp/ Model	Bend Angle	Stand. Cons.*	Long Reach†	Part No.	Stock No.
Mini	60°	■		3560SFLX3-60	1600-1139
	80°	■		3560SFLX4-80	1600-1141
No. 1	80°	■		61SFLX4-80	1610-1105
No. 2	60°	■		62SFLX3-60	1620-1105
	80°	■		62SFLX4-80	1620-1106
No. 3	60°	■		64SFLX3-60	1640-1112
No. 4	80°	■		64SFLX4-80	1640-1113
	60°	■	■	64SFLX3-60LR	1640-1121
	80°	■	■	64SFLX4-80LR	1640-1122

Eliminator® Series

Amp/ Model	Bend Angle	EL Cons.‡	Long Reach†	Part No.	Stock No.
250	60°	■		EL62SFLX3-60	1620-1115
	80°	■		EL62SFLX4-80	1620-1116
450	60°	■		EL64SFLX3-60	1640-1143
	80°	■		EL64SFLX4-80	1640-1144
	80°	■	■	EL64SFLX4-80LR	1640-1149

**Standard Style Consumables*
‡Eliminator Style Consumables
†Long Reach Conductor Tube (2" longer)

Standard WeldSkill® Series

Amp/ Model	Bend Angle	Stand. Cons.*	Long Reach†	Part No.	Stock No.
250	60°	■		62SFLX3-60	1620-1105
	80°	■		62SFLX4-80	1620-1106
400	60°	■		64SFLX3-60	1640-1112
	80°	■		64SFLX4-80	1640-1113
	60°	■	■	64SFLX3-60LR	1640-1121
	80°	■	■	64SFLX4-80LR	1640-1122

Outer Jacket Repair Kit
250A - Part No. FLXSJ-RK (Stock No. 1620-1345)
350/450A - Part No. FLXLJ-RK (Stock No. 1640-1385)
(Repair Kits include the neoprene outer jacket and stainless steel straps)

Conductor Tubes - Air-Cooled

Mini-MIG

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/4" (57 mm) Radius	**35-60-60**	1600-1102	Neoprene Rubber	O.D. M12 x 1.5-6g	I.D. M9 x 1.25-6g
45 Degree with 1-3/4" (44.5 mm) Radius	**35-60-45**	1600-1101	Neoprene Rubber	O.D. M12 x 1.5-6g	I.D. M9 x 1.25-6g

Classic No. 1

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/2" (63.5 mm) Radius	**61-60**	1610-1102	Neoprene Rubber	--	I.D. M10 x 1.5-6H
180 Degree, Straight	**61-180**	1610-1104	Neoprene Rubber	--	I.D. M10 x 1.5-6H

Classic No. 2

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**62J-60**	1620-1301	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
60 Degree with 2" (50.5 mm) Radius	**62A-60**	1620-1102	Fiber	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
80 Degree with 2" (50.5 mm) Radius	**62ELJ-80**	1620-1307	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H
180 Degree, Straight	**62ELJ-180**	1620-1308	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H

Classic No. 3

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**63J-60**	1630-1111	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	**63J-45**	1630-1110	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
180 Degree, Straight	**63ELJ-180**	1630-1118	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H

Classic No. 4

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**64J-60**	1640-1106	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	**64J-45**	1640-1105	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
60 Degree with 3" (76.2 mm) Radius	**64A-60**	1640-1102	Fiber	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	**64A-45**	1640-1101	Fiber	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
Eliminator 60 Degree with 3" (76.2 mm) Radius	**64ELJ-60**	1640-1117	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	**64ELJ-45**	1640-1116	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 80 Degree with 2" (50.5 mm) Radius	**64ELJ-80**	1640-1118	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 180 Degree, Straight	**64ELJ-180**	1640-1119	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H

Classic No. 5

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 5" (127 mm) Radius	**65J-60**	1650-1111	Metal	I.D. 7/16"-20 UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A
45 Degree with 5" (127 mm) Radius	**65J-45**	1650-1110	Metal	I.D. 7/16"-20 UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A
180 Degree, Straight	**65J-180**	1650-1113	Metal	I.D. 7/16"-20 UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A

Classic No. 6

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 5" (127 mm) Radius	**66J-60**	1660-1826	Metal	I.D. 7/16"-20 UNF-2B	I.D. M12 x 1.5 6H O.D. M17 x 2.0-6G

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Conductor Tubes - Air-Cooled

Velocity Mini-MIG

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/4" (57 mm) Radius	**VCTS35-60-60**	1600-1106	Neoprene Rubber	O.D. M12 x 1.5-6g	--

Velocity Classic No. 1

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/4" (57mm) Radius	**VA61-60**	1010-1105	Neoprene Ruber	O.D. M12 x 1.5-6g	--

Velocity Classic No. 2

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**VCTL62-60**	1620-1371	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
45 Degree with 3" (76.2 mm) Radius	**VCTL62-45**	1620-1372	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
80 Degree with 3" (76.2 mm) Radius	**VCTL62-80**	1620-1373	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
180 Degree, Straight	**VCTL62-180**	1620-1374	Metal	I.D. 3/8"-24 UNF-2B I.D.	--

Velocity Classic No. 3

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**VCTL63-60**	1630-1225	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
45 Degree with 3" (76.2 mm) Radius	**VCTL63-45**	1630-1226	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
80 Degree with 3" (76.2 mm) Radius	**VCTL63-80**	1630-1227	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
180 Degree, Straight	**VCTL63-180**	1630-1228	Metal	I.D. 3/8"-24 UNF-2B I.D.	--

Velocity Classic No. 4

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**VCTL64-60**	1640-1391	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
45 Degree with 3" (76.2 mm) Radius	**VCTL64-45**	1640-1392	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
80 Degree with 3" (76.2 mm) Radius	**VCTL64-80**	1640-1393	Metal	I.D. 3/8"-24 UNF-2B I.D.	--
180 Degree, Straight	**VCTL64-180**	1640-1394	Metal	I.D. 3/8"-24 UNF-2B I.D.	--

Velocity Classic No. 5

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 5" (127 mm) Radius	**VCTL66-60**	1660-1242	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
45 Degree with 5" (127 mm) Radius	**VCTL66-45**	1660-1243	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
80 Degree with 5" (127 mm) Radius	**VCTL66-80**	1660-1241	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
180 Degree, Straight	**VCTL66-180**	1660-1244	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
60 Degree with 5" (127 mm) Radius	VCTL66H-60	1660-1245	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
45 Degree with 5" (127 mm) Radius	VCTL66H-45	1660-1246	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
80 Degree with 5" (127 mm) Radius	VCTL66H-80	1660-1247	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----
180 Degree, Straight	VCTL66H-180	1660-1248	Metal	I.D. 7/16"-20 UNF-2B I.D.	-----

** VCTL66H Series Conductor tubes for use with 45H Series Conduit Liner

Conductor Tubes - Air-Cooled

Spray Master® 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2" (50.5 mm) Radius	**MS63-60S**	1630-1196	Metal	--	I.D. M11 x 1.5-6H
60 Degree with 3" (76.2 mm) Radius	**MS63-60**	1630-1189	Metal	--	I.D. M11 x 1.5-6H
60 Degree with 2" (50.5 mm) Radius	**MS62A-60**	1620-1340	Metal	--	I.D. 3/8" 24 UNF-2B

Spray Master 350

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**MS63-60**	1630-1189	Metal	--	I.D. M11 x 1.5-6H
45 Degree with 3" (76.2 mm) Radius	**MS63-45**	1630-1188	Metal	--	I.D. M11 x 1.5-6H
180 Degree, Straight	**MS63-180**	1630-1187	Metal	--	I.D. M11 x 1.5-6H

Spray Master 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Heavy Duty 60 Degree with 3" (76.2 mm) Radius	**MS64H-60**	1640-1319	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Heavy Duty 45 Degree with 3" (76.2 mm) Radius	**MS64H-45**	1640-1318	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Long Reach 60 Degree with 3" (76.2 mm) Radius	**MS64H-60LM ***	1640-1317	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Long Reach 45 Degree with 3" (76.2 mm) Radius	**MS64H-45LM ***	1640-1323	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
60 Degree with 3" (76.2 mm) Radius	**MS64-60S ****	1640-1342	Metal	--	I.D. M12 x 1.5-6H

** Long reach conductor tube – 2" longer than standard*
*** Comes standard on all 450 Amp Spray Master MIG guns with the suffix "EL"*

Velocity Spray Master 250, 350, 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Heavy Duty 60 Degree with 3" (76.2 mm) Radius	**SMVCT-60**	1240-1374	Metal	--	--
Heavy Duty 45 Degree with 3" (76.2 mm) Radius	**SMVCT-45**	1240-1373	Metal	--	--
Heavy Duty 180 Degree, Straight	**SMVCT-180**	1240-1375	Metal	--	--
Long Reach, Heavy Duty 60 Degree with 3" (76.2 mm) Radius	**SMVCT-60LM**	1640-1374	Metal	--	--
Long Reach, Heavy Duty 45 Degree with 3" (76.2 mm) Radius	**SMVCT-45LM**	1640-1373	Metal	--	--

Compact Eliminator® 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	**EL63J-60**	1630-1137	Metal	--	I.D. M11 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	**EL63J-45**	1630-1136	Metal	--	I.D. M11 x 1.5-6H

Compact Eliminator 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	**EL64J-60**	1640-1137	Metal	--	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	**EL64J-45**	1640-1136	Metal	--	I.D. M12 x 1.5-6H
60 Degree with 2-1/4" (57 mm) Radius	**EL64-60**	1640-1110	Fiber	--	I.D. M12 x 1.5-6H

Standard Eliminator 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	**EL64J-60**	1640-1137	Metal	--	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	**EL64J-45**	1640-1136	Metal	--	I.D. M12 x 1.5-6H
180 Degree, Straight	**EL64J-180**	1640-1135	Metal	--	I.D. M12 x 1.5-6H
60 Degree with 2-1/4" (57 mm) Radius	**EL64-60**	1640-1110	Fiber	--	I.D. M12 x 1.5-6H
45 Degree with 2-1/4" (57 mm) Radius	**EL64-45**	1640-1111	Fiber	--	I.D. M12 x 1.5-6H

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Conductor Tubes - Air-Cooled

Tuff-n-Lite 350

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	**64TL-60**	1635-1031	Fiber	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A

Supra® XT - SEHD

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**SE64J-60**	1640-1347	Metal	O.D. 9/16"-18 UNF-2A	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
45 Degree with 3" (76.2 mm) Radius	**SE64J-45**	1640-1346	Metal	O.D. 9/16"-18 UNF-2A	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A

Supra XT - SEL

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
45 Degree with 3" (76.2 mm) Radius	**SEL64J-45**	1640-1321	Metal	O.D. 9/16"-18UNF-2A	I.D. M12 x 1.5-6H

PulseMaster® 350 & 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 45 Degree with 3" (76.2 mm) Radius	**PMA64EL-45**	1642-1130	Metal	--	I.D. M12 x 1.5-6H

SSG Spool

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 180 Degree, Straight	**PMP64EL-180**	1642-1140	Metal	--	I.D. M12 x 1.5-6H
Eliminator 30 Degree with 3" (76.2 mm) Radius	**PMP64EL-30**	1642-1141	Metal	--	I.D. M12 x 1.5-6H

PMP Push/Pull

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 180 Degree, Straight	**PMP64EL-180**	1642-1140	Metal	--	I.D. M12 x 1.5-6H
Eliminator 30 Degree with 3" (76.2 mm) Radius	**PMP64EL-30**	1642-1141	Metal	--	I.D. M12 x 1.5-6H

Smoke Master® 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 1.5" (38 mm) Radius	**S62-60**	2020-2006	Powder Coat	O.D. M11 x 1.5-6G	I.D. M11 x 1.5-6H
45 Degree with 1.5" (38 mm) Radius	**S62-45**	2020-2011	Powder Coat	O.D. M11 x 1.5-6G	I.D. M11 x 1.5-6H

Smoke Master 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**S64-60**	1046-2258	Teflon	I.D. M12 x 1.5-6G	I.D. M11 x 1.5-6H

Flux Cored 350

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3.1" (79 mm) Radius	**64FC-60**	1641-1127	Thermo Flex	--	I.D. 5/16"-18 UNC-2B O.D. 1/2"-13 UNC-2A

Flux Cored 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3.6" (92 mm) Radius	**66FC-60**	1661-1127	Thermo Flex	--	I.D. 3/8"-16 UNC-2B O.D. 5/8"-11 UNC-2A

Conductor Tubes - Water-Cooled

PulseMaster® 400 & 500

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
45 Degree with 4" (101.6 mm) Radius	**PMW64-45**	1644-2925	Metal	--	I.D. 3/8"-16 UNC-2B

Supra® 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 4" (101.6 mm) Radius	**SW64-60**	1644-1125	Neoprene	--	O.D. M11 x 1.0-6G

Standard 600

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**WCS66-60**	1664-1106	Neoprene	--	I.D. 7/16"-20 UNF-2B

