

**TWECO**<sup>®</sup>

AN ESAB<sup>®</sup> BRAND



# MIG Guns, Welding Accessories & Consumables **2017 Catalog**

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## 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®, Stoodly®, 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 ...



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.

<p><b>MIG Welding</b> Gas Metal Arc Welding (GMAW) also Flux Cored (FCAW)</p>	<p><b>STICK Welding</b> Shielded Metal Arc Welding (SMAW)</p>	<p><b>TIG Welding</b> Gas Tungsten Arc Welding (GTAW) with Lift Start capability</p>	<p><b>High Frequency TIG Welding</b> Gas Tungsten Arc Welding (GTAW)</p>
<p><b>Carbon Arc Gouging</b> Carbon Arc Gouging Carbon Arc Cutting - Air (CAC-A)</p>	<p><b>Plasma Welding</b> Plasma Arc Welding (PAW)</p>	<p><b>Type of Coolant</b> Either Air Cooled or Water Cooled MIG Guns</p>	<p><b>Application Usage</b> Light, Medium or Heavy Duty Fabrications</p>
<p><b>Current Range</b> Alternating Current (AC) Direct Current (DC) or Both (AC/DC)</p>	<p><b>Current Output</b> Constant Current (CC) Constant Voltage (CV) or Both (CC/CV)</p>	<p><b>Maximum Output Power</b> Measured in Amps 10A up to 600A</p>	<p><b>Power Supply Voltage Range</b> Measured in Volts 208V up to 440V</p>
<p><b>Input Power</b> Single Phase Three Phase or Both</p>	<p><b>Power Supply Frequency</b> 50 or 60 Hertz or Both</p>	<p><b>Duty Cycle</b> Amount of Time used before overheating occurs</p>	<p><b>Maximum Wire Size</b> used by MIG Guns</p>

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# EASY FIND GUIDE - MIG Gun Selection Guide

**MIG GUNS**

Wire Diameter	Amperage Range												Recommended	Alternate					
	30	100	150	200	250	300	350	400	450	500	550	600			650				
Solid Wire – Mild Steel and Stainless Steel	.023" - .030" (0.6 - 0.8 mm)	CO <sub>2</sub>		75-25														Tweco Fusion® 140	Tweco® Classic® No.1, Velocity Classic No. 1
	.035" (0.9 mm)	CO <sub>2</sub>		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 <sub>2</sub>		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

Wire Diameter	Amperage Range												Recommended	Alternate						
	30	100	150	200	250	300	350	400	450	500	550	600			650					
Flux Cored Wire	.030" (0.8 mm)	Self-shielded														Tweco Fusion 140	Tweco Classic No. 1, Velocity Classic No. 1			
	.035" (0.9 mm)	Self-shielded		CO <sub>2</sub> or 75-25														Tweco Fusion 180, 220, 250	Tweco Classic No. 2, Velocity Classic No. 2	
	.045" (1.2 mm)	Self-shielded		CO <sub>2</sub> 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 <sub>2</sub> 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														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 <sub>2</sub> or 75-25														Tweco Classic No.6

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

Wire Diameter	Amperage Range												Recommended	Alternate			
	30	100	150	200	250	300	350	400	450	500	550	600			650		
Solid Wire – Aluminum	.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 #
<b>Spray Master® Series</b>	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
<b>Velocity™ Spray Master® Series</b>	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
<b>Classic® No. Series</b>	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
<b>Velocity™ Classic® No. Series</b>	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
<b>Tweco Fusion® Series</b>	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
<b>PulseMaster® Air-Cooled Series</b>	350, 450	12, 15 ft (3.7, 4.6 m)	Small & Ergonomic	Crimped	Tweco, Euro-Kwik	Air	Smart Option or Standard	50-55
<b>Compact Eliminator®</b>	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
<b>Eliminator®</b>	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
<b>Mini-MIG</b>	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
<b>Velocity™ Mini-MIG</b>	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
<b>Tuff-n-Lite</b>	350	15 ft (4.6 m)	Straight	Mechanical	Tweco, Miller	Air	Top Trigger Capability	64-65
<b>Supra® XT</b>	400	15 ft (4.6 m)	Straight	Mechanical	Tweco, Miller, Lincoln	Air	Top Trigger Capability	66-69
<b>SmokeMaster® Series</b>	250, 450	15 ft (4.6 m)	Ergonomic	Crimped	Tweco, Miller, Lincoln	Air	Fume Extraction Cam-Style Contact Tips	70-72
<b>Flux Cored SEFC Series</b>	350, 450	10, 15 ft (3, 4.6 m)	Straight	Crimped	Tweco, Miller, Lincoln	Air	Galvanized Steel Inner Core Tube Cablehoz Design	74-75
<b>Tweco Spool Gun Series</b>	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
<b>PullMaster® Series</b>	300	33, 50 ft (10, 15.2 m)	Pistol Grip	Crimped	Tweco	Air	Smart Option or Standard	80-81
<b>PulseMaster® Water-Cooled Series</b>	400, 500	12, 25 ft (3.7, 7.6 m)	Ergonomic	Crimped	Tweco	Water	Smart Option or Standard	82-86
<b>Supra</b>	450	10, 12, 15 ft (3, 3.7, 4.6 m)	Oval/Paddle Contour	Crimped	Tweco, Miller	Water	Quick Water Connections	88-89
<b>Standard Water-Cooled</b>	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.

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.

## 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

## MIG Gun 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
<b>Applications</b>	Light - Medium Duty Fabrication	Medium - Heavy Duty Fabrication	Heavy Duty Fabrication	Light - Medium Duty Fabrication	Medium - Heavy Duty Fabrication	Heavy Duty Fabrication
<b>Standard Options</b>	Dual Schedule	■	■		■	■
	Locking Trigger			■		■
	Rear Connector	■	■	■	■	■
	Velocity Consumables				■	■
	Eliminator Consumables	■	■	■		
	Long Reach Conductor Tube			■		■
	Knucklehead™ Flexible Conductor Tube		■	■		■
<b>Output Current</b>	250 Amps	350 Amps	450 Amps	250 Amps	350 Amps	450 Amps
<b>Duty Cycle - Mixed Gases</b>	80%	80%	80%	80%	80%	80%
<b>Wire Diameter</b>	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)
<b>Process</b>	MIG	■	■	■	■	■
	Aluminum	■	■	■	■	■
	Flux Cored Gas Shielded	■	■	■	■	■
	Flux Cored Self Shielded	■	■	■	■	■

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



# Spray Master® MIG Gun & Welding Consumables

MIG GUNS

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  
"DSRS" = Dual Schedule Rocker Switch

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

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

## 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

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

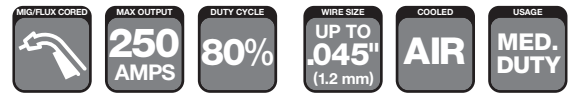


**THICK-WALLED DIFFUSER DESIGN**  
acts as "heat sink" and conducts heat away from the arc source

**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

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.



# 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

MIG GUNS

## 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

## 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.

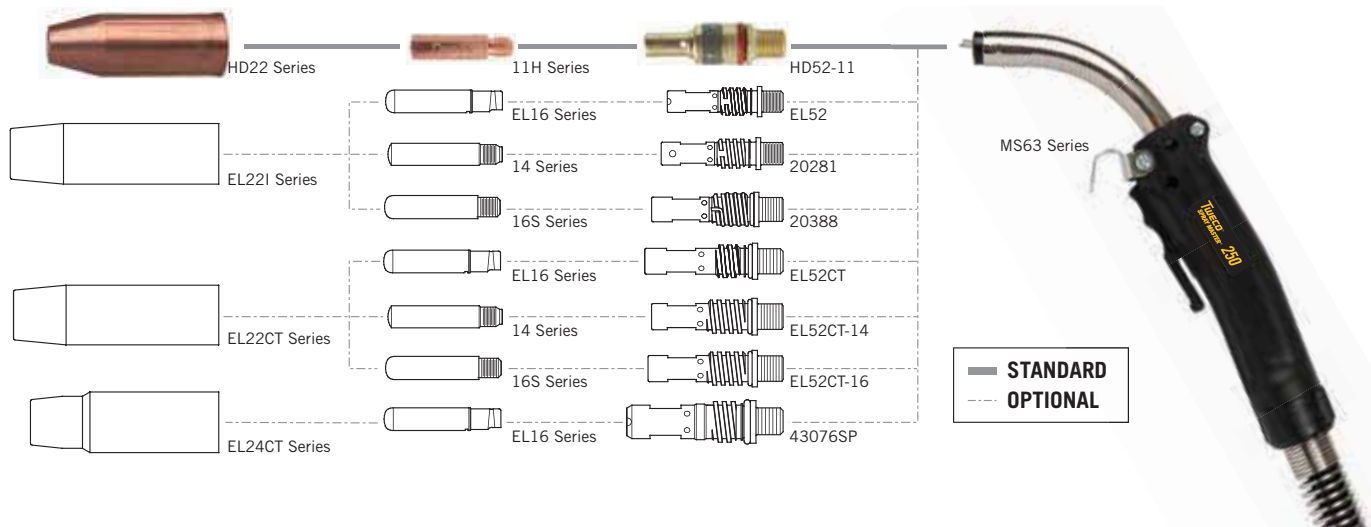
## Miller® Style Rear Connector

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

## 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



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.

# Spray Master® 350 Amp MIG Gun

MIG GUNS



**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

## 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.

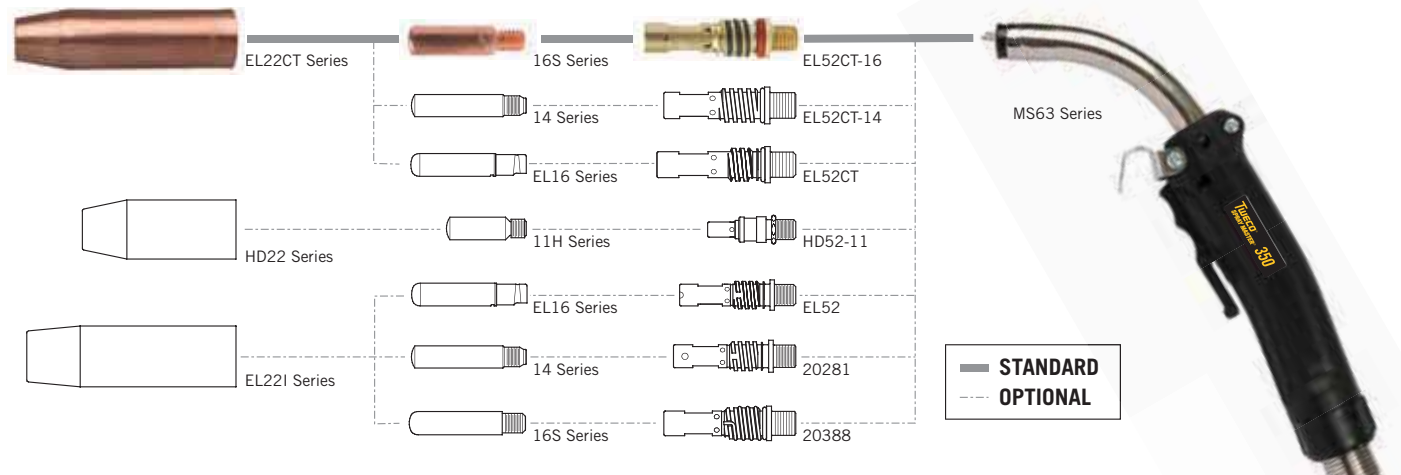
## Miller® Style Rear Connector

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

## 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

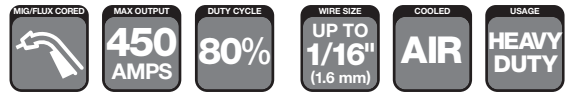
Suffix "K4" = Knucklehead Conductor Tube – Part No. MS63SFLX4-80 (Stock No. 1630-1198);  
"DSRS" = Dual Schedule Rocker Switch;  
Suffix "EL" = Eliminator Front End Consumables



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

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# 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

MIG GUNS

## 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

## 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.

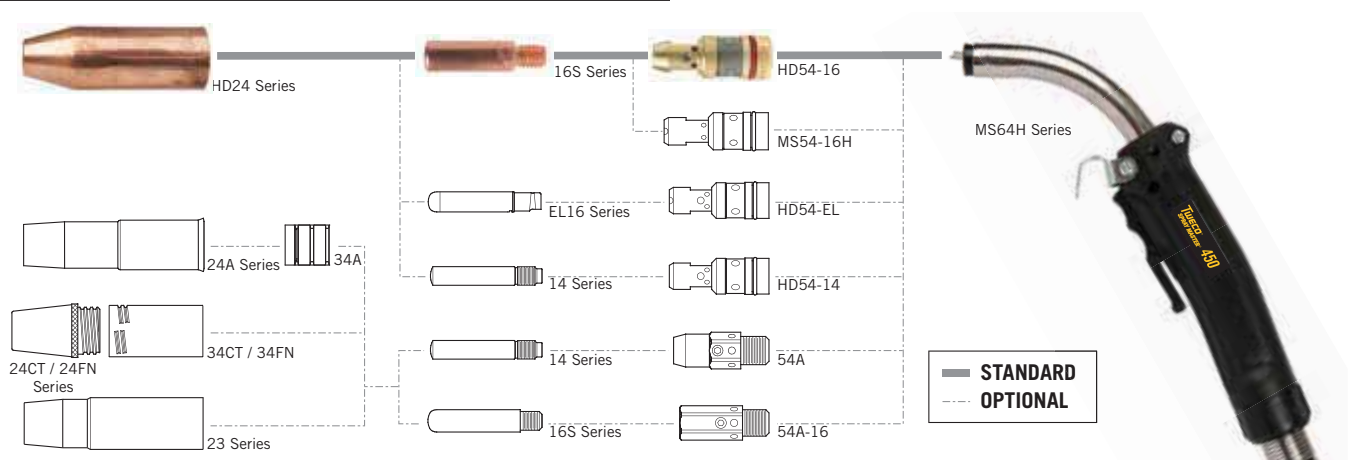
## Miller® Style Rear Connector

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	

## 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



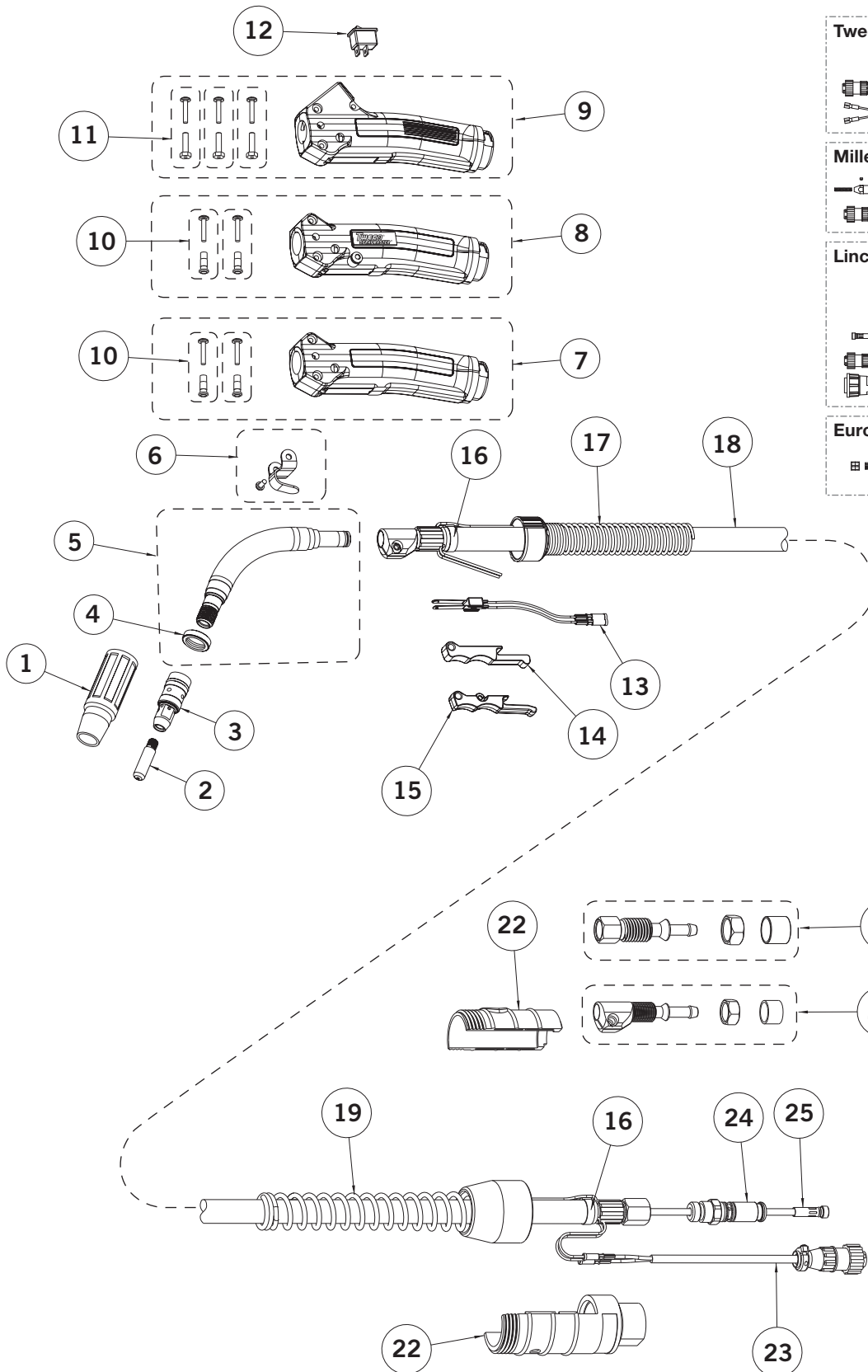
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	80%	Mixed	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

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

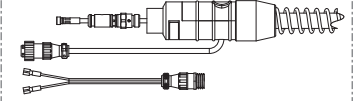
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# Spray Master® MIG Gun Replacement Parts

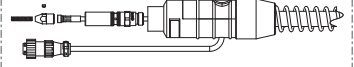
MIG GUNS



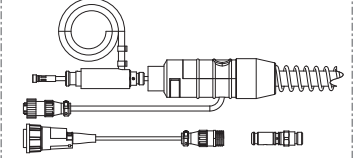
**Tweco® Style Rear Connector**



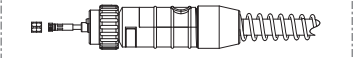
**Miller® Style Rear Connector**



**Lincoln® Style Rear Connector**



**Euro-Kwik Style Rear Connector**



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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
18	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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# Spray Master® V250 Amp MIG Gun

MIG GUNS



**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

## 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.

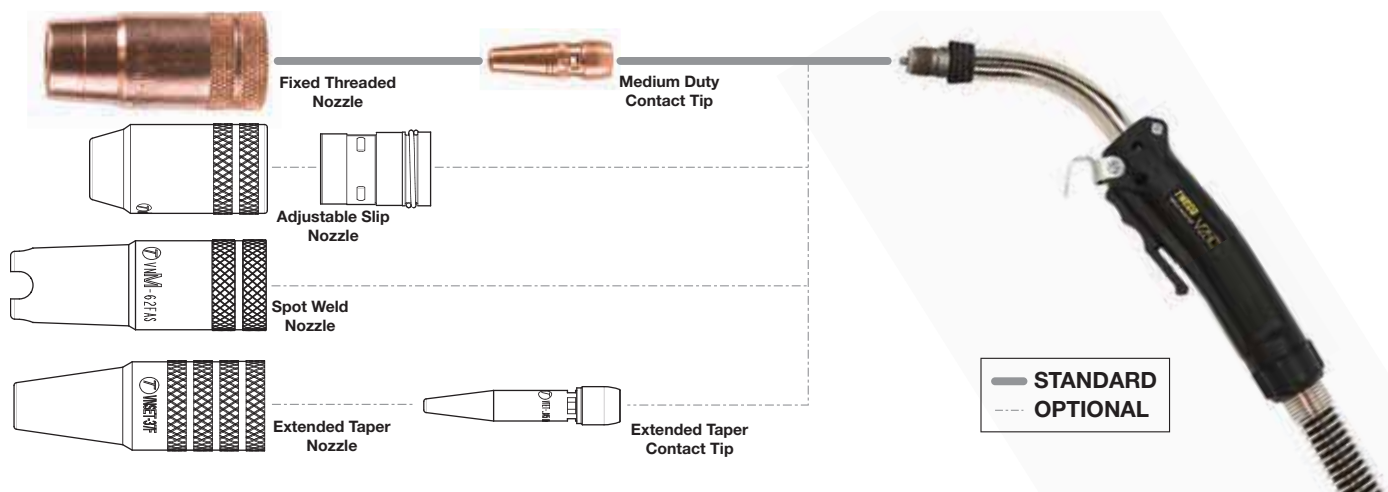
## Miller® Style Rear Connector

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

## 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.



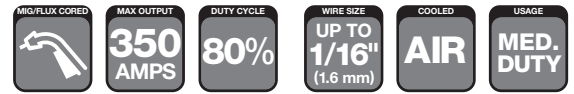
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	80%	Mixed	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

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

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

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# 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

MIG GUNS

## 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

## 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.

## Miller® Style Rear Connector

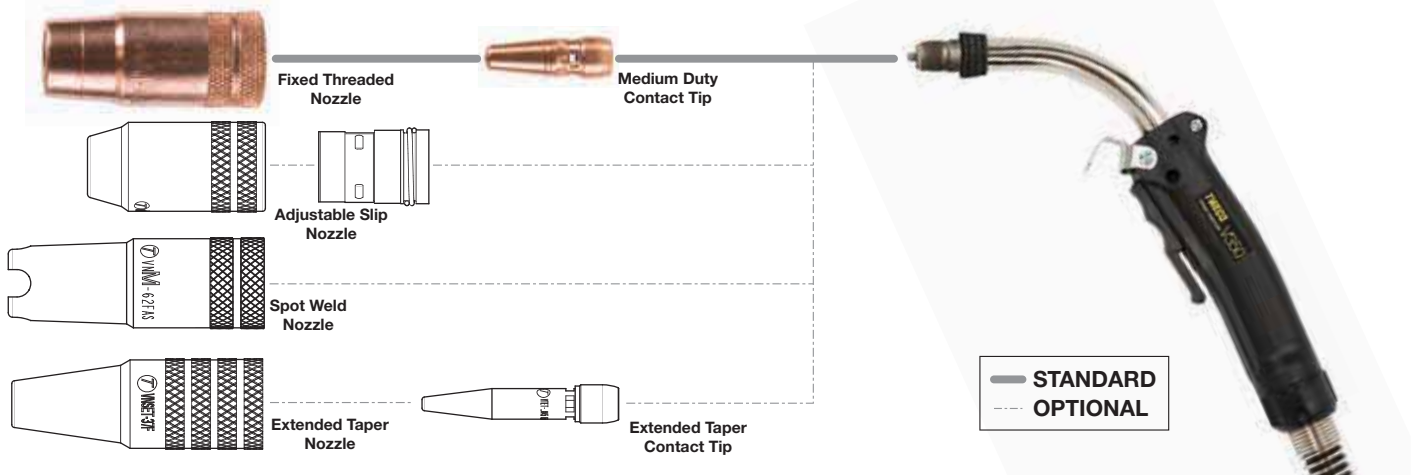
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	SMV310M-116	1036-1751
	12 ft (3.6 m)	SMV312M-116	1036-1754
	15 ft (4.6 m)	SMV315M-116	1036-1765
	15 ft (4.6 m)	SMV315M-116K4	1036-1768
	15 ft (4.6 m)	SMV315M-332K4	1036-1791
	15 ft (4.6 m)	SMV315M-116CT180	1036-1777
	20 ft (6.1 m)	SMV320M-116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

## 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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# Spray Master® V450 Amp MIG Gun

MIG GUNS



**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

## 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.

## Miller® Style Rear Connector

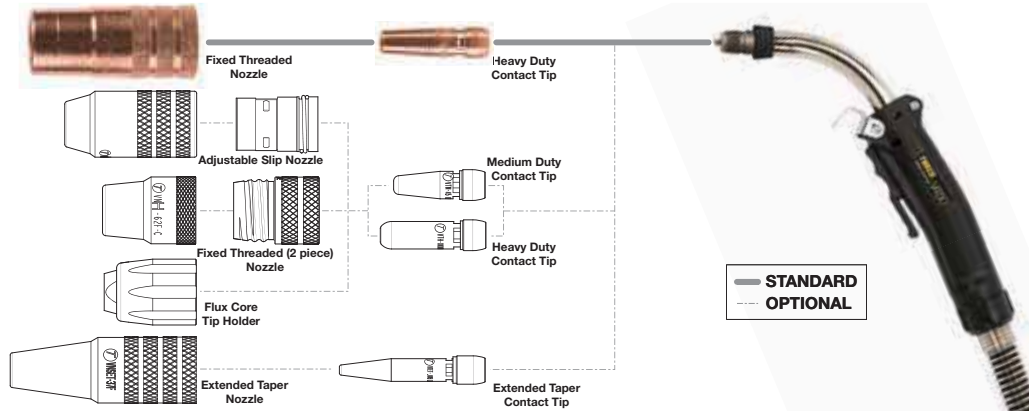
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	SMV410M-116	1040-1827
	12 ft (3.6 m)	SMV412M-116	1040-1830
	15 ft (4.6 m)	SMV415M-116	1040-1844
	15 ft (4.6 m)	SMV415M-116DSRS	1040-1846
	15 ft (4.6 m)	SMV415M-116LC	1040-1848
	15 ft (4.6 m)	SMV415M-116LM	1040-1849
	15 ft (4.6 m)	SMV415M-116K4	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

## 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

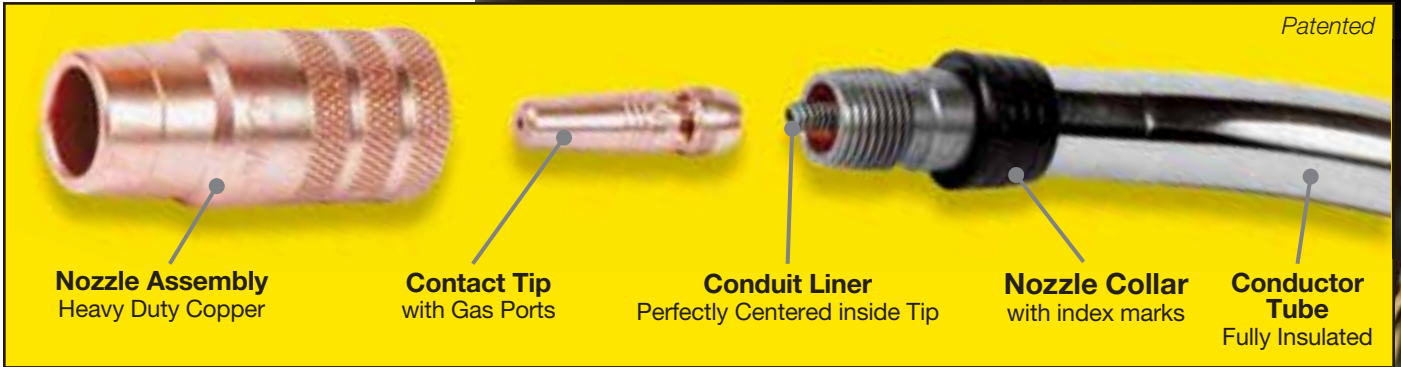


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# Spray Master®

## V-Series MIG Guns with Velocity™ Consumables

Patented



### FEATURES

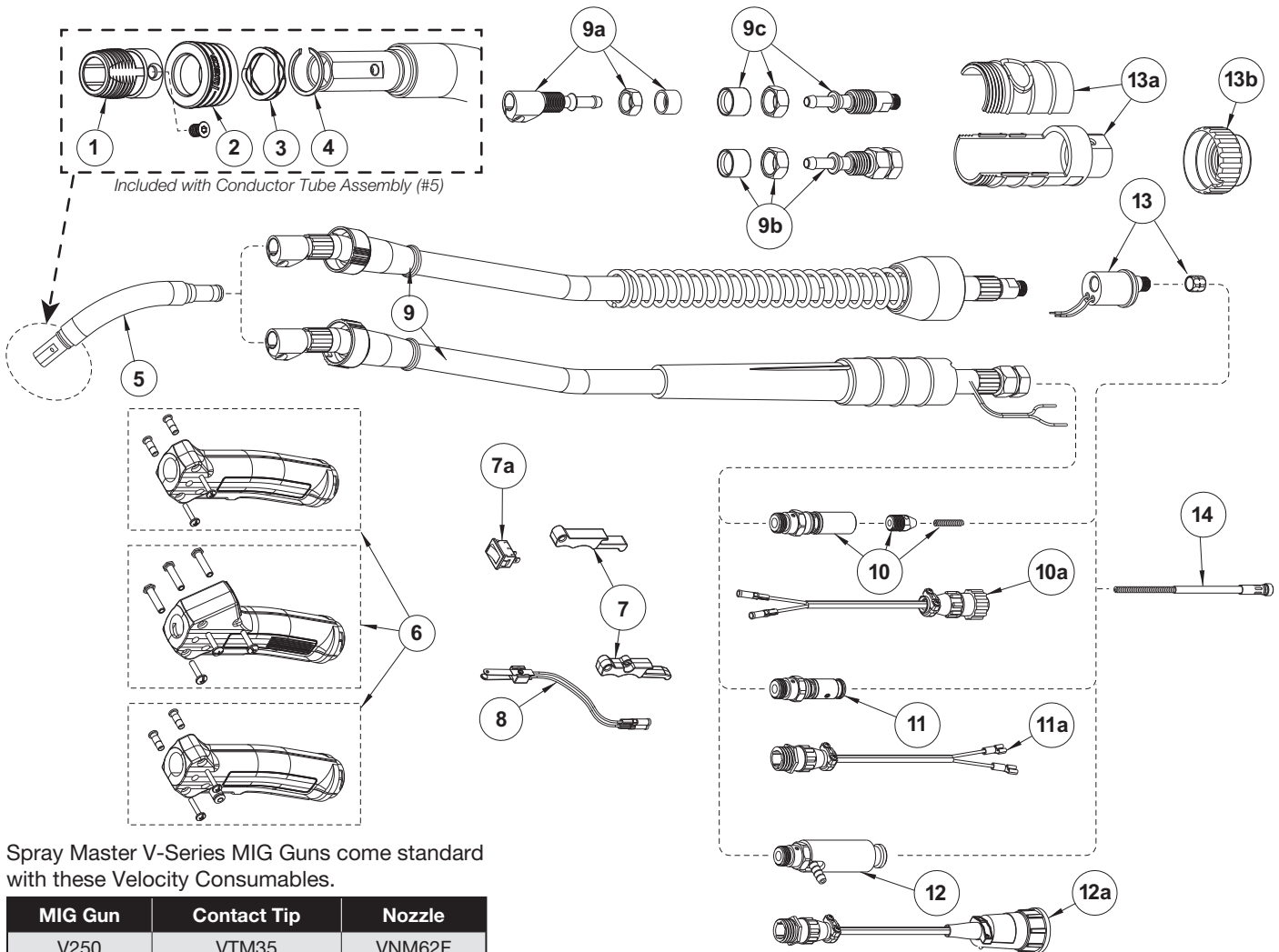
- **Velocity™ Consumables** with new ground-breaking innovation inspired by welders for welders
- **Solid Copper Conductor Path** with fewer connections for optimized electrical surface contact
- **Fewer Consumable Parts** mean less complexity and lower cost of ownership
- **Gas Ported Velocity Contact 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



MIG GUNS

# Spray Master® V-Series Replacement Parts

MIG GUNS



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	<b>SMVCT45</b>	1240-1373
45° Conductor Tube Long Reach Assembly	<b>SMVCT45LM</b>	1640-1373
60° Conductor Tube Assembly	<b>SMVCT60</b>	1240-1374
60° Conductor Tube Long Reach Assembly	<b>SMVCT60LM</b>	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

MIG GUNS

#	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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## 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. MIG Gun Series