Conductor Tube - Rigid Extensions
For Traditional Style Guns



No. 3 & 4 Extensions

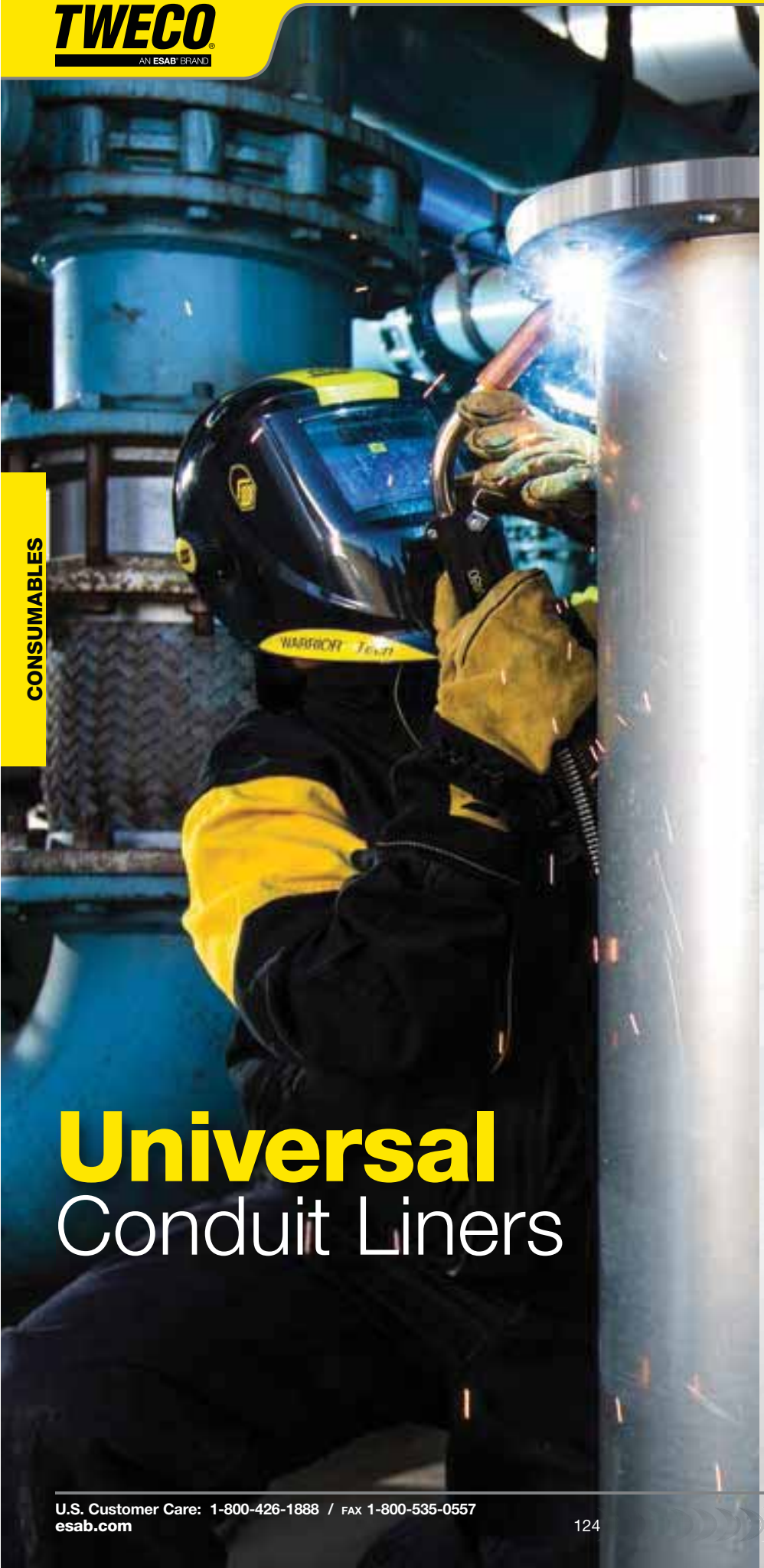
Description	Part No.	Stock No.
Extension 4" (102 mm) Straight 180°	**64A-4EX**	1640-1301
Extension 6" (152 mm) Straight 180°	**64A-6EX**	1640-1302
Extension 8" (203 mm) Straight 180°	**64A-8EX**	1640-1303
Extension 45°	**64EX-45**	1640-1311
Extension 60°	**64EX-60**	1640-1312

No. 5 Extensions

Description	Part No.	Stock No.
Extension 4" (102 mm) Straight 180°	**65-4EX**	1650-1301
Extension 6" (152 mm) Straight 180°	**65-6EX**	1650-1302
Extension 8" (203 mm) Straight 180°	**65-8EX**	1650-1303
Extension 45°	**65EX-45**	1650-1311
Extension 60°	**65EX-60**	1650-1312



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Universal Conduit Liners

The Only Conduit Liner You Will Ever Need!

- Reduce inventory carrying costs with MIG Gun conduit liners
- Save shelf space by stocking only one Tweco® Universal Conduit Liner for each wire size
- Reduces complexity and simplifies product offering by reducing the number of SKUs
- Welding shops can improve productivity by consolidating conduit liners to one Tweco brand

Steps to Pick the Correct Conduit Liner and Adapter.

Refer to the Adapter Compatibility Chart on opposite page at right:

1. What wire size are you using?
2. Pick the related Tweco liner, 15 ft (4.6 m) or 25 ft (7.6 m).
3. What MIG gun brand are you using? For Tweco, Lincoln® & Profax® brands, the Tweco Universal Conduit liner has the adapter already attached *(skip to step 7)*.
4. For other brands, pick the related adapter.
5. Unscrew the adapter from the Tweco Universal Conduit liner.
6. Then screw-on the selected adapter, and hand tighten it.
7. Use as any standard liner. For assembly, follow instructions on the inside panel of the Tweco Universal Conduit box.

Adapter **Tweco® Universal Conduit Liner**



Patent Pending

Replace Multiple Conduit Liner Brands

With One Tweco Universal Brand



Tweco Universal Conduit Liner
(comes fitted with Tweco Adapter)



Adapters for major MIG Gun Brands

Tweco Universal Conduit Liners

Adapter Compatibility Chart

Wire Size	Tweco Universal Conduit Liner*	Length	Adapter Part No. /Stock No.				
			Tweco, Lincoln®, Profax®	Miller® Migmatic®, Hobart®	Bernard®	Miller Roughneck®	Tregaskiss®
.030" – .035" (0.8 – 0.9 mm)	**42-3035-15**	15 ft (4.6 m)	 **44U-TWE** 1440-1238 (1 each) 1440-1240 (25 each)	 **44U-MIL-M** 1440-1238 (1 each) 1440-1245 (25 each)	 **44U-BER** 1440-1236 (1 each) 1440-1242 (25 each)	 **44U-MIL-C** 1440-1248 (1 each) 1440-1249 (25 each)	 **44U-TRE** 1440-1219 (1 each) 1440-1220 (25 each)
	42-3035-25	25 ft (7.6 m)					
.040" – .045" (1.0 – 1.2 mm)	**42-4045-15**	15 ft (4.6 m)					
	42-4045-25	25 ft (7.6 m)					
.035" – .045" (0.9 – 1.2 mm)	**44-3545-15**	15 ft (4.6 m)					
	44-3545-25	25 ft (7.6 m)					
1/16" (1.6 mm)	**44-116-15**	15 ft (4.6 m)					
	44-116-25	25 ft (7.6 m)					
5/64" (2.0 mm)	**44-564-15**	15 ft (4.6 m)	**44U-TWE-H** 1440-1239 (1 each)	**44U-MIL-H** 1440-1246 (1 each)	**44U-BER-H** 1440-1243 (1 each)	**44U-MIL-C-H** 1440-1217 (1 each)	**44U-TRE-H** 1440-1221 (1 each)
	44-564-25	25 ft (7.6 m)					
3/32" (2.4 mm)	**44-332-15**	15 ft (4.6 m)					
	44-332-25	25 ft (7.6 m)					

**Tweco Universal Conduit Liner supplied standard with Tweco adapter fitted. Tweco Conduits for Lincoln and Profax do not require adapters.*
Adapter 44U-ASORT comes with one adapter each of 44U-MIL-M, 44U-BER, 44U-MIL-C, and 44U-TRE

Lincoln is a registered trademark of Lincoln Electric Company. Profax is a registered trademark of Profax. Bernard, Miller, Migmatic, Hobart, Roughneck and Tregaskiss are registered trademarks of Illinois Tool Works, Inc. The aforementioned registered trademarks are in no way affiliated with Tweco. Tweco is registered trademark of ESAB.

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Conduit Liners - For Use With Steel Welding Wires

160 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.023" (0.6 mm)	15 ft (4.6 m)	**23-40-15**	1400-1123
.030" - .035" (0.8 - 0.9 mm)	15 ft (4.6 m)	**35-40-15**	1400-1133
.030" - .035" (0.8 - 0.9 mm)	20 ft (6.1 m)	**35-40-20**	1400-1134
.040" - .045" (1.0 - 1.2 mm)	15 ft (4.6 m)	**45-40-15**	1400-1143

180-250 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 - 0.9 mm)	15 ft (4.6 m)	**42-3035-15**	1420-1113
.030" - .035" (0.8 - 0.9 mm)	25 ft (7.6 m)	**42-3035-25**	1420-1115
.040" - .045" (1.0 - 1.2 mm)	15 ft (4.6 m)	**42-4045-15**	1420-1123
.040" - .045" (1.0 - 1.2 mm)	25 ft (7.6 m)	**42-4045-25**	1420-1125
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	**42-116-15**	1420-1124

300-450 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 - 1.2 mm)	15 ft (4.6 m)	**44-3545-15**	1440-1103
.035" - .045" (0.9 - 1.2 mm)	25 ft (7.6 m)	**44-3545-25**	1440-1105
.052" - 1/16" 1(.3 - 1.6 mm)	15 ft (4.6 m)	**44-116-15**	1440-1113
.052" - 1/16" (1.3 - 1.6 mm)	25 ft (7.6 m)	**44-116-25**	1440-1115
5/64" (2.0 mm)	15 ft (4.6 m)	**44-564-15**	1440-1123
5/64" (2.0 mm)	25 ft (7.6 m)	**44-564-25**	1440-1125
3/32" (2.4 mm)	15 ft (4.6 m)	**44-332-15**	1440-1127

500-650 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 - 1.2 mm)	15 ft (4.6 m)	**45-3545-15**	1450-1103
.052" - 1/16" 1.3 - 1.6 mm)	15 ft (4.6 m)	**45-116-15**	1450-1113
.052" - 1/16" (1.3 - 1.6 mm)	25 ft (7.6 m)	**45-116-25**	1450-1115
5/64" (2.0 mm)	15 ft (4.6 m)	**45-564-15**	1450-1123
5/64" (2.0 mm)	25 ft (7.6 m)	**45-564-25**	1450-1125
3/32" (2.4 mm)	15 ft (4.6 m)	**45H-332-15**	1450-1133
7/64" (2.8 mm)	15 ft (4.6 m)	**45H-764-15**	1450-1143
1/8" (3.2 mm)	15 ft (4.6 m)	**45-18-15**	1450-1153



Tweco Universal Conduit Liner

Conduit Liners - For Use With Aluminum Welding Wires

160 Amp - Teflon

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 - 0.9 mm)	10 ft (3 m)	**35TF-40-10**	1400-1031

180-250 Amp - Teflon

Wire Size	Length	Part No.	Stock No.
.030" - 3/64" (0.8 - 1.2 mm)	15 ft (4.6 m)	**42N-3545-15**	1420-1003

300-450 Amp - Nylon

Wire Size	Length	Part No.	Stock No.
.030" - 3/64" (0.8 - 1.2 mm)	15 ft (4.6 m)	**44N-3545-15**	1440-1003
1/16" (1.6 mm)	15 ft (4.6 m)	**44N-116-15**	1440-1012

500-650 Amp - Wire Nylon Wrap

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	15 ft (4.6 m)	**45N-116-15**	1450-1013

Conduit Liners - For PulseMaster® MIG Guns Using Aluminum/Steel Welding Wires

Steel Wrapped / Teflon

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 - 1.2 mm)	12 ft (4 m)	**44PSTF-3545-12**	1441-1138
.035" - .045" (0.9 - 1.2 mm)	15 ft (4.6 m)	**44PSTF-3545-15**	1441-1137
.052" - 1/16" (1.3 - 1.6 mm)	12 ft (4 m)	**44PSTF-116-12**	1441-1136
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	**44PSTF-116-15**	1441-1135

Bronze Jump Liner

Wire Size	Length	Part No.	Stock No.
Max .045" (1.2 mm)	10-1/4" (260 mm)	**44JT-3545**	1644-1088
Max .062" (1.6 mm)	10-1/4" (260 mm)	**44JT-116**	1644-1086

Conduit Liners - For PullMaster® MIG Guns Using Aluminum/Steel Welding Wires

Steel Wrapped / Teflon

Wire Size	Length	Part No.	Stock No.
3/64" - 1/16" (1.2 - 1.6 mm)	33 ft (10 m)	**PMP44-116-33**	1441-1125
3/64" - 1/16" (1.2 - 1.6 mm)	50 ft (15.2 m)	**PMP44-116-50**	1441-1126
.035" - .045" (0.9 - 1.2 mm)	33 ft (10 m)	**PMP44-3545-33**	1441-1127
3/64" - 1/16" (1.2 - 1.6 mm)	33 ft (10 m)	**PMPS44-116-33**	1441-1129
035" - .045" (0.9 - 1.2 mm)	33 ft (10 m)	**PMPS44-3545-33**	1441-1131

Teflon Jump Liner for Flex Tube

Wire Size	Description	Part No.	Stock No.
1/16" (1.6 mm)	Flex Tube	**PMP-44FLX-116**	1644-1095
1/16" (1.6 mm)	Rigid Tube	**PMP-44PTF-116**	1644-1096

Bronze Jump Liner

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	--	**PMP-44-116**	1644-1097

Conduit Liners - For R44 & R45 Series Using Steel Welding Wires

Tapered lead in angle on the machined conduit stop allows for the transition of the welding wire into the MIG gun smoother
Tin/Zinc plated wire

300-450 Amp - Steel Wound

(Including No. 5 Euro-Kwik Series)

Wire Size	Length	Part No.	Stock No.
035" - .045" (0.9 - 1.2 mm)	8 ft (2.4 m)	**R44-3545-8**	1440-1225
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	**R44-116-15**	1440-1231

500-650 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 - 1.2 mm)	4 ft (1.2 m)	**R45-3545-4**	1450-1024
.035" - .045" (0.9 - 1.2 mm)	8 ft (2.4 m)	**R45-3545-8**	1450-1025
.052" - 1/16" (1.3 - 1.6 mm	8 ft (2.4 m)	**R45-116-8**	1450-1030
.052" - 1/16" (1.3 - 1.6 mm	15 ft (4.6 m)	**R45-116-15**	1450-1031

Conduit Liners - For R45 Series Using Aluminum Welding Wires

500-650 Amp - Wire Nylon Wrap

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	15 ft (4.6 m)	**R45WN-116-15**	1450-1045

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International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Features & Benefits

Tweco® offers a broad range of Manual Welding Products and Accessories to meet the needs of every welder.

- Electrode Holders
- Ground Clamps
- Switchable Magnetic Products
- Cable Connectors
- Cable Lugs
- Splicers
- Terminals
- Accessories

Electrode Holders

Tweco Electrode Holders are designed to mechanically hold a welding electrode in position. The efficient 6-position Jaw pattern allows you to get into the correct position your application requires. Ergonomic handle has operator appeal with reversible top & bottom insulators that are easy to replace. Rugged and reliable design made from heavy duty copper alloy and is fully insulated.

Manual Welding
Products & Accessories

EASY FIND GUIDE - Electrode Holder Selection Guide

Electrode Holders	Style	Amperage Range 200	250	300	350	400	450	500	Recommended Model	Page
	High Profile								TwecoTong A-532	130
									TwecoTong T-532	131
									TwecoTong A-316	130
									TwecoTong T-316	131
									TwecoTong A-732	130
									TwecoTong T-732	131
	TITE								Tweco-Tite 4TT	131
	Low Profile								TwecoTong A-14	130
									TwecoTong A-14-HD	130
									TwecoTong A-38-HD	130

TwecoTong®



Tweco-Tite™

Model	Output Current (Amps)	Electrode Size in (mm)	Cable Connection	Application Light Duty Fab	Medium Duty Fab	Heavy Duty Fab	Extra Heavy Duty Fab	Page
TwecoTong A-532	200	5/32" (4.0 mm)	2/0 (67.4 mm)	■				130
TwecoTong T-532	200	5/32" (4.0 mm)	2/0 (67.4 mm)	■				131
TwecoTong A-316	250	3/16" (4.8 mm)	2/0 (67.4 mm)	■	■			130
TwecoTong T-316	250	3/16" (4.8 mm)	2/0 (67.4 mm)	■	■			131
TwecoTong A-732	300	7/32" (5.6 mm)	2/0 (67.4 mm)		■	■		130
TwecoTong T-732	300	7/32" (5.6 mm)	2/0 (67.4 mm)		■	■		131
TwecoTong A-14	350	1/4" (6.4 mm)	2/0 (67.4 mm)		■	■		130
TwecoTong A-14-HD	400	1/4" (6.4 mm)	4/0 (107 mm)			■	■	130
TwecoTong A-38-HD	500	3/8" (9.5 mm)	4/0 (107 mm)				■	130
Tweco-Tite 4TT	400	1/4" (6.4 mm)	3/0 (85 mm)	■	■	■		131

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Electrode Holders - TwecoTong® A-Series



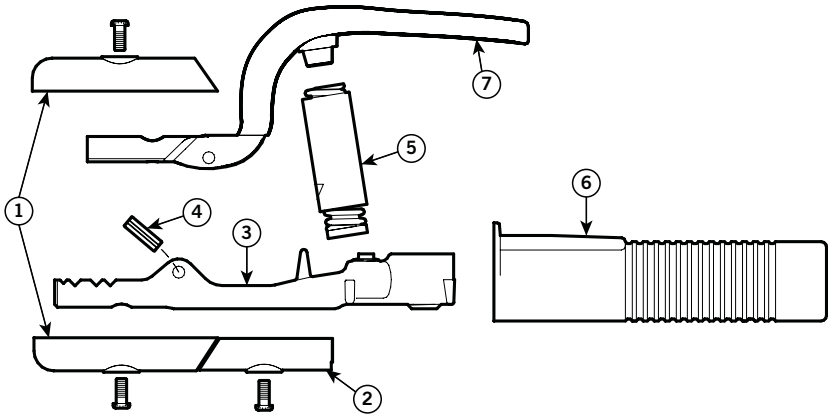
FEATURES

- **TwecoTong Electrode Holders** are designed to mechanically hold a welding electrode in position
- **Reversible Top & Bottom Insulators** are easy to replace
- **Efficient 6-Position Jaw Patterns**
- **Ball Point Cable Connections**
- **Fully Insulated & Protected Springs**
- **Heavy Duty Copper Alloy**

TwecoTong A-Series Electrode Holders

Amperage	Body Alloy	Electrode	Cable	Length	Part No.	Stock No.
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/2" (216 mm)	**A-532***	9110-1101
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/2" (216 mm)	**A532-MC****	9110-1109
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	**A-316***	9110-1102
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	**A316-MC****	9110-1110
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	**A-732***	9110-1103
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	**A732-MC****	9110-1111
350	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	11" (279 mm)	**A-14**	9110-1104
400	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	12" (305 mm)	**A-14-HD**	9110-1105
500	Copper Alloy	3/8" (9.5 mm)	4/0 (107 mm)	13-1/4" (336 mm)	**A-38-HD**	9110-1106

** Clamshell packaging. Sold individually or master packed in quantities of 12 each.*
*** Sold in Master Pack Boxed Quantities of 24.*



TwecoTong A-Series Replacement Parts

#	Description	A-532 Part No Stock No.	A-316 Part No Stock No.	A-732 Part No Stock No.	A-14 Part No Stock No.	A-14-HD Part No Stock No.	A-38-HD Part No Stock No.
1	Tip Insulation	**A-532-1P** 9910-2102	**A-532-1P** 9910-2102	**A-732-1P** 9910-2302	**A-732-1P** 9910-2302	**A-732-1P** 9910-2302	**A-38-HD-1P** 9910-2602
2	Body Insulation	**A-532-3** 9910-2103	**A-532-3** 9910-2103	**A-532-3** 9910-2103	**A-14-3** 9910-2403	**A-14-3** 9910-2403	**A-38-HD-3** 9910-2603
3	Lower Body Tong w/o Insulation	**A-316-4R** 9910-2204	**A-316-4R** 9910-2204	**A-732-4** 9910-2304	**A-14-4** 9910-2404	**A-14-HD-4** 9910-2504	**A-38-HD-4** 9910-2604
4	Hinge Pin	**A-532-11** 9910-2111	**A-532-11** 9910-2111	**A-532-11** 9910-2111	**A-532-11** 9910-2111	**A-532-11** 9910-2111	**FGC-200-5** 9910-2610
5	Spring with Insulation	**A-532-6** 9910-2106	**A-316-6** 9910-2206	**A-316-6** 9910-2206	N/A	N/A	N/A
6	Molded Handle	**A-532-7** 9910-2107	**A-316-7** 9910-2207	**A-732-7** 9910-2307	**A-14-7** 9910-2407	**A-14-HD-7** 9910-2507	**A-38-HD-7** 9910-2607
NS	Handle Screws	**AL-300-12** 9910-2712	**AL-300-12** 9910-2712	**AL-300-12** 9910-2712	**AL-300-12** 9910-2712	**AL-300-12** 9910-2712	**AL-300-12** 9910-2712
NS	Cable Connection Screw	**A-532-24** 9910-2124	**A-532-24** 9910-2124	**A-532-24** 9910-2124	**A-14-24** 9910-2424	**A-14-24** 9910-2424	**A-14-24** 9910-2424

Electrode Holders - TwecoTong® T-Series



T-532 T-316 T-732

FEATURES

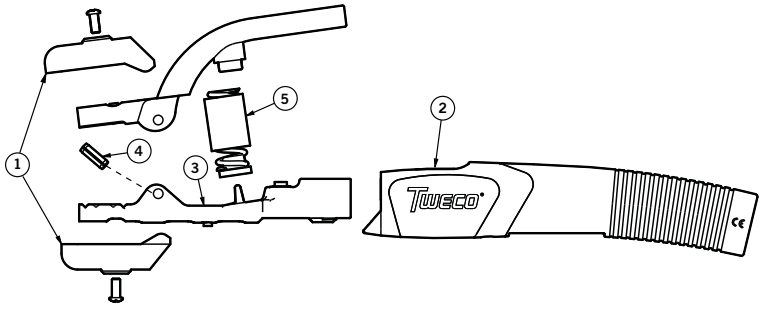
- **Ergonomic Handle** has 12-degree angle
- **Efficient 6-Position Jaw Patterns** to hold the welding electrode in position
- **Double Ball Point Cable Connections** accept up to 2/0 welding cable
- **Rugged & Reliable Design** with operator appeal
- **Designed to meet IEC 60974-11**
- **Fully Insulated & Protected Springs**

TwecoTong T-Series Electrode Holders

Amperage	Body Alloy	Electrode	Cable	Length	Part No.	Stock No.
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	**T532-MC***	9110-1122
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	**T532****	9110-1131
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	**T316-MC***	9110-1123
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	**T316****	9110-1132
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	**T732-MC***	9110-1124
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	**T732****	9110-1133

** Sold in Master Pack Boxed Quantities of 24.*

*** Sold Individually*



TwecoTong T-Series Replacement Parts

#	Description	T532 Part No./Stock No.	T-316 Part No./Stock No.	T-732 Part No./Stock No.
1	Tip Insulation	**T-532-1** / 9910-2104	**T-532-1** / 9910-2104	**T-732-1** / 9910-2303
2	Molded Handle	**T-532-7** / 9910-2108	**T-316-7** / 9910-2208	**T-732-7** / 9910-2308
3	Lower Body Tong w/o Insulation	**A-316-4R** / 9910-2204	**A-316-4R** / 9910-2204	**A-732-4** / 9910-2304
4	Hinge Pin	**A-532-11** / 9910-2111	**A-532-11** / 9910-2111	**A-532-11** / 9910-2111
5	Spring with Insulation	**A-532-6** / 9910-2106	**A-316-6** / 9910-2206	**A-316-6** / 9910-2206
NS	Handle Screws	**AL-300-12** / 9910-2712	**AL-300-12** / 9910-2712	**AL-300-12** / 9910-2712
NS	Cable Connection Screw	**A-532-24** / 9910-2124	**A-532-24** / 9910-2124	**A-532-24** / 9910-2124

Electrode Holders - TwecoTite



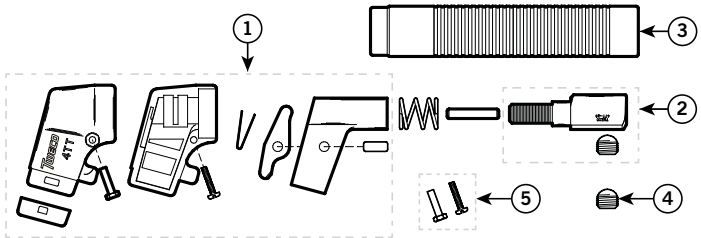
4TT

FEATURES

- **Tweco-Tite Electrode Holders with Fully Insulated Body** designed for effortless installation of electrodes
- **45 Degree Angled Head** holds the welding electrode in place
- **Rugged & Reliable Design** with operator appeal

4TT Tweco-Tite Electrode Holder

Amperage	Electrode	Cable	Part No.	Stock No.
400	1/4" (6.4 mm)	3/0 (85 mm)	**4TT**	9120-1000



4TT Tweco-Tite Replacement Parts

#	Description	Part No.	Stock No.
1	Head Assy - Complete (renewable)	**4TT-1**	9911-2001
2	Connector Body w/Ball-Point Screw	**4TT-20**	9911-2020
3	Handle Only	**4TT-30**	9911-2030
4	Ball-Point Screw	**A-532-24**	9910-2124
5	Binder Post & Screw - for Head Ins.	**122FM**	2020-2122

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Ground Clamps

Features & Benefits

A Clamp for Every Need:

- Flat Jaw Copper Ground Clamp
- Steel Ground Clamp
- Copper Ground Clamp
- Switchable Magnetic Ground Clamp
- Rotary Ground Clamps

Tweco Ground Clamps are highly efficient devices for grounding weldments. Available in a variety of designs to meet the demands of your unique application. Made from high quality copper or steel for long lasting durability. They may also be used for other high amperage grounding applications.

Tweco Ground Clamps are designed with ample contact surface area providing cool, efficient operation. They can be quickly attached or moved from one rotation weldment or fixture to the other, saving on welding down time.

EASY FIND GUIDE - Ground Clamps Selection Guide

Ground Clamps	Application	Amperage Range 200	300	400	500	600	700	800	1500	2000	Recommended Model	Page
	Plate										FGC 200	135
											FGC 300	135
											FGC 500	135
											SGC 300	135
											SGC 500	135
	Pipe										GC 200	135
											GC 300	135
											GC 500	135
											SMGC 200	139
											SMGC 300	139
											SMGC 600	139
	Rotary										GCRG 140	136
											RG 140	136
											RG 230	136
											RG 240	136
											RG 440	136
											RG 640	136

Model	Output: Current (Amps)	Output: Jaw Opening	Output: No. of Heads	Output: Cable Connection	Process: Plate	Process: Pipe	Process: Rotary	Application: Light Duty Fab	Application: Med. Duty Fab	Application: Heavy Duty Fab	Application: Extra Heavy Duty Fab	Page
FGC 200	200	2" (50.8 mm)	--	Ball-Point thru 1/0	■			■				135
FGC 300	300	3-1/2" (88.9 mm)	--	Ball-Point thru 3/0	■			■	■			135
FGC 500	500	3-3/4" (95.3 mm)	--	Ball-Point thru 4/0	■				■	■		135
SGC 300	300	2" (50.8 mm)	--	1/2" Stud	■			■	■			135
SGC 500	500	2" (50.8 mm)	--	1/2" Stud	■				■	■		135
GC 200	200	3" (76.2 mm)	--	Ball-Point thru 1/0		■		■				135
GC 300	300	4" (101.0 mm)	--	Ball-Point thru 3/0		■		■	■			135
GC 500	500	5-1/4" (133.0 mm)	--	Ball-Point thru 4/0		■			■	■		135
SMGC 200	200	--	--	Ball-Point thru 1/0		■		■				139
SMGC 300	300	--	--	Ball-Point thru 3/0		■		■	■			139
SMGC 600	600	--	--	Ball-Point thru 4/0		■				■		139
GCRG 140	400	--	1	1 thru 4/0			■		■	■		137
RG 140	400	--	1	1 thru 4/0			■		■	■		137
RG 230	600	--	1	2 thru 3/0			■			■		137
RG 240	800	--	1	2 thru 4/0			■			■	■	137
RG 440	1500	--	2	4 thru 4/0			■				■	137
RG 640	2000	--	3	6 thru 4/0			■				■	137

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Ground Clamps - Selection Options

Flat Jaw Copper Ground Clamp



Steel Ground Clamp



Copper Ground Clamp



Switchable Magnetic Ground Clamp



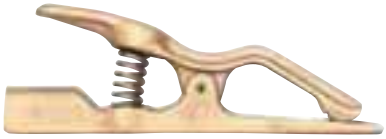
Rotary Ground Clamps





Ground Clamps - Steel & Copper

Ideal for most Light to Medium Duty fabrication needs.