		Classic No. 1	Classic No. 2	Classic No. 3	Classic No. 4	Classic No. 5	Classic No. 6
<b>Applications</b>		Light Duty Fabrication	Medium Duty Fabrication	Med/Heavy Duty Fabrication	Med/Heavy Duty Fabrication	Heavy Duty Fabrication	Heavy Duty Fabrication
<b>Standard Options</b>	Dual Schedule				■		
	Rear Connector	■	■	■	■	■	■
	Knucklehead™ Flexible Conductor Tube		■		■		
<b>Output Current</b>		180 Amps	200 Amps	300 Amps	400 Amps	500 Amps	600 Amps
<b>Duty Cycle - CO<sub>2</sub></b>		60%	60%	60%	60%	60%	60%
<b>Wire Diameter</b>		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)
<b>Process</b>	MIG	■	■	■	■	■	■
	Aluminum	■	■	■	■		
	Flux Cored Gas Shielded				■	■	■
	Flux Cored Self Shielded					■	■

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



# Classic® No. 1 180 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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)	<b>110-3035</b>	1010-1111
	12 ft (3.6 m)	<b>112-3035</b>	1010-1112
	15 ft (4.6 m)	<b>115-3035</b>	1010-1113
	20 ft (6.1 m)	<b>120-3035</b>	1010-1114
Up To .045" (1.2 mm)	10 ft (3 m)	<b>110-4045</b>	1010-1121
	12 ft (3.6 m)	<b>112-4045</b>	1010-1122
	15 ft (4.6 m)	<b>115-4045</b>	1010-1123
	20 ft (6.1 m)	<b>120-4045</b>	1010-1124

## 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)	<b>L115-3035</b>	1010-1145

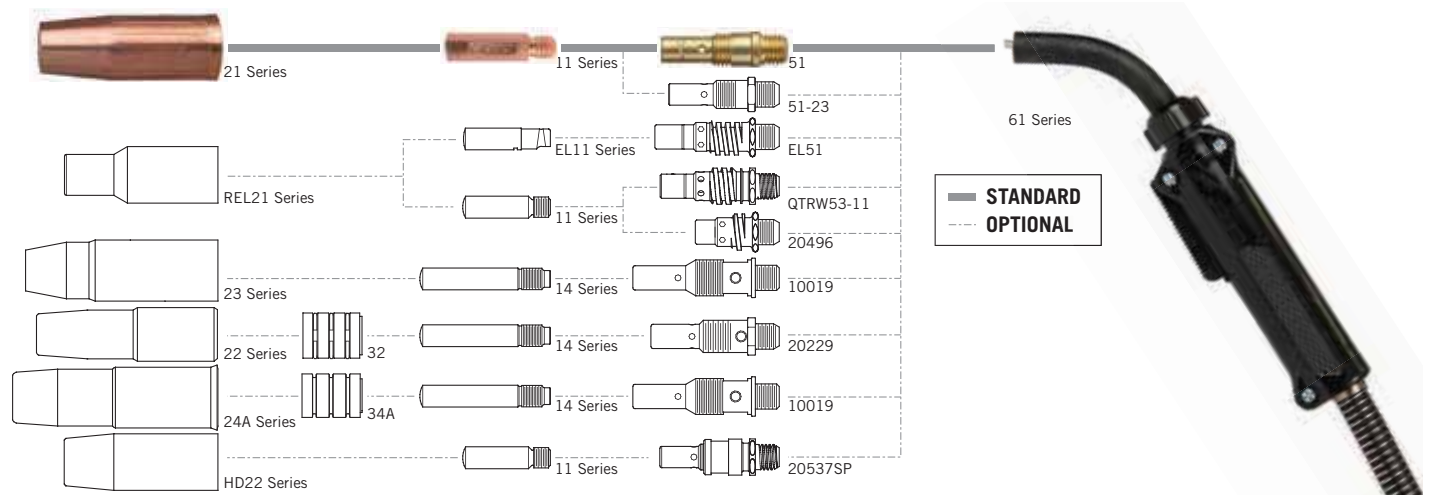
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

## Euro-Kwik Style Rear Connector

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

## Miller® Style Rear Connector

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

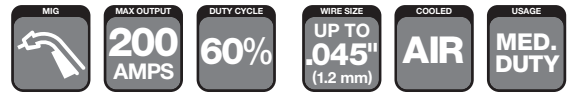


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light Duty Fabrication

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

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# Classic® No.2 200 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

## 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

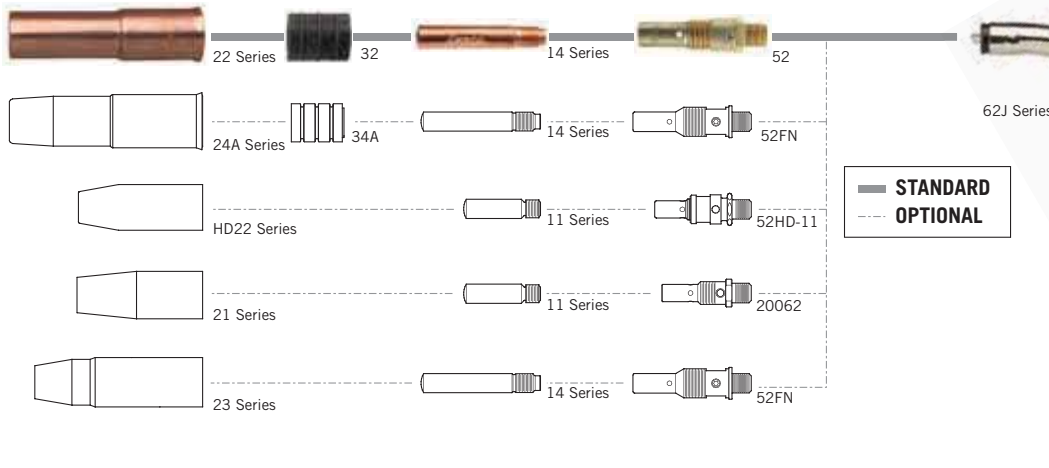
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	X210-3035	1020-1612
	10 ft (3 m)	X210-4045	1020-1621
Up To .045" (1.2 mm)	12 ft (3.6 m)	X212-4045	1020-1622
	12 ft (3.6 m)	X212FN-4045†	1020-1652
	15 ft (4.6 m)	X215-4045	1020-1623
	15 ft (4.6 m)	X215FN-4045	1020-1653

† 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).

## 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)



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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See Page 30 & 31 for Replacement Parts & Optional Accessories

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# Classic® No. 3 300 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

## 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

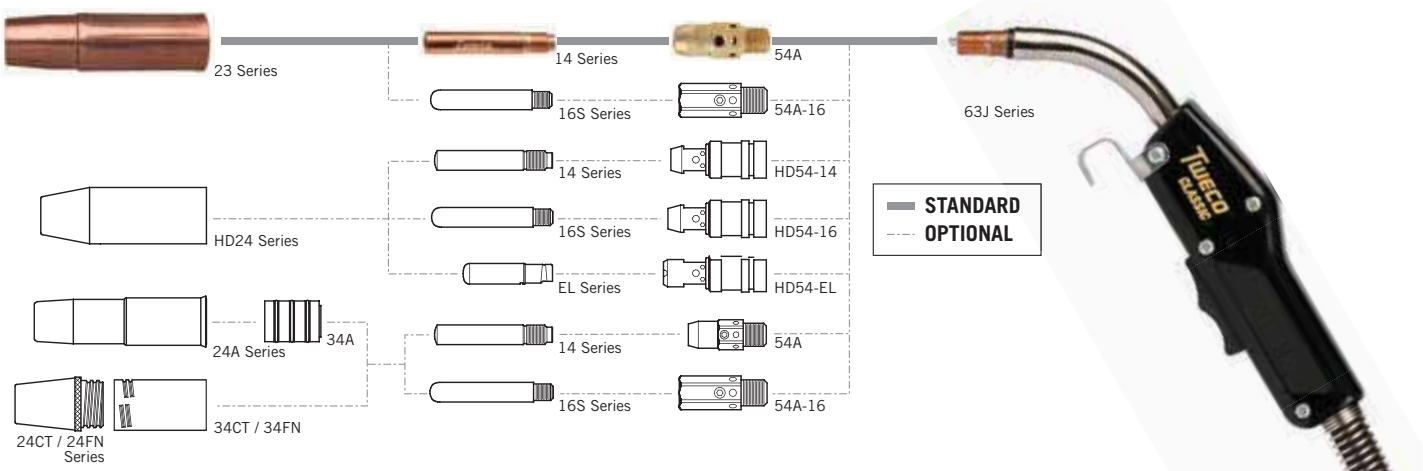
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

## 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

## Euro-Kwik Style Rear Connector

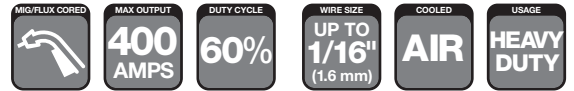
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	X310-3545	1030-1601
	12 ft (3.6 m)	X312-3545	1030-1602



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
300 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Medium/Heavy Duty Fabrication

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See Page 30 & 31 for Replacement Parts & Optional Accessories

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# Classic® No. 4 400 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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
Up To .045" (1.2 mm)	25 ft (7.6 m)	425-3545	1040-1105
	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
1/16" (1.6 mm)	25 ft (7.6 m)	425-116	1040-1115
	15 ft (4.6 m)	DS420-116	1040-1514
5/64" (2.0 mm)	15 ft (4.6 m)	415-564	1040-1123

## 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.

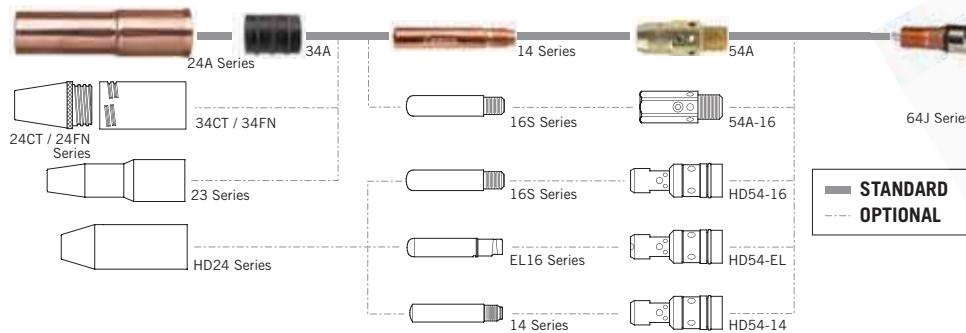
## Euro-Kwik Style Rear Connector

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

## 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
Up To .045" (1.2 mm)	25 ft (7.6 m)	M425-3545	1040-1129
	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
5/64" (2.0 mm)	25 ft (7.6 m)	M425-116	1040-1128
	15 ft (4.6 m)	M415-564	1040-1138



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO <sub>2</sub> 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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# Classic® No. 5 500 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

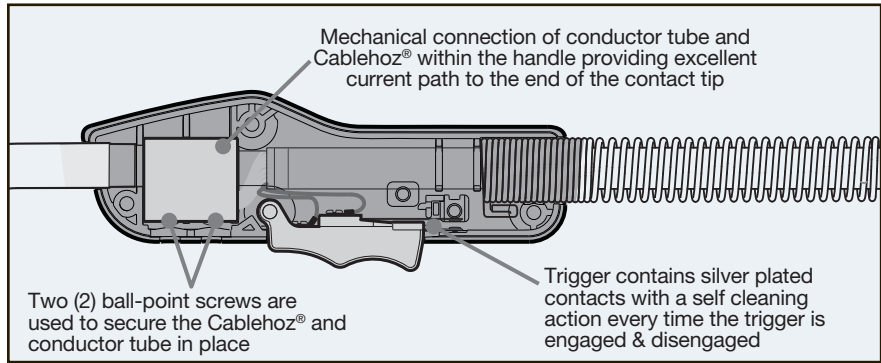
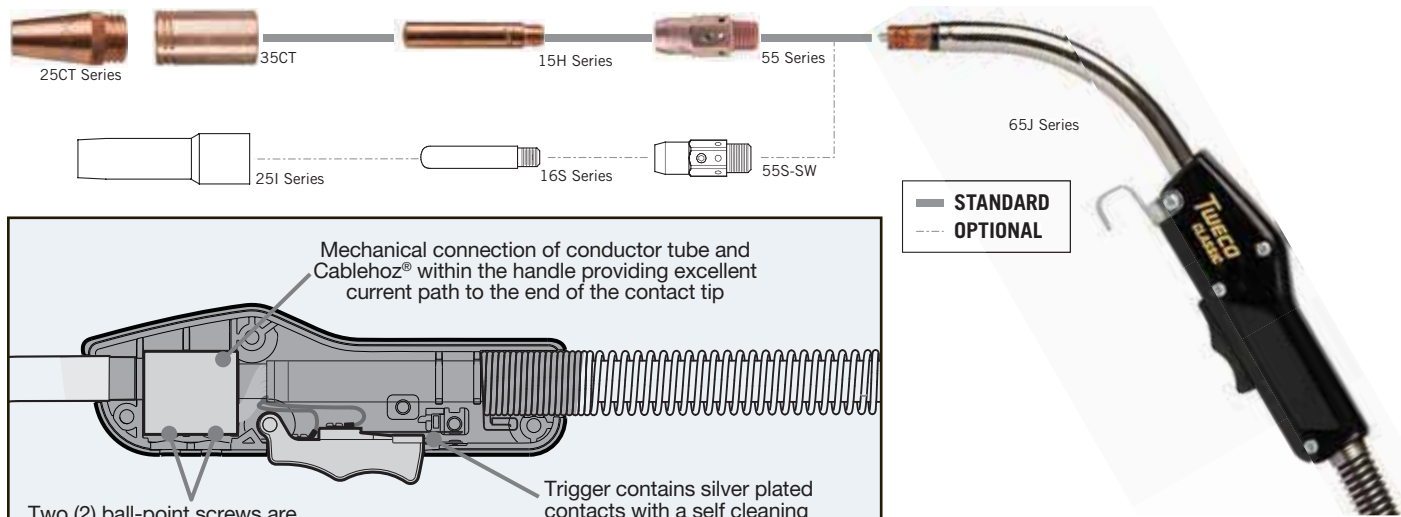
Fits Lincoln LNT7, 8, 9, SP200

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

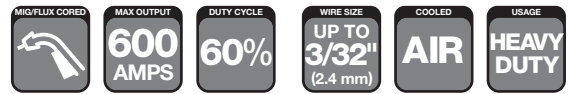
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	M515-116	1050-1173
Up To 3/32" (2.4 mm)	15 ft (4.6 m)	M515-332	1050-1175



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 3/32" (2.4 mm)	Air	Heavy Duty Fabrication

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

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# Classic® No. 6 600 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

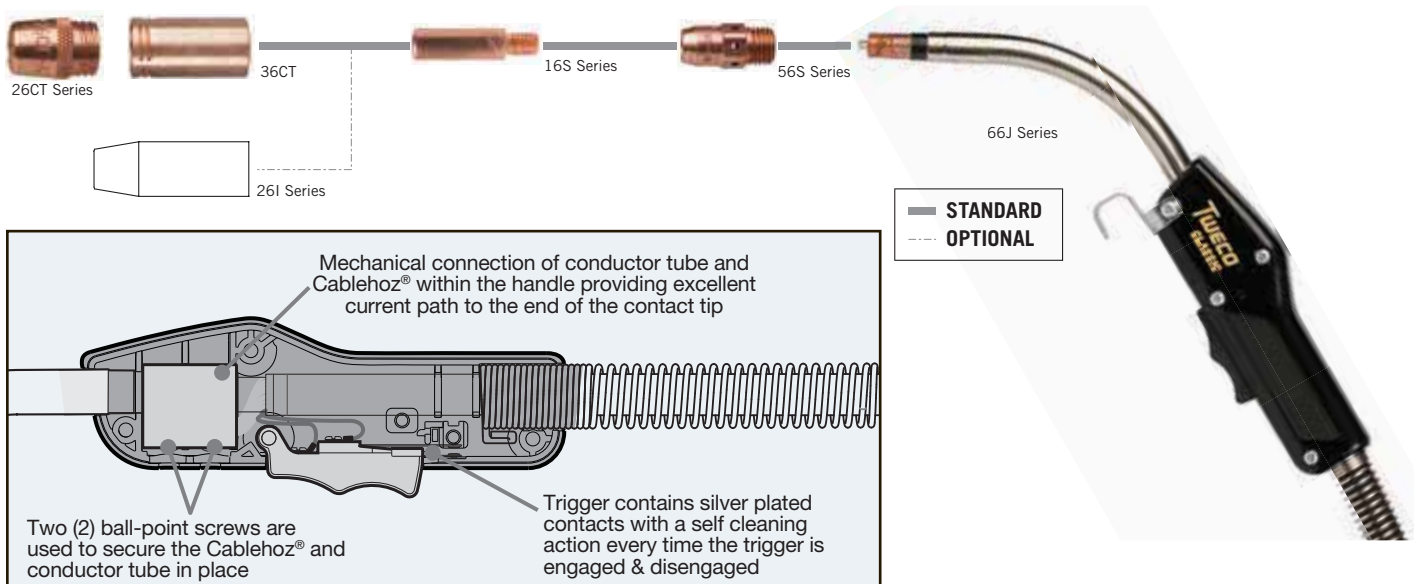
## Tweco® Style Rear Connector

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



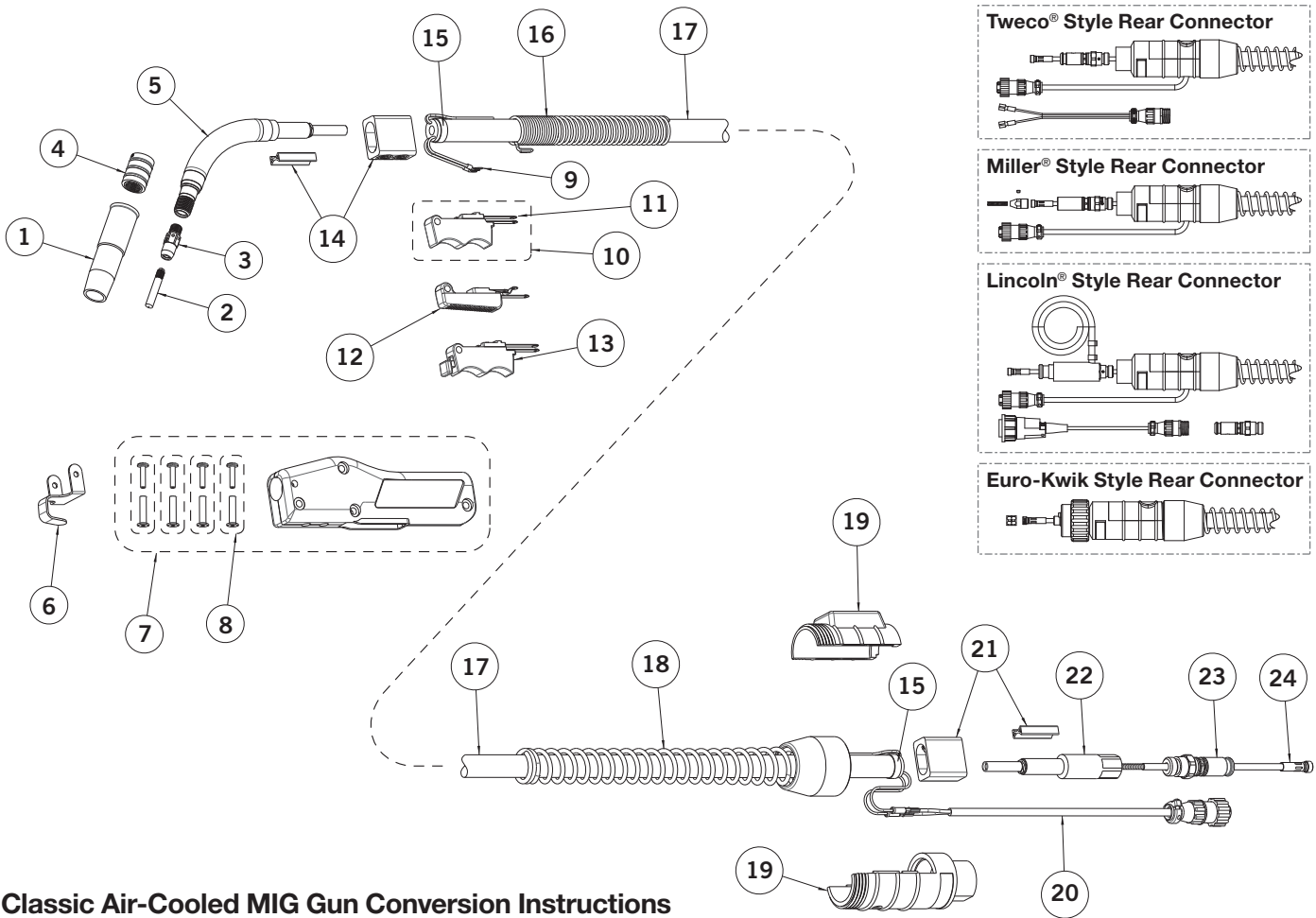
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
600 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 3/32" (2.4 mm)	Air	Heavy Duty Fabrication



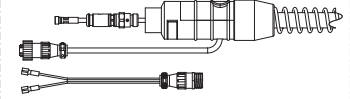
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# Classic® No. Series Replacement Parts

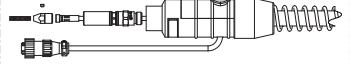
MIG GUNS



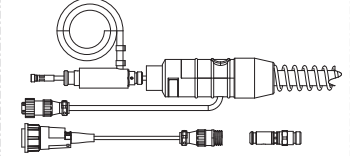
**Tweco® Style Rear Connector**



**Miller® Style Rear Connector**



**Lincoln® Style Rear Connector**

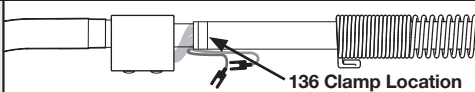
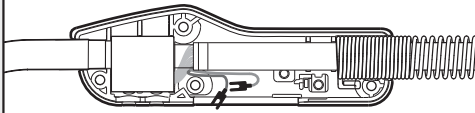
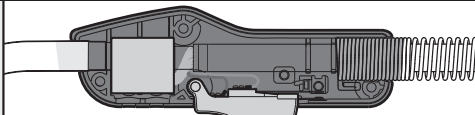
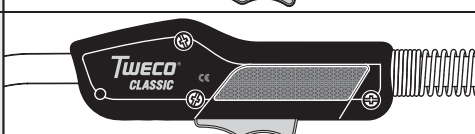
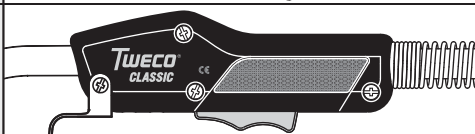



**Euro-Kwik Style Rear Connector**



## 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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## 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

# Classic No. Velocity MIG Gun Series



		Velocity Classic No. 1	Velocity Classic No. 2	Velocity Classic No. 3	Velocity Classic No. 4	Velocity Classic No. 5
<b>Applications</b>		Light Duty Fabrication	Medium Duty Fabrication	Med/Heavy Duty Fabrication	Med/Heavy Duty Fabrication	Heavy Duty Fabrication
<b>Standard Options</b>	Dual Schedule				■	
	Rear Connector	■	■	■	■	■
	Knucklehead™ Flexible Conductor Tube		■		■	
<b>Output Current</b>		180 Amps	200 Amps	300 Amps	400 Amps	500 Amps
<b>Duty Cycle - CO<sub>2</sub></b>		60%	60%	60%	60%	60%
<b>Wire Diameter</b>		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)
<b>Process</b>	MIG	■	■	■	■	■
	Aluminum	■	■	■	■	
	Flux Cored Gas Shielded				■	■
	Flux Cored Self Shielded					■

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





# Velocity Classic® No. 1 180 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

## 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

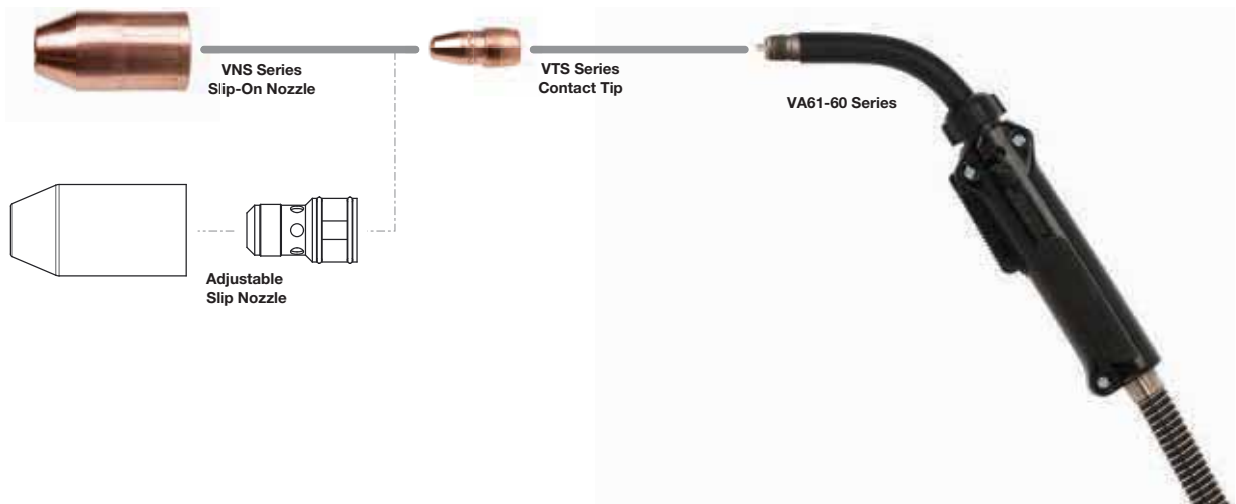
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

## 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

## Miller® Style Rear Connector

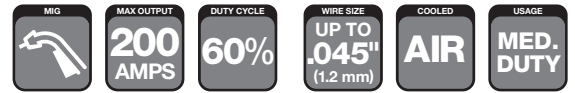
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	VM110-3035	1010-1125
	12 ft (3.6 m)	VM112-3035	1010-1126
	15 ft (4.6 m)	VM115-3035	1010-1127



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light Duty Fabrication



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# Velocity Classic® No.2 200 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

## 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
	20 ft (6.1 m)	VL220-3035	1020-1150

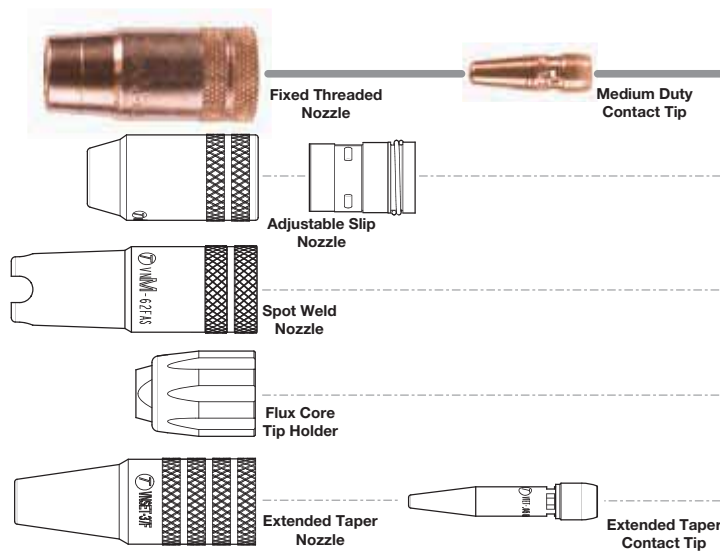
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

## Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	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

## 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
	10 ft (3 m)	VX210-4045	1020-1306
Up To .045" (1.2 mm)	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 <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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

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# Velocity Classic® No. 3 300 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

## 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

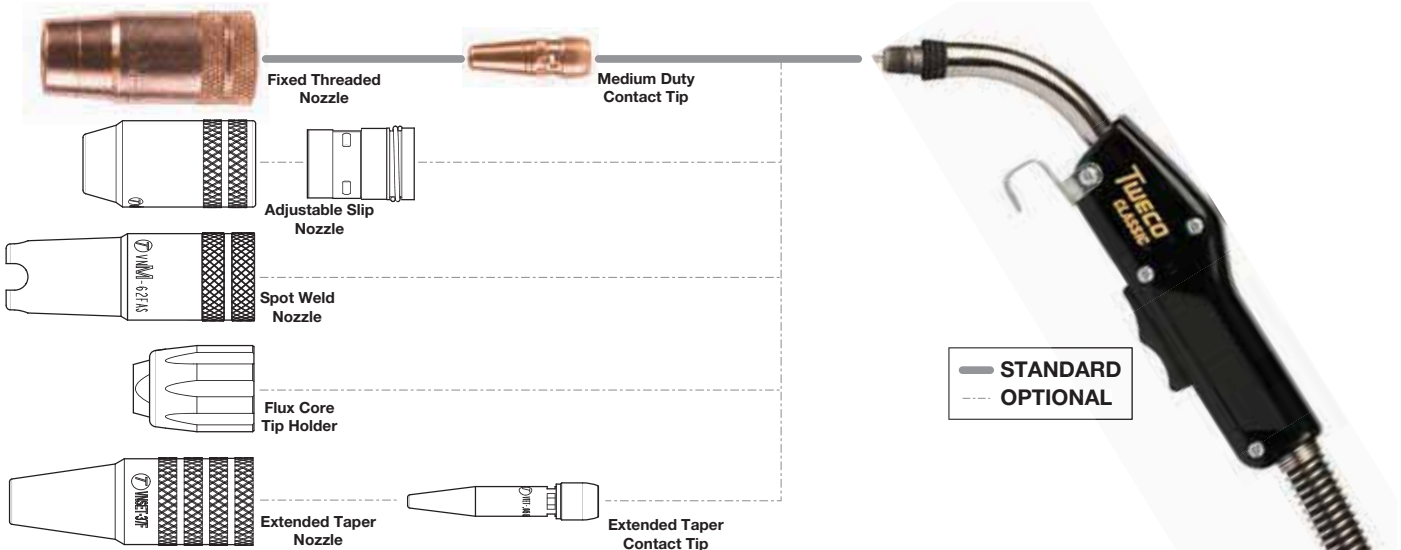
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. IMS354-DSLJ (Stock No. 2060-2137) must be ordered separately.

## Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	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

## Euro-Kwik Style Rear Connector

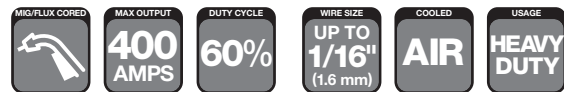
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	VX310-3545	1030-1020
	12 ft (3.6 m)	VX312-3545	1030-1021
	15 ft (4.6 m)	VX315-3545	1030-1022
Up To 5/64" (2.0 mm)	15 ft (4.6 m)	VX315-564	1030-1023



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
300 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Medium/Heavy Duty Fabrication

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

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# Velocity Classic® No. 4 400 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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
Up To 1/16" (1.6 mm)	25 ft (7.6 m)	V425-3545	1040-1907
	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
5/64" (2.0 mm)	20 ft (6.1 m)	VDS420-116	1040-1910
	15 ft (4.6 m)	V415-564	1040-1912

## 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
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	VL415-3545K4**	1040-1930
	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.

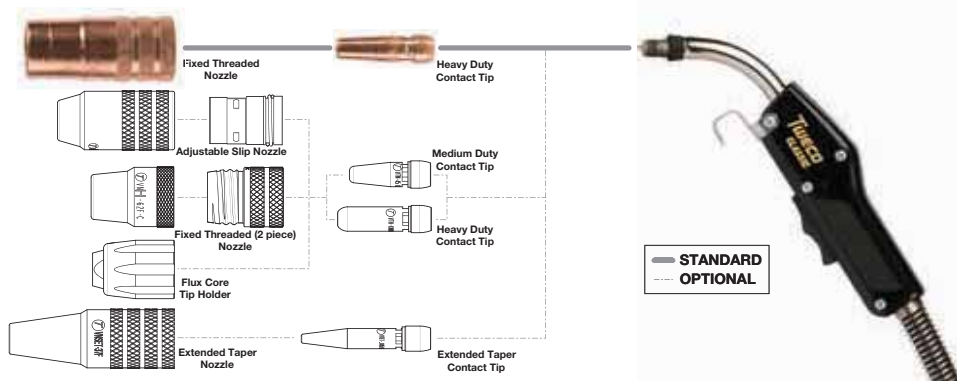
## Euro-Kwik Style Rear Connector

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

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

## 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
Up To 1/16" (1.6 mm)	25 ft (7.6 m)	VM425-3545	1040-1919
	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



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

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

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# Velocity Classic® No. 5 500 Amp MIG Gun

**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

## 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

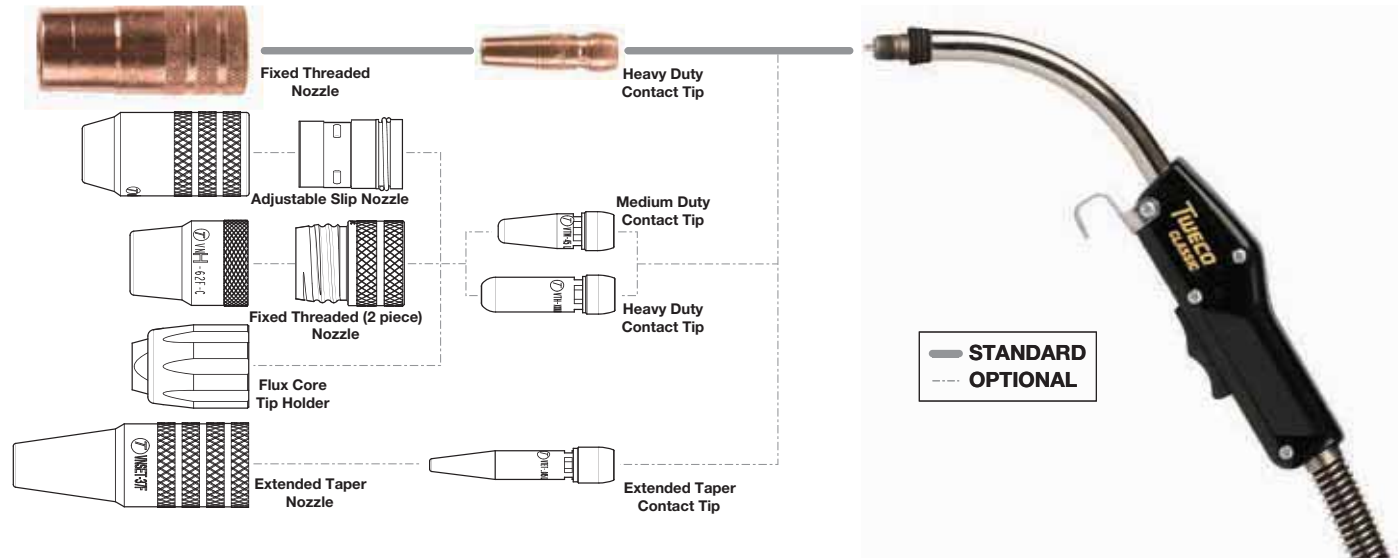
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

## 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

## 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



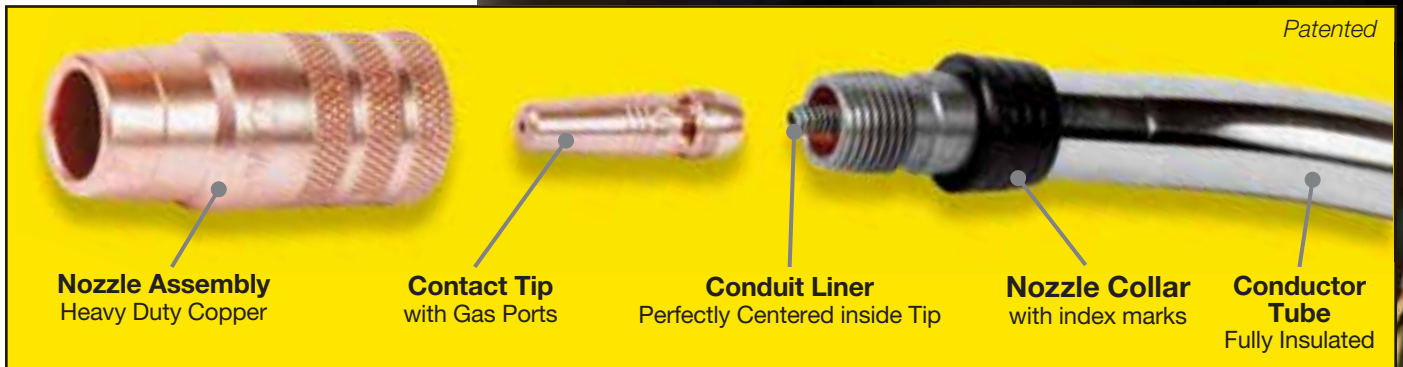
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 3/32" (2.4 mm)	Air	Heavy Duty Fabrication

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

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## Velocity Classic No.

Series MIG Guns  
with Velocity™  
Consumables



### FEATURES

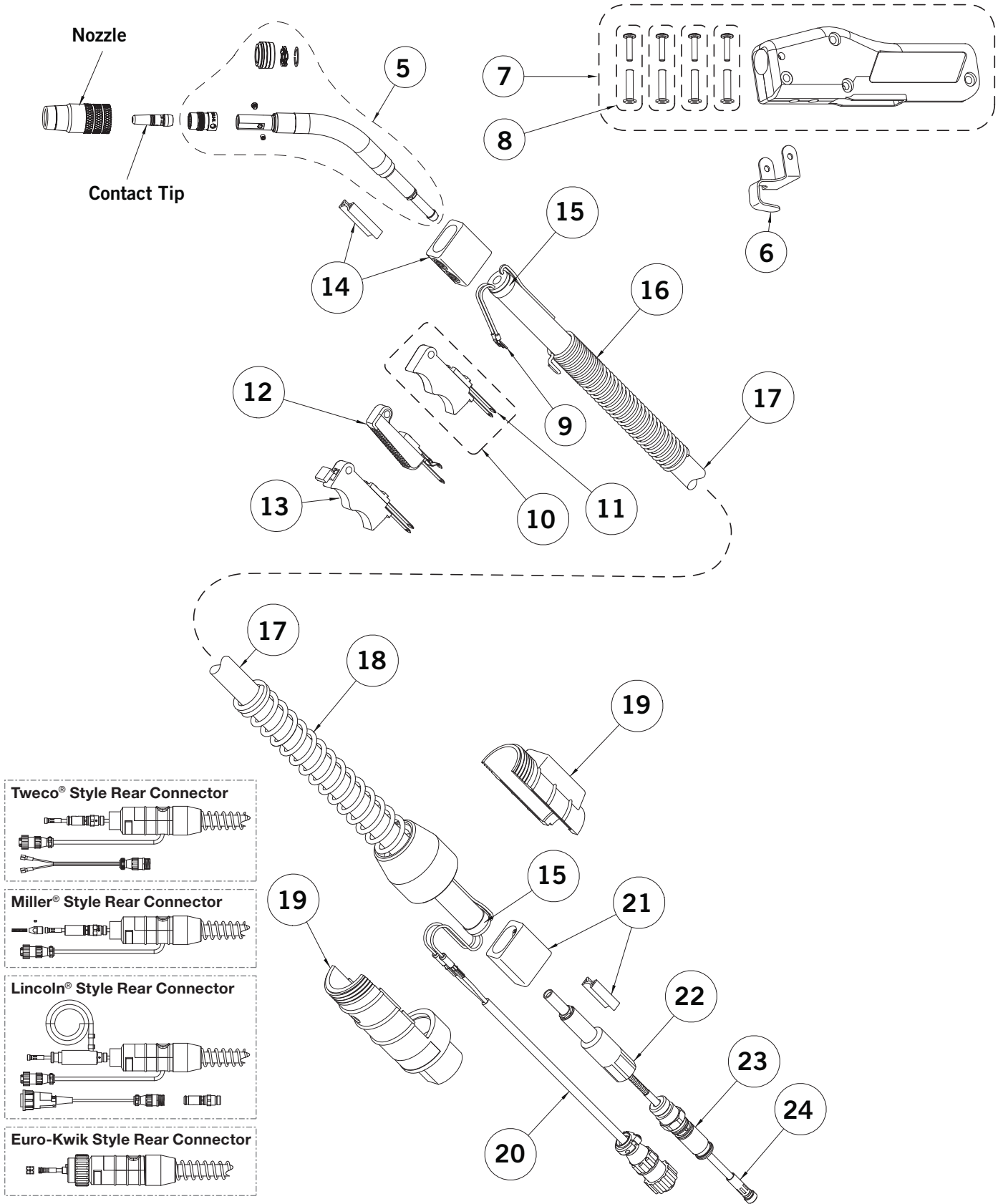
- **Velocity™ Consumables** with new ground-breaking innovation inspired by welders for welders
- **Solid Copper Conductor Path** with fewer connections for optimized electrical surface contact
- **Fewer Consumable Parts** mean less complexity and lower cost of ownership
- **Gas Ported Velocity Contact 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



MIG GUNS

# Velocity Classic® No. Series Replacement Parts

MIG GUNS



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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



## 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

## MIG Gun Series

		Tweco Fusion 140	Tweco Fusion 180	Tweco Fusion 220	Tweco Fusion 250
<b>Applications</b>		Light Duty Fabrication	Light Duty Fabrication	Medium Duty Fabrication	Medium/Heavy Duty Fabrication
<b>Standard Options</b>	<b>Rear Connector</b>	■	■	■	■
<b>Output Current</b>		140 Amps	180 Amps	220 Amps	250 Amps
<b>Duty Cycle - CO<sub>2</sub></b>		40%	40%	40%	80%
<b>Wire Diameter</b>		Up to .035" (0.9 mm)	Up to .035" (0.9 mm)	Up to .035" (0.9 mm)	Up to .045" (1.2 mm)
<b>Process</b>	<b>MIG</b>	■	■	■	■
	<b>Aluminum</b>	■	■	■	■

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



# Tweco Fusion® 140 Amp MIG Gun

MIG GUNS



**40% Duty Cycle - CO<sub>2</sub> 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

## 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

## 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

## Euro-Kwik Style Rear Connector

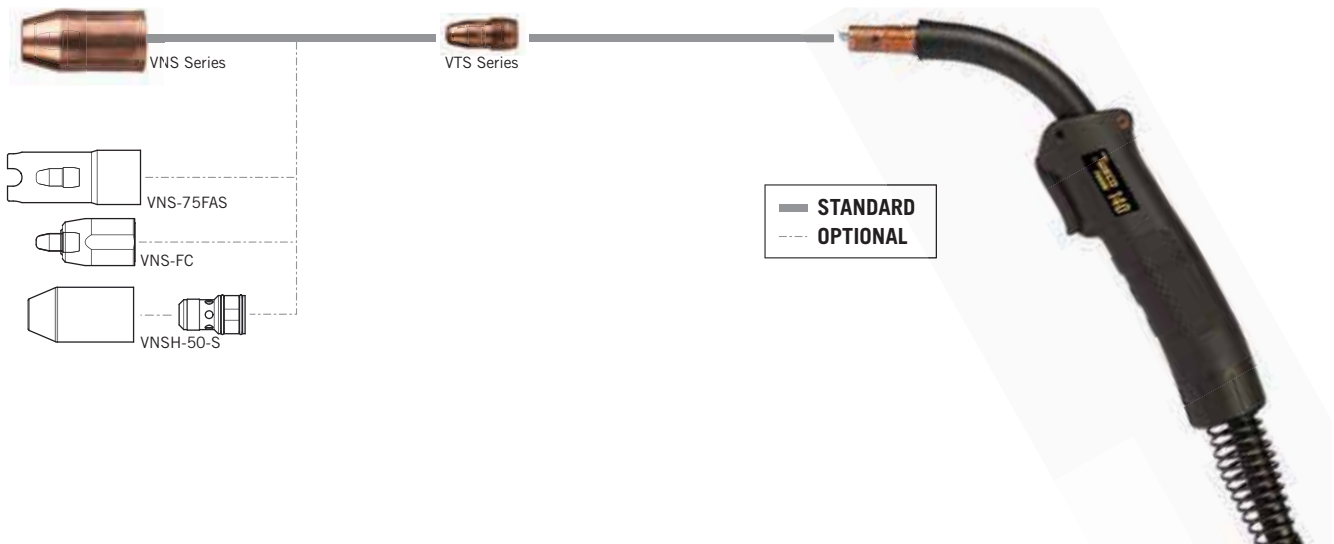
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	F140X-10-3035	1017-1323

Conduit Liner – WS42 Series

## 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

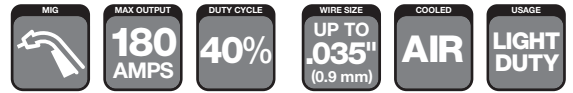
Note: Gun length is measured from the front case to the rear case +/-3".



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
120 Amps	20%	CO <sub>2</sub> Carbon Dioxide	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

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# Tweco Fusion® 180 Amp MIG Gun



**40% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

## 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

## 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

## Euro-Kwik Style Rear Connector

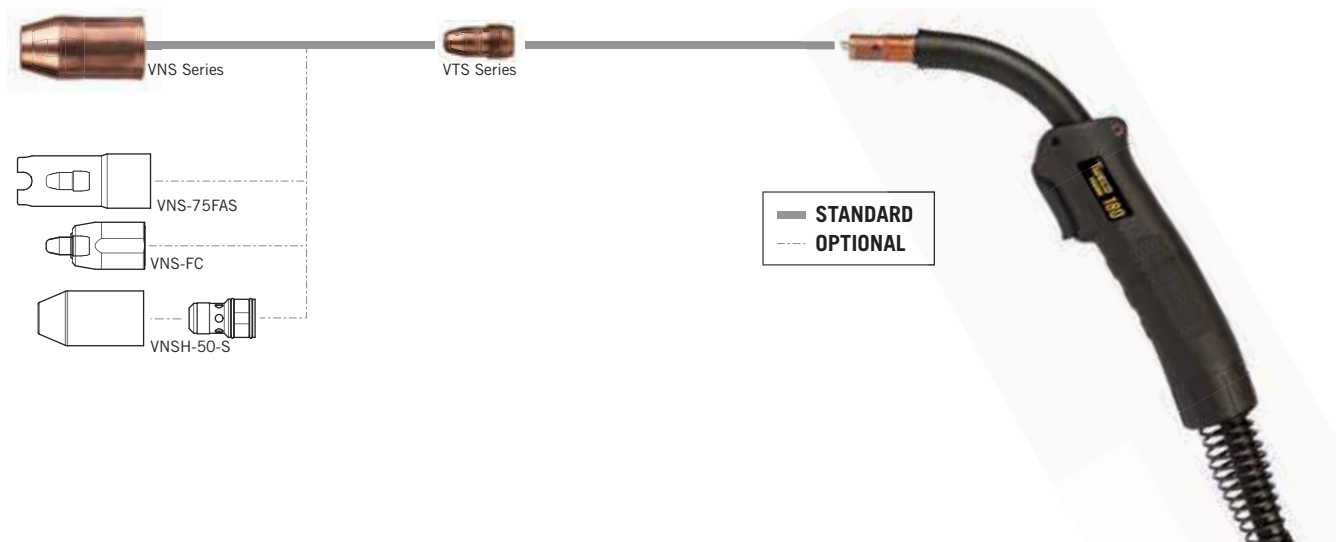
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	F180X-10-3035	1017-1335
	12 ft (3.6 m)	F180X-12-3035	1017-1334

Conduit Liner – WS42 Series

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

## 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



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	40%	CO <sub>2</sub> Carbon Dioxide	Up To .035" (0.9 mm)	Air	Light Duty Fabrication



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# Tweco Fusion® 220 Amp MIG Gun

MIG GUNS



**40% Duty Cycle - CO<sub>2</sub> 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

## 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

## 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

## Euro-Kwik Style Rear Connector

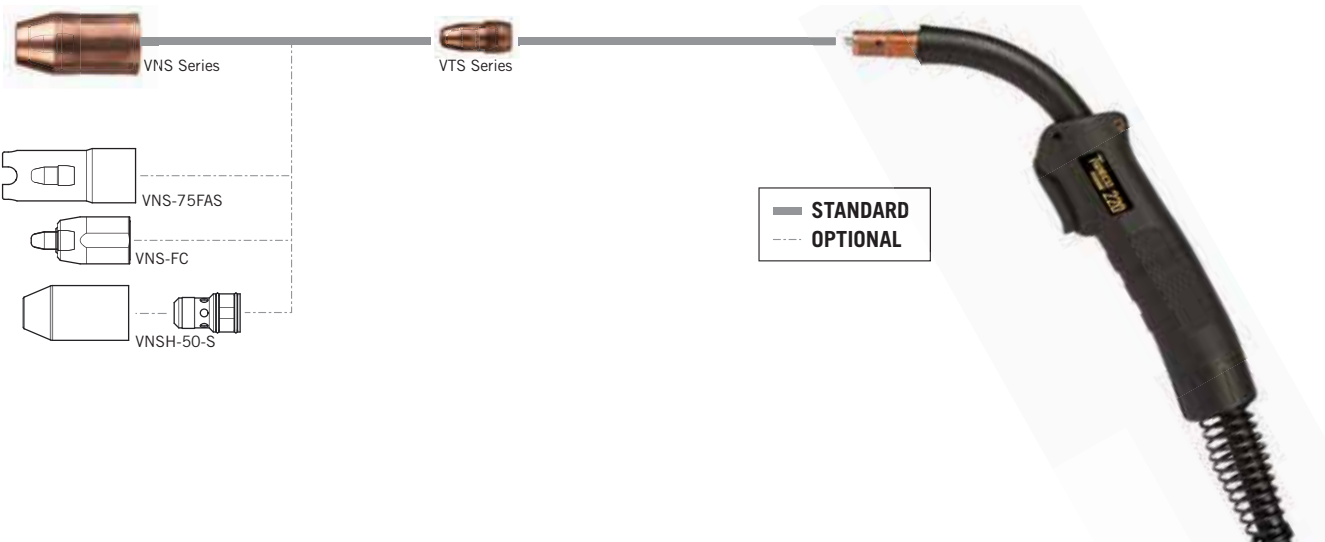
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	F220X-10-3035	1023-1264
	12 ft (3.6 m)	F220X-12-3035	1023-1265
	15 ft (4.6 m)	F220X-15-3035	1023-1263

Conduit Liner – WS42 Series

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

## Miller® Style Rear Connector

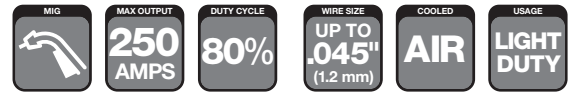
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	F220M-15-3035	1023-1259



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
220 Amps	40%	CO <sub>2</sub> Carbon Dioxide	Up To .035" (0.9 mm)	Air	Medium Duty Fabrication

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

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# Tweco Fusion® 250 Amp MIG Gun



**80% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

## 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

## 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

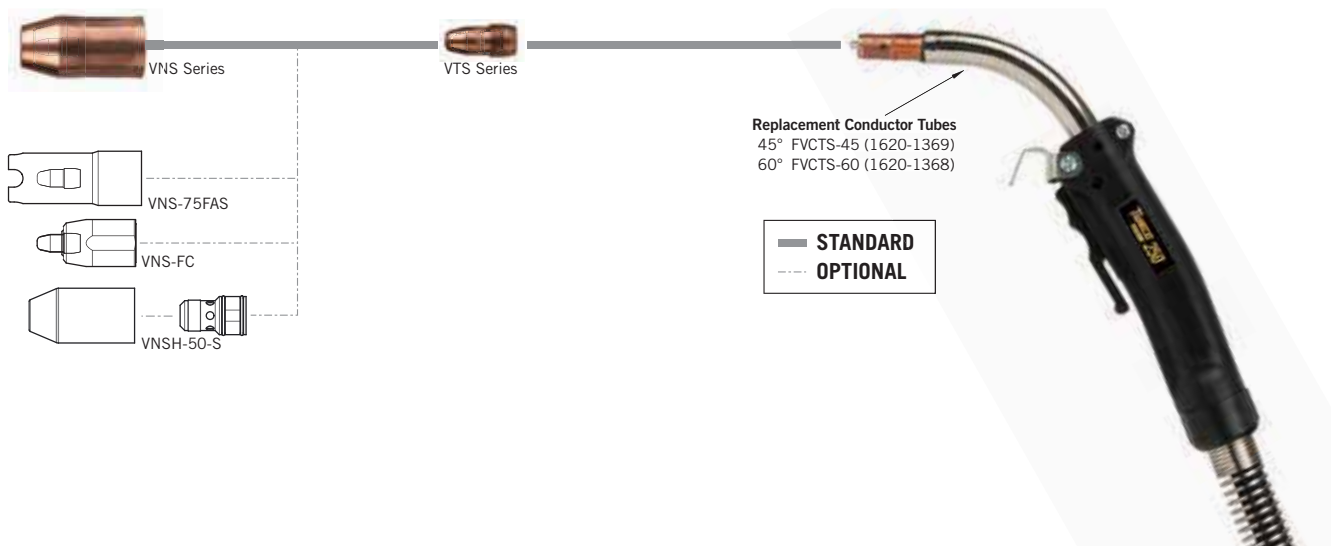
## Euro-Kwik Style Rear Connector

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

## 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

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 <sub>2</sub> Carbon Dioxide	Up To .035" (0.9 mm)	Air	Heavy Duty Fabrication

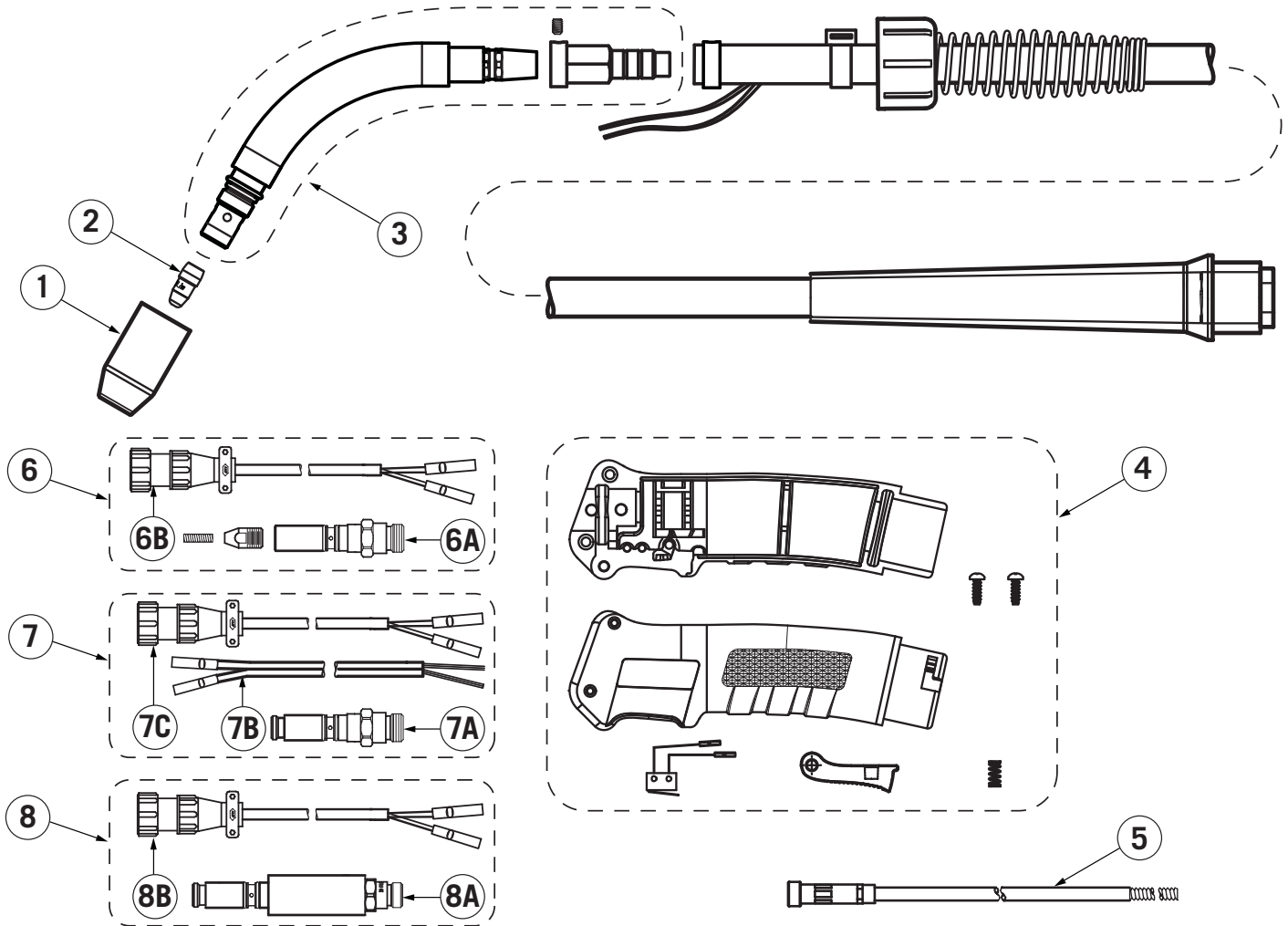


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# Tweco Fusion® 140, 180 & 220 Amp MIG Gun

## Replacement Parts

MIG GUNS



#	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

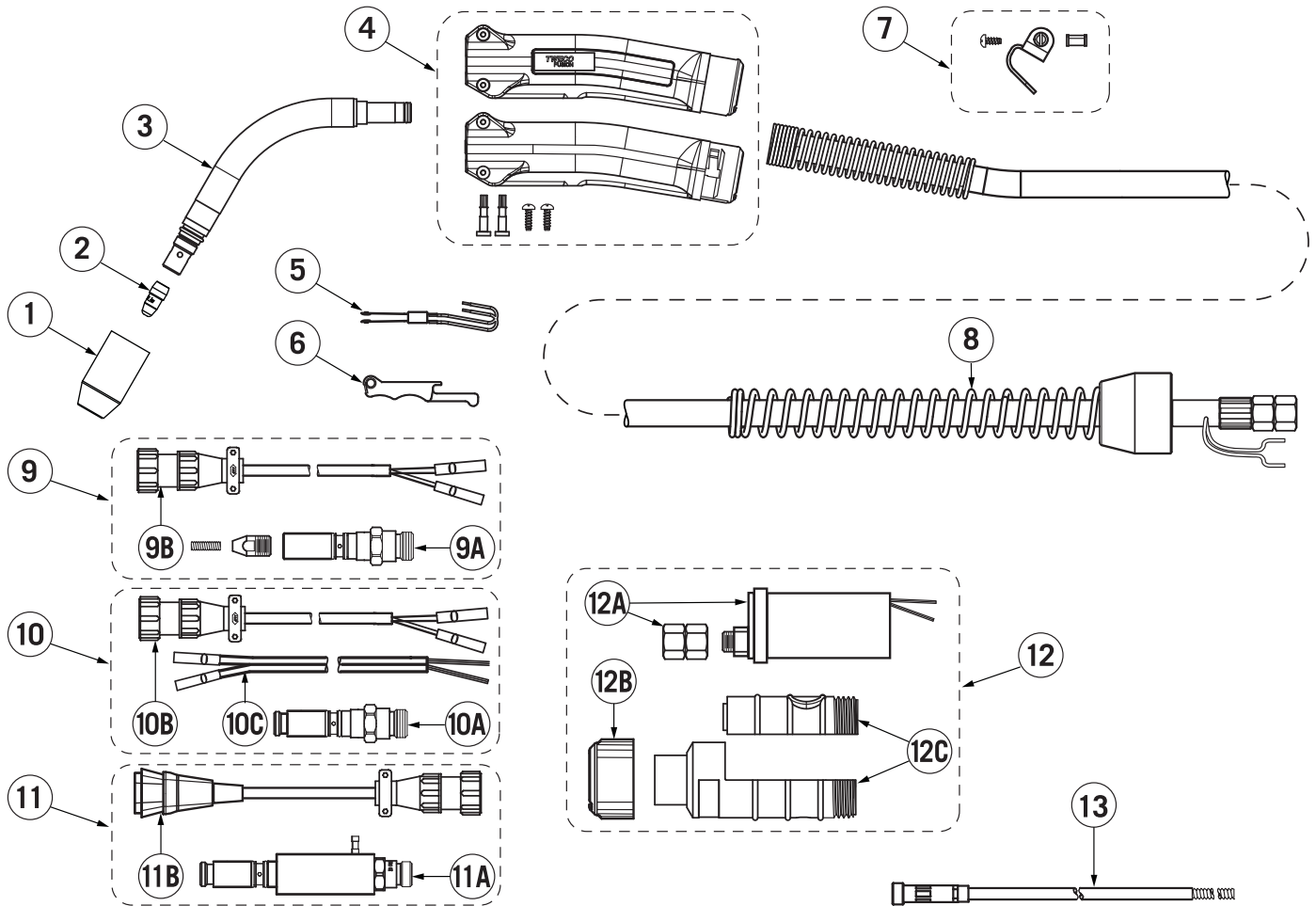
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# Tweco Fusion® 250 Amp MIG Gun

## Replacement Parts

MIG GUNS



#	Description	Part No.	Stock No.
1	Velocity™ Nozzle	<b>Refer to Page 100</b>	
2	Velocity Contact Tip	<b>Refer to Page 100</b>	
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	<b>Refer to Pages 124-127</b>	

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

# PulseMaster™ 350 Amp MIG Gun

MIG GUNS



Tweco® PulseMaster Smart MIG® Gun with digital display

Tweco PulseMaster Standard 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)	PMA312-3545	1038-1152
	15 ft (4.6 m)	PMA315-3545	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)	PMA312X-3545	1038-1153
	15 ft (4.6 m)	PMA315X-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

**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

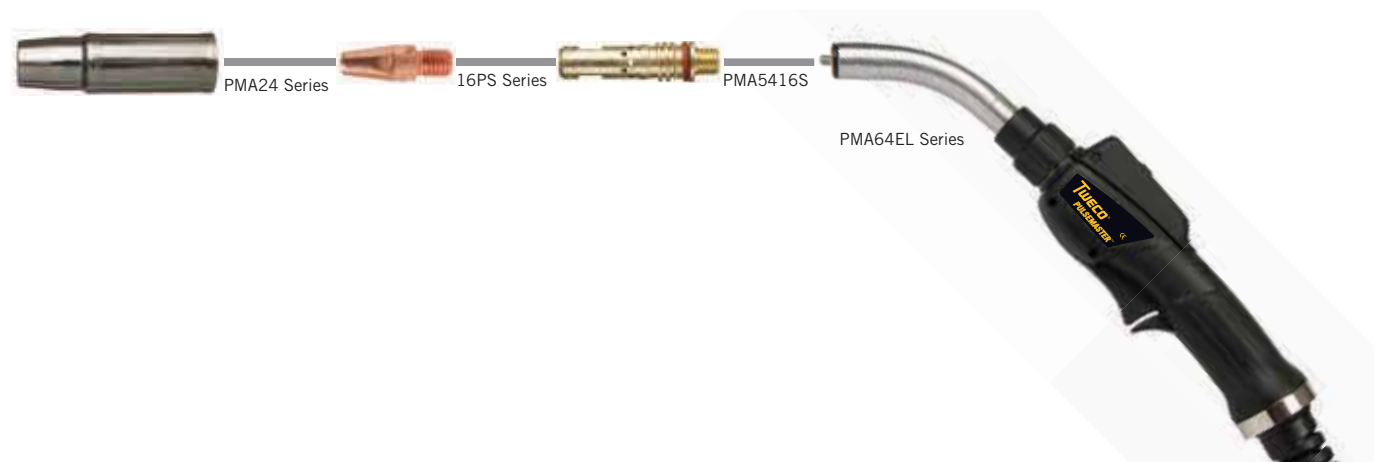
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

**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

**Euro-Kwik Style Rear Connector**

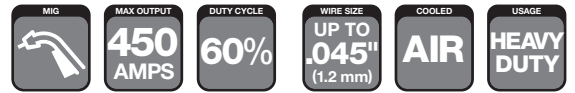
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	PMA312X-3545	1038-1151
	15 ft (4.6 m)	PMA315X-3545	1038-1156