Flat Jaw Copper Ground Clamps

Ideal for plate grounding.

Amperage	Jaw Opening	Cable	Length	Part No.	Stock No.
200	5/8" - Depth 2" (15.9 mm - 50.8 mm)	Ball-Point thru 1/0	5" (127 mm)	**FGC-200**	9205-1320
300	1" - Depth 3-1/2" (25.4 mm - 88.9 mm)	Ball-Point thru 3/0	7-14" (184 mm)	**FGC-300**	9205-1330
500	1-1/4" - Depth 3-3/4" (31.8 mm - 95.3 mm)	Ball-Point thru 4/0	9-1/4" (234 mm)	**FGC-500**	9205-1350



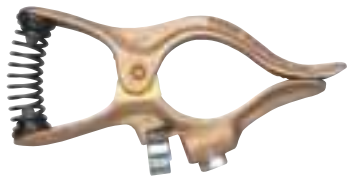
Steel Ground Clamps

Ideal for plate grounding and lower amperage needs.

Amperage	Jaw Opening	Cable	Length	Part No.	Stock No.
300	2" - Depth 1-3/4" (50.8 mm - 44.4 mm)	1/2" Stud Connection	9" (228 mm)	**SGC-300**	9205-1230
500	2" - Depth 1-3/4" (50.8 mm - 44.4 mm)	1/2" Stud Connection	9" (228 mm)	**SGC-500**	9205-1250

Steel Ground Clamp Replacement Parts

Description	Part No.	Stock No.
Cone Head Replacement Jaw - for SGC-300 and SGC-500	**SGC-500-4**	9920-2504



Copper Ground Clamps

Ideal for pipe grounding.

Amperage	Jaw Opening	Cable	Length	Part No.	Stock No.
200	1" - Depth 3" (25.4 mm - 76.2 mm)	Ball-Point thru 1/0	6" (157 mm)	**GC-200**	9205-1120
300	1-1/2" - Depth 4" (38.1 mm - 101.0 mm)	Ball-Point thru 3/0	8-1/2" (216 mm)	**GC-300***	9205-1130
300	1-1/2" - Depth 4" (38.1 mm - 101.0 mm)	Ball-Point thru 3/0	8-1/2" (216 mm)	**GC-300MC****	9205-1131
500	2" - Depth 5-1/4" (50.8 mm - 133.0 mm)	Ball-Point thru 4/0	10" (254 mm)	**GC-500**	9205-1150

** Clamshell packaging. Sold individually or master packed in quantities of 12 each.*
*** Sold in Master Pack Boxed Quantities of 24.*

Copper Ground Clamp Replacement Parts

Description	Part No.	Stock No.
Insulated Spring - for GC-300	**GC-300-2**	9920-2302
Cable Support Ring - for GC-300	**GC-300-11**	9920-2311
Cable Connection Screw - for GC-300	**GC-300-12**	9920-2312

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Tweco® Roto-Ground - Heavy Duty Rotary Ground Devices



RG-440



GCRG-140

Tweco Roto-Ground is a highly efficient device for grounding weldments while being rotated on turning rolls or positioners. The 2" shaft shoulders up to a steel nut which the user welds to his rotating work or fixture. Tweco Roto-Grounds have no brushes, springs or mercury. A simple tension adjusting bolt provides maximum efficiency.

Roto-Ground Clamps

Ideal for high amperage grounding.

Amperage	Cable	Number of Heads	Shaft Stud	Length	Part No.	Stock No.
400	1 - 4/0	1	3/4" NC	--	**GCRG-140**	9210-1314
400	1 - 4/0	1	3/4" NC	8" (203 mm)	**RG-140**	9250-1114
600	2 - 3/0	1	1-1/8" NC	10-1/4" (260 mm)	**RG-230**	9250-1123
800	2 - 4/0	1	1-3/8" NC	10-5/8" (270 mm)	**RG-240**	9250-1124
1500	4 - 4/0	2	1-3/8" NC	10-5/8" (270 mm)	**RG-440**	9250-1144
2000	6 - 4/0	3	1-3/8" NC	10-5/8" (270 mm)	**RG-640**	9250-1164



RG-240-11



A-14-24



2-5

Roto-Ground Accessories

Description	Part No.	Stock No.
Lubricating Cup	**RG-240-11**	9922-2129
Ball-Point Cable Connection Screw	**A-14-24**	9910-2424
Special Shaft Lubricant	**1Z-L**	9900-1123
Fibre Cover Screw	**2-5**	9940-2125

Roto-Ground Replacement Parts

Description	RG-140 Part No. / Stock No.	RG-230 Part No. / Stock No.	RG-240 Part No. / Stock No.	RG-440 Part No. / Stock No.	RG-640 Part No. / Stock No.
Head	**RG-140-2-0** 9922-2103	--	**RG-240-4-0** 9922-2124	**RG-240-4-0** 9922-2124	**RG-240-4-0** 9922-2124
Head Shaft	**RG-140-2** 9922-2102	**RG-230-2** 9922-2112	**RG-240-2** 9922-2122	**RG-440-2** 9922-2132	**RG-640-2** 9922-2142
Work Attachment Nut	**RG-140-5** 9922-2105	**RG-230-5** 9922-2115	**RG-240-5** 9922-2125	**RG-240-5** 9922-2125	**RG-240-5** 9922-2125
Fibre Cover	--	**RG-240-7** 9922-2127	**RG-240-7** 9922-2127	**RG-240-7** 9922-2127	**RG-240-7** 9922-2127



8Z-L

Tweco Shaft Lubricant

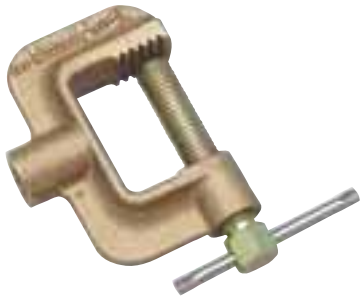
An electrical conductive grease to be used as a lubricant for roto-grounds and may be used when making mechanical connections with copper or aluminum cables. Effective as a lubricant on sliding or moving electrical contacts such as switches and rotating grounding devices. Apply generously to contact area from 1 oz (29.6 mL) or 8 oz (237.0 mL) plastic bottles. Reduce electrical resistance by as much as 40 to 50%

Description	Part No.	Stock No.
1 oz (29.6 mL) Plastic Squeeze Bottle	**1Z-L**	9900-1123
8 oz (237.0 mL) Plastic Squeeze Bottle	**8Z-L**	9900-1124

Tweco® Roto-Work - Heavy Duty Rotary Ground Clamps



WCRG-1200



GC-600-75

Tweco Roto-Work Ground Clamps are designed primarily to work in conjunction with the Tweco Roto-Ground Device. However, they may also be used for other high amperage grounding applications. The Roto-Ground shaft screws into the tapped back of the Roto-Work Clamp. The clamp is quickly attached or moved from one rotation weldment or fixture to the other without removing the Roto-Ground from it, saving on welding down time.

Roto-Work Clamps are made from a copper alloy. They come in 600, 1200 and 2000 ampere capacity. Number WCRG-2000 has two tightening screws. Number WCRG-600 works only with No. RG-230 due to its smaller shaft size. Large tightening screws and ample contact surface area provide cool, efficient operation.

Tweco Roto-Work Ground Clamps

Amperage	Fits Roto-Ground	Clamp Contact	Throat Height	Throat Depth	Over-All Height	Over-All Width	Tapped For	Part No.	Stock No.
600	RG-230	6-1/4 sq in	2-1/2" (63.5 mm)	2-1/2" (63.5 mm)	5-3/4" (146.0 mm)	2-1/2" (63.5 mm)	1-1/8" NC	**WCRG-600**	9255-1106
1200	RG-240/440	9 sq in	3" (76.2 mm)	3" (76.2 mm)	6-3/4" (171.0 mm)	3" (76.2 mm)	1-3/8" NC	**WCRG-1200**	9255-1112
2000	RG-440/640	12 sq in	3" (76.2 mm)	3" (76.2 mm)	6-3/4" (171.0 mm)	4" (102.0 mm)	1-3/8" NC	**WCRG-2000**	9255-1120

Tweco Ground Clamps with Cap Screws

Amperage	Jaw Opening	Cable	Part No.	Stock No.
500	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	1/2" Cap Screw	**GC-600-50**	9210-1150
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	3/4" Cap Screw	**GC-600-75***	9255-1075
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	Double Ball-Point	**GC-600-DBP**	9210-1201
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	Tweco Male Plug	**GC-600-TMP**	9210-1202

**Clamp Only - Tapped 3/4" for RG-140 Roto-Ground Only*



138

Work Clamp Adapter

Description	Part No.	Stock No.
Work Clamp Adapter W/ 1-1/8"-7 UNC 2A OD Thread & 5/8"-11 UNC-2A ID Thread - Fits WCRG-600 Roto-Work Clamp	**118**	9922-2018
Work Clamp Adapter W/ 1-3/8"-6 UNC 2A OD Thread & 5/8"-11 UNC-2A ID Thread - Fits WCRG-1200 & WCRG-2000 Roto-Work Clamps	**138**	9922-2038

"C" Type Clamp Parts

Description	Part No.	Stock No.
Cap Screw - 1/2" x 3/4" NC	**CS-6**	9920-2100
Fitting-No.2 Male Plug (threaded 1/2" NC)	**GCM-2-4**	9920-2102
Fitting-Double Ball-Point (threaded 1/2"NC)	**GCS-40**	9920-2103
Cover	**24R-MBP**	9940-2124

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



Switchable Magnetic Ground Clamps

It's simple to use – just turn the knob. It's easy to operate and mounts on all surfaces. Turn the knob clockwise and you instantly have a secure grip. Perfect for flat and pipe applications. Available in 200, 300, and 600 Amp sizes to meet any welding need. These Switchable Magnetic Ground Clamps are designed to save welders time and money. Clamp can be used to ground on flat, round, and irregular surfaces. Convenient tab to easily attach ground line and cut set up time. Can withstand heat up to 176°F (80°C). Magnetic switch is easy to operate: a simple twist of the knob turns the magnetic field on and off to make use and clean up quick and easy.

Switchable Magnetic Products

Switchable Magnetic Ground Clamps



Easy Connect & Easy Release On/Off Knob

SMGC200



Just Turn Off & Wipe Away Debris

SMGC300



Cuts Set Up Time

SMGC600

Amperage	Height	Width	Length	Weight	Std. Pkg.	Part No.	Stock No.
200	2.5" (63.5 mm)	1.58" (40.1 mm)	2.19" (55.6 mm)	0.38 lbs	10	**SMGC200**	9255-1060
300	2.26" (57.4 mm)	1.58" (40.1 mm)	2.7" (68.6 mm)	0.61 lbs	10	**SMGC300**	9255-1061
600	2.6" (66.0 mm)	2.83" (71.9 mm)	4.09" (103.9 mm)	2.0 lbs	5	**SMGC600**	9255-1062

Switchable Magnetic Multi-Angle Clamps





SMMA 300



SMMA 400

- Work-holding switchable magnetic products
- Holds flat, round, odd shaped products
- Perfect for cutting, drilling, grinding, beveling

Description	Capacity/Power	Part No.	Stock No.
Switchable Magnetic Multi Angle 300	Magnetic Power 150 lbs	**SMMA 300**	9255-1064
Switchable Magnetic Multi Angle 400	Holding Power 400 lbs	**SMMA 400**	9255-1063

Switchable Magnetic Pick & Pack Lifters & Hooks





SMLM 60



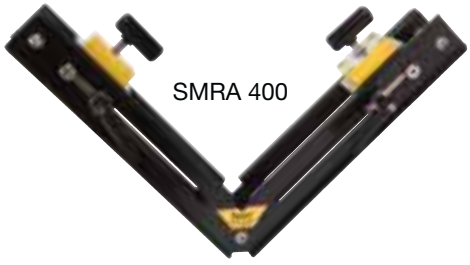
SMLH 600

- Products to pick, place, slide and reposition steel base metals
- Ideal for small steel handling, dragging sheet, picking and pulling parts out of burn table or handling scrap

Description	Capacity/Power	Part No.	Stock No.
Switchable Magnetic Lifter Manual 60	Recommended Lift Capacity 60 lbs	**SMLM 60**	9255-1065
Switchable Magnetic Lifter Hook 600	Lift Capacity 200 lbs	**SMLH 600**	9255-1066

Switchable Magnetic Right-Angle (90º) Clamp





SMRA 400

- Holds base plate – flat or round – at 90-degree angles for perfect positioning for code work and precision welding or cutting
- Ideal for automated tables used in plasma cutting

Description	Capacity/Power	Part No.	Stock No.
Switchable Magnetic Right Angle 400	Holding Power 400 lbs	**SMRA 400**	9255-1067