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

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

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# PulseMaster™ 450 Amp MIG Gun



Tweco® PulseMaster Smart MIG® Gun with digital display

Tweco PulseMaster Standard 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

MIG GUNS

**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)	PMA412-3545	1041-1510
	15 ft (4.6 m)	PMA415-3545	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)	PMA412X-3545	1041-1515
	15 ft (4.6 m)	PMA415X-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

**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

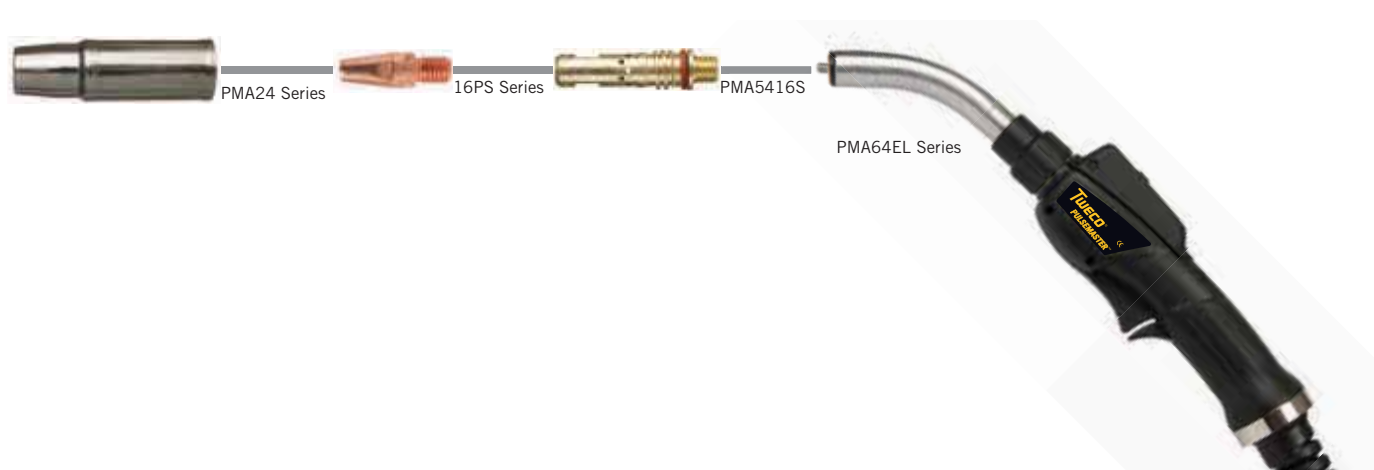
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

**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

**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



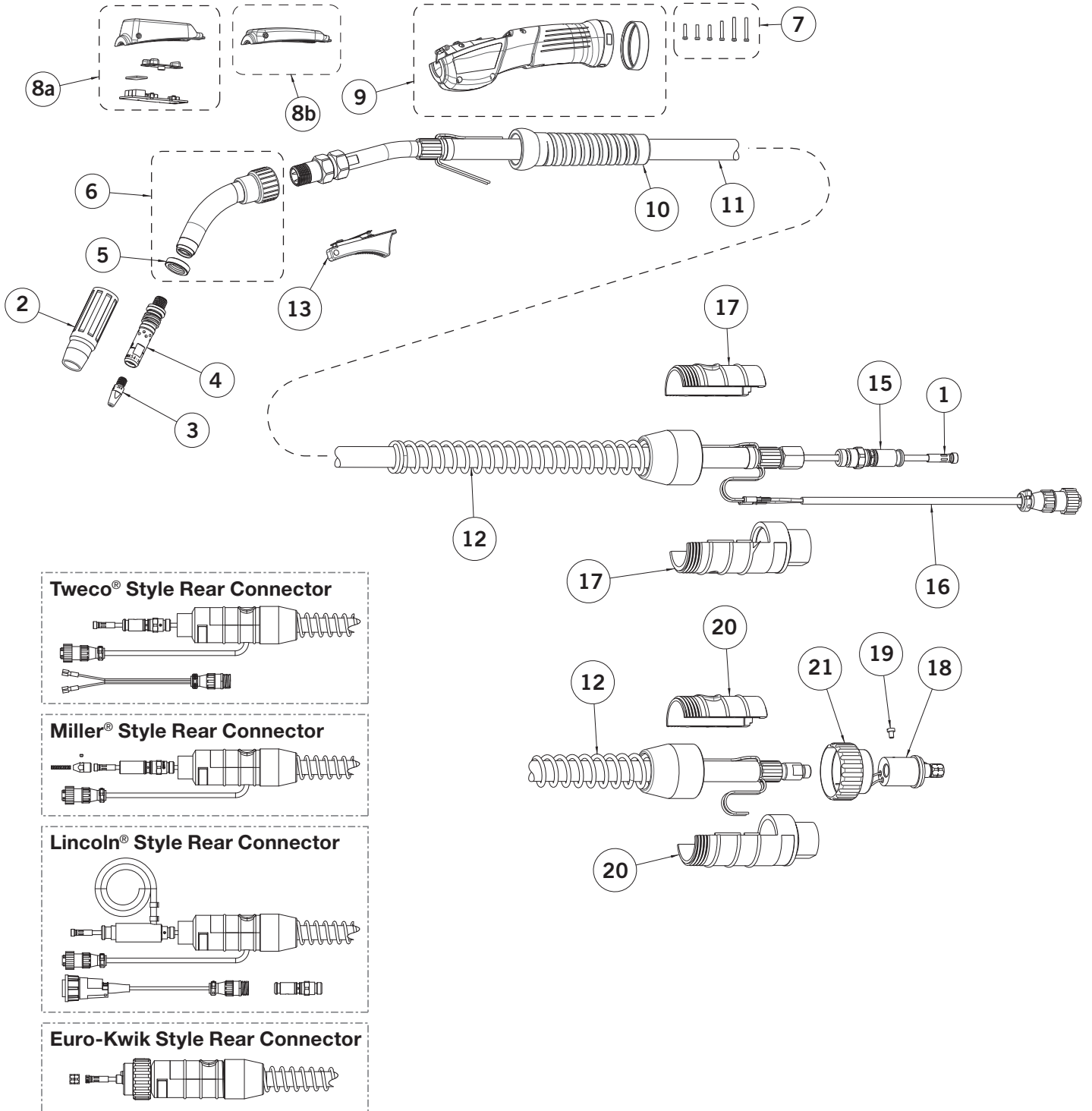
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Heavy Duty Fabrication

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

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# PulseMaster™ Series Replacement Parts

MIG GUNS



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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



## Compact Eliminator<sup>®</sup> and Eliminator<sup>®</sup> 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<sup>®</sup>
- **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<sub>2</sub> or mixed gases

# Eliminator<sup>®</sup> MIG Gun Series



		Compact Eliminator® 250	Compact Eliminator 450	Standard Eliminator 450
<b>Applications</b>		Light/Medium Duty Fabrication	Heavy Duty Fabrication	Heavy Duty Fabrication
<b>Standard Options</b>	Rear Connector	■	■	■
	Dual Schedule		■	■
	Knucklehead Flexible Conductor Tube	■	■	■
<b>Output Current</b>		250 Amps	450 Amps	450 Amps
<b>Duty Cycle - CO<sub>2</sub></b>		60%	60%	60%
<b>Wire Diameter</b>		Up to .045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 1/16" (1.6 mm)
<b>Process</b>	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® 250 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

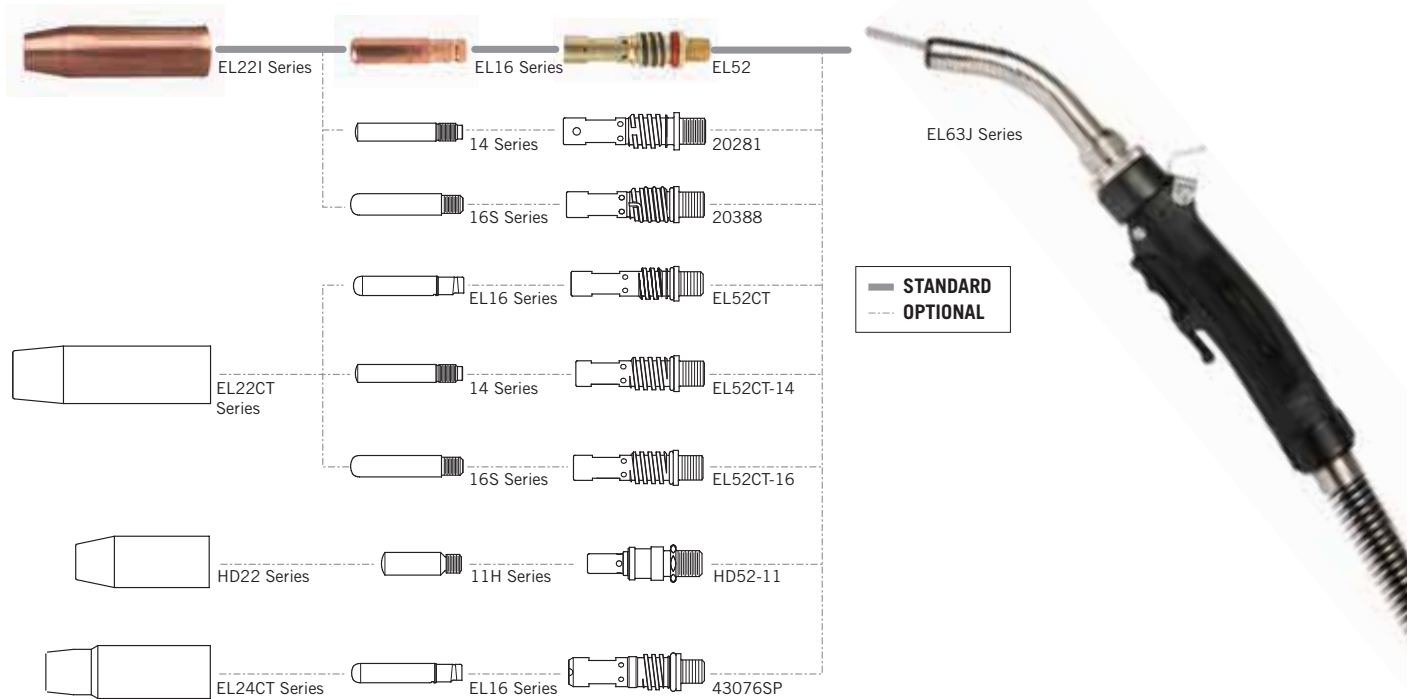
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	ELC212M-4045	1028-1158
	15 ft (4.6 m)	ELC215M-4045	1028-1162
	25 ft (7.6 m)	ELC225M-4045	1028-1170

## 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

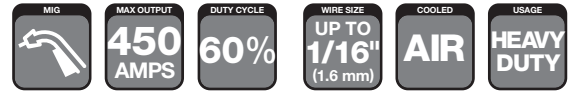
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	XELC215-4045	1028-1137



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

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

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# Compact Eliminator® 450 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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)	<b>ELC415-3545</b>	1048-1210
Up To 1/16" (1.6mm)	15 ft (4.6 m)	<b>ELC415-116</b>	1048-1211
	20 ft (6.1 m)	<b>ELC420-116</b>	1048-1216
	25 ft (7.6 m)	<b>ELC425-116</b>	1048-1221

## Lincoln® Style Rear Connector

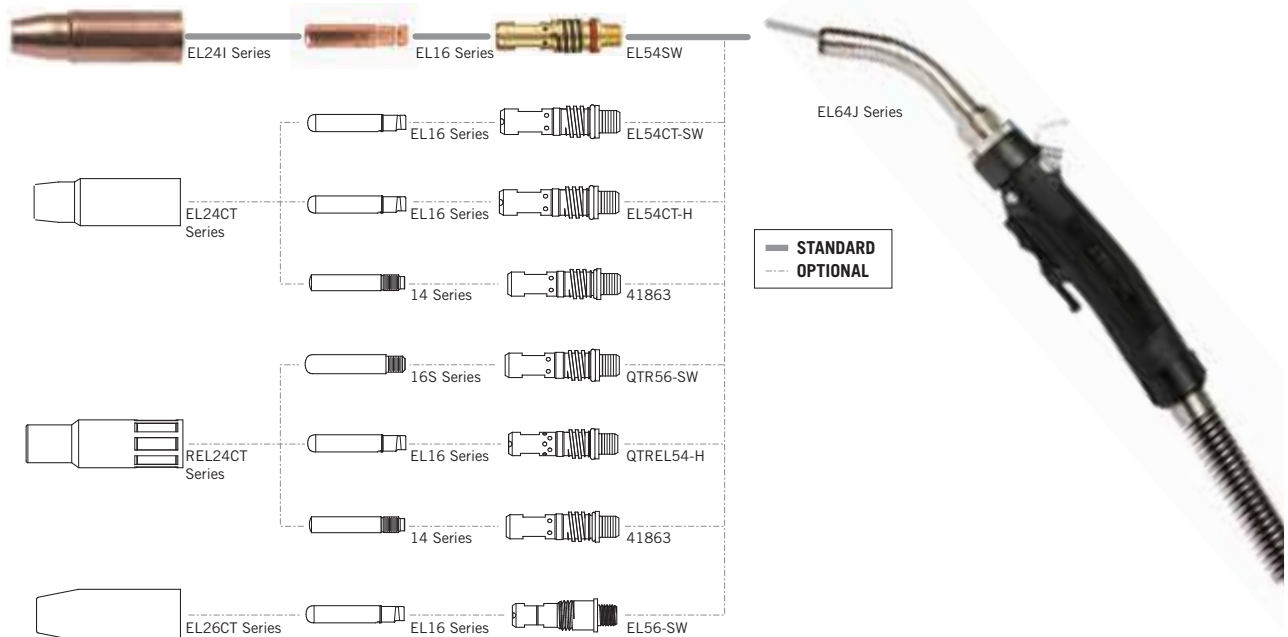
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2mm)	15 ft (4.6 m)	<b>ELC415L-3545</b>	1048-1285
Up To 1/16" (1.6mm)	15 ft (4.6 m)	<b>ELC415L-116</b>	1048-1286

## Euro-Kwik Style Rear Connector

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

## Miller® Style Rear Connector

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



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

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

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# Standard Eliminator® 450 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

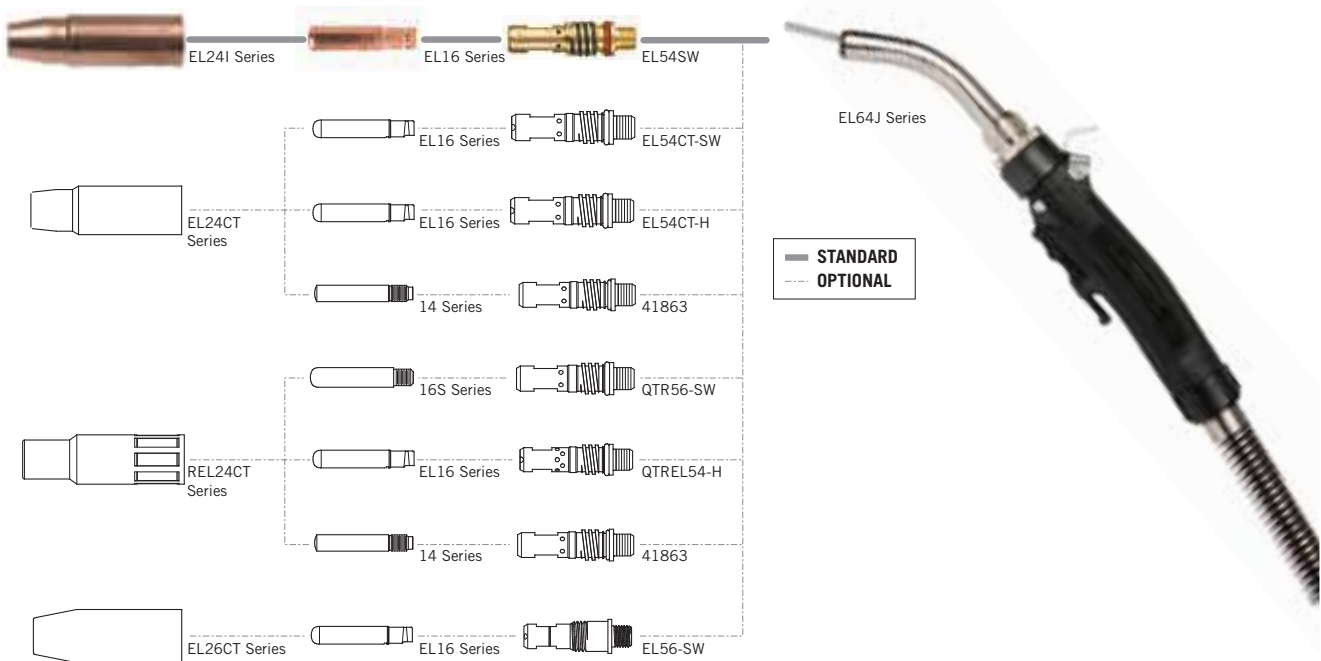
Fits Lincoln LN7, 8, 9, SP200

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

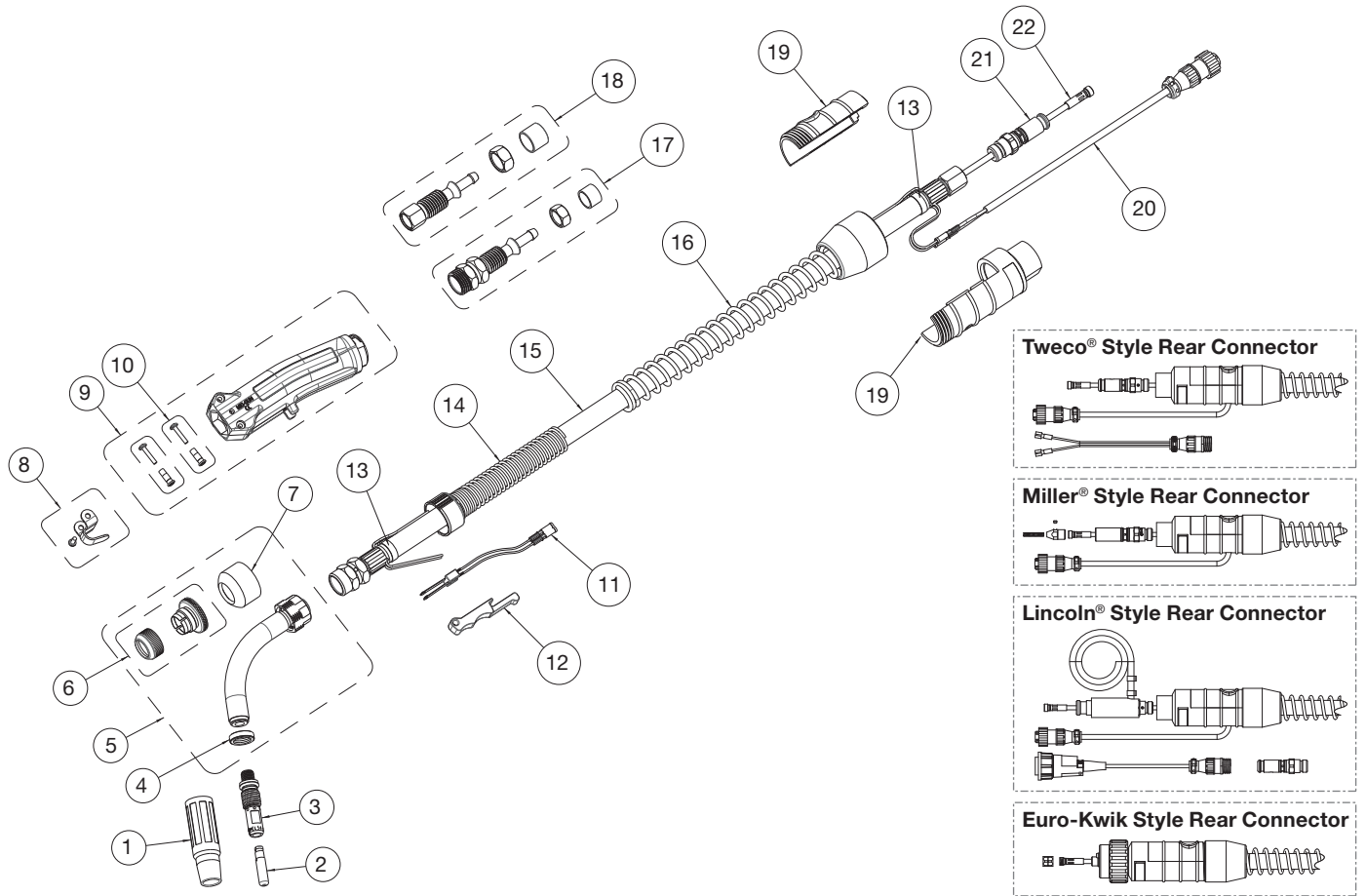


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

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

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# Eliminator® Series Replacement Parts



MIG GUNS

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



# Mini-MIG 160 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

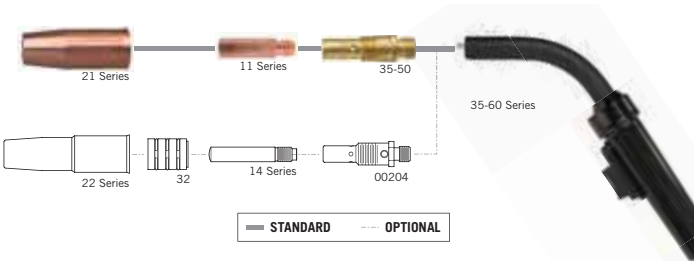
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	L35-10	1000-1231
	10 ft (3 m)	L35-10PM*	1000-1235
	12 ft (3.6 m)	L35-12	1000-1231
	15 ft (4.6 m)	L35-15	1000-1232
	15 ft (4.6 m)	L35-15PM*	1000-1236

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-DSL-J (Stock No. 2060-2137) Must be ordered separately.  
\*Fits Lincoln Power MIG 140/180 machines.

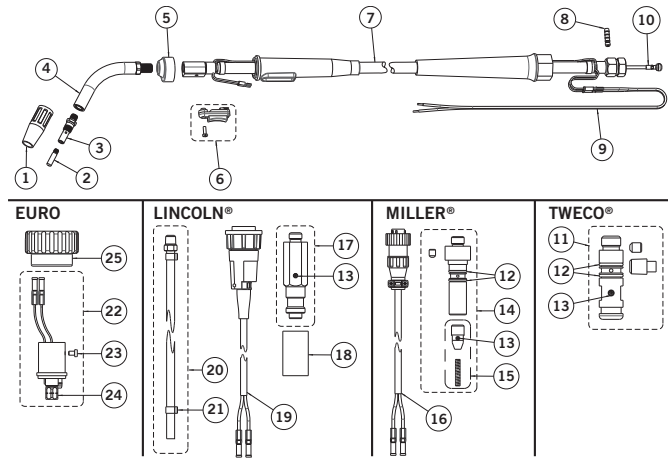
## Euro-Kwik Style Rear Connector

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.

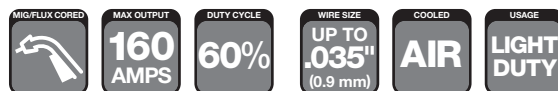


## Mini-MIG Gun Replacement Parts



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

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# Velocity Mini-MIG 160 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

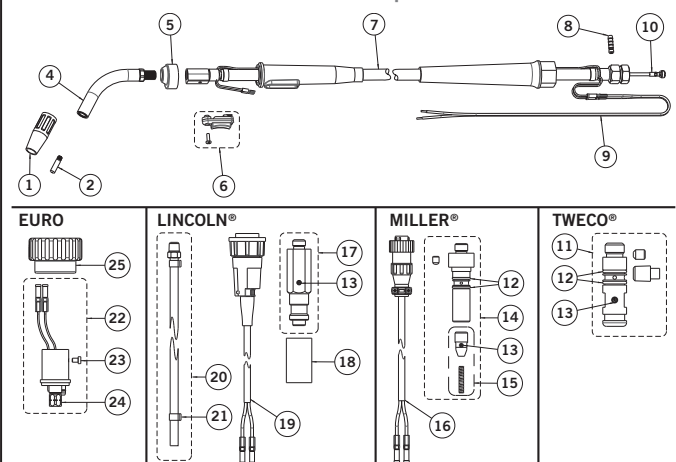
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	VX23-10	1000-1816
	10 ft (3 m)	VX35-10	1000-1817
	12 ft (3.6 m)	VX35-12	1000-1818
	15 ft (4.6 m)	VX35-15	1000-1819

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 <sub>2</sub> 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	<b>VNS Series</b>	
2	Contact Tip	<b>VTS Series</b>	
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	<b>Refer to Pages 124-127</b>	
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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# Tuff-n-Lite 350 Amp MIG Gun

**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

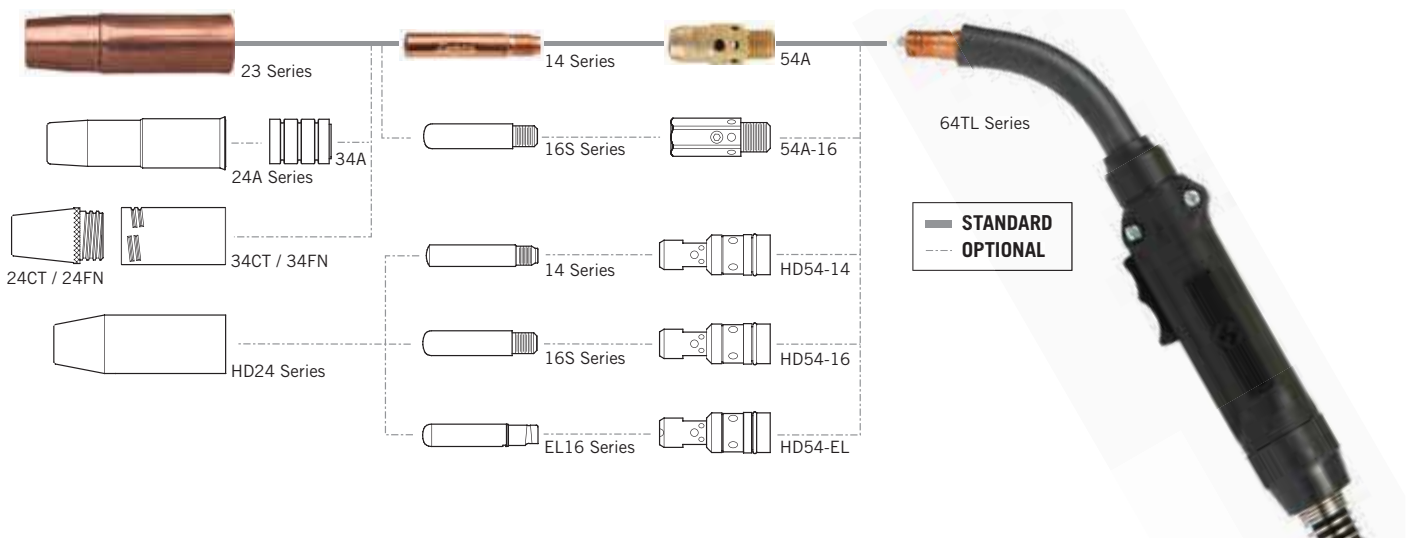
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	TL350M-15-116	1036-1237

### 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<sub>2</sub> or Mixed Gases**



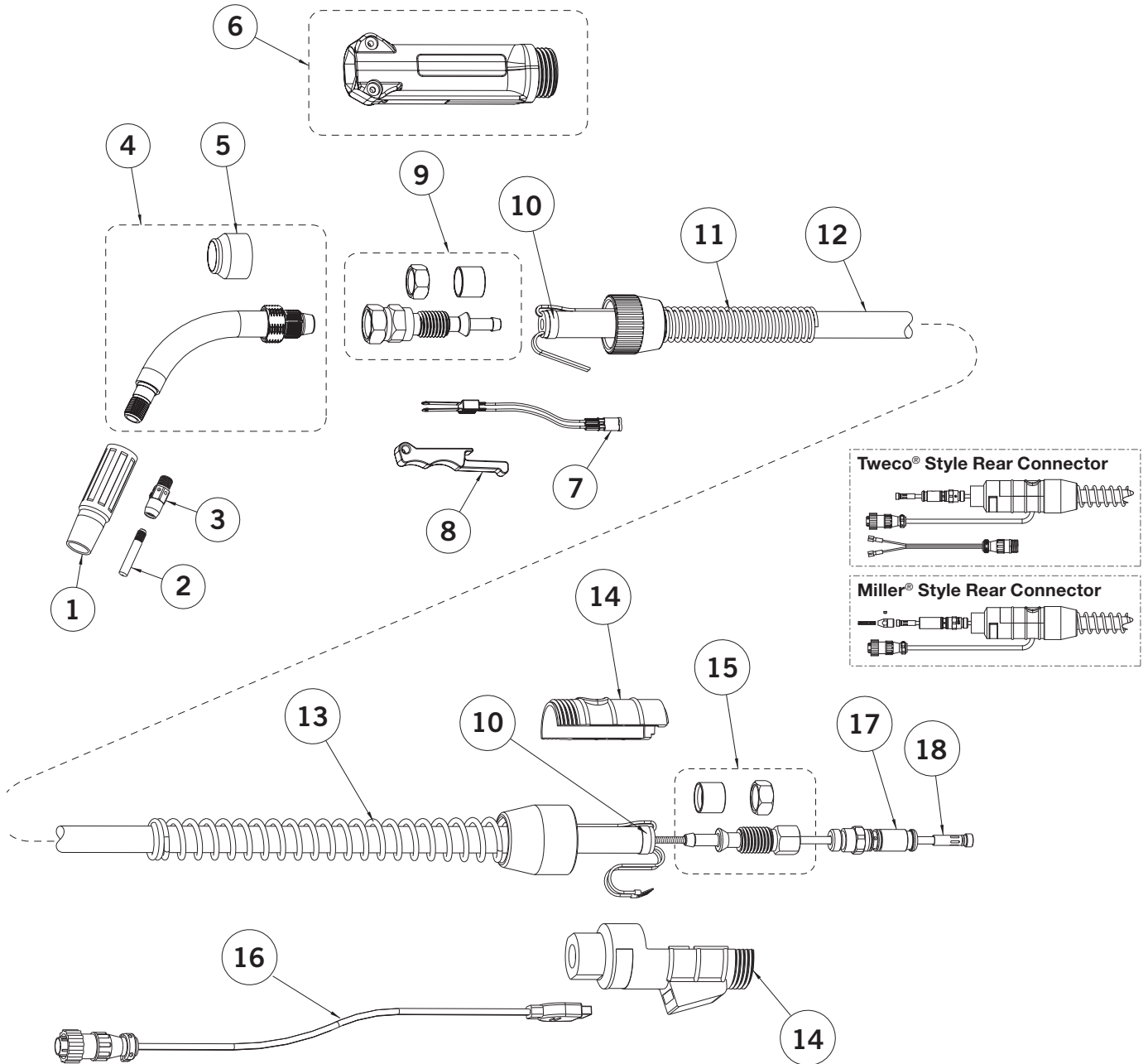
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
350 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

**EASY FIND**  
**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	<b>23 Series</b>	
2	Contact Tip	<b>14 Series</b>	
3	Diffuser	<b>54A</b>	
4	Conductor Tube	<b>64TL Series</b>	
5	Nut Insulator	<b>64TL-NC</b>	2035-2128
6	Handle Assembly	<b>TL350-86R</b>	2035-2136
7	Trigger Blade Assembly	<b>EL96B</b>	2060-2606
8	Trigger	<b>EL96</b>	2060-2605
9	Front Cable Connector	<b>104TL</b>	2035-2130
10	Cable Clamp	<b>136</b>	2060-2690

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

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# Supra® XT SEHD 400 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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.