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

EASY FIND GUIDE - Cable Lug Selection Guide

Cable Lugs	Style	Amperage Range	Recommended	Page
		50 75 150 225 250 325		
	Crimp Lugs for Welding Cable		T-62	141
			T-120	141
			T-3040	141
			T-40HD	141
	Crimp Lugs for Power Cable		T-810	141
			T-68	141
			T-46	141
	Ball-Point Lugs without Insulated Cover		10-45	141
			10-180	141
			40-45	141
			40-180	141
	Ball-Point Lugs with Insulated Cover		10-45C	141
			10-180C	141
			40-45C	141
			40-180C	141
	Heavy Duty Lugs		140-HD-180	141
			140-HD-180C	141
			240-HD-180	141

Crimp Lugs



Ball-Point Lugs



Heavy Duty Lugs



TwecoLugs® - Crimp or Solder Type Lugs

(Use Tweco "Lug-Set")


T-120


T-40HD

TwecoLugs (Crimp Lugs) for Welding Cable

Cable	Amp Rating	Stud Hole	I.D. Solder Socket	Std Pkg	Part No.	Stock No.
6 thru 2	150	17/32" (13.5 mm)	.461" (11.7 mm)	50	**T-62-50**	9520-1115
6 thru 2	150	17/32" (13.5 mm)	.461" (11.7 mm)	5	**T-62**	9520-1104
1 thru 2/0	225	17/32" (13.5 mm)	.559" (14.2 mm)	50	**T-120-50**	9520-1116
1 thru 2/0	225	17/32" (13.5 mm)	.559" (14.2 mm)	5	**T-120**	9520-1105
3/0 & 4/0	250	17/32" (13.5 mm)	.660" (16.7 mm)	25	**T-3040-25**	9520-1117
3/0 & 4/0	250	17/32" (13.5 mm)	.660" (16.7 mm)	5	**T-3040**	9520-1107
4/0 Heavy Duty	325	21/32" (17.7 mm)	.776" (19.7 mm)	25	**T-40HD-25**	9520-1118
4/0 Heavy Duty	325	21/32" (17.7 mm)	.776" (19.7 mm)	5	**T-40HD**	9520-1109


T-68


T-46

TwecoLugs (Crimp Lugs) for Power Cable

Cable	Amp Rating	Stud Hole	I.D. Solder Socket	Std Pkg	Part No.	Stock No.
8 thru 10	50	13/64" (5.2 mm)	.238" (6.1 mm)	10	**T-810**	9520-1101
6 thru 8	70	21/64" (8.3 mm)	.289" (7.3 mm)	10	**T-68**	9520-1102
4 thru 6	90	21/64" (8.3 mm)	.347" (8.8 mm)	10	**T-46**	9520-1103


10-45


40-180

Ball-Point Lugs without Insulated Cover

Description	Cable	Amp Rating	Stud Hole	Std Pkg	Part No.	Stock No.
45° Angle	thru 1/0	150	17/32" (13.5 mm)	1	**10-45**	9515-1100
180° Offset	thru 1/0	150	17/32" (13.5 mm)	1	**10-180**	9515-1102
45° Angle	thru 4/0	325	17/32" (13.5 mm)	1	**40-45**	9515-1110
180° Offset	thru 4/0	325	17/32" (13.5 mm)	1	**40-180**	9515-1112


10-45C


40-180C

Ball-Point Lugs with Insulated Cover

Description	Cable	Amp Rating	Stud Hole	Std Pkg	Part No.	Stock No.
45° Angle	thru 1/0	150	17/32" (13.5 mm)	1	**10-45C**	9515-1101
180° Offset	thru 1/0	150	17/32" (13.5 mm)	1	**10-180C**	9515-1103
45° Angle	thru 4/0	325	17/32" (13.5 mm)	1	**40-45C**	9515-1111
180° Offset	thru 4/0	325	17/32" (13.5 mm)	1	**40-180C**	9515-1113


140-HD-180


140-HD-180C


240-HD-180

Heavy Duty Mechanical Ball-Point Lugs

Description	Cable	Amp Rating	Stud Hole	Length	Part No.	Stock No.
180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	4-3/8" (111 mm)	**140-HD-180**	9515-1120
With Insulated Cover - 180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	5-1/2" (140 mm)	**140-HD-180C**	9515-1121
180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	4-5/8" (131 mm)	**240-HD-180**	9515-1122

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Cable Connectors



MPC Connectors

Tweco MPC connectors provide a positive cam action which optimizes interface between connector halves. The connectors are equipped with heat and oil resistant covers. The MPC connectors are furnished with zinc plated cover and ball-point cable screws. They are interchangeable with older Tweco MBP Connectors. The Whip Cable Connector is used when down sizing cable to an electrode holder. It is a No. 2 male connector with cable hole sized to fit 4, 2, 1 or 1/0 cable. The 2-1-MPC will fit any No. 2 or No. 4 female connector.

MPC Series

Positive-CAM Mechanical Connection - zinc plated type cable & cover screws

Description	Type Cable Connection	Cable Capacity	Standard Package	Part No.	Stock No.
Complete Connection	Single Ball-Point	4, 2, 1	Pkg. 1 ea. Male & Female	**1-MPC**	9425-1100
Male Half	Single Ball-Point	4, 2, 1	Pkg. 2 ea. Male Only	**1-MPC-1**	9425-1110
Female Half	Single Ball-Point	4, 2, 1	Pkg. 2 ea. Female Only	**1-MPC-2**	9425-1120
Complete Connection	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 1 ea. Male & Female	**2-MPC ‡**	9425-1200
Complete Connection	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 1 ea. Male & Female	**2-MPC-MC****	9425-1201
Male Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Male Only	**2-MPC-1 †**	9425-1210
Male Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Male Only	**2-MPC-1-MC***	9425-1211
Female Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Female Only	**2-MPC-2 †**	9425-1220
Female Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Female Only	**2-MPC-2-MC***	9425-1221
Complete Connection	Double Ball-Point	3/0 or 4/0	Pkg. 1 ea. Male & Female	**4-MPC ‡**	9425-1400
Complete Connection	Double Ball-Point	3/0 or 4/0	Pkg. 1 ea. Male & Female	**4-MPC-MC****	9425-1401
Male Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Male Only	**4-MPC-1 †**	9425-1410
Male Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Male Only	**4-MPC-1-MC***	9425-1411
Female Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Female Only	**4-MPC-2 †**	9425-1420
Female Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Female Only	**4-MPC-2-MC***	9425-1422
Whip Connection	Single Ball-Point	4, 2, 1, 1/0	Pkg. 2 ea.	**2-1-MPC**	9425-1140

**Sold in Master Pack Boxed Quantities of 48.*
***Sold in Master Pack Quantities of 24.*
† Clamshell packaging. Sold individually or master packed in quantities of 24 each.
‡ Clamshell packaging. Sold individually or master packed in quantities of 12 each.

Replacement Tapered Machine Plugs


1-M-T

Ball-Point Connection

Taper Length	Taper Dimensions	Cable	Part No.	Stock No.
1-1/8" (28.6 mm)	21/64" to 23/64" (8.3 mm x 9.1 mm)	4 thru 1	**1-M-T**	9505-1800
1-1/8" (28.6 mm)	21.64" to 23/64" (8.3 mm x 9.1 mm)	1/0 thru 3/0	**2-M-T**	9505-1801

Cable Connector Replacement Parts

MPC Series Positive-CAM - Zinc plated type cable & cover screws

Description	Part No.	Stock No.
Insulating Cover Only, All 1-MPC	**1R-C**	9940-2103
Insulating Cover Only, All 2 & 4 MPC	**24R-MBP**	9940-2124
Cable Connection Screw, Zinc Plated, All 2-MPC	**A-532-24**	9910-2124
Cable Connection Screw, Zinc Plated, All 4-MPC	**A-14-24**	9910-2424
Cover Screw, Zinc Plated, All MPC Connectors	**2-5**	9940-2125

Panel Receptacles


238-TSF


2916-BPF

For use with MPC Connectors

Cable Fitting Type	Fits Tweco Connector	For Cable Size	Cable Attachment	Part No.	Stock No.
Ball-Point	No. 1	4, 2, 1	5/16" Ball-Point (7.9 mm)	**1516-BPF**	9580-1100
Threaded	No. 1	4, 2, 1, 1/0	5/16" Thread. Stud (7.9 mm)	**114-TSF**	9580-1101
Threaded	No. 2, 4	1/0, 2/0, 3/0	3/8" Thread. Stud (9.5 mm)	**238-TSF**	9580-1102
Ball-Point	No. 2, 4	1/0, 2/0, 3/0	9/16" Ball-Point (14.3 mm)	**2916-BPF**	9580-1103
Threaded	No. 2, 4	1/0, 2/0, 3/0	1/2" - 20 Thread. Stud (12.7 mm)	**212-TSF**	9580-1104

Cable Splicers


TS-3040

Copper Cable Splicers

Cable	Amp Rating	Tube I.D.	Standard Package	Part No.	Stock No.
6 thru 2	150	.461" (11.7 mm)	50	**TS-62-50**	9610-1105
6 thru 2	150	.461" (11.7 mm)	5	**TS-62**	9610-1101
1 thru 2/0	225	.599" (15.2 mm)	5	**TS-120**	9610-1102
3/0 thru 4/0	250	.660" (16.8 mm)	5	**TS-3040**	9610-1103
4/0 Heavy Duty	325	.776" (19.7 mm)	5	**TS-40HD**	9610-1104


BP-1030

Ball-Point Cable Splicers

Cable	Amp Rating	Cable Fitting Type	Standard Package	Part No.	Stock No.
4 thru 1/0		Ball-Point	1	**BP-410**	9605-1101
1/0 thru 3/0		Ball-Point	1	**BP-1030**	9605-1103
2/0 thru 4/0		Double Ball-Point	1	**BP-2040**	9605-1105

Tweco® Terminals

Tweco Terminals and TwecoLugs


2-SF-50

Tweco Screw-On Terminals Fits Terminal Size 1/2" (12.7 mm) NC

Accepts Tweco Connector Number	Part No.	Stock No.
No. 2 & No. 4 Male Half	**2-SF-50**	9505-1152

Receptacle Conversion Adapters


2-CLC

Fits Cam Locking Machine Receptacle	Fits Tweco Male Plug Ends	Part No.	Stock No.
Large - 11/16" I.D. (17.5 mm)	No. 2-MPC, 4-MPC	**2-CLC**	9505-1811

Tweco Female Terminals


1-AF

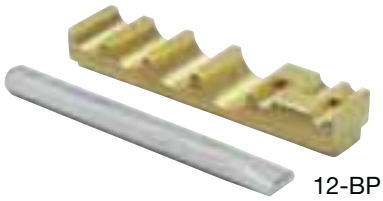

1-0F

Stud Hole Size 17/32" (13.5 mm)

Description	Accepts Male Ends	Standard Package	Part No.	Stock No.
45° Angle	1-MPC	1	**1-AF**	9510-1100
180° Offset	1-MPC	1	**1-OF**	9510-1101
45° Angle	2-MPC, 4-MPC	1	**2-AF**	9510-1110
180° Offset	2-MPC, 4-MPC	1	**2-OF**	9510-1111

Accessories

Tweco® "Lug-Set" Block & Punch


12-BP

For use with TwecoLugs

Description	Part No.	Stock No.
Block & Punch	**12-BP**	9900-1140

Jacket Stripping Cable Cutting Hand Tool


T-908

For use with lugs with an insulated cover

Description	Part No.	Stock No.
Tweco Cable Cutting Hand Tool	**T-908**	9900-1190

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178



WeldSkill®
WM MIG Guns

Features & Benefits

OPERATOR APPEAL
- Oval handle shape reduces operator fatigue

DURABLE & DEPENDABLE FOR INDUSTRIAL APPLICATIONS
- Heavy duty design
- High impact resistant handle and components
- Three layer conductor tube construction (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket)

FIELD REPAIRABLE
- Split-half handle case provides access for ease of repair
- Easily repair Cablehoz® - no additional connectors required

IMPROVED PERFORMANCE WITH LONGER LIFE CONSUMABLES
- Wide selection of front end consumables available
- Heavy duty contact tips in high heat applications offered

		WeldSkill WM 250 Amp	WeldSkill WM 400 Amp	WeldSkill WM 500 Amp
Applications		Light-Medium Duty Fabrication	Medium Duty Fabrication	Heavy Duty Fabrication
Standard Options	**Rear Connector**	■	■	■
	Knucklehead™ Flexible Conductor Tube	■	■	
Output Current		250 Amps	400 Amps	500 Amps
Duty Cycle - CO_2		60%	60%	60%
Wire Diameter		Up to .045” (1.2 mm)	Up to 1/16” (1.6 mm)	Up to 1/16” (1.6 mm)
Process	**MIG**	■	■	■
	Aluminum	■	■	■



Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 250 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

WeldSkill® WM 250 Amp Air-Cooled MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light to Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. WM250J-60 (Stock No. 1620-1310) on all guns up to 15 ft (4.6 m)
- **Part No.** 62J-45 (Stock No. 1620-1300) on guns over 15ft. (4.6m)
- Conduit Liner – WS42 Series

FEATURES
- **Oval Handle Shape** reduces operator fatigue
- **Dependable Welding** for a wide variety of industrial applications
- **High Impact-Resistant Handle and Components** for long-lasting durability
- **Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) for improved electrical conductivity
- **Improved Performance** with longer life consumables
- **Heavy Duty Design** with operator appeal
- **Wide Selection** of front end consumables available
- **Heavy Duty Contact Tips** in high heat applications offered
- **Improved Strain Relief** provides excellent flexibility

Tweco® Style Rear Connector
Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**WM250-15-4045**	1027-1007
	15 ft (4.6 m)	**WM250-15-4045K4§**	1027-1060

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	**WM250M-10-4045**	1027-1030
	12 ft (3.6 m)	**WM250M-12-4045**	1027-1031
	15 ft (4.6 m)	**WM250M-15-4045**	1027-1032
	15 ft (4.6 m)	**WM250M-15-4045K4§**	1027-1061
	25 ft (7.6 m)	**WM250M-25-4045**	1027-1023

Part No. MSAK354 (Stock No. 2642-2470) Control wire assembly furnished.

Lincoln® Style Rear Connector
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**WM250L-15-4045**	1027-1082

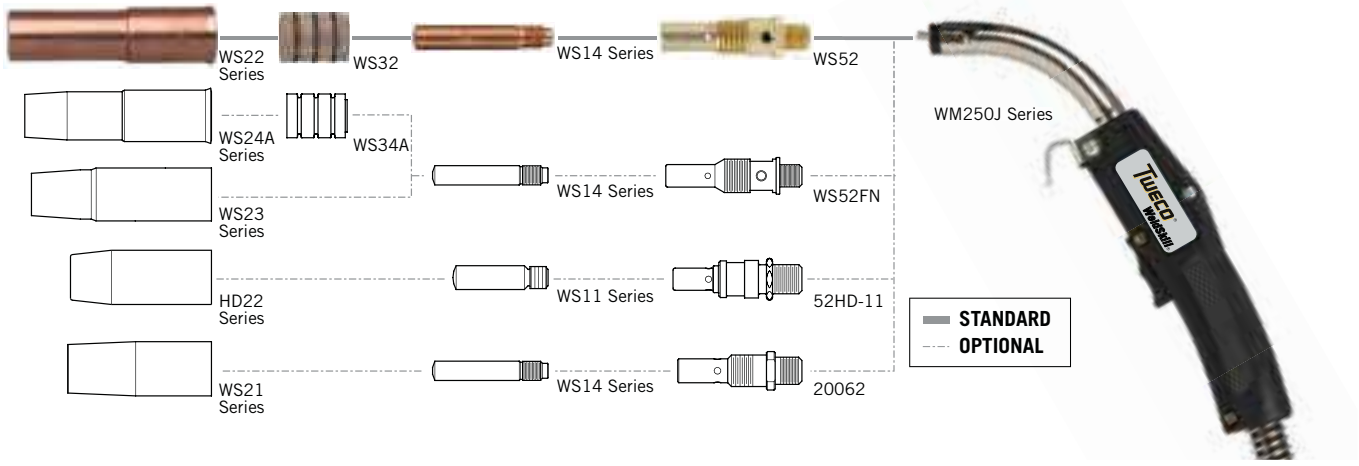
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Part No. LAK354 (Stock No. 2642-2450) Control wire assembly furnished.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**WM250X-15-4045**	1027-1057

§ Suffix "K4" = *Knucklehead Conductor Tube – Part No. 62SFLX480 (Stock No. 1620-1106)*



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	60%	CO_2 Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

EASY FIND GUIDE
See Page 149 for Replacement Parts & Optional Accessories

Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco. Tweco is registered trademark of ESAB.

MIG | MAX OUTPUT 400 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO 1/16" (1.6 mm) | COOLED AIR | USAGE HEAVY DUTY

WeldSkill® WM 400 Amp Air-Cooled MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. WM400J-60 (Stock No. 1640-1305) on all guns up to 15 ft (4.6 m)
- **Part No.** 62J-45 (Stock No. 1620-1300) on guns over 15ft. (4.6m)
- Conduit Liner – WS44 Series

FEATURES
- **Oval Handle Shape** reduces operator fatigue
- **Dependable Welding** for a wide variety of industrial applications
- **High Impact-Resistant Handle and Components** for long-lasting durability
- **Three-Layer Conductor Tube Construction** (copper tube/silicon-resin glass insulator/metal jacket) for improved electrical conductivity
- **Improved Performance** with longer life consumables
- **Heavy Duty Design** with operator appeal
- **Wide Selection** of front end consumables available
- **Heavy Duty Contact Tips** in high heat applications offered
- **Improved Strain Relief** provides excellent flexibility

Tweco® Style Rear Connector
Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	**WM400-12-3545**	1047-1001
	15 ft (4.6 m)	**WM400-15-3545**	1047-1002
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**WM400-15-116**	1047-1007
	15 ft (4.6 m)	**WM400-15-116K4§**	1040-1170
	25 ft (7.6 m)	**WM400-25-116**	1047-1016

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**WM400M-15-3545**	1047-1027
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	**WM400M-12-116**	1047-1031
	15 ft (4.6 m)	**WM400M-15-116**	1047-1032
	15 ft (4.6 m)	**WM400M-15-116K4§**	1040-1171
	25 ft (7.6 m)	**WM400M-25-116**	1047-1019

Part No. MSAK354 (Stock No. 2642-2470) Control wire assembly furnished.

Lincoln® Style Rear Connector
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**WM400L-15-3545**	1047-1077
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**WM400L-15-116**	1047-1082
	15 ft (4.6 m)	**WM400L-15-116K4§**	1040-1172
	25 ft (7.6 m)	**WM400L-25-116**	1047-1022

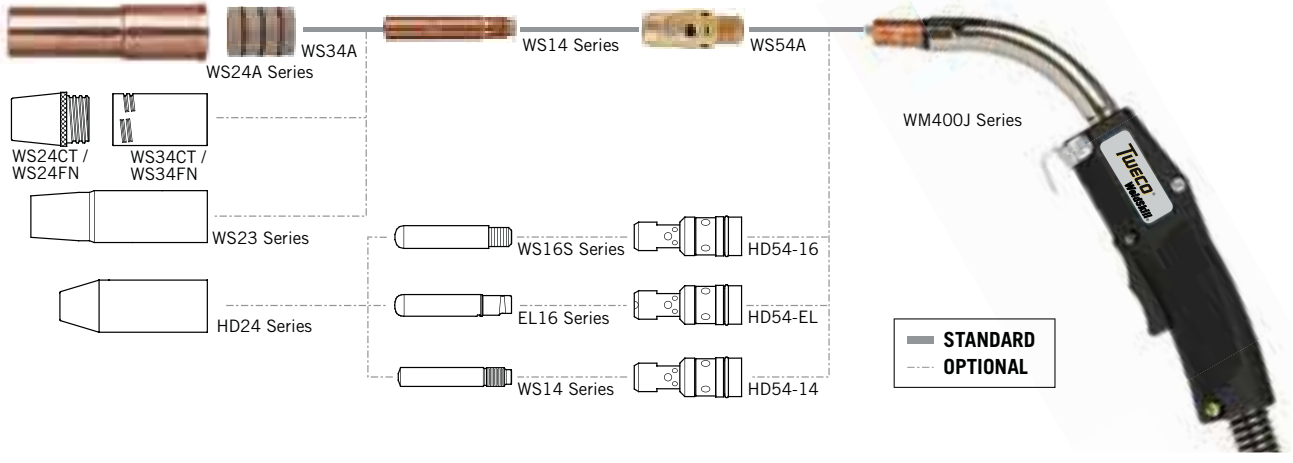
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Part No. LAK354 (Stock No. 2642-2450) Control wire assembly furnished.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	**WM400X-15-3545**	1047-1052
1/16" (1.6 mm)	15 ft (4.6 m)	**WM400X-15-116**	1047-1057

§ Suffix "K4" = *Knucklehead Conductor Tube – Part No. 64SFLX480 (Stock No. 1640-1113)*



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Medium Duty Fabrication

EASY FIND GUIDE
See Page 149 for Replacement Parts & Optional Accessories

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Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

MIG | MAX OUTPUT 250 AMPS | DUTY CYCLE 60% | WIRE SIZE UP TO .045" (1.2 mm) | COOLED AIR | USAGE MED. DUTY

WeldSkill® WM 500 Amp Air-Cooled MIG Gun



60% Duty Cycle - CO_2 Carbon Dioxide
Suitable for Light to Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), **Aluminum** (GMAW)

Standard Options Include:
- Rear Connector
- Standard Conductor Tube – Part No. WM500J-60 (Stock No. 1650-1120) on all guns up to 15 ft (4.6 m)
- Conduit Liner – WS45 Series

FEATURES

- **Oval Handle Shape** reduces operator fatigue
- **Dependable Welding** for a wide variety of industrial applications
- **High Impact-Resistant Handle and Components** for long-lasting durability
- **Three-Layer Conductor Tube Construction** (copper tube/silicon-resin glass insulator/metal jacket) for improved electrical conductivity
- **Improved Performance** with longer life consumables
- **Heavy Duty Design** with operator appeal
- **Wide Selection** of front end consumables available
- **Heavy Duty Contact Tips** in high heat applications offered
- **Improved Strain Relief** provides excellent flexibility

Tweco® Style Rear Connector

Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**WM500-15-116**	1057-1007

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**WM500M-15-116**	1057-1032

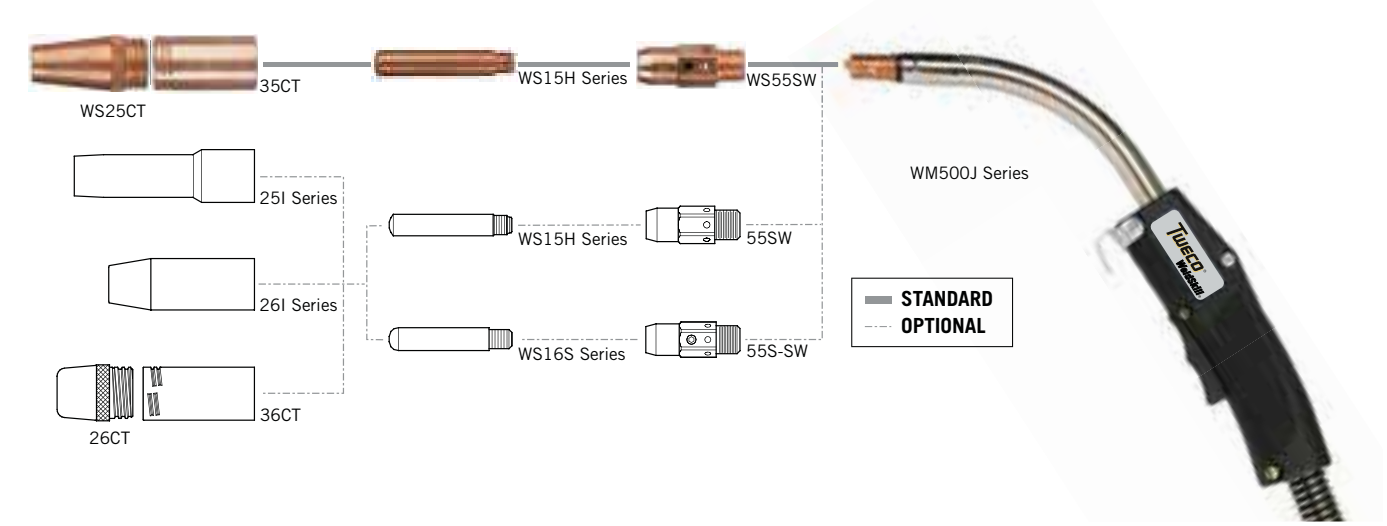
Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	**WM500L-15-116**	1057-1082
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	**WM500L-15-332**	1057-1092

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

Part No. LAK354 (Stock No. 2642-2450) Control wire assembly furnished.

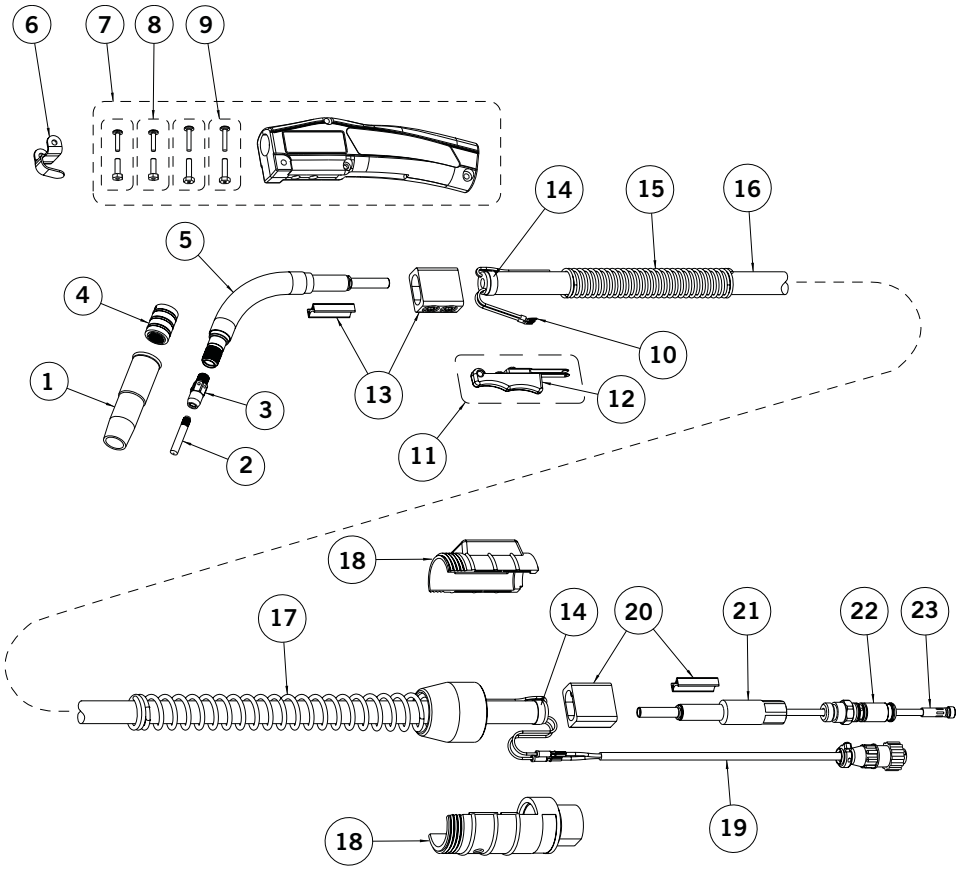


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	60%	CO_2 Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