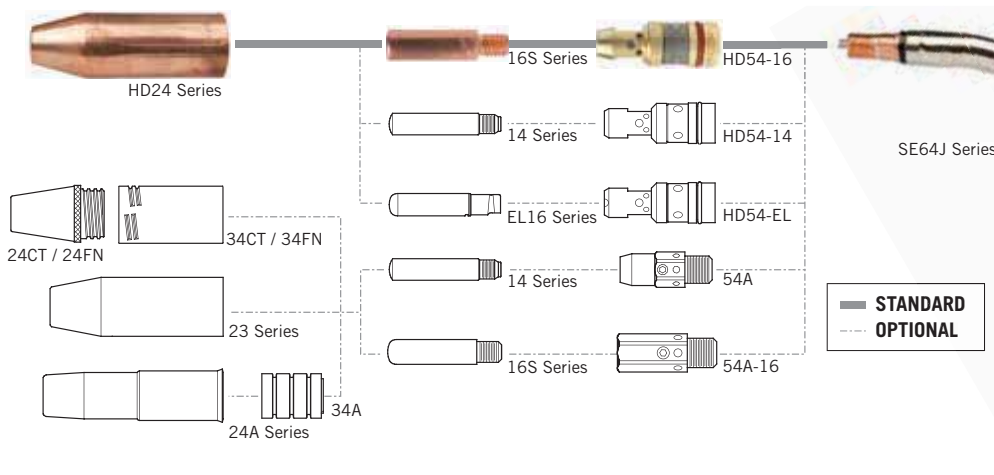
## Euro-Kwik Style Rear Connector

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<sub>2</sub> or Mixed Gases**

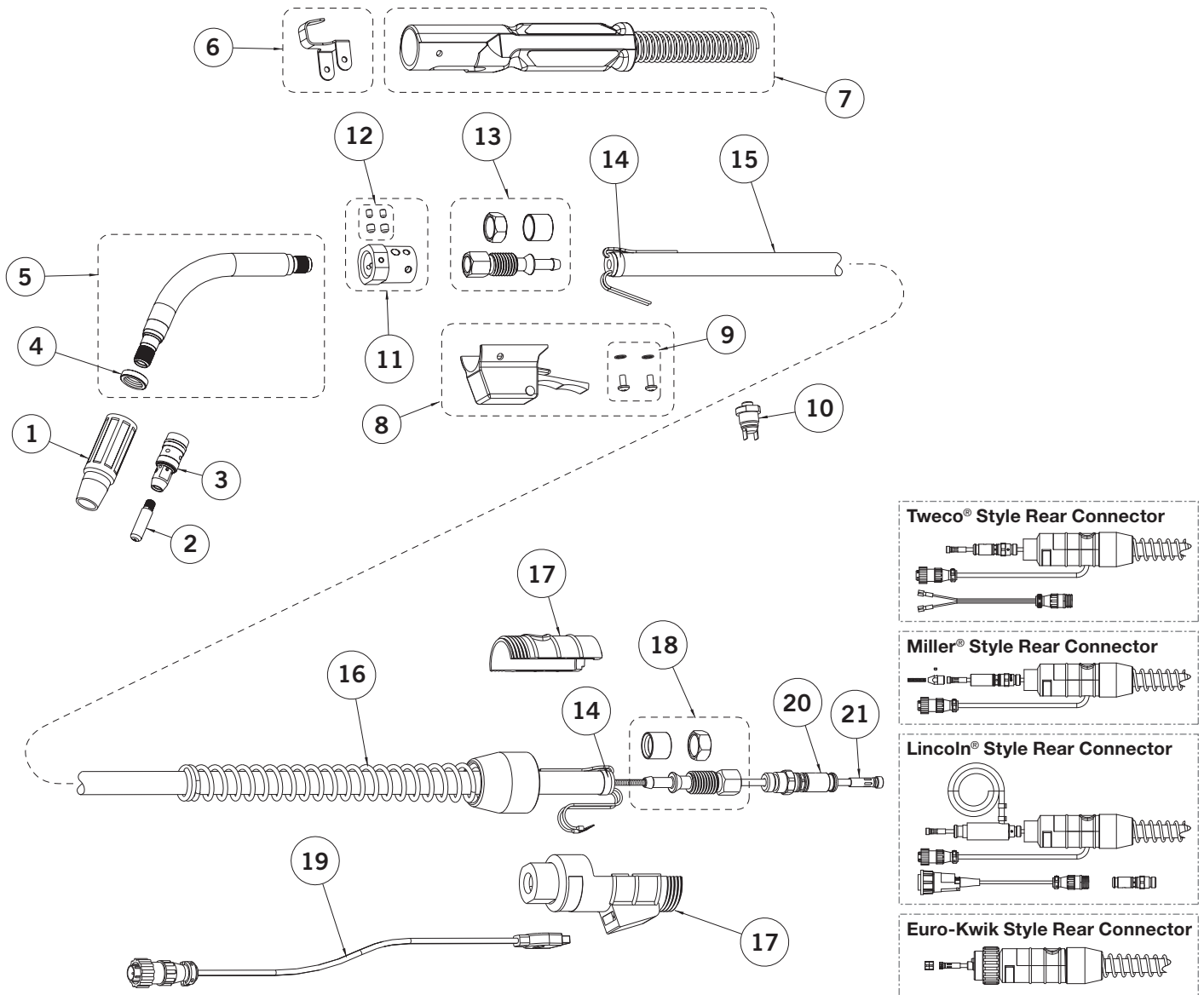


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

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

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# Supra® XT SEHD 400 Amp MIG Gun Replacement Parts



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

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

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# Supra® XT SEL 400 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

## Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

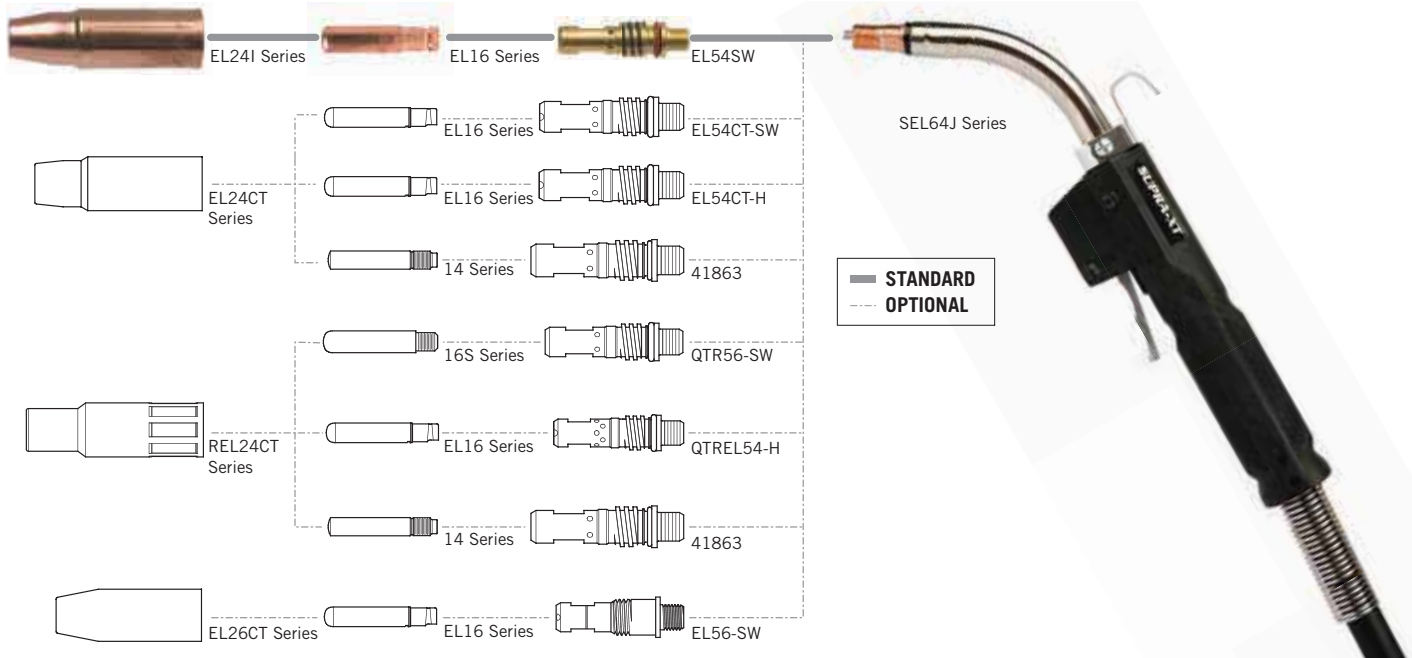
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	SEL400L-5M1,6	1040-1242

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.

## 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

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.

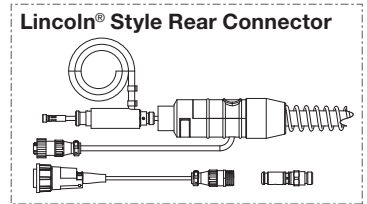
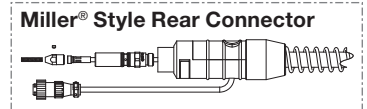
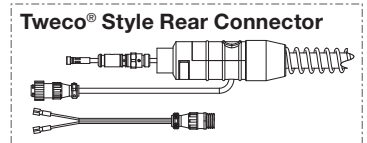
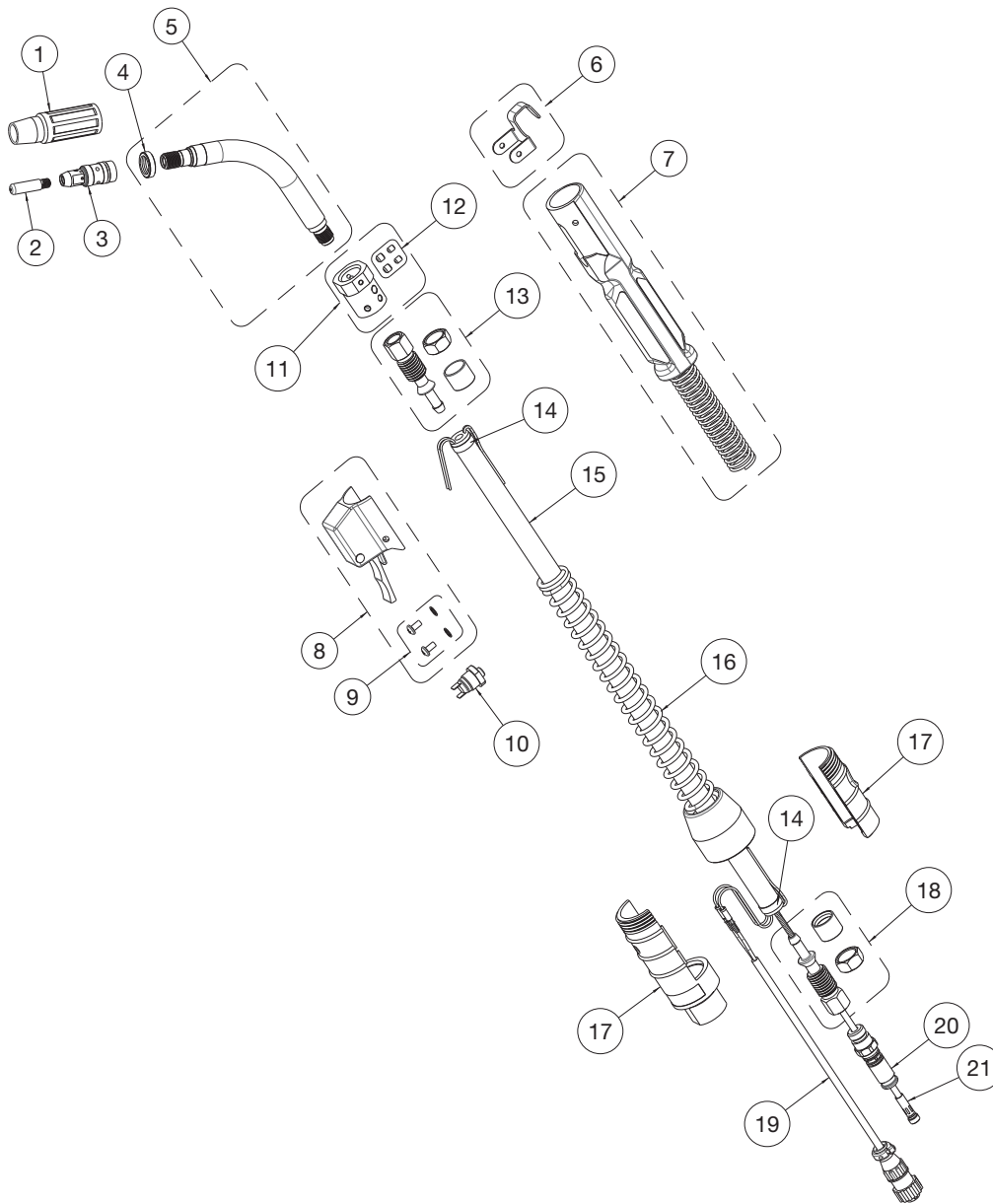


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

**EASY FIND 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	<b>EL24I Series</b>	
2	Contact Tip	<b>EL16 Series</b>	
3	Diffuser	<b>EL54 Series</b>	
4	Nozzle Insulator	<b>66J-3</b>	1660-1836
5	Conductor Tube	<b>SEL64J Series</b>	
6	Gun Hanger	<b>154</b>	2040-2154
7	Handle Assembly	<b>SE86-H</b>	2060-2052
8	Trigger Assembly	<b>SE96</b>	2060-2056
9	Trigger Housing Screws	<b>SE96-SW</b>	2060-2055
10	Trigger Switch	<b>SE96-B</b>	2060-2054
11	Front Pivot Block Assembly	<b>SE66</b>	2060-2051
12	Pivot Block Set Screw	<b>SE66-B</b>	2060-2050

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

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

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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

## 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.

## Miller® Style Rear Connector

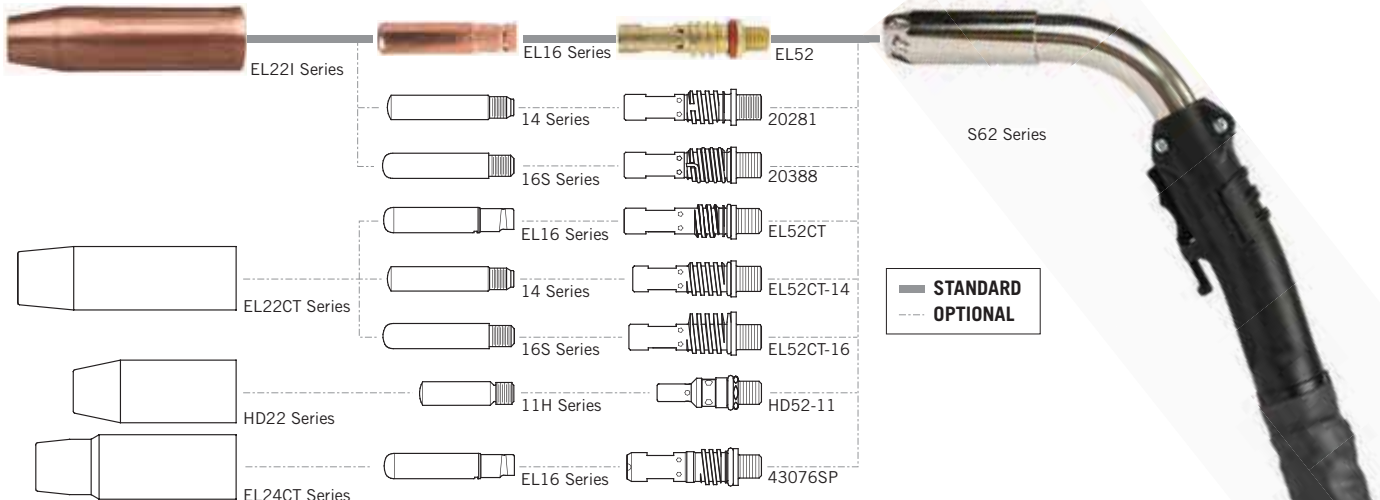
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	S212M-4045	1026-1106
	15 ft (4.6 m)	S215M-4045	1026-1107

## 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

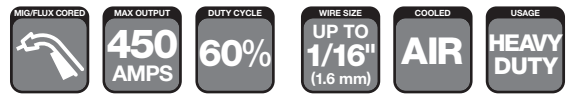
- **Handle Slide Valve** allows the operator to regulate vacuum on the MIG gun
- **Efficiently Removes 90% of Smoke** from the welding zone
- **Surrounding Air** is drawn over the front end consumables and conductor tube to keep cool
- **Tough Outer Jacket** made from leather protecting inner vacuum 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 <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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

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



**60% Duty Cycle - CO<sub>2</sub> 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

MIG GUNS

## 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

## 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

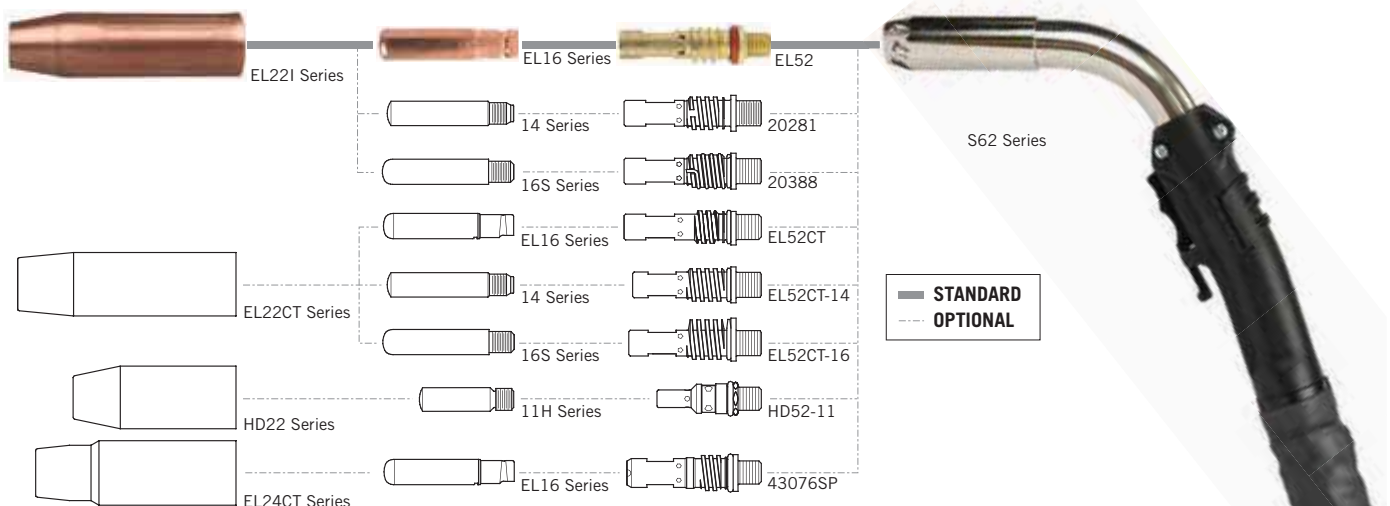
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

## 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

### 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



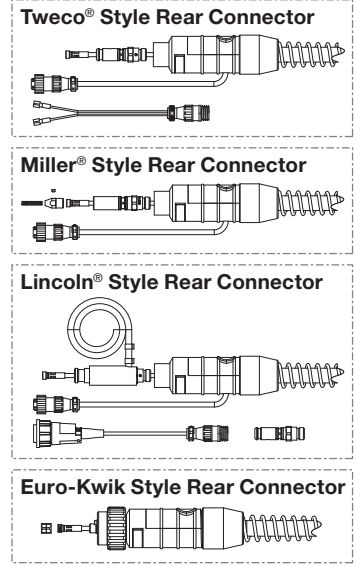
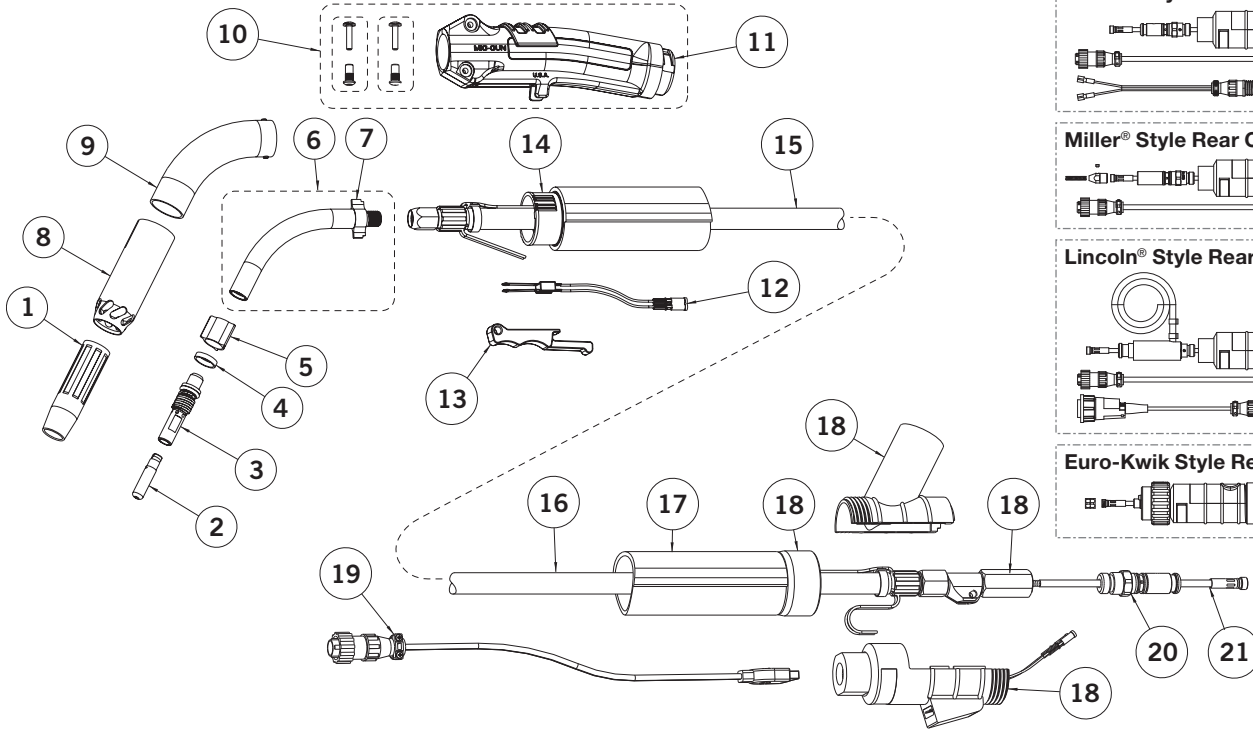
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication



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

MIG GUNS



#	Description	250 Amp		450 Amp	
		Part No.	Stock No.	Part No.	Stock No.
1	Nozzle	EL221 Series		EL221 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),**

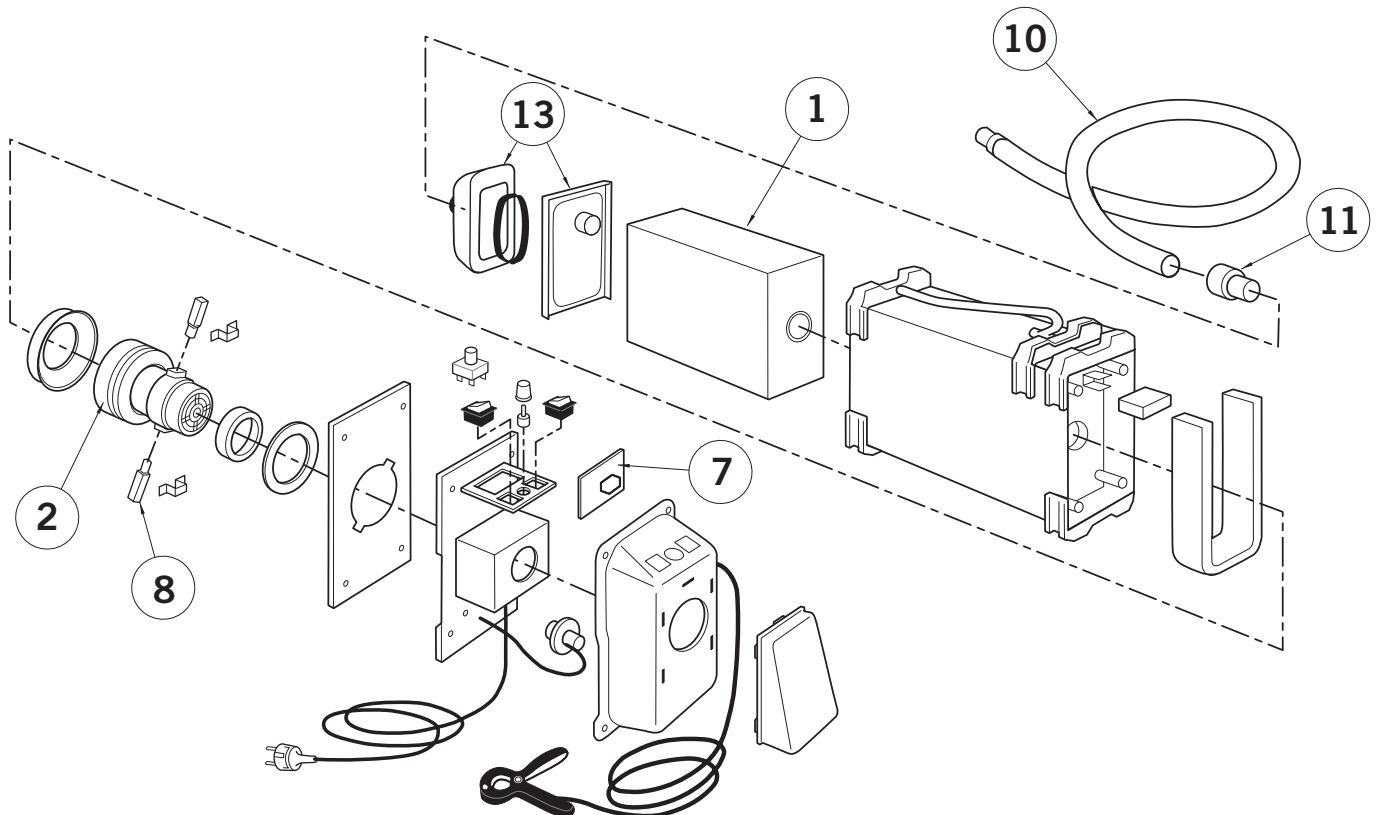
## Standard Options Include:

- 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

MIG GUNS

# 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

## Flux Cored SEFC 350 Amp MIG Gun

MIG GUNS



**60% Duty Cycle - CO<sub>2</sub> 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
- **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
- **Metal "Paddle" Style Trigger Lever**

## Flux Cored SEFC 450 Amp MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

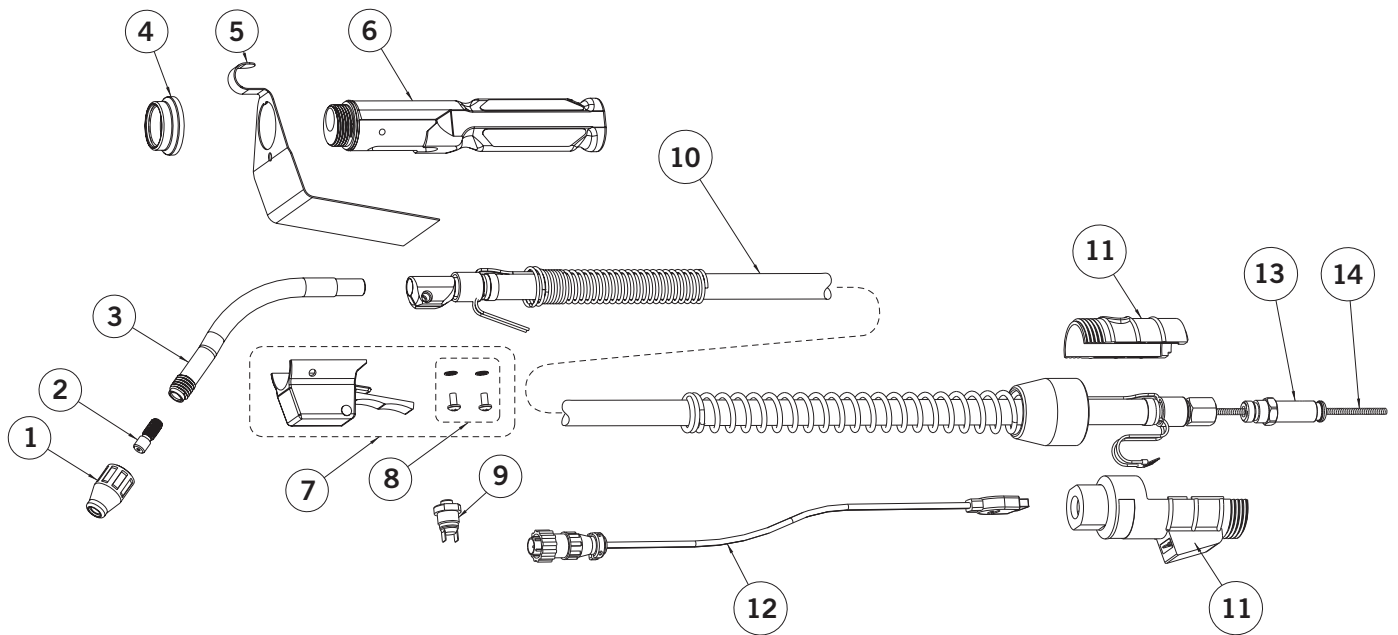
Wire Size	Length	Part No.	Stock No.
Up To 1/8" (3.2 mm)	15 ft (4.6 m)	SEFC450M-15	1041-1139

Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	60%	CO <sub>2</sub> 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
	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 GUNS



## 20% Duty Cycle - Mixed Gases

Suitable for Light Duty Fabrication.

**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

### 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 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



## 60% Duty Cycle - Mixed Gases

Suitable for Medium Duty Fabrication.