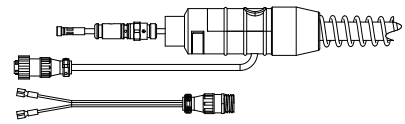
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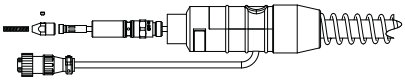
WeldSkill® WM MIG Gun Replacement Parts



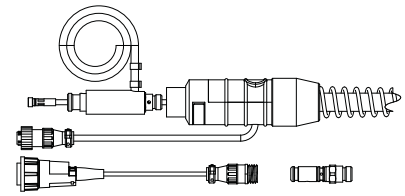
Tweco® Style Rear Connector



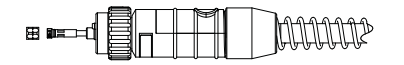
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



#	Description	WeldSkill 250 Amp		WeldSkill 400 Amp		WeldSkill 500 Amp	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
1	Nozzles	WS22 Series		WS24A Series		WS25CT Series	
2	Contact Tips	WS14 Series		WS14 Series		WS15H Series	
3	Gas Diffusers	WS52		WS54A		WS55SW	
4	Nozzle Insulators	WS32		WS34A		35CT	
5	Conductor Tubes	WM250J Series		WM400J Series		WM500J Series	
6	Gun Hanger	152	2020-2152	152	2020-2152	WM155	2050-2095
7	Handle Assembly	WM1-80	2042-2029	WM4-80	2042-2031	WM5-80	2042-2032
8	Binder Post & Screw - (2 ea. Required)	122FMS	2020-2123	122FMS	2020-2123	--	--
	Binder Post & Screw - (1 ea. Required)	--	--	--	--	122FMS	2020-2123
	Binder Post & Screw - (1 ea. Required)	--	--	--	--	124FMS	2040-2125
9	Binder Post & Screw - (2 ea. Required)	122FM	2020-2122	122FM	2020-2122	124FM	2040-2124
10	Trigger Control Wire Terminal (2 ea.)	244DS	2040-2245	244	2040-2244	244	2040-2244
11	Trigger Assembly	WM91	2010-2095	WM92	2020-2096	WM92	2020-2096
12	Trigger Blades	91C	2010-2093	92C	2020-2094	92C	2020-2094
13	Front Cable Connector	WM102	2020-2107	104	2040-2104	104	2040-2104
14	Cable Clamp	136	2060-2690	136	2060-2690	136	2060-2690
15	Front Strain Relief Spring	WM2SSR	2020-2134	WM4SSR	2040-2141	WM5SSR	2050-2096
16	Cablehoz®	200	1720-2100	400	1740-2100	500	1750-2100
17	Rear Strain Relief Spring	235RSSR	2060-2035	235RSSR	2060-2035	235RSSR	2060-2035
18	Rear Case (Direct Plug)	R6RC	2060-2040	R6RC	2060-2040	R6RC	2060-2040
	Rear Case (Euro Style)	X6RC	2060-2006	X6RC	2060-2006	X6RC	2060-2006
19	Control Wire (Standard)	MS354-DSM	2060-2140	MS354-DSM	2060-2140	MS354-DSM	2060-2140
	Control Wire (Dual Schedule)	194DS	2040-2195	194DS	2040-2195	194DS	2040-2195
20	Rear Cable Connector (Direct Plug)	104	2040-2104	--	--	--	--
	Rear Cable Connector (Euro Style)	172X-M	2020-2181	174X-M	2040-2181	176X-M	2060-2181
21	Adapter (Direct Plug)	M170-2H	2020-2165	M170-4H	2020-2166	M170-5H	2020-2167
22	Connector Plug	Refer to Pages 92-93		Refer to Pages 92-93		Refer to Pages 92-93	
23	Conduit Liners	Refer to Page 154		Refer to Page 154		Refer to Page 154	

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Contact Tips - Standard Threaded Style

WS11, WS11H & WS11T Series

0.25" (6.35 mm) Outside Diameter - M6 x 1.0 Threads - 1.00" (25.4 mm) Overall Length
25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.023" (0.6 mm)	.031" (0.79 mm)	**WS11-23**	1110-1140	--	--	**WS11T-23**	1110-1340
.030" (0.8 mm)	.038" (0.97 mm)	**WS11-30**	1110-1141	--	--	**WS11T-30**	1110-1341
.035" (0.9 mm)	.044" (1.12 mm)	**WS11-35**	1110-1142	--	--	**WS11T-35**	1110-1342
.045" (1.2 mm)	.054" (1.37 mm)	**WS11-45**	1110-1144	**WS11H45**	1110-1244	**WS11T-45**	1110-1344

WS14, WS14H, & WS14T Series

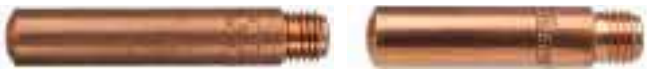
0.25" (6.35 mm) Outside Diameter - .250-28 UNF Threads - 1.50" (38.1 mm) Overall Length
25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.030" (0.8 mm)	.038" (0.97 mm)	**WS14-30**	1140-1166	--	--	**WS14T-30**	1140-1341
.035" (0.9 mm)	.044" (1.12 mm)	**WS14-35**	1140-1167	**WS14H-35**	1140-1242	**WS14T35**	1140-1342
.040" (1.0 mm)	.048" (1.22 mm)	**WS14-40**	1140-1168	**WS14H-40**	1140-1243	--	--
.045" (1.2 mm)	.054" (1.37 mm)	**WS14-45**	1140-1169	**WS14H-45**	1140-1244	**WS14T-45**	1140-1344
.052" (1.3 mm)	.064" (1.65 mm)	**WS14-52**	1140-1170	**WS14H-52**	1140-1245	**WS14T-52**	1140-1345
1/16" (1.6 mm)	.073" (1.85 mm)	**WS14-116**	1140-1171	**WS14H-116**	1140-1246	**WS14T-116**	1140-1346
5/64" (2.0 mm)	.090" (2.29 mm)	**WS14-564**	1140-1174	**WS14H-564**	1140-1247	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	**WS14A364**	1140-1172	**WS14AH-364**	1140-1248	--	--

WS15H & WS15HFC Series

0.345" (8.8 mm) Outside Diameter - .3125-24 UNF Threads - 1.970"(50 mm) Overall Length / HFC 1.590" (40.4 mm) Overall Length
25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.044" (1.12 mm)	**WS15H-35**	1150-1230	--	--	--	--
.045" (1.2 mm)	.054" (1.37 mm)	**WS15H-45**	1150-1232	--	--	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	**WS15H-116**	1150-1234	**WS15HFC-116**	1150-1268	--	--
5/64" (2.0 mm)	.090" (2.29 mm)	**WS15H-564**	1150-1235	--	--	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	**WS15H-332**	1150-1238	--	--	--	--
7/64" (2.8 mm)	.120" (3.05 mm)	**WS15H-764**	1150-1237	--	--	--	--

16S & 16ST Series

0.375" (9.5 mm) Outside Diameter - M8 x 1.25 Threads - 1.50" (38.1 mm) Overall Length
25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.044" (1.12 mm)	**WS16S-35**	1160-1425	--	--	WS16ST-35	1160-1440
.045" (1.2 mm)	.054" (1.37 mm)	**WS16S-45**	1160-1426	--	--	**WS16ST-45**	1160-1441
.052" (1.3 mm)	.064" (1.65 mm)	**WS16S-52**	1160-1427	--	--	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	**WS16S-116**	1160-1428	--	--	**WS16ST-35**	1160-1443
5/64" (2.0 mm)	.090" (2.29 mm)	WS16S-564	1160-1429	--	--	--	--

Nozzles & Nozzle Insulators - Air-Cooled

WS21 Series

3-Piece Nozzle Design - 0.750" (19.05 mm) Outside Diameter
Standard Alloy Copper. Self Insulated Nozzles.
2 per pack


WS21 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**WS21-37**	1210-1340	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	**WS21T-37**	1210-1343	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**WS21-50F**	1210-1346	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	**WS21-50**	1210-1341	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WS21-62**	1210-1342	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WS22 Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter
Standard Alloy Copper. Use with Nozzle Insulator Part No. WS32 (Stock No. 1320-1100).
2 per pack


WS22 Series


WS32 Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**WS22-37SS**	1220-1345	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	**WS22T-37SS**	1220-1336	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	**WS22-50**	1220-1341	Standard	Adjustable Recess To Protruding
	1/2" (12.7 mm)	**WS22-50SS**	1220-1346	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WS22-62**	1220-1342	Standard	Adjustable Recess To Protruding
	5/8" (15.9 mm)	**WS22-62SS**	1220-1347	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess

WSHD22 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Standard Alloy Copper. Use with HD52 Series Gas Diffusers. Self-Insulated Nozzle.
2 per pack


WSHD22 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	1/2" (12.7 mm)	**WSHD22-50**	1220-1330	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WS23 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Standard Alloy Copper. Self-Insulated Nozzles.
2 per pack


WS23 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**WS23-37**	1230-1010	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**WS23-50**	1230-1011	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	**WS23-50F**	1230-1016	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**WS23-62**	1230-1012	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WS23H-62**	1230-1221	Heavy Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WS23-75**	1230-1013	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WS23T Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter
Standard Alloy Copper. Self-Insulated Nozzles.
2 per pack


WS23T Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	**WS23T-37**	1230-1035	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	**WS23T-37F**	1230-1303	Tapered	Flush To 1/16" (1.6 mm) Tip Recess

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Nozzles & Nozzle Insulators - Air-Cooled

WS24A Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter
Use with Nozzle Insulator Part No. WS34A (Stock No. 1340-1125).
2 per pack


WS24A Series


WS34A Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	**WS24A-37SS**	1240-1559	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	**WS24A-50**	1240-1555	Standard	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	**WS24A-50SS**	1240-1560	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WS24A-62**	1240-1556	Standard	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	**WS24A-62SS**	1240-1561	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WS24AH-62SS**	1240-1566	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**WS24A-75**	1240-1557	Standard	Adjustable Tip Recess - Tip Protruding

WS24CT Series

Coarse Thread Nozzle
Use with Nozzle Insulator Part No. WS34CT (Stock No. 1340-1126).
2 per pack


WS24CT Series


WS34CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**WS24CT-50S**	1240-1580	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WS24CT-62S**	1240-1581	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WS24CT-62R**	1240-1591	Tapered	1/2" (12.7 mm) Tip Recess
	3/4" (19.5 mm)	**WS24CT-75S**	1240-1582	Standard Short Stop	5/32" (3.97 mm) Tip Recess

WS24FN Series

Fine Thread Nozzle
Use with Nozzle Insulator Part No. WS34FN (Stock No. 1340-1127).
2 per pack


WS24FN Series


WS34FN Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**WS24FN-50S**	1240-1715	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WS24FN-62S**	1240-1727	Standard Short Stop	5/32" (3.97 mm) Tip Recess

WSHD24 Series

3-Piece Nozzle Design - 1.125" (28.6 mm) Outside Diameter
Use with HD54 Series Gas Diffusers.
2 per pack


WSHD24 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On (A)	5/8" (15.9 mm)	**WSHD24L-62**	1240-1572	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	**WSHD24L-62F**	1240-1573	Tapered	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	**WSHD24-62**	1240-1570	Standard (1)	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**WSHD24L-75**	1240-1574	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	**WSHD24-75**	1240-1571	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

Nozzles & Nozzle Insulators - Air-Cooled

25CT Series

Coarse Thread Nozzle
Use with Nozzle Insulator Part No. WS35CT (Stock No. 1350-1425).
2 per pack


WS25CT Series


WS35CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	**WS25CT-50**	1250-1439	Standard	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	**WS25CT-62**	1250-1440	Standard	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	**WS25CT-75**	1250-1441	Standard	1/8" (3.2 mm) Tip Recess

Gas Diffusers - Standard Air-Cooled

MINI-MIG Series



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WS35-50	1500-1140	Brass	WS11 Series	WS21 Series

WM150 Series



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WS51	1510-1140	Brass	WS11 Series	WS21 Series

WM250 Series



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WS52	1520-1140	Brass	WS14 Series	WS22 Series
WS52FN	1520-1141	Brass	WS14 Series	WS24A , WS23 Series

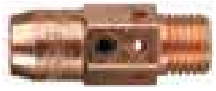
WM400 Series



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WS54A	1540-1145	Brass	WS14 Series	WS24A, WS24CT, & WS23 Series

WM500 Series



5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WS55SW*	1550-1140	Copper	WS15H Series	WS25CT Series
WS55H**	1550-1141	Copper	WS15H Series	WS25CT Series

**Use with WS45-3545, WS45-116, and WS45N-3545 Series Conduit Liners*
***Use with WS45H-332, 45H-764, and 45-18 Series Conduit Liners*

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International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

WeldSkill® Conductor Tubes - Air-Cooled

WeldSkill Standard 150

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/4" (57 mm) Radius	**WM150J-60**	1610-1116	Metal	I.D. 3/8"-24 UNF-2B	I.D. M10 x 1.5-6H
45 Degree with 2-1/4" (57 mm) Radius	**WM150J-45**	1610-1115	Metal	I.D. 3/8"-24 UNF-2B	I.D. M10 x 1.5-6H
60 Degree with 2" (50.5 mm) Radius	**WM150-60**	1610-1112	Neoprene Rubber	I.D. 3/8"-24 UNF-2B	I.D. M10 x 1.5-6H
80 Degree with 2" (50.5 mm) Radius	**WM150-80**	1610-1113	Neoprene Rubber	I.D. 3/8"-24 UNF-2B	I.D. M10 x 1.5-6H
180 Degree, Straight	**WM150-180**	1610-1114	Neoprene Rubber	I.D. 3/8"-24 UNF-2B	I.D. M10 x 1.5-6H

WeldSkill Standard 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**WM250J-60**	1620-1310	Metal	I.D. 3/8"-24 UNF-2B	3/8"-24 NF-2B