**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

### 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

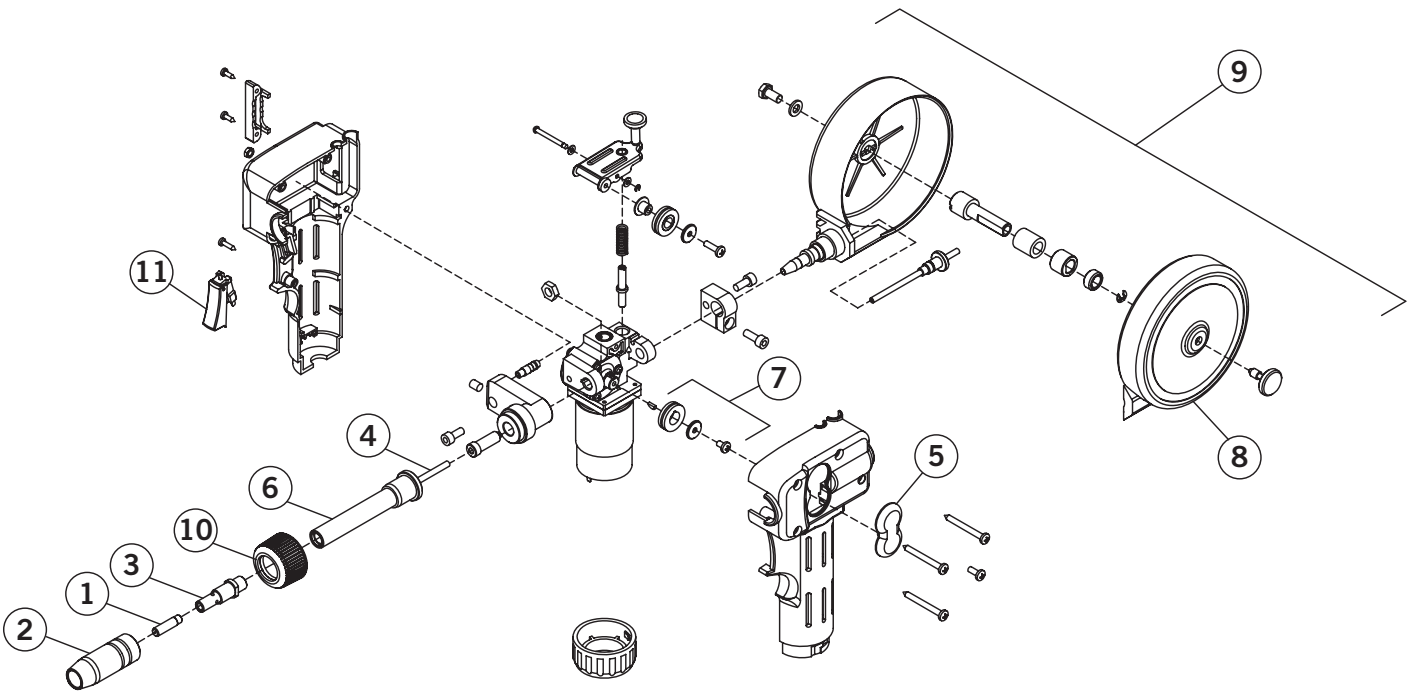
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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

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# Tweco® Spool Gun 160 & 250 Amp Replacement Parts

MIG GUNS



#	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 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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# Tweco® Spool Gun 300 Amp

MIG GUNS



**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

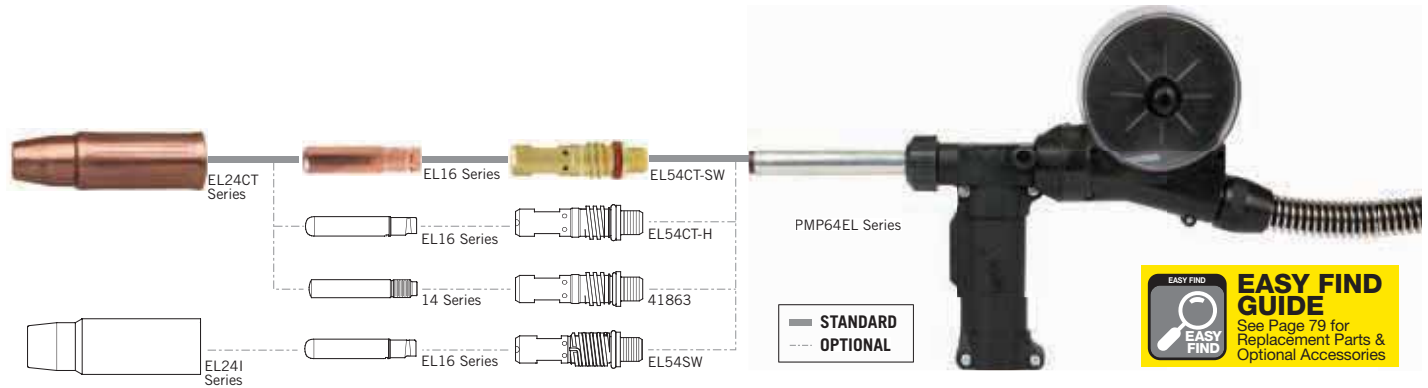
- Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) with quick disconnect
- Tweco® 300 Amp Spool Guns include **3-turn Potentiometer** for fine wire feed speed control

## Tweco® Style Rear Connector

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

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



# Tweco® ESG-1 Control Box



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

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

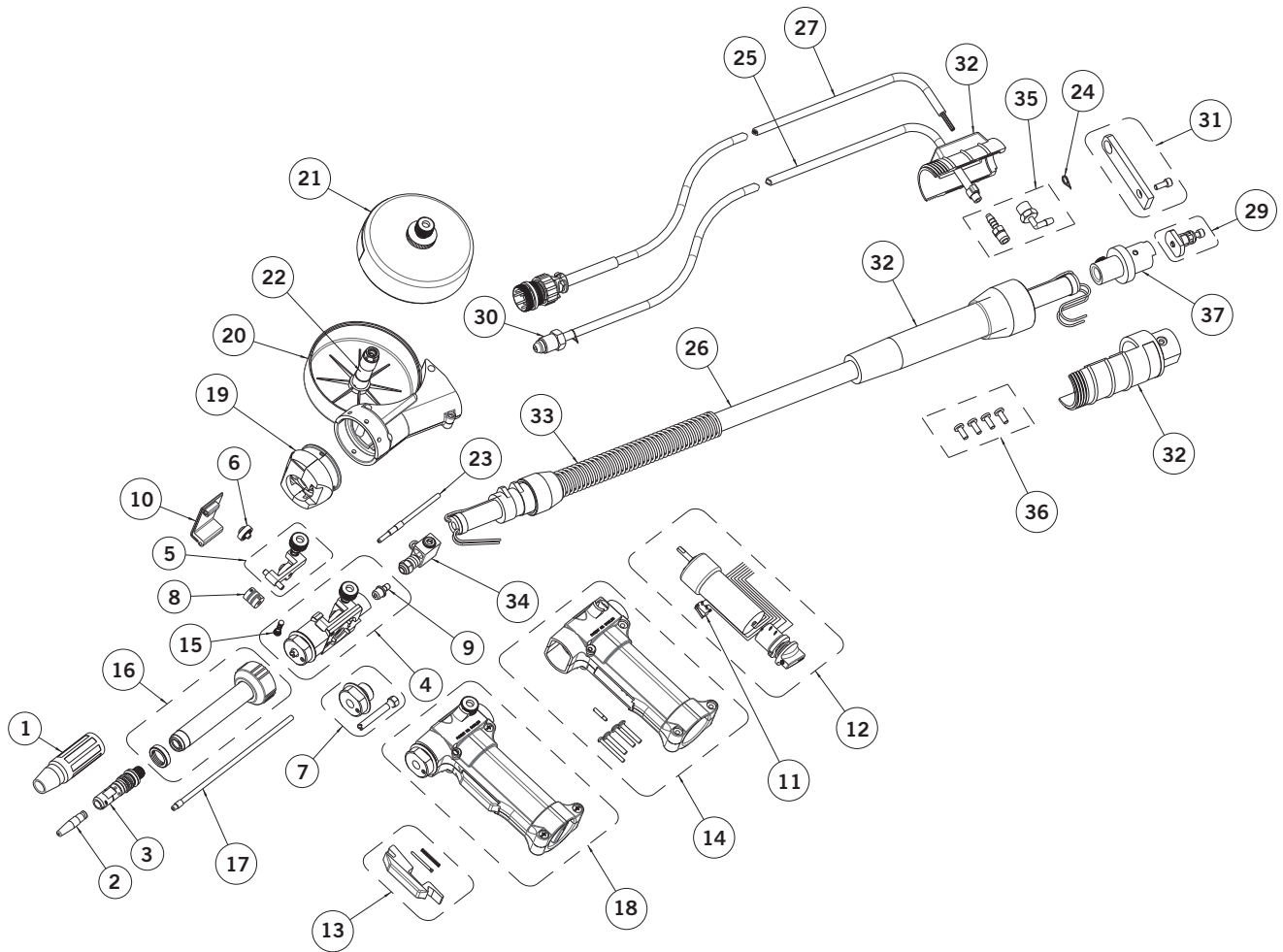
**WELDING PROCESSES:**  
**MIG (GMAW), Aluminum (GMAW)**

**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

MIG GUNS



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

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

# PullMaster™ 300 Amp MIG Gun

MIG GUNS



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



**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.*

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

**Tweco Style Rear Connector**

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	33 ft (10.1 m)	PMP333-3545	1027-1407
	50 ft (15.2 m)	PMP350-3545	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.

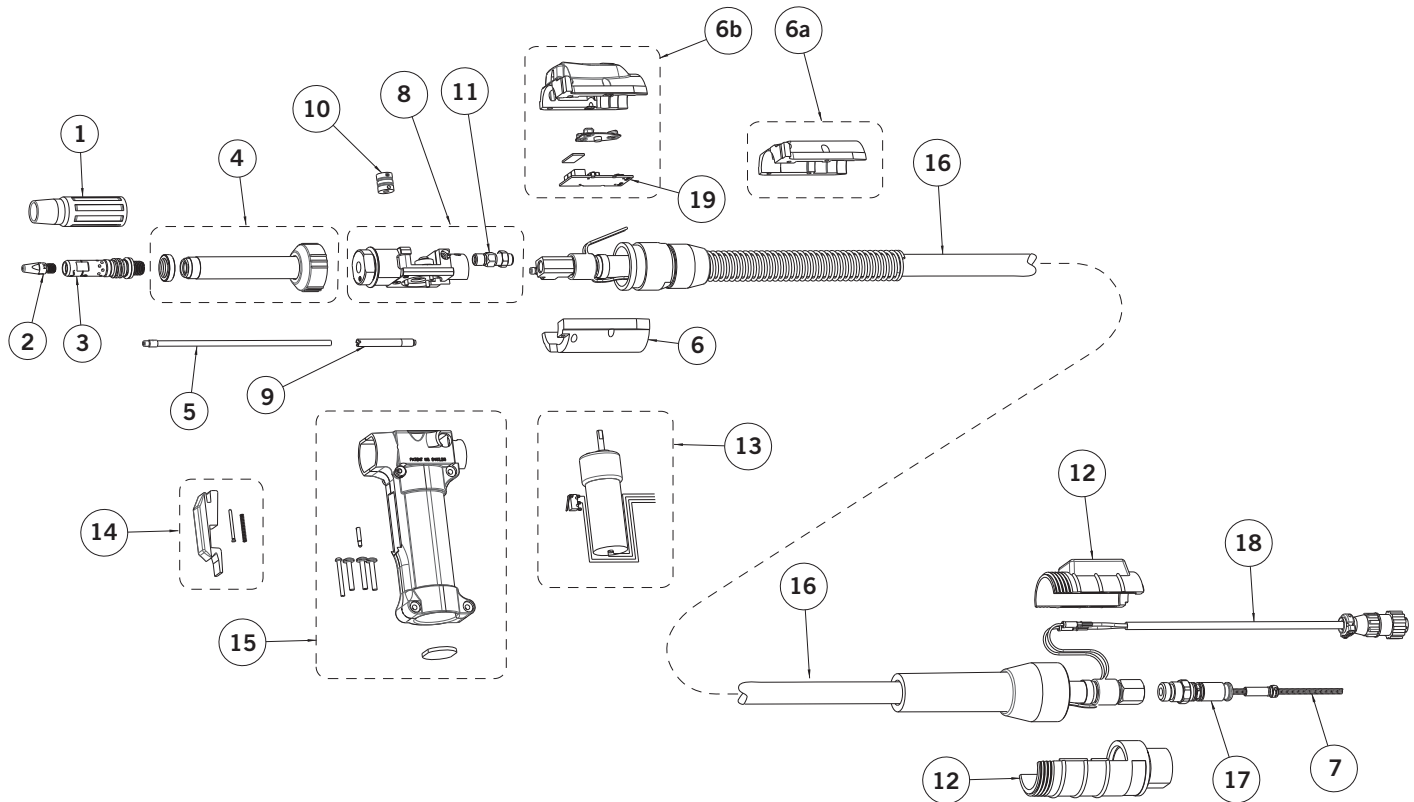
**WELDING PROCESSES:**  
MIG (GMAW), Aluminum (GMAW)

**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	<b>PMA24 Series</b>	
2	Contact Tip	<b>16APS Series</b>	
3	Diffuser	<b>PMA54-16S</b>	1543-1106
4	Conductor Tube	<b>PMP64EL Series</b>	
5	Teflon Jump Liner, Flex Tube	<b>PMP-44FLX-116</b>	1644-1095
	Teflon Jump Liner, Rigid Tubes	<b>PMP-44PTF-116</b>	1644-1096
	Bronze Jump Liner for Steel Wires, Rigid Tubes	<b>PMP-44-116</b>	1644-1097
6a	Support Assembly Front (Std.)	<b>EPG186</b>	2031-2046
6b	Support Assembly Front (Including Smart Cover, PCB Membrane, Lens & Lower Support)	<b>PMPS186</b>	2060-2725
7	33 ft (10 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Wire	<b>PMP 44-116-33</b>	1441-1125
	50 ft (15 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Wire	<b>PMP 44-116-50</b>	1441-1126
	33 ft (10 m) Conduit Assembly, .035" - .045" (0.9 mm - 1.1 mm) Wire	<b>PMP 44-3545-33</b>	1441-1127
	33 ft (10 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Steel Wire	<b>PMPS 44-116-33</b>	1441-1129
	33 ft (10 m) Conduit Assembly, .035" - .045" (0.9 mm - 1.1 mm) Steel Wire	<b>PMPS 44-3545-33</b>	1441-1131
8	Head Block Assembly	<b>PMP103</b>	2060-1726
NS	Pressure Arm Assembly	<b>SPG103-1</b>	2060-1727
9	Front Wire Guide Assembly	<b>PMPS-106TA</b>	2060-1729

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

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## 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

# Water-Cooled MIG Gun Series

		<b>PulseMaster</b> 400 Amp	<b>PulseMaster</b> 500 Amp	<b>Supra</b> 450 Amp	<b>Standard</b> 600 Amp
<b>Applications</b>		Light-Medium Duty Fabrication	Heavy Duty Fabrication	Medium-Heavy Duty Fabrication	Medium-Heavy Duty Fabrication
<b>Standard Options</b>	Rear Connector	■	■	■	■
	Standard without "Smart" Capability	■	■		
	"Smart" Capability	■	■		
<b>Output Current</b>		400 Amps	500 Amps	450 Amps	600 Amps
<b>Duty Cycle - Mixed Gases</b>		100%	100%	100%	100%
<b>Wire Diameter</b>		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)
<b>Process</b>	MIG	■	■	■	■
	Aluminum	■	■	■	■



**PulseMaster™** 500 Amp  
Water-Cooled Smart MIG Gun



**Supra®** 450 Amp  
Water-Cooled MIG Gun



**Standard** 600 Amp  
Water-Cooled MIG Gun

# PulseMaster™ 400 Amp Water-Cooled MIG Gun

MIG GUNS



Tweco® PulseMaster Smart MIG® Gun with digital display

Tweco PulseMaster Standard 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

**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

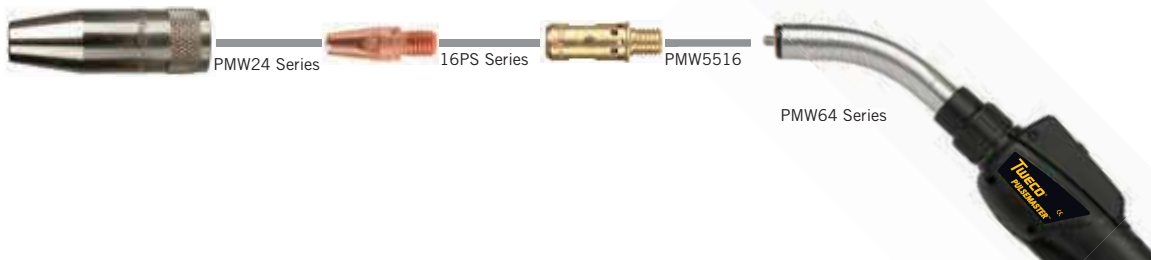
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

**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

**Euro-Kwik Style Rear Connector**

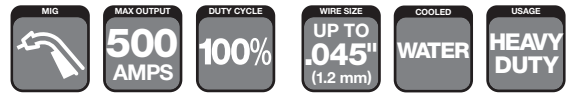
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	PMW412X-3545	1042-1505
	15 ft (4.6 m)	PMW415X-3545	1042-1506



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

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# PulseMaster™ 500 Amp Water-Cooled MIG Gun



**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

**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

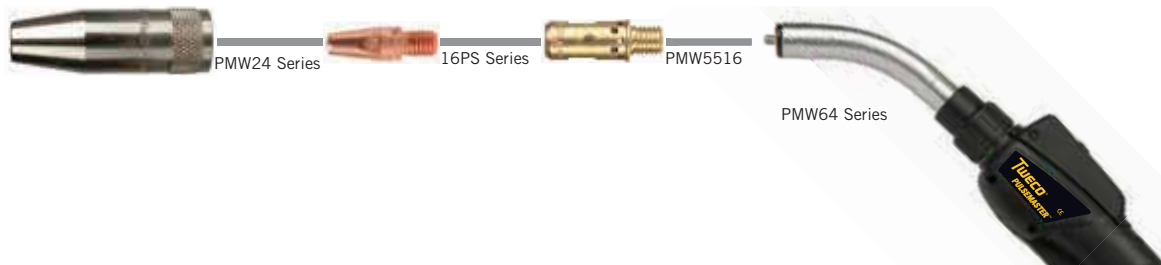
*Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.*

**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

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

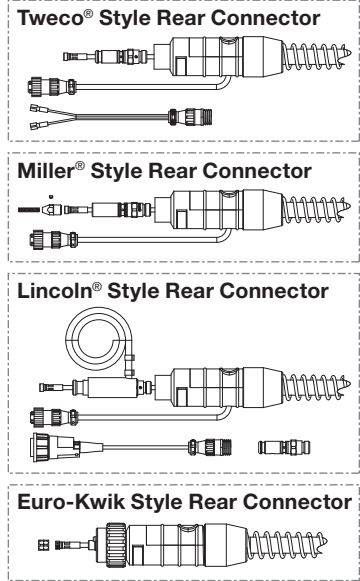
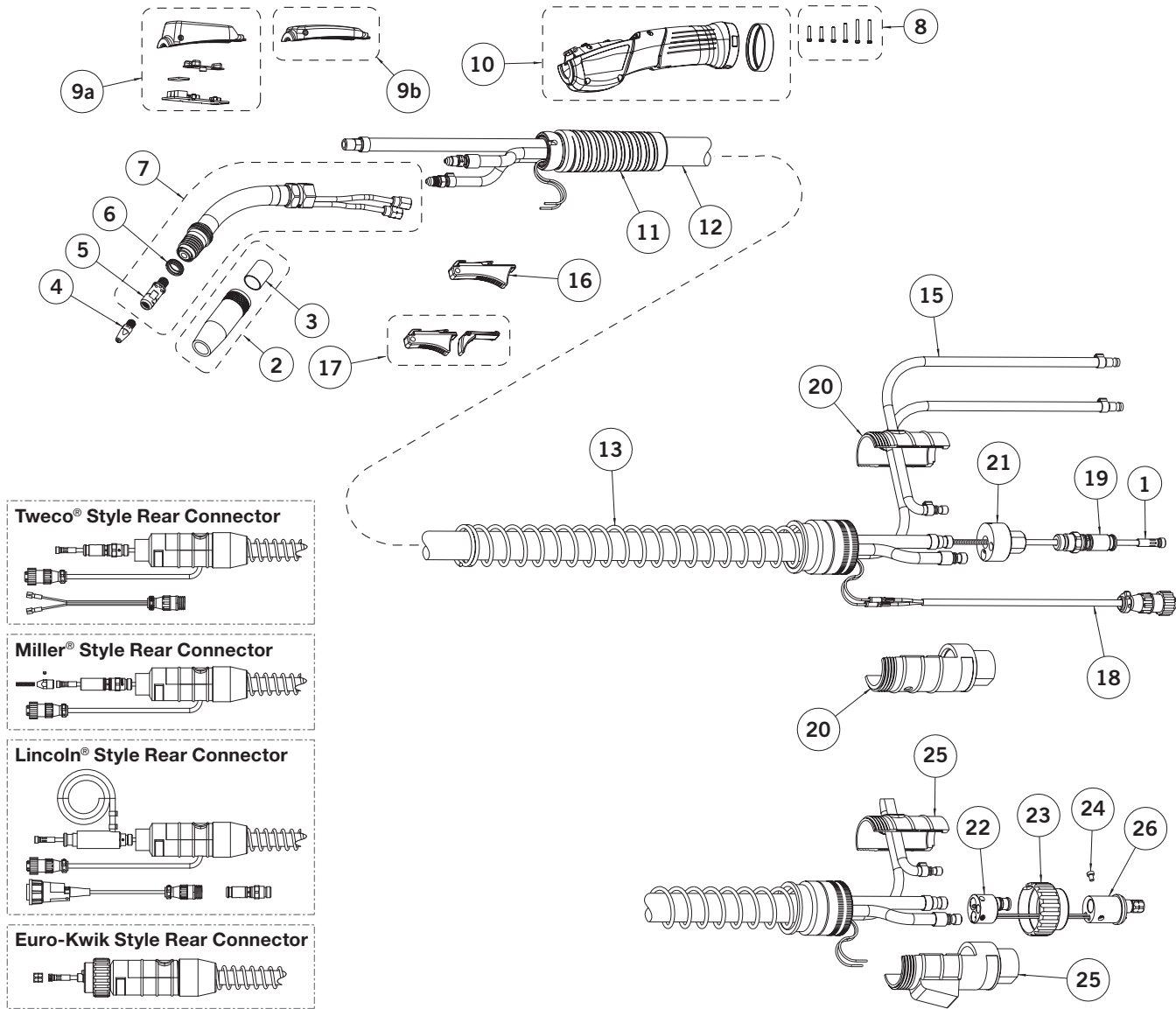
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MIG GUNS

# PulseMaster™ Water-Cooled MIG Gun

## Replacement Parts

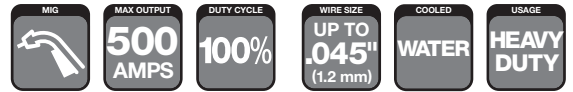
MIG GUNS



#	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

MIG GUNS

## 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

# Supra® 450 Amp Water-Cooled MIG Gun

MIG GUNS



**100% Duty Cycle - CO<sub>2</sub> 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

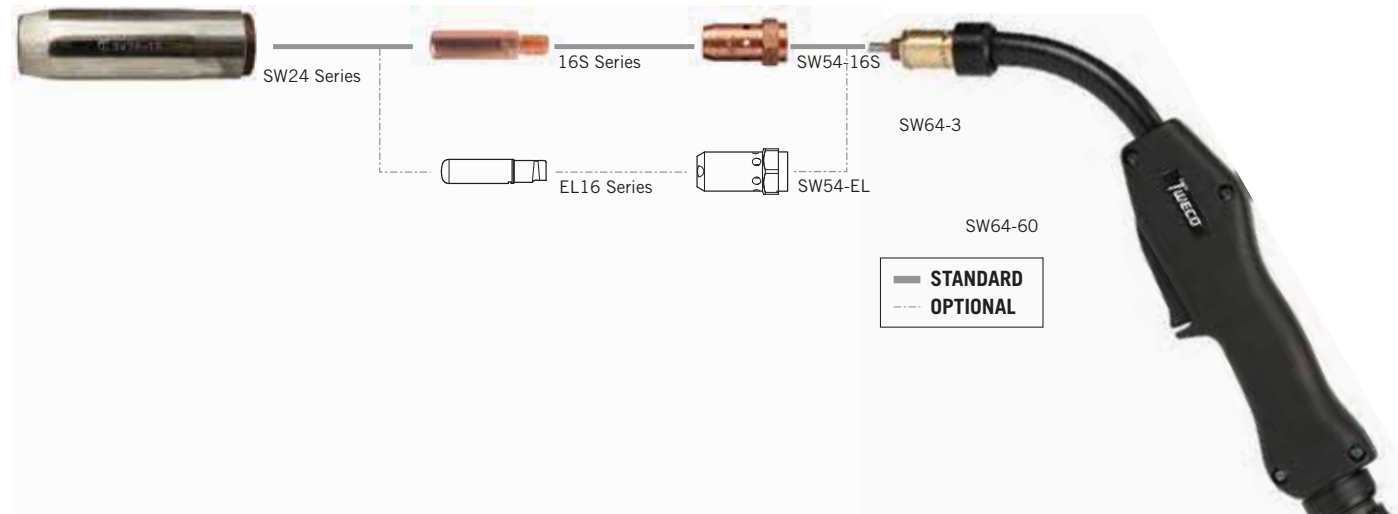
## Tweco® Style Rear Connector

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



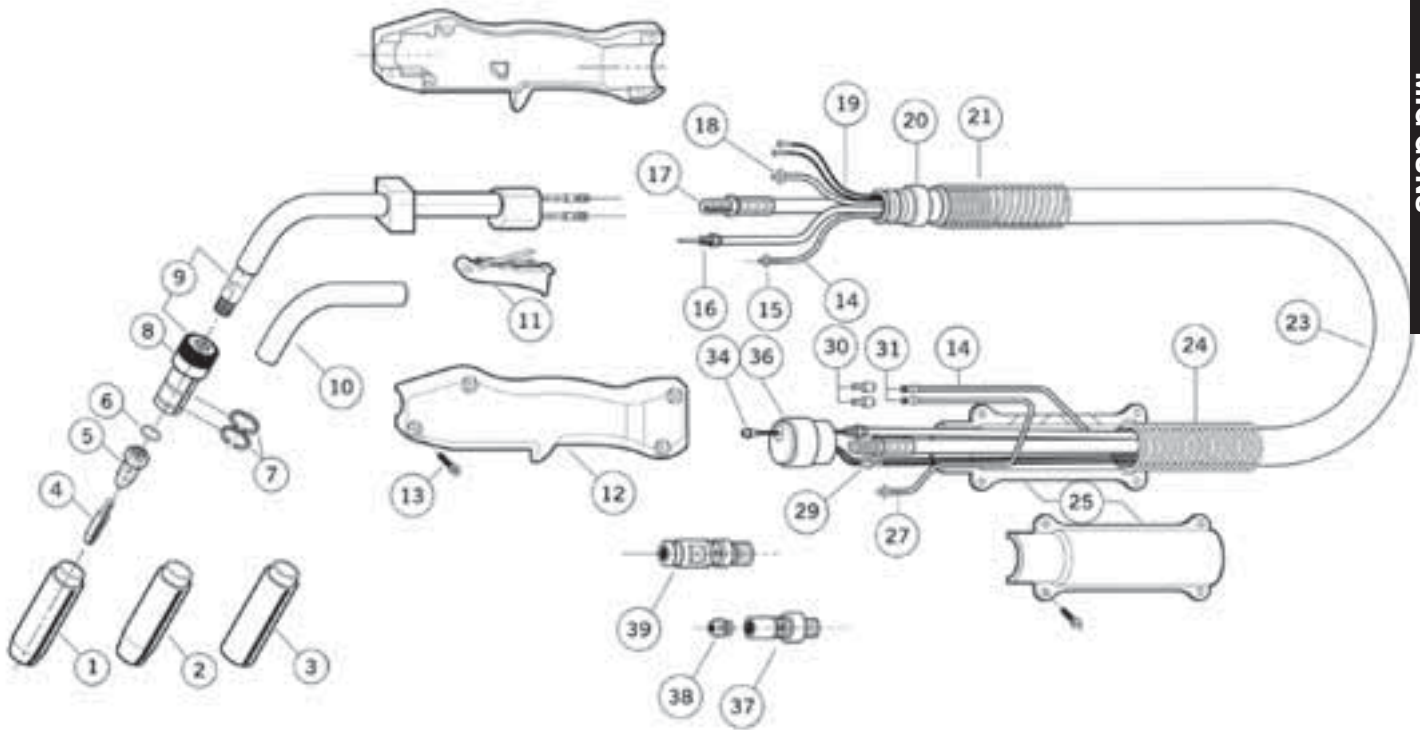
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
450 Amps	100%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Water	Heavy Duty Fabrication

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

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# 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	Part No.	Stock No.
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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# Standard 600 Amp Water-Cooled MIG Gun

MIG GUNS



**100% Duty Cycle - CO<sub>2</sub> 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**

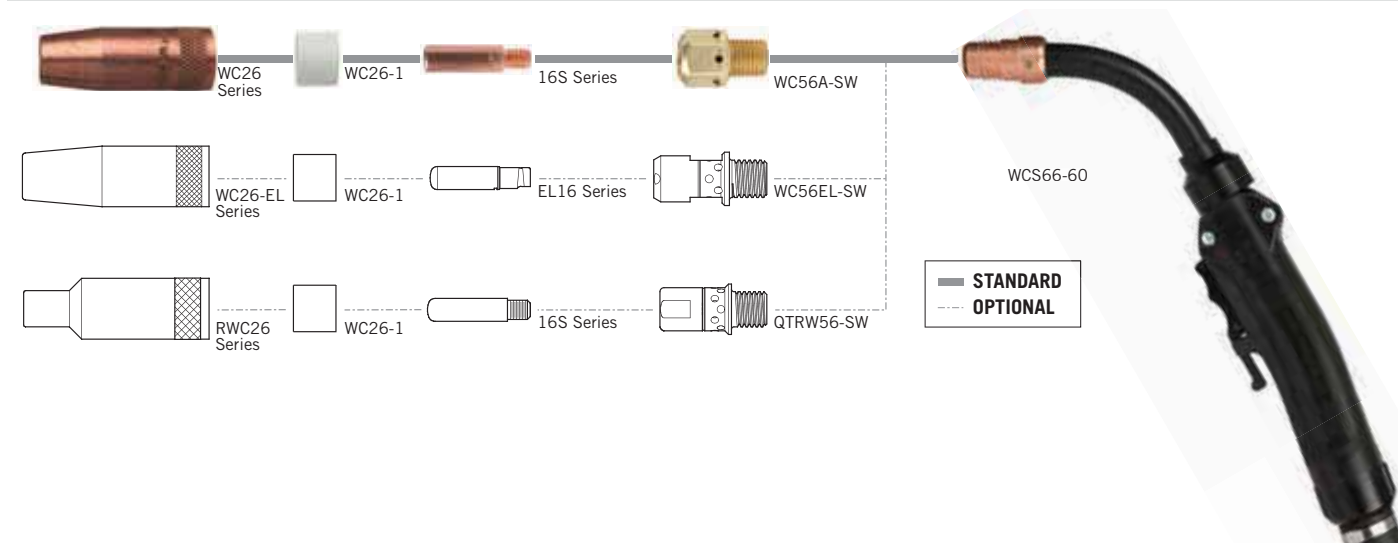
- **Large Water Lines** for maximum cooling
- **Threaded Water Line Connections** making hook-up easy (LH CGA)
- **Increased Duty Cycle** at high amperage applications
- **Large Diameter Wire Capacity** up to 7/64” (2.8 mm)
- **Outer Cover** protects components from weld spatter/abrasion

- **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)	<b>WCS610-116</b>	1064-1114
	12 ft (3.6 m)	<b>WCS612-116</b>	1064-1115
.045" (1.2 mm)	15 ft (4.6 m)	<b>WCS615-3545</b>	1064-1106
1/16" (1.6 mm)	15 ft (4.6 m)	<b>WCS615-116</b>	1064-1116
3/32" (2.4 mm)	15 ft (4.6 m)	<b>WCS615-332</b>	1064-1136
7/64" (2.8 mm)	15 ft (4.6 m)	<b>WCS615-764</b>	1064-1146

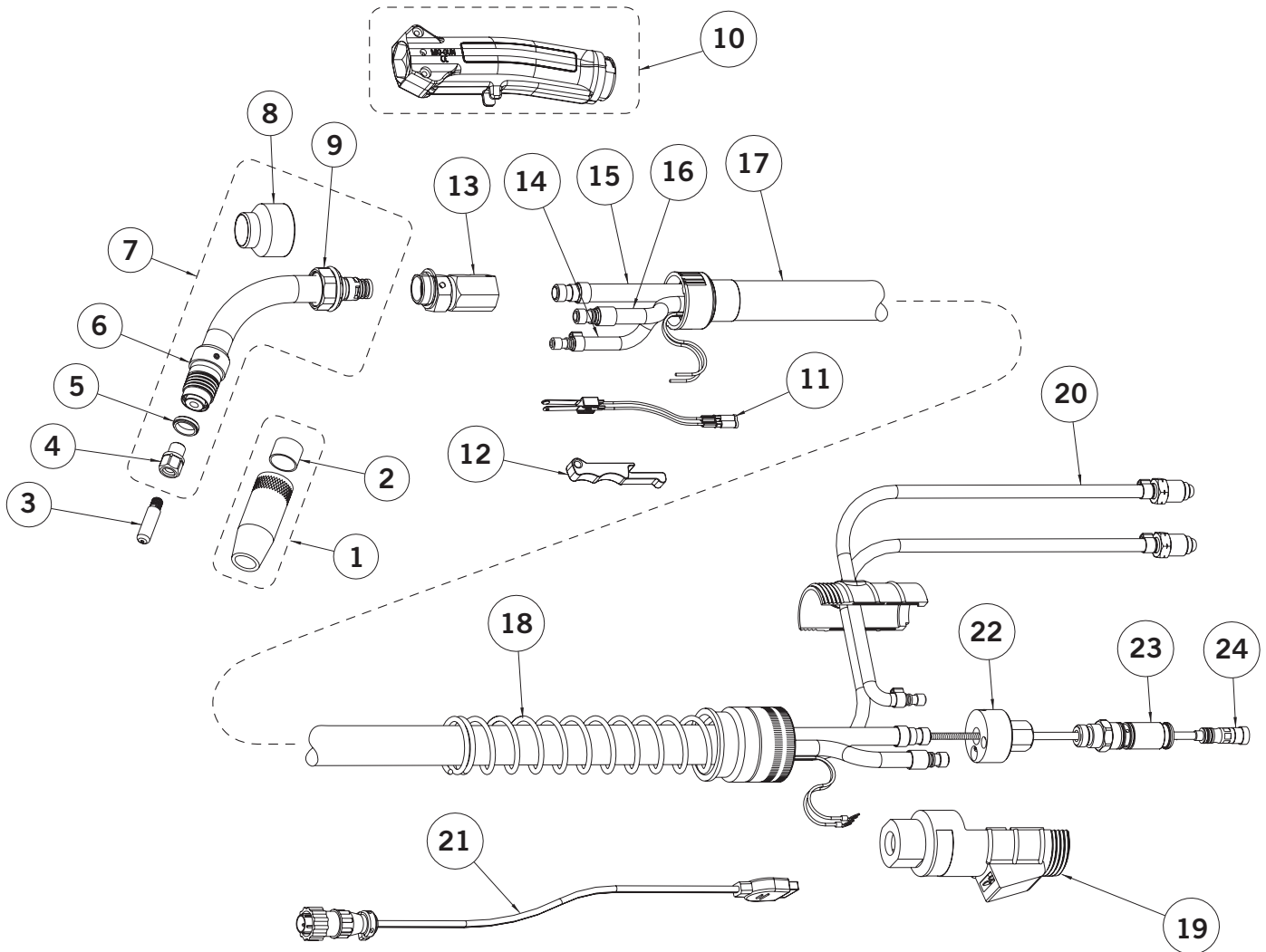


Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
600 Amps	100%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.1 mm)	Water	Heavy Duty Fabrication

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

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# Standard 600 Amp Water-Cooled MIG Gun Replacement Parts



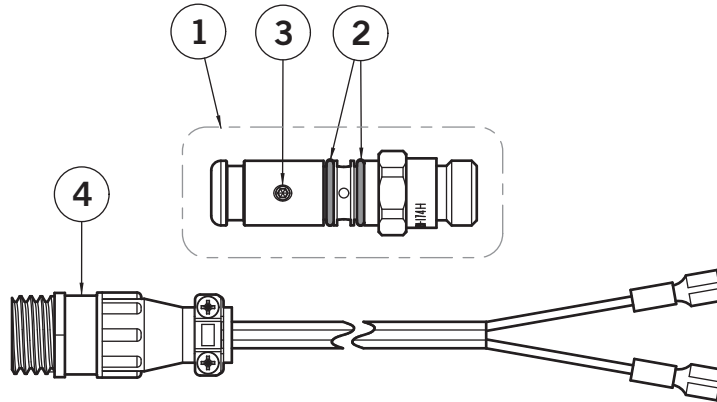
#	Description	Part No.	Stock No.
1	Nozzle	<b>WC26 Series</b>	
2	Spatter Shield	<b>WC26-1</b>	1264-1009
3	Contact Tip	<b>16S Series</b>	
4	Diffuser	<b>WC56A-SW</b>	
5	Pressure Ring Insulator	<b>WC36-R</b>	2064-1036
6	Conductor Tube Housing	<b>WCS36-H</b>	1344-1145
7	Conductor Tube	<b>WCS66-60</b>	
8	Nut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

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

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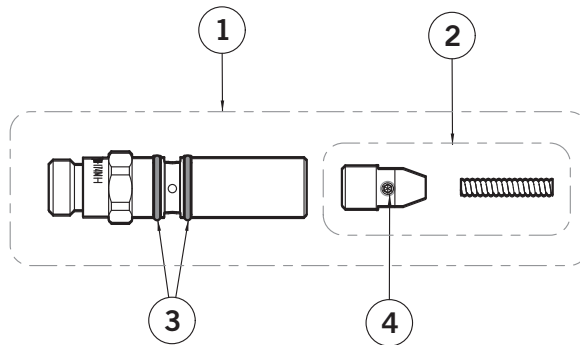
# Tweco® MIG Gun Direct Plug & Control Wire Jumpers

MIG GUNS



## Tweco® Style

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

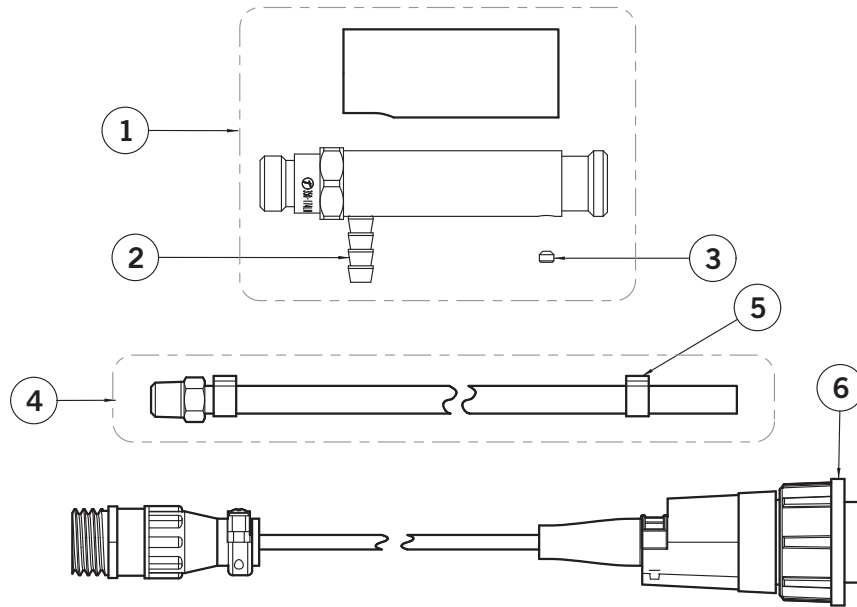


## Miller® Style

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

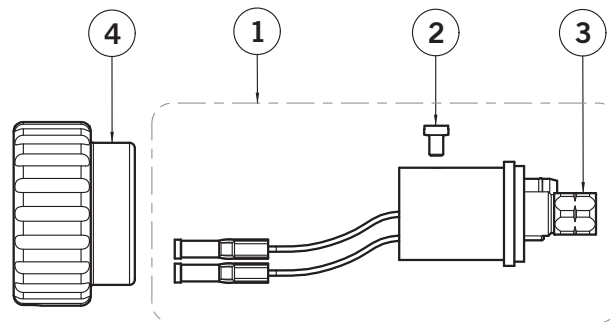
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# Tweco® MIG Gun Direct Plug & Control Wire Jumpers



## 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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# Velocity<sup>TM</sup> 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.**



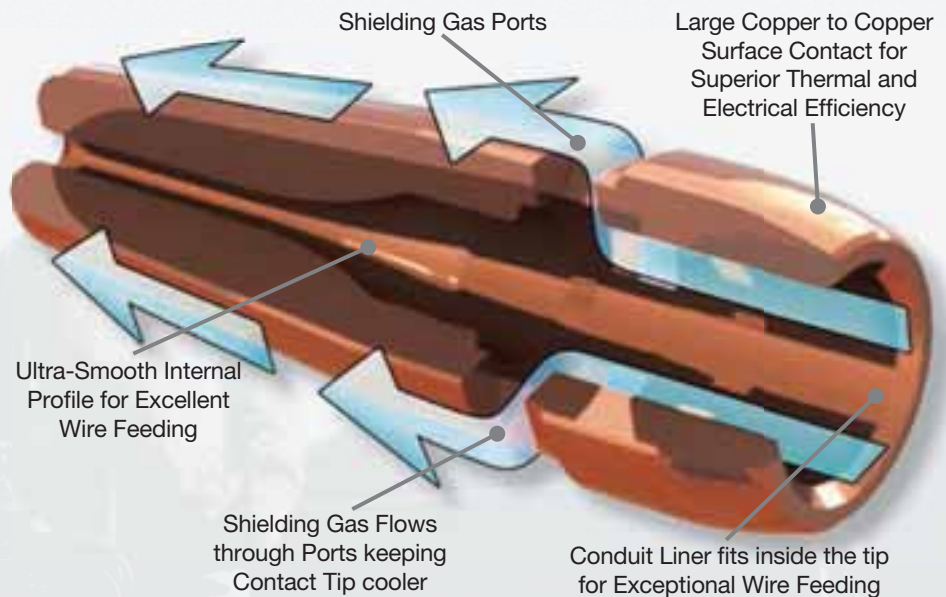
## Tweco Velocity Contact Tips - Stay Cooler, Last Longer

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 less 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.**



CONSUMABLES

## 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.



# 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)

## Nozzles



Fixed Threaded



Adjustable Slip



Spot Weld



Flux Core Tip Holder



Extended Taper Nozzle

## Contact Tips



Light Duty



Tip Holder



Extended Taper

CONSUMABLES

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



Solid Copper



Roll Stamp with Size

Large Copper to Copper Surface Contact



Perfectly Centered Liner

Shielding Gas Outlet

Insulated Conductor Tube

Conduit Liner Seats Inside the Tip

# Velocity Adjustable Slip Nozzles - Flushness Relationship



Adjustable Slip Nozzle



Tip Holder



Contact Tip



Conductor Tube

- **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.



Recess

Flush

Protruding

CONSUMABLES

# 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.

### Nozzles



Fixed Threaded



Adjustable Slip



Spot Weld

### Contact Tips



Medium Duty

CONSUMABLES

## 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

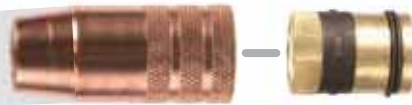
**Fixed Threaded** maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

**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.



Fixed Threaded



Adjustable Slip



Fixed Threaded (2 piece)



Heavy Duty

## Flux Core Overview

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



Flux Core Tip Holder



Medium & Heavy Duty

## 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



Extended Taper Nozzle



Extended Taper

# 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



Long Lasting, Heavy Duty Solid Copper Nozzle Assembly

## Velocity Contact Tip



Solid Copper Alloy Roll Stamp with Size

Perfectly Centered Conduit Liner Seats Inside the Tip for Superior Feedability

## Conductor Tube



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.

CONSUMABLES



**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.



**Velocity™** Wire Process Charts

		AMP OUTPUT					
		30 – 100	100 – 200	200 – 300	300 – 400	> 400	> 500
<b>SOLID WIRE SIZE</b>	.023" / 0.6 mm	Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed					
	.030" / 0.8 mm		Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed				
	.035" / 0.9 mm		Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed				
	.040" / 1.0 mm	Light Duty Velocity	Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed				
	.045" / 1.2 mm		Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed Argon or Argon / Helium Mixed				
	.052" / 1.3 mm		Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed Argon or Argon / Helium Mixed				
	1/16" / 1.6 mm		Straight CO <sub>2</sub> Argon / CO <sub>2</sub> Mixed Argon or Argon / Helium Mixed				

		AMP OUTPUT					
		30 – 100	100 – 200	200 – 300	300 – 400	400 – 500	> 500
<b>FLUX CORE WIRE SIZE</b>	.030" / 0.8 mm	Self Shielded					
	.035" / 0.9 mm	Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed					
	.040" / 1.0 mm	Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed					
	.045" / 1.2 mm	Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed					
	.052" / 1.3 mm	Light Duty Velocity CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed					
	1/16" / 1.6 mm		Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed				
	5/64" / 2.0 mm		Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed				
	3/32" / 2.4 mm		Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed				
	7/64" / 2.8 mm		Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed				
	1/8" / 3.2 mm		Self Shielded CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixed				

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)	<b>VTM23</b>	1160-1750
.030" (0.8 mm)	<b>VTM30</b>	1160-1751
.035" (0.9 mm)	<b>VTM35</b>	1160-1752
.040" (1.0 mm)	<b>VTM40</b>	1160-1753
.045" (1.2 mm)	<b>VTM45</b>	1160-1754
3/64" (1.2 mm)*	<b>VTMA364*</b>	1160-1755
.052" (1.3 mm)	<b>VTM52</b>	1160-1756
1/16" (1.6 mm)	<b>VTM116</b>	1160-1757
1/16" (1.6 mm)*	<b>VTMA116*</b>	1160-1758
5/64" (2.0 mm)	<b>VTM564</b>	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)	<b>VTH30</b>	1160-1760
.035" (0.9 mm)	<b>VTH35</b>	1160-1761
.040" (1.0 mm)	<b>VTH40</b>	1160-1762
.045" (1.2 mm)	<b>VTH45</b>	1160-1763
3/64" (1.2 mm)*	<b>VTHA364*</b>	1160-1764
.052" (1.3 mm)	<b>VTH52</b>	1160-1765
1/16" (1.6 mm)	<b>VTH116</b>	1160-1766
1/16" (1.6 mm)*	<b>VTHA116*</b>	1160-1767
5/64" (2.0 mm)	<b>VTH564</b>	1160-1768
3/32" (2.4 mm)	<b>VTH332</b>	1160-1769
7/64" (2.8 mm)	<b>VTH764</b>	1160-1770
1/8" (3.2 mm)	<b>VTH18</b>	1160-1771

## Extended Taper Contact Tips

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

## Extended HD Taper Contact Tips

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

## Medium Duty Nozzles

Self Insulated Nozzles. 2 per pack

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

## Heavy Duty Nozzles

Self Insulated Nozzles. 2 per pack

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

## Extended Taper Nozzle

Extended Taper Nozzle	<b>VNET37F</b>	1240-1897
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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	<b>VCTLSS</b>	1640-1397	Retaining Ring	<b>PMA64RS</b>	1640-1396	45° Conductor Tube	<b>SMVCT45</b>	1240-1373
Nozzle Collar	<b>VCTLCLK</b>	1640-1398	Sleeve Screw	<b>VCT41CS</b>	2040-2048	60° Conductor Tube	<b>SMVCT60</b>	1240-1374
Wave Spring	<b>VCTLSPR</b>	1640-1399	Liner Set Screw	<b>41CS</b>	2040-2047	O-Ring Seal	<b>94-710-036</b>	9471-0036

For additional information visit us online at [Tweco.com](http://Tweco.com) or call customer service.

## 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

CONSUMABLES



## 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)	<b>11-23</b>	1110-1100	--	--	<b>11T-23</b>	1110-1300
.030" (0.8 mm)	.038" (0.97 mm)	<b>11-30</b>	1110-1101	<b>11H-30</b>	1110-1201	<b>11T-30</b>	1110-1301
.035" (0.9 mm)	.044" (1.12 mm)	<b>11-35</b>	1110-1102	<b>11H-35</b>	1110-1202	<b>11T-35</b>	1110-1302
.040" (1.0 mm)	.048" (1.22 mm)	<b>11-40</b>	1110-1103	<b>11H-40</b>	1110-1203	--	--
.045" (1.2 mm)	.054" (1.37 mm)	<b>11-45</b>	1110-1104	<b>11H-45</b>	1110-1204	<b>11T-45</b>	1110-1304
3/64" AL (1.2 mm)	.059" (1.50 mm)	--	--	<b>11AH-364</b>	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)	<b>14-23</b>	1140-1100	--	--	<b>14T-23</b>	1140-1300
.030" (0.8 mm)	.038" (0.97 mm)	<b>14-30</b>	1140-1101	--	--	<b>14T-30</b>	1140-1301
.035" (0.9 mm)	.044" (1.12 mm)	<b>14-35</b>	1140-1102	<b>14H-35</b>	1140-1202	<b>14T-35</b>	1140-1302
.040" (1.0 mm)	.048" (1.22 mm)	<b>14-40</b>	1140-1103	<b>14H-40</b>	1140-1203	--	--
.045" (1.2 mm)	.054" (1.37 mm)	<b>14-45</b>	1140-1104	<b>14H-45</b>	1140-1204	<b>14T-45</b>	1140-1304
.052" (1.3 mm)	.064" (1.65 mm)	<b>14-52</b>	1140-1105	<b>14H-52</b>	1140-1205	<b>14T-52</b>	1140-1305
1/16" (1.6 mm)	.073" (1.85 mm)	<b>14-116</b>	1140-1106	<b>14H-116</b>	1140-1206	<b>14T-116</b>	1140-1306
5/64" (2.0 mm)	.090" (2.29 mm)	<b>14-564</b>	1140-1109	<b>14H-564</b>	1140-1209	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	<b>14A364</b>	1140-1113	<b>14AH-364</b>	1140-1213	--	--
1/16" AL (1.6 mm)	.082" (2.08 mm)	--	--	<b>14AH-116</b>	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)	<b>15H-35</b>	1150-1202	--	--	--	--
.045" (1.2 mm)	.054" (1.37 mm)	<b>15H-45</b>	1150-1204	<b>15HFC-45</b>	1150-1254	--	--
.052" (1.3 mm)	.064" (1.65 mm)	<b>15H-52</b>	1150-1205	<b>15HFC-52</b>	1150-1255	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	<b>15H-116</b>	1150-1206	<b>15HFC-116</b>	1150-1256	--	--
5/64" (2.0 mm)	.090" (2.29 mm)	<b>15H-564</b>	1150-1209	<b>15HFC-564</b>	1150-1259	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	<b>15H-332</b>	1150-1210	<b>15HFC-332</b>	1150-1260	--	--
7/64" (2.8 mm)	.120" (3.05 mm)	<b>15H-764</b>	1150-1211	<b>15HFC-764</b>	1150-1261	--	--
1/8" (3.2 mm)	.144" (3.66 mm)	<b>15H-18</b>	1150-1212	<b>15HFC-18</b>	1150-1262	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	<b>15AH-364</b>	1150-1213	--	--	--	--
1/16" AL (1.6 mm)	.082" (2.08 mm)	<b>15AH-116</b>	1150-1214	--	--	--	--

## 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)	<b>16S-35</b>	1160-1102	<b>16ST-35</b>	1160-1135
.040" (1.0 mm)	.048" (1.22 mm)	<b>16S-40</b>	1160-1103	--	--
.045" (1.2 mm)	.054" (1.37 mm)	<b>16S-45</b>	1160-1104	<b>16ST-45</b>	1160-1137
.052" (1.3 mm)	.064" (1.65 mm)	<b>16S-52</b>	1160-1105	<b>16ST-52</b>	1160-1138
1/16" (1.6 mm)	.073" (1.85 mm)	<b>16S-116</b>	1160-1106	<b>16ST-116</b>	1160-1139
5/64" (2.0 mm)	.090" (2.29 mm)	<b>16S-564</b>	1160-1109	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	<b>16S-332</b>	1160-1110	--	--
7/64" (2.8 mm)	.120" (3.05 mm)	<b>16S-764</b>	1160-1111	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	<b>16AS-364</b>	1160-1113	--	--
1/16" AL (1.6 mm)	.082" (2.08 mm)	<b>16AS-116</b>	1160-1114	--	--

CONSUMABLES

## 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)	<b>14RZ-35</b>	1140-1430	<b>14RZT-35</b>	1140-1440
.045" (1.2 mm)	.051" (1.30 mm)	<b>14RZ-45</b>	1140-1432	<b>14RZT-45</b>	1140-1442
.052" (1.3 mm)	.058" (1.47 mm)	<b>14RZ-52</b>	1140-1433	<b>14RZT-52</b>	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)	<b>16RZ-35</b>	1160-1180	<b>16RZT-35</b>	1160-1190
.045" (1.2 mm)	.051" (1.30 mm)	<b>16RZ-45</b>	1160-1182	<b>16RZT-45</b>	1160-1192
.052" (1.3 mm)	.058" (1.47 mm)	<b>16RZ-52</b>	1160-1183	<b>16RZT-52</b>	1160-1193



## Contact Tips - Long Life PulseMaster® Threaded Style

### 16PS Series

0.375" (9.5 mm) Outside Diameter - M8 x 1.25 Threads - 1.81" (46 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)	<b>16PS-30</b>	1160-1543
.035" (0.9 mm)	.041" (1.04 mm)	<b>16PS-35</b>	1160-1535
.045" (1.2 mm)	.051" (1.30 mm)	<b>16PS-45</b>	1160-1537
.047" (1.2 mm)	.064" (1.63 mm)	<b>16APS-364</b>	1160-1538
.054" (1.3 mm)	.058" (1.50 mm)	<b>16PS-52</b>	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" (8.8 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)	<b>EL16-30</b>	1160-1610	<b>EL16T-30</b>	1160-1601
.035" (0.9 mm)	.044" (1.12 mm)	<b>EL16-35</b>	1160-1611	<b>EL16T-35</b>	1160-1602
.040" (1.0 mm)	.048" (1.22 mm)	<b>EL16-40</b>	1160-1612	<b>EL16T-40</b>	1160-1603
.045" (1.2 mm)	.054" (1.37 mm)	<b>EL16-45</b>	1160-1613	<b>EL16T-45</b>	1160-1604
.052" (1.3 mm)	.064" (1.65 mm)	<b>EL16-52</b>	1160-1615	<b>EL16T-52</b>	1160-1605
1/16" (1.6 mm)	.073" (1.85 mm)	<b>EL16-116</b>	1160-1616	<b>EL16T-116</b>	1160-1606
5/64" (2.0 mm)	.090" (2.29 mm)	<b>EL16-564</b>	1160-1618	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	<b>EL16-332</b>	1160-1619	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	<b>EL16A-364</b>	1160-1614	<b>EL16AT-364</b>	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)	--	--	<b>EL16RZT-35</b>	1160-1705
.045" (1.2 mm)	.051" (1.30 mm)	<b>EL16RZ-45</b>	1160-1732	<b>EL16RZT-45</b>	1160-1707
.052" (1.3 mm)	.058" (1.47 mm)	<b>EL16RZ-52</b>	1160-1733	<b>EL16RZT-52</b>	1160-1708

# 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

CONSUMABLES

## 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)	<b>21-37F</b>	1210-1102	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess
	3/8" (9.5 mm)	<b>21-37</b>	1210-1100	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	<b>21T-37</b>	1210-1300	<b>Tapered</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	<b>21T-37F</b>	1210-1302	<b>Tapered</b>	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	<b>21-50F</b>	1210-1112	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	<b>21-50</b>	1210-1110	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>21-62</b>	1210-1120	<b>Standard</b>	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)	<b>REL21-50F</b>	1210-1316	<b>Straight</b>	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	<b>REL21-50P</b>	1210-1321	<b>Straight</b>	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)	<b>22-37SS</b>	1220-1101	<b>Standard Short Stop</b>	Flush to 1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	<b>22T-37SS</b>	1220-1301	<b>Standard Short Stop</b>	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	<b>22-50</b>	1220-1110	<b>Standard</b>	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	<b>22-50SS</b>	1220-1111	<b>Standard Short Stop</b>	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>22-62</b>	1220-1120	<b>Standard</b>	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	<b>22-62SS</b>	1220-1121	<b>Standard Short Stop</b>	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)	<b>HD22-37</b>	1220-1305	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>HD22-50</b>	1220-1306	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>HD22-50F</b>	1220-1311	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>HD22-62</b>	1220-1307	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>HD22-62F</b>	1220-1312	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess

## 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)	<b>23-37</b>	1230-1100	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>23-50</b>	1230-1110	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>23-50F</b>	1230-1112	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>23-62</b>	1230-1120	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>23-62F</b>	1230-1122	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>23-75</b>	1230-1130	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>23-75F</b>	1230-1132	<b>Standard</b>	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)	<b>23T-37</b>	1230-1300	<b>Tapered</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	<b>23T-37F</b>	1230-1302	<b>Tapered</b>	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)	<b>23H-50</b>	1230-1210	<b>Heavy Duty</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>23H-62</b>	1230-1220	<b>Heavy Duty</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>23H-62F</b>	1230-1222	<b>Heavy Duty</b>	Flush To 1/16" (1.6 mm) Tip Recess
	3/4" (19.5 mm)	<b>23H-75</b>	1230-1230	<b>Heavy Duty</b>	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)	<b>24A-37SS</b>	1240-1101	<b>Standard Short Stop</b>	1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	<b>24AT-37SS</b>	1240-1301	<b>Standard Short Stop</b>	1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	<b>24A-50</b>	1240-1110	<b>Standard</b>	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	<b>24A-50SS</b>	1240-1111	<b>Standard Short Stop</b>	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>24A-62</b>	1240-1120	<b>Standard</b>	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	<b>24A-62SS</b>	1240-1121	<b>Standard Short Stop</b>	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>24AH-62</b>	1240-1220	<b>Standard Heavy Duty</b>	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	<b>24AH-62SS</b>	1240-1221	<b>Standard Short Stop</b>	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	<b>24A-75</b>	1240-1130	<b>Standard</b>	Adjustable Tip Recess - Tip Protruding
	3/4" (19.5 mm)	<b>24AH-75</b>	1240-1230	<b>Standard Heavy Duty</b>	Adjustable Tip Recess - Tip Protruding
	3/4" (19.5 mm)	<b>24AH-75SS</b>	1240-1231	<b>Standard Short Stop</b>	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



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



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



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

†Outer shell made from red brass Alloy 230

## Nozzles & Nozzle Insulators - Air-Cooled

### PMA24 Series PulseMaster® and PullMaster™ Air-Cooled Nozzles

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

2 per pack



PMA24 Series

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

### 25CT Series

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



25CT Series



35CT Insulator  
*(sold separately)*

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

### 25I Series

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

2 per pack



25I Series

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

### 26CT Series

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



26CT Series



36CT Insulator  
*(sold separately)*

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

### 26I Series

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

2 per pack



26I Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	5/8" (15.9 mm)	<b>26I-62</b>	1260-1120	<b>Standard</b>	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	<b>26I-75</b>	1260-1130	<b>Standard</b>	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)	<b>21-62FAS</b>	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)	<b>24A-100FAS</b>	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)	<b>25CT-162FAS</b>	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



EL22I Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	<b>EL22I-37</b>	1260-1601	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL22I-50</b>	1260-1602	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL22I-50P</b>	1260-1686	Standard	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	<b>EL22I-62</b>	1260-1603	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>EL22I-75</b>	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)	<b>EL22CT-37</b>	1260-1625	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	<b>EL22CT-37F</b>	1260-1635	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL22CT-50</b>	1260-1626	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL22CT-50F</b>	1260-1636	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL22CT-62</b>	1260-1627	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL22CT-62F</b>	1260-1637	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL22CT-62P</b>	1260-1692	Standard	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	<b>EL22CT-62H</b>	1260-1629	Standard, Heavy Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>EL22CT-75</b>	1260-1628	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

**Nozzles - Eliminator® Style Air-Cooled**

**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



EL24I Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	<b>EL24I-37</b>	1260-1606	<b>Tapered</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL24I-50</b>	1260-1607	<b>Tapered</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL24I-62</b>	1260-1608	<b>Tapered</b>	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL24I-62R</b>	1260-1677	<b>Tapered</b>	3/8" (9.5 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL24I-62H</b>	1260-1631	<b>Tapered, Heavy Duty</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>EL24I-75</b>	1260-1609	<b>Tapered</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>EL24I-75H</b>	1260-1632	<b>Tapered, Heavy Duty</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

**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



EL24CT Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	<b>EL24CT-37</b>	1260-1650	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL24CT-50</b>	1260-1651	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>EL24CT-50P</b>	1260-1701	<b>Standard</b>	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	<b>EL24CT-62</b>	1260-1652	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL24CT-62F</b>	1260-1667	<b>Standard</b>	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL24CT-62R</b>	1260-1682	<b>Standard</b>	3/8" (9.5 mm) Tip Recess
	5/8" (15.9 mm)	<b>EL24CT-62H</b>	1260-1657	<b>Standard, Heavy Duty</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>EL24CT-75</b>	1260-1653	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
3/4" (19.5 mm)	<b>EL24CT-75H</b>	1260-1658	<b>Standard, Heavy Duty</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess	

**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



REL24 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	<b>REL24CT-50</b>	1240-1305	<b>Straight</b>	5/32" (3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>REL24CT-50F</b>	1240-1315	<b>Straight</b>	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	<b>REL24CT-50P</b>	1240-1310	<b>Straight</b>	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	<b>REL24CT-62</b>	1240-1306	<b>Straight</b>	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>REL24CT-62F</b>	1240-1316	<b>Straight</b>	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>REL24CT-62P</b>	1240-1311	<b>Straight</b>	5/32" (3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>REL24CT-75F</b>	1240-1317	<b>Straight</b>	Flush To 1/16" (1.6 mm) Tip Recess
	3/4" (19.5 mm)	<b>REL24CT-75P</b>	1240-1312	<b>Straight</b>	5/32" (3.97 mm) Tip Protruding

CONSUMABLES

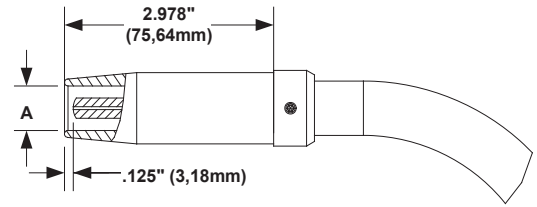


### Nozzles & Nozzle Insulators - Water-Cooled

#### WC24 Series – Standard Tip Recess

Use with WC24-1 (Stock No. 1244-1009)  
Nozzle Insulator .125" (3.18 mm)

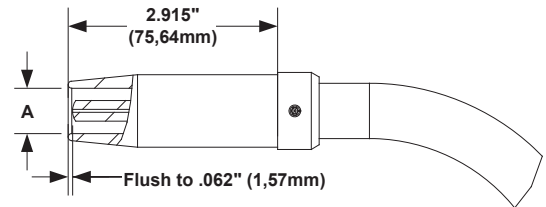
Bore Size "A"	Part No.	Stock No.
.500" (12.7mm)	<b>WC24-50</b>	1244-1110
.625" (15.9 mm)	<b>WC24-62</b>	1244-1120
.750" (19.1 mm)	<b>WC24-75</b>	1244-1130



#### 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)	<b>WC24-50F</b>	1244-1112
.625" (15.9 mm)	<b>WC24-62F</b>	1244-1122



#### SW24 Series

Use with Insulator Ring Part No. SW64-3 (Stock No. 2044-1020).  
2 per pack



Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	5/8" (15.9 mm)	<b>SW24-15</b>	1244-1026	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	11/16" (17 mm)	<b>SW24-17</b>	1244-1025	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	13/16" (21 mm)	<b>SW24-21</b>	1244-1027	<b>Standard</b>	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



Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On (Standard)	5/8" (15.9 mm)	<b>WC26-62</b>	1264-1120	<b>Standard</b>	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WC26-62R</b>	1264-1123	<b>Standard</b>	1/4" (6.4 mm) Tip Recess
	3/4" (19.5 mm)	<b>WC26-75</b>	1264-1130	<b>Standard</b>	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	<b>WC26-75F</b>	1264-1132	<b>Standard</b>	Tip Flush
	3/4" (19.5 mm)	<b>WC26-75R</b>	1264-1133	<b>Standard</b>	1/4" (6.4 mm) Tip Recess
Thread-On* (Eliminator®)	1/2" (12.7 mm)	<b>WC26-50EL*</b>	1262-1031	<b>Standard</b>	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WC26-62EL*</b>	1262-1032	<b>Standard</b>	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WC26-62ELF*</b>	1262-1037	<b>Standard</b>	Tip Flush
	3/4" (19.5 mm)	<b>WC26-75EL*</b>	1262-1033	<b>Standard</b>	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	<b>WC26-75ELF*</b>	1262-1038	<b>Standard</b>	5/32" (3.97 mm) Tip Protruding
	3/4" (19.5 mm)	<b>WC26-75ELR*</b>	1262-1042	<b>Standard</b>	Tip Flush

\*Use with Eliminator style contact tips

**Nozzles & Nozzle Insulators - Water-Cooled**

**RWC26 Series**

Nickel plated nozzles.

Use with Spatter Shield Part No. WC26EL-1 (Stock No. 1262-1049).

2 per pack



RWC26 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	<b>RWC26-50</b>	1264-1430	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>RWC26-62</b>	1264-1431	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>RWC26-75</b>	1264-1432	<b>Standard</b>	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

**PMW24 Series PulseMaster™ Water-Cooled Nozzles**

Nickel plated nozzles.