WeldSkill Standard 400

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	**WM400J-60**	1640-1305	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
45 Degree with 3" (76.2 mm) Radius	**WM400J-45**	1640-1306	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A

WeldSkill Standard 500

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 5" (127 mm) Radius	**WM500J-60**	1650-1120	Metal	I.D. 7/16"-20UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A

Conduit Liners - For Use With Steel Welding Wires

WM150 & WM250 Series - Steel Wound

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 - 0.9 mm)	15 ft (5 m)	**WS42-3035-15**	1420-1140
.030" - .035" (0.8 - 0.9 mm)	25 ft (8 m)	**WS42-3035-25**	1420-1145
.040" - .045" (1.0 - 1.2 mm)	15 ft (5 m)	**WS42-4045-15**	1420-1141
.040" - .045" (1.0 - 1.2 mm)	25 ft (8 m)	**WS42-4045-25**	1420-1146

WM400 Series - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 - 1.2 mm)	15 ft (5 m)	**WS44-3545-15**	1440-1140
.035" - .045" (0.9 - 1.2 mm)	25 ft (8 m)	**WS44-3545-25**	1440-1145
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (5 m)	**WS44-116-15**	1440-1141
.052" - 1/16" (1.3 - 1.6 mm)	25 ft (8 m)	**WS44-116-25**	1440-1146
5/64" (2.0 mm)	15 ft (5 m)	**WS44-564-15**	1440-1142
5/64" (2.0 mm)	25 ft (8 m)	**WS44-564-25**	1440-1147

WM500 Series - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 - 1.2 mm)	15 ft (5 m)	**WS45-3545-15**	1450-1104
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (5 m)	**WS45-116-15**	1450-1114
3/32" (2.4 mm)	15 ft (5 m)	**WS45H-332-15**	1450-1134



Conduit Liners - For Use With Aluminum Welding Wires

WM150 & WM250 Series - Teflon

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 - 0.9 mm)	15 ft (5 m)	**WS42N-3545-15**	1420-1142

WM400 Series - Nylon

Wire Size	Length	Part No.	Stock No.
.030" - 3/64" (0.8 - 1.2 mm)	15 ft (5 m)	**WS44N-3545-15**	1440-1135
1/16" (1.6 mm)	15 ft (5 m)	**WS44N-116-15**	1440-1136

Electrode Holders



WS532



WS732

WeldSkill® Electrode Holders

Amperage	Body Alloy	Electrode	Cable	Length	Part No.	Stock No.
200	Brass Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/4" (209 mm)	**WS532**	9110-1180
250	Brass Alloy	3/16" (5.0 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	**WS316**	9110-1181
300	Brass Alloy	7/32" (5.5 mm)	2/0 (67.4 mm)	10" (253 mm)	**WS732**	9110-1182
350	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	11" (279 mm)	**WS350E**	9110-1118
400	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	12" (305 mm)	**WS400E**	9110-1119



WHT-400

WeldSkill "Hold-Tite" Electrode Holder

Amperage	Body Alloy	Electrode	Cable	Length	Part No.	Stock No.
400	--	1/4" (6.4 mm)	3/0 (85 mm)	--	WHT-400	9120-1010

Ground Clamps



WS300GC

Copper Ground Clamps

Amperage	Jaw Opening	Jaw Depth	Cable	Length	Part No.	Stock No.
200	1" (24 mm)	2-1/2" (63 mm)	Through 1/0	6" (152 mm)	**WS200GC**	9205-1215
300	1-1/2" (38 mm)	3-1/2" (88 mm)	Through 2/0	8-1/4" (209 mm)	**WS300GC**	9205-1216
500	2" (50 mm)	4-7/8" (123 mm)	Through 3/0	10" (253 mm)	**WS500GC**	9205-1217



WS300SGC

Steel Ground Clamps

Amperage	Jaw Opening	Jaw Depth	Cable	Length	Part No.	Stock No.
180	1-3/4" (44 mm)	2" (50 mm)	Through 1/0	6-1/2" (165 mm)	**WS180SGC**	9205-1245
300	2" (50 mm)	2-1/2" (63 mm)	Through 3/0	7-3/4" (196 mm)	**WS300SGC**	9205-1246
500	2-1/4" (50 mm)	3" (76 mm)	Through 4/0	9-1/2" (241 mm)	**WS500SGC**	9205-1247

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

Cable Connectors


4-WPC

Positive-CAM Mechanical Cable Connectors

Description	Cable	Std Pkg	Part No.	Stock No.
Complete Set of Connectors	4, 2, 1	1	**1-WPC**	9425-1125
Connector Male Half Only	4, 2, 1	2	**1-WPC-P**	9425-1126
Connector Female Half Only	4, 2, 1	2	**1-WPC-R**	9425-1127
Complete Set of Connectors	1/0, 2/0, 3/0	1	**2-WPC**	9425-1225
Connector Male Half Only	1/0, 2/0, 3/0	2	**2-WPC-P**	9425-1226
Connector Female Half Only	1/0, 2/0, 3/0	2	**2-WPC-R**	9425-1227
Complete Set of Connectors	3/0 or 4/0	1	**4-WPC**	9425-1425
Connector Male Half Only	3/0 or 4/0	2	**4-WPC-P**	9425-1246
Connector Female Half Only	3/0 or 4/0	2	**4-WPC-R**	9425-1247


WDC-75

Dinse Style Mechanical Cable Connectors

Description	Cable	Std Pkg	Part No.	Stock No.
Complete Set of Connectors	4, 2, 1	1	**WDC-25**	9425-1445
Connector Male Half Only	4, 2, 1	2	**WDC-25-P**	9425-1446
Connector Female Half Only	4, 2, 1	2	**WDC-25-R**	9425-1447
Complete Set of Connectors	1/0, 2/0, 3/0	1	**WDC-50**	9425-1430
Connector Male Half Only	1/0, 2/0, 3/0	2	**WDC-50-P**	9425-1431
Connector Female Half Only	1/0, 2/0, 3/0	2	**WDC-50-R**	9425-1432
Complete Set of Connectors	3/0 or 4/0	1	**WDC-75**	9425-1435
Connector Male Half Only	3/0 or 4/0	2	**WDC-75-P**	9425-1436
Connector Female Half Only	3/0 or 4/0	2	**WDC-75-R**	9425-1437


WDP-25

Panel Receptacles

To Fit Dinse Style Male Connectors

Fits WeldSkill Connector	Cable	Std Pkg	Part No.	Stock No.
Panel fitting accepts WDC-25-P	4,2,1	1	**WDP-25**	9580-1129
Panel fitting accepts WDC-50-P & WDC-75-P	1/0 through 4/0	1	**WDP-50**	9580-1130

Miscellaneous Connectors

Description	Part No.	Stock No.
50 mm Dinse Male to Tweco #2 & #4 Positive Cam Connectors	**2MDC-CK**	9425-1240


WS-120H

Hammer-on Cable Lugs

Amperage	Cable	Stud Hole Size	I.D. Cable Socket	Std Pkg	Part No.	Stock No.
250	3/0 through 4/0	17/32" (13.5 mm)	.660" (16.8 mm)	5	**WS-3040H**	9520-1128
225	1 through 2/0	17/32" (13.5 mm)	.559" (14.2 mm)	5	**WS-120H**	9520-1127
150	6 through 2	17/32" (13.5 mm)	.461" (11.7 mm)	5	**WS-62H**	9520-1125

Warranty Information

LIMITED WARRANTY: ESAB warrants 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 ESAB products as stated below, ESAB shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with ESAB's specifications, instructions, recommendations and recognized standard industry practice, and not subject to abuse, misuse, neglect, alteration, accident, improper care and/or maintenance including lack of lubrication and protection from the elements, use of non ESAB genuine parts including consumables; will correct such defects by suitable repair or replacement, at ESAB's sole option, of any components or parts of the product determined by ESAB to be defective.

THIS WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

LIMITATION OF LIABILITY: ESAB shall not under any circumstances be liable for special or consequential damages, such as, but not limited to, damage or loss of purchased or replacement goods, or claims of customers of distributor (hereinafter "Purchaser") for service interruption.

The remedies of the Purchaser set forth herein are exclusive and the liability of ESAB 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 ESAB 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.

THIS WARRANTY BECOMES INVALID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY ESAB PRODUCT.

THIS WARRANTY IS INVALID IF THE PRODUCT IS SOLD 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 1 year from the date ESAB delivered the product to the authorized distributor.

TWECO an ESAB Brand

1 YEAR PARTS AND LABOR UNLESS SPECIFIED
- QRC-2000 Nozzle Cleaning Stations
- TC and TCV Water Coolers (No Labor)
- TSC-96 Smoke Collector (No Labor)
- ESG-1, EPG-CR1, CR2 Control
- Boxes for Spool & Pull Guns (No Labor)
- Professional Eliminator® Spool Guns (No Labor)

180 DAYS PARTS / NO LABOR
- Professional MIG Guns (i.e. PulseMaster™, PullMaster™, Spray Master®, Eliminator®, Supra™, Classic No., SEFC, series MIG Guns etc.)

90 DAYS PARTS AND LABOR UNLESS SPECIFIED
- Robotic Deflection Mounts
- QRM-1 and QRM-2 Anti-Spatter Applicator

30 DAYS PARTS / NO LABOR
- All Other Products Including:
- Tweco Fusion® MIG Guns
- WeldSkill® MIG and Spool Guns (No Labor)
- (from the date sold by authorized distributor to purchaser)

VICTOR an ESAB Brand

5 YEARS PARTS / NO LABOR
- Victor® Slimlite Medical
- Victor®

3 YEARS PARTS / NO LABOR
- TurboTorch®

2 YEARS PARTS / NO LABOR
- CutSkill®, Oxygen Conservers, Victor® VSP,
- HP&I Brass Regulators/Manifolds
- All other Victor® Medical products

1 YEARS PARTS / NO LABOR
- Firepower®
- Steel Cylinders, Cutting Machine Motors (i.e. VCM 200)
- HP&I Stainless Regulators/Manifolds
- Parts in Rental Applications
- (from the date sold by seller to authorized distributor)

90 DAYS PARTS / NO LABOR
- HP&I Corrosive Gas Regulators/Manifolds

ARCAIR an ESAB Brand

1 YEAR PARTS AND LABOR UNLESS SPECIFIED
- Arcair® N7500 (No Labor)

30 DAYS PARTS / NO LABOR
- All Other Products

THERMAL DYNAMICS

4 YEARS PARTS AND LABOR
- Cutmaster® TRUE™ (Power Source)

2 YEARS PARTS AND LABOR
- Drag-Gun® Plus, PAK® 200, PAK 45 (Power Source)
- Auto-Cut® and Ultra-Cut® (Power Source, Gas Control and RAS), XT CNC

1 YEAR PARTS AND LABOR UNLESS SPECIFIED
- AirCut® 15C, CutSkill® units (Power Source),
- Water Recirculators
- Stand Off Controls, Remote Controls, other Consoles
- 1Torch®, SureLok®, XTR, XT-300 / XT-301 and Maximizer® torches

180 DAYS PARTS AND LABOR UNLESS SPECIFIED
- All Other "Torch and Leads" Packages

90 DAYS PARTS / NO LABOR
- Replacement Repair Parts

TWECO an ESAB Brand

5 YEARS PARTS* / 3 YEARS LABOR
- ArcMaster®, Excelarc®, Fabricator®, Fabstar®, PowerMaster®
- Portafeed®, Ultrafeed®, Ultima® 150, WC-100B
  - *5 years on the Original Main Power Transformer and Inductors not mounted on PCBoards.
  - *3 years on Power Supply Components

2 YEARS PARTS AND LABOR UNLESS SPECIFIED
- Auto-Darkening Welding Helmet (Electronic Lens),
  - **1 Month Harness Assembly
- Victor® Regulator for Fabricator® 181i (No labor)

1 YEARS PARTS AND LABOR UNLESS SPECIFIED
- 95S, Water Recirculators
- All Plasma Welding Consoles (e.g. WC-1 Controller, WT Timer, WF-100 Capstain Feeder, etc.)

180 DAYS PARTS AND LABOR UNLESS SPECIFIED
- Plasma Welding Torch and Leads Packages
- Gas Regulators "Supplied with Power Sources" (No Labor)

90 DAYS PARTS / NO LABOR
- Remote Controls
- MIG and TIG Torches (Supplied with Power Sources)
- Replacement Repair Parts

30 DAYS PARTS / NO LABOR
- MIG Torch for Fabricator 181i

5-2-1 YEARS PARTS / NO LABOR
- Firepower® Welders

Contact your **STOODY** representative for warranty information on this product.

VICTOR THERMAL DYNAMICS TWECO STOODY ARCAIR TURBOTORCH Firepower CIGWELD

ESAB limited warranty shall not apply to: Consumable Parts for MIG, TIG, Plasma welding, Plasma cutting and Oxyfuel torches, O-rings, fuses, filters or other parts that fail due to normal wear.

* Warranty repairs or replacement claims under this limited warranty must be submitted by an authorized ESAB repair facility within thirty (30) days of the repair.

* No employee, agent, or representative of ESAB is authorized to change this warranty in any way or grant any other warranty, and ESAB shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfillment of ESAB's obligations to purchaser with respect to the product.

* This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in ESAB's sole judgment, impaired the safety or performance of any ESAB product. Purchaser's rights under this warranty are void if the product is sold to purchaser by unauthorized persons.

Canada Customer Care: 1-905-827-4515 / FAX 1-800-588-1714
International Customer Care: 1-940-381-1212 / FAX 1-940-483-8178

The Americas

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Fax: 1-800-535-0557 (tollfree)

International Customer Care
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Fax: 1-940-483-8178

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Sales Office, Latin America
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Notes

TWECO®
AN ESAB® BRAND

03-20-17 / Note: Specifications subject to change without notice. Products may vary from those pictured.

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LAS- EN GASTECHNIEK®
THE ART OF WELDING