2 per pack



PMW24 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	<b>PMW24-50F</b>	1260-1735	<b>Standard</b>	Flush To 1/2" (12.5 mm)
	1/2" (12.7 mm)	<b>PMW24-50</b>	1260-1736	<b>Standard</b>	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	<b>PMW24-62F</b>	1260-1737	<b>Standard</b>	Flush To 5/8" (16 mm)
	5/8" (15.9 mm)	<b>PMW24-62</b>	1260-1738	<b>Standard</b>	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	<b>PMW24-75F</b>	1260-1739	<b>Standard</b>	Flush To 3/4" (19 mm)
	3/4" (19.5 mm)	<b>PMW24-75</b>	1260-1740	<b>Standard</b>	0.156" (3.9 mm) Tip Recess

CONSUMABLES

**Gas Diffusers - Standard Air-Cooled**

**Mini-MIG Series 160 Amp**

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>35-50</b>	1500-1100	Brass	11 Series	21 Series

**51 Series 100 Amp**

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>51</b>	1510-1101	Brass	11 Series	21 Series
<b>51-23</b>	1510-1100	Brass	11-23	21 Series
<b>EL51</b>	1510-1105	Brass	EL11 Series	REL21 Series
<b>QTRW53-11</b>	1525-1141	Brass	11 Series	REL21 Series

**52 Series 200 Amp**

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>52</b>	1520-1101	Brass	14 Series	22 Series
<b>52FN</b>	1520-1102	Brass	14 Series	24A or 23 Series
<b>MS52T-11</b>	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)

## 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

### 400 Amp

5 per pack



WC54A



QTRW54-16

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

### 600 Amp

5 per pack



WC56A-SW



WC56EL-H

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

CONSUMABLES

# 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
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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
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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
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Standard 600 Series	600	60 Degrees		■	Neoprene Rubber	123
Traditional Series	400	60, 80 & 180 Degree Extensions				123

CONSUMABLES

# 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

CONSUMABLES

## 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
	80°	■		64SFLX4-80	1640-1113
No. 4	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 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

\*Standard Style Consumables  
‡Eliminator Style Consumables  
†Long Reach Conductor Tube (2" longer)

**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	<b>35-60-60</b>	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	<b>35-60-45</b>	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	<b>61-60</b>	1610-1102	Neoprene Rubber	--	I.D. M10 x 1.5-6H
180 Degree, Straight	<b>61-180</b>	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	<b>62J-60</b>	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	<b>62A-60</b>	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	<b>62ELJ-80</b>	1620-1307	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H
180 Degree, Straight	<b>62ELJ-180</b>	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	<b>63J-60</b>	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	<b>63J-45</b>	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	<b>63ELJ-180</b>	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	<b>64J-60</b>	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	<b>64J-45</b>	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	<b>64A-60</b>	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	<b>64A-45</b>	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	<b>64ELJ-60</b>	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	<b>64ELJ-45</b>	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	<b>64ELJ-80</b>	1640-1118	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 180 Degree, Straight	<b>64ELJ-180</b>	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	<b>65J-60</b>	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	<b>65J-45</b>	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	<b>65J-180</b>	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	<b>66J-60</b>	1660-1826	Metal	I.D. 7/16"-20 UNF-2B	I.D. M12 x 1.5 6H O.D. M17 x 2.0-6G

## 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

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## 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	<b>MS63-60S</b>	1630-1196	Metal	--	I.D. M11 x 1.5-6H
60 Degree with 3" (76.2 mm) Radius	<b>MS63-60</b>	1630-1189	Metal	--	I.D. M11 x 1.5-6H
60 Degree with 2" (50.5 mm) Radius	<b>MS62A-60</b>	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	<b>MS63-60</b>	1630-1189	Metal	--	I.D. M11 x 1.5-6H
45 Degree with 3" (76.2 mm) Radius	<b>MS63-45</b>	1630-1188	Metal	--	I.D. M11 x 1.5-6H
180 Degree, Straight	<b>MS63-180</b>	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	<b>MS64H-60</b>	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	<b>MS64H-45</b>	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	<b>MS64H-60LM *</b>	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	<b>MS64H-45LM *</b>	1640-1323	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
60 Degree with 3" (76.2 mm) Radius	<b>MS64-60S **</b>	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	<b>SMVCT-60</b>	1240-1374	Metal	--	--
Heavy Duty 45 Degree with 3" (76.2 mm) Radius	<b>SMVCT-45</b>	1240-1373	Metal	--	--
Heavy Duty 180 Degree, Straight	<b>SMVCT-180</b>	1240-1375	Metal	--	--
Long Reach, Heavy Duty 60 Degree with 3" (76.2 mm) Radius	<b>SMVCT-60LM</b>	1640-1374	Metal	--	--
Long Reach, Heavy Duty 45 Degree with 3" (76.2 mm) Radius	<b>SMVCT-45LM</b>	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	<b>EL63J-60</b>	1630-1137	Metal	--	I.D. M11 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	<b>EL63J-45</b>	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	<b>EL64J-60</b>	1640-1137	Metal	--	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	<b>EL64J-45</b>	1640-1136	Metal	--	I.D. M12 x 1.5-6H
60 Degree with 2-1/4" (57 mm) Radius	<b>EL64-60</b>	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	<b>EL64J-60</b>	1640-1137	Metal	--	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	<b>EL64J-45</b>	1640-1136	Metal	--	I.D. M12 x 1.5-6H
180 Degree, Straight	<b>EL64J-180</b>	1640-1135	Metal	--	I.D. M12 x 1.5-6H
60 Degree with 2-1/4" (57 mm) Radius	<b>EL64-60</b>	1640-1110	Fiber	--	I.D. M12 x 1.5-6H
45 Degree with 2-1/4" (57 mm) Radius	<b>EL64-45</b>	1640-1111	Fiber	--	I.D. M12 x 1.5-6H

## 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	<b>PMW64-45</b>	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	<b>SW64-60</b>	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	<b>WCS66-60</b>	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°	<b>64A-4EX</b>	1640-1301
Extension 6" (152 mm) Straight 180°	<b>64A-6EX</b>	1640-1302
Extension 8" (203 mm) Straight 180°	<b>64A-8EX</b>	1640-1303
Extension 45°	<b>64EX-45</b>	1640-1311
Extension 60°	<b>64EX-60</b>	1640-1312

### No. 5 Extensions

Description	Part No.	Stock No.
Extension 4" (102 mm) Straight 180°	<b>65-4EX</b>	1650-1301
Extension 6" (152 mm) Straight 180°	<b>65-6EX</b>	1650-1302
Extension 8" (203 mm) Straight 180°	<b>65-8EX</b>	1650-1303
Extension 45°	<b>65EX-45</b>	1650-1311
Extension 60°	<b>65EX-60</b>	1650-1312



# 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



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### 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)										
	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)						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)
	44-116-25	25 ft (7.6 m)										
5/64" (2.0 mm)	44-564-15	15 ft (4.6 m)										
	44-564-25	25 ft (7.6 m)										
3/32" (2.4 mm)	44-332-15	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)					
	44-332-25	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.

## 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

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## 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)	<b>44PSTF-3545-12</b>	1441-1138
.035" - .045" (0.9 - 1.2 mm)	15 ft (4.6 m)	<b>44PSTF-3545-15</b>	1441-1137
.052" - 1/16" (1.3 - 1.6 mm)	12 ft (4 m)	<b>44PSTF-116-12</b>	1441-1136
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	<b>44PSTF-116-15</b>	1441-1135

### Bronze Jump Liner

Wire Size	Length	Part No.	Stock No.
Max .045" (1.2 mm)	10-1/4" (260 mm)	<b>44JT-3545</b>	1644-1088
Max .062" (1.6 mm)	10-1/4" (260 mm)	<b>44JT-116</b>	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)	<b>PMP44-116-33</b>	1441-1125
3/64" - 1/16" (1.2 - 1.6 mm)	50 ft (15.2 m)	<b>PMP44-116-50</b>	1441-1126
.035" - .045" (0.9 - 1.2 mm)	33 ft (10 m)	<b>PMP44-3545-33</b>	1441-1127
3/64" - 1/16" (1.2 - 1.6 mm)	33 ft (10 m)	<b>PMPS44-116-33</b>	1441-1129
.035" - .045" (0.9 - 1.2 mm)	33 ft (10 m)	<b>PMPS44-3545-33</b>	1441-1131

### Teflon Jump Liner for Flex Tube

Wire Size	Description	Part No.	Stock No.
1/16" (1.6 mm)	Flex Tube	<b>PMP-44FLX-116</b>	1644-1095
1/16" (1.6 mm)	Rigid Tube	<b>PMP-44PTF-116</b>	1644-1096

### Bronze Jump Liner

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	--	<b>PMP-44-116</b>	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)	<b>R44-3545-8</b>	1440-1225
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	<b>R44-116-15</b>	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)	<b>R45-3545-4</b>	1450-1024
.035" - .045" (0.9 - 1.2 mm)	8 ft (2.4 m)	<b>R45-3545-8</b>	1450-1025
.052" - 1/16" (1.3 - 1.6 mm)	8 ft (2.4 m)	<b>R45-116-8</b>	1450-1030
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	<b>R45-116-15</b>	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)	<b>R45WN-116-15</b>	1450-1045

## 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








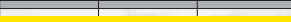

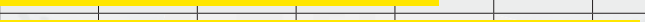
Tweco Electrode Holders are designed to mechanically hold a welding electrode in position. The efficient 6-position Jaw pattern allows you to get into the correct position your application requires. Ergonomic handle has operator appeal with reversible top & bottom insulators that are easy to replace. Rugged and reliable design made from heavy duty copper alloy and is fully insulated.

MANUAL PRODUCTS

# Manual Welding Products & Accessories



# EASY FIND GUIDE - Electrode Holder Selection Guide

	Style	Amperage Range						Recommended Model	Page	
		200	250	300	350	400	450			500
Electrode Holders	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			Application				Page
	Current (Amps)	Electrode Size in (mm)	Cable Connection	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab	Extra Heavy Duty Fab	
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

**Electrode Holders - TwecoTong® A-Series**



**FEATURES**

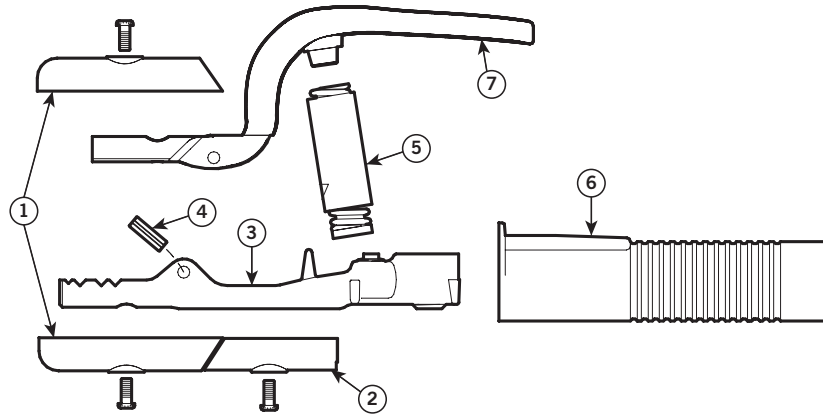
- TwecoTong Electrode Holders are designed to mechanically hold a welding electrode in position
- Reversible Top & Bottom Insulators are easy to replace
- Efficient 6-Position Jaw Patterns
- Ball Point Cable Connections
- Fully Insulated & Protected Springs
- Heavy Duty Copper Alloy

**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)	<b>A-532*</b>	9110-1101
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/2" (216 mm)	<b>A532-MC**</b>	9110-1109
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	<b>A-316*</b>	9110-1102
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	<b>A316-MC**</b>	9110-1110
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	<b>A-732*</b>	9110-1103
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	<b>A732-MC**</b>	9110-1111
350	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	11" (279 mm)	<b>A-14</b>	9110-1104
400	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	12" (305 mm)	<b>A-14-HD</b>	9110-1105
500	Copper Alloy	3/8" (9.5 mm)	4/0 (107 mm)	13-1/4" (336 mm)	<b>A-38-HD</b>	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	<b>A-532-1P</b> 9910-2102	<b>A-532-1P</b> 9910-2102	<b>A-732-1P</b> 9910-2302	<b>A-732-1P</b> 9910-2302	<b>A-732-1P</b> 9910-2302	<b>A-38-HD-1P</b> 9910-2602
2	Body Insulation	<b>A-532-3</b> 9910-2103	<b>A-532-3</b> 9910-2103	<b>A-532-3</b> 9910-2103	<b>A-14-3</b> 9910-2403	<b>A-14-3</b> 9910-2403	<b>A-38-HD-3</b> 9910-2603
3	Lower Body Tong w/o Insulation	<b>A-316-4R</b> 9910-2204	<b>A-316-4R</b> 9910-2204	<b>A-732-4</b> 9910-2304	<b>A-14-4</b> 9910-2404	<b>A-14-HD-4</b> 9910-2504	<b>A-38-HD-4</b> 9910-2604
4	Hinge Pin	<b>A-532-11</b> 9910-2111	<b>A-532-11</b> 9910-2111	<b>A-532-11</b> 9910-2111	<b>A-532-11</b> 9910-2111	<b>A-532-11</b> 9910-2111	<b>FGC-200-5</b> 9910-2610
5	Spring with Insulation	<b>A-532-6</b> 9910-2106	<b>A-316-6</b> 9910-2206	<b>A-316-6</b> 9910-2206	N/A	N/A	N/A
6	Molded Handle	<b>A-532-7</b> 9910-2107	<b>A-316-7</b> 9910-2207	<b>A-732-7</b> 9910-2307	<b>A-14-7</b> 9910-2407	<b>A-14-HD-7</b> 9910-2507	<b>A-38-HD-7</b> 9910-2607
NS	Handle Screws	<b>AL-300-12</b> 9910-2712	<b>AL-300-12</b> 9910-2712	<b>AL-300-12</b> 9910-2712	<b>AL-300-12</b> 9910-2712	<b>AL-300-12</b> 9910-2712	<b>AL-300-12</b> 9910-2712
NS	Cable Connection Screw	<b>A-532-24</b> 9910-2124	<b>A-532-24</b> 9910-2124	<b>A-532-24</b> 9910-2124	<b>A-14-24</b> 9910-2424	<b>A-14-24</b> 9910-2424	<b>A-14-24</b> 9910-2424

# Manual Welding Products

Electrode Holders

## Electrode Holders - TwecoTong® T-Series



### FEATURES

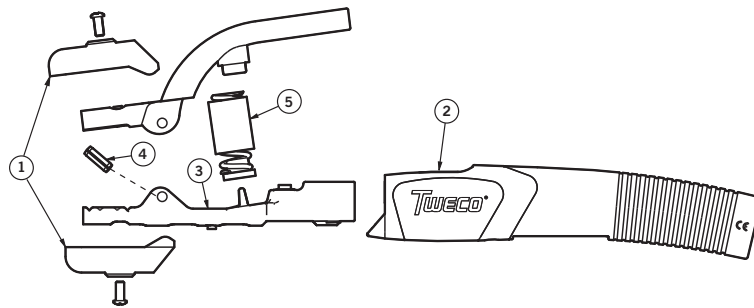
- **Ergonomic Handle** has 12-degree angle
- **Efficient 6-Position Jaw Patterns** to hold the welding electrode in position
- **Double Ball Point Cable Connections** accept up to 2/0 welding cable
- **Rugged & Reliable Design** with operator appeal
- **Designed to meet IEC 60974-11**
- **Fully Insulated & 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)	<b>T532-MC*</b>	9110-1122
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	<b>T532**</b>	9110-1131
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	<b>T316-MC*</b>	9110-1123
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/2" (241 mm)	<b>T316**</b>	9110-1132
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	<b>T732-MC*</b>	9110-1124
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	<b>T732**</b>	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	<b>T-532-1</b> / 9910-2104	<b>T-532-1</b> / 9910-2104	<b>T-732-1</b> / 9910-2303
2	Molded Handle	<b>T-532-7</b> / 9910-2108	<b>T-316-7</b> / 9910-2208	<b>T-732-7</b> / 9910-2308
3	Lower Body Tong w/o Insulation	<b>A-316-4R</b> / 9910-2204	<b>A-316-4R</b> / 9910-2204	<b>A-732-4</b> / 9910-2304
4	Hinge Pin	<b>A-532-11</b> / 9910-2111	<b>A-532-11</b> / 9910-2111	<b>A-532-11</b> / 9910-2111
5	Spring with Insulation	<b>A-532-6</b> / 9910-2106	<b>A-316-6</b> / 9910-2206	<b>A-316-6</b> / 9910-2206
NS	Handle Screws	<b>AL-300-12</b> / 9910-2712	<b>AL-300-12</b> / 9910-2712	<b>AL-300-12</b> / 9910-2712
NS	Cable Connection Screw	<b>A-532-24</b> / 9910-2124	<b>A-532-24</b> / 9910-2124	<b>A-532-24</b> / 9910-2124

## Electrode Holders - TwecoTite



4TT

### 4TT Tweco-Tite Replacement Parts

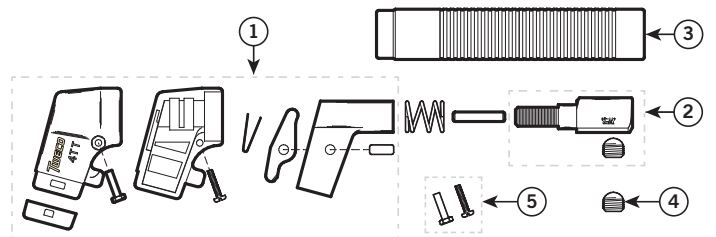
#	Description	Part No.	Stock No.
1	Head Assy - Complete (renewable)	<b>4TT-1</b>	9911-2001
2	Connector Body w/Ball-Point Screw	<b>4TT-20</b>	9911-2020
3	Handle Only	<b>4TT-30</b>	9911-2030
4	Ball-Point Screw	<b>A-532-24</b>	9910-2124
5	Binder Post & Screw - for Head Ins.	<b>122FM</b>	2020-2122

### 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)	<b>4TT</b>	9120-1000



## 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.

MANUAL PRODUCTS

# Ground Clamps

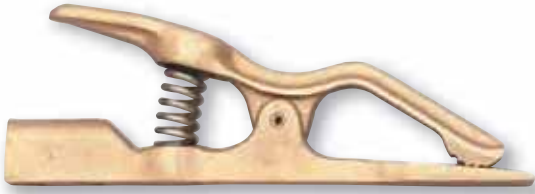
# EASY FIND GUIDE - Ground Clamps Selection Guide

	Application	Amperage Range								Recommended Model	Page	
		200	300	400	500	600	700	800	1500			2000
Ground Clamps	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
	Rotary										GCRG 140	136
											RG 140	136
											RG 230	136
											RG 240	136
											RG 440	136
											RG 640	136

Model	Output				Process			Application				Page
	Current (Amps)	Jaw Opening	No. of Heads	Cable Connection	Plate	Pipe	Rotary	Light Duty Fab	Med. Duty Fab	Heavy Duty Fab	Extra Heavy Duty Fab	
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

### Ground Clamps - Selection Options

#### Flat Jaw Copper Ground Clamp



#### Steel Ground Clamp



#### Copper Ground Clamp



#### Switchable Magnetic Ground Clamp

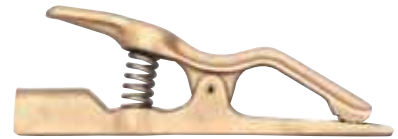


#### Rotary Ground Clamps



## 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)	<b>FGC-200</b>	9205-1320
300	1" - Depth 3-1/2" (25.4 mm - 88.9 mm)	Ball-Point thru 3/0	7-14" (184 mm)	<b>FGC-300</b>	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)	<b>FGC-500</b>	9205-1350



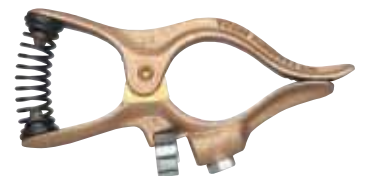
### Steel Ground Clamps

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)	<b>SGC-300</b>	9205-1230
500	2" - Depth 1-3/4" (50.8 mm - 44.4 mm)	1/2" Stud Connection	9" (228 mm)	<b>SGC-500</b>	9205-1250

### Steel Ground Clamp Replacement Parts

Description	Part No.	Stock No.
Cone Head Replacement Jaw - for SGC-300 and SGC-500	<b>SGC-500-4</b>	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)	<b>GC-200</b>	9205-1120
300	1-1/2" - Depth 4" (38.1 mm - 101.0 mm)	Ball-Point thru 3/0	8-1/2" (216 mm)	<b>GC-300*</b>	9205-1130
300	1-1/2" - Depth 4" (38.1 mm - 101.0 mm)	Ball-Point thru 3/0	8-1/2" (216 mm)	<b>GC-300MC**</b>	9205-1131
500	2" - Depth 5-1/4" (50.8 mm - 133.0 mm)	Ball-Point thru 4/0	10" (254 mm)	<b>GC-500</b>	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	<b>GC-300-2</b>	9920-2302
Cable Support Ring - for GC-300	<b>GC-300-11</b>	9920-2311
Cable Connection Screw - for GC-300	<b>GC-300-12</b>	9920-2312

**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	--	<b>GCRG-140</b>	9210-1314
400	1 - 4/0	1	3/4" NC	8" (203 mm)	<b>RG-140</b>	9250-1114
600	2 - 3/0	1	1-1/8" NC	10-1/4" (260 mm)	<b>RG-230</b>	9250-1123
800	2 - 4/0	1	1-3/8" NC	10-5/8" (270 mm)	<b>RG-240</b>	9250-1124
1500	4 - 4/0	2	1-3/8" NC	10-5/8" (270 mm)	<b>RG-440</b>	9250-1144
2000	6 - 4/0	3	1-3/8" NC	10-5/8" (270 mm)	<b>RG-640</b>	9250-1164



RG-240-11



A-14-24



2-5

**Roto-Ground Accessories**

Description	Part No.	Stock No.
Lubricating Cup	<b>RG-240-11</b>	9922-2129
Ball-Point Cable Connection Screw	<b>A-14-24</b>	9910-2424
Special Shaft Lubricant	<b>1Z-L</b>	9900-1123
Fibre Cover Screw	<b>2-5</b>	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	<b>RG-140-2-0</b> 9922-2103	--	<b>RG-240-4-0</b> 9922-2124	<b>RG-240-4-0</b> 9922-2124	<b>RG-240-4-0</b> 9922-2124
Head Shaft	<b>RG-140-2</b> 9922-2102	<b>RG-230-2</b> 9922-2112	<b>RG-240-2</b> 9922-2122	<b>RG-440-2</b> 9922-2132	<b>RG-640-2</b> 9922-2142
Work Attachment Nut	<b>RG-140-5</b> 9922-2105	<b>RG-230-5</b> 9922-2115	<b>RG-240-5</b> 9922-2125	<b>RG-240-5</b> 9922-2125	<b>RG-240-5</b> 9922-2125
Fibre Cover	--	<b>RG-240-7</b> 9922-2127	<b>RG-240-7</b> 9922-2127	<b>RG-240-7</b> 9922-2127	<b>RG-240-7</b> 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%

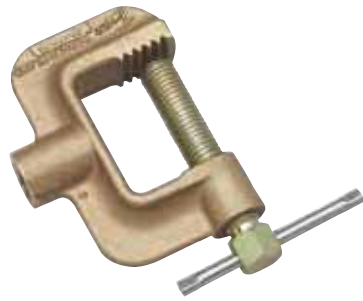
Description	Part No.	Stock No.
1 oz (29.6 mL) Plastic Squeeze Bottle	<b>1Z-L</b>	9900-1123
8 oz (237.0 mL) Plastic Squeeze Bottle	<b>8Z-L</b>	9900-1124



### 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	<b>WCRG-600</b>	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	<b>WCRG-1200</b>	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	<b>WCRG-2000</b>	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	<b>GC-600-50</b>	9210-1150
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	3/4" Cap Screw	<b>GC-600-75*</b>	9255-1075
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	Double Ball-Point	<b>GC-600-DBP</b>	9210-1201
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	Tweco Male Plug	<b>GC-600-TMP</b>	9210-1202

\*Clamp Only - Tapped 3/4" for RG-140 Roto-Ground Only

### 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	<b>118</b>	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	<b>138</b>	9922-2038



138

### "C" Type Clamp Parts

Description	Part No.	Stock No.
Cap Screw - 1/2" x 3/4" NC	<b>CS-6</b>	9920-2100
Fitting-No.2 Male Plug (threaded 1/2" NC)	<b>GCM-2-4</b>	9920-2102
Fitting-Double Ball-Point (threaded 1/2"NC)	<b>GCS-40</b>	9920-2103
Cover	<b>24R-MBP</b>	9940-2124

## 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.

MANUAL PRODUCTS

# Switchable Magnetic Products



# Manual Welding Products

Switchable Magnetic Work Holding 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	<b>SMGC200</b>	9255-1060
300	2.26" (57.4 mm)	1.58" (40.1 mm)	2.7" (68.6 mm)	0.61 lbs	10	<b>SMGC300</b>	9255-1061
600	2.6" (66.0 mm)	2.83" (71.9 mm)	4.09" (103.9 mm)	2.0 lbs	5	<b>SMGC600</b>	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	<b>SMMA 300</b>	9255-1064
Switchable Magnetic Multi Angle 400	Holding Power 400 lbs	<b>SMMA 400</b>	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	<b>SMLM 60</b>	9255-1065
Switchable Magnetic Lifter Hook 600	Lift Capacity 200 lbs	<b>SMLH 600</b>	9255-1066

## Switchable Magnetic Right-Angle (90°) 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	<b>SMRA 400</b>	9255-1067

MANUAL PRODUCTS

# EASY FIND GUIDE - Cable Lug Selection Guide

	Style	Amperage Range					Recommended	Page
		50	75	150	225	250		
Cable Lugs	Crimp Lugs for Welding Cable	[Yellow bar from 50 to 150]					T-62	141
		[Yellow bar from 50 to 225]					T-120	141
		[Yellow bar from 50 to 250]					T-3040	141
		[Yellow bar from 50 to 325]					T-40HD	141
	Crimp Lugs for Power Cable	[Blue bar from 50 to 75]					T-810	141
		[Blue bar from 50 to 100]					T-68	141
		[Blue bar from 50 to 100]					T-46	141
	Ball-Point Lugs without Insulated Cover	[Black bar from 50 to 150]					10-45	141
		[Black bar from 50 to 150]					10-180	141
		[Black bar from 50 to 325]					40-45	141
	Ball-Point Lugs with Insulated Cover	[Yellow bar from 50 to 150]					10-45C	141
		[Yellow bar from 50 to 150]					10-180C	141
[Yellow bar from 50 to 325]					40-45C	141		
[Yellow bar from 50 to 325]					40-180C	141		
Heavy Duty Lugs	[Grey bar from 50 to 325]					140-HD-180	141	
	[Grey bar from 50 to 325]					140-HD-180C	141	
	[Grey bar from 50 to 325]					240-HD-180	141	

## Crimp Lugs



## Ball-Point Lugs



## Heavy Duty Lugs



MANUAL PRODUCTS

# Manual Welding Products

Cable Lugs

## TwecoLugs® - Crimp or Solder Type Lugs

(Use Tweco "Lug-Set")



### 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	<b>T-62-50</b>	9520-1115
6 thru 2	150	17/32" (13.5 mm)	.461" (11.7 mm)	5	<b>T-62</b>	9520-1104
1 thru 2/0	225	17/32" (13.5 mm)	.559" (14.2 mm)	50	<b>T-120-50</b>	9520-1116
1 thru 2/0	225	17/32" (13.5 mm)	.559" (14.2 mm)	5	<b>T-120</b>	9520-1105
3/0 & 4/0	250	17/32" (13.5 mm)	.660" (16.7 mm)	25	<b>T-3040-25</b>	9520-1117
3/0 & 4/0	250	17/32" (13.5 mm)	.660" (16.7 mm)	5	<b>T-3040</b>	9520-1107
4/0 Heavy Duty	325	21/32" (17.7 mm)	.776" (19.7 mm)	25	<b>T-40HD-25</b>	9520-1118
4/0 Heavy Duty	325	21/32" (17.7 mm)	.776" (19.7 mm)	5	<b>T-40HD</b>	9520-1109



### 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	<b>T-810</b>	9520-1101
6 thru 8	70	21/64" (8.3 mm)	.289" (7.3 mm)	10	<b>T-68</b>	9520-1102
4 thru 6	90	21/64" (8.3 mm)	.347" (8.8 mm)	10	<b>T-46</b>	9520-1103

### 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	<b>10-45</b>	9515-1100
180° Offset	thru 1/0	150	17/32" (13.5 mm)	1	<b>10-180</b>	9515-1102
45° Angle	thru 4/0	325	17/32" (13.5 mm)	1	<b>40-45</b>	9515-1110
180° Offset	thru 4/0	325	17/32" (13.5 mm)	1	<b>40-180</b>	9515-1112



### 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	<b>10-45C</b>	9515-1101
180° Offset	thru 1/0	150	17/32" (13.5 mm)	1	<b>10-180C</b>	9515-1103
45° Angle	thru 4/0	325	17/32" (13.5 mm)	1	<b>40-45C</b>	9515-1111
180° Offset	thru 4/0	325	17/32" (13.5 mm)	1	<b>40-180C</b>	9515-1113



### 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)	<b>140-HD-180</b>	9515-1120
With Insulated Cover - 180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	5-1/2" (140 mm)	<b>140-HD-180C</b>	9515-1121
180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	4-5/8" (131 mm)	<b>240-HD-180</b>	9515-1122



MANUAL PRODUCTS

## 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	<b>1-MPC</b>	9425-1100
Male Half	Single Ball-Point	4, 2, 1	Pkg. 2 ea. Male Only	<b>1-MPC-1</b>	9425-1110
Female Half	Single Ball-Point	4, 2, 1	Pkg. 2 ea. Female Only	<b>1-MPC-2</b>	9425-1120
Complete Connection	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 1 ea. Male & Female	<b>2-MPC ‡</b>	9425-1200
Complete Connection	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 1 ea. Male & Female	<b>2-MPC-MC**</b>	9425-1201
Male Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Male Only	<b>2-MPC-1 †</b>	9425-1210
Male Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Male Only	<b>2-MPC-1-MC*</b>	9425-1211
Female Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Female Only	<b>2-MPC-2 †</b>	9425-1220
Female Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Female Only	<b>2-MPC-2-MC*</b>	9425-1221
Complete Connection	Double Ball-Point	3/0 or 4/0	Pkg. 1 ea. Male & Female	<b>4-MPC ‡</b>	9425-1400
Complete Connection	Double Ball-Point	3/0 or 4/0	Pkg. 1 ea. Male & Female	<b>4-MPC-MC**</b>	9425-1401
Male Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Male Only	<b>4-MPC-1 †</b>	9425-1410
Male Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Male Only	<b>4-MPC-1-MC*</b>	9425-1411
Female Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Female Only	<b>4-MPC-2 †</b>	9425-1420
Female Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Female Only	<b>4-MPC-2-MC*</b>	9425-1422
Whip Connection	Single Ball-Point	4, 2, 1, 1/0	Pkg. 2 ea.	<b>2-1-MPC</b>	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.

MANUAL PRODUCTS

### Replacement Tapered Machine Plugs



Ball-Point Connection 1-M-T

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	<b>1-M-T</b>	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	<b>2-M-T</b>	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	<b>1R-C</b>	9940-2103
Insulating Cover Only, All 2 & 4 MPC	<b>24R-MBP</b>	9940-2124
Cable Connection Screw, Zinc Plated, All 2-MPC	<b>A-532-24</b>	9910-2124
Cable Connection Screw, Zinc Plated, All 4-MPC	<b>A-14-24</b>	9910-2424
Cover Screw, Zinc Plated, All MPC Connectors	<b>2-5</b>	9940-2125

### Panel Receptacles

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)	<b>1516-BPF</b>	9580-1100
Threaded	No. 1	4, 2, 1, 1/0	5/16" Thread. Stud (7.9 mm)	<b>114-TSF</b>	9580-1101
Threaded	No. 2, 4	1/0, 2/0, 3/0	3/8" Thread. Stud (9.5 mm)	<b>238-TSF</b>	9580-1102
Ball-Point	No. 2, 4	1/0, 2/0, 3/0	9/16" Ball-Point (14.3 mm)	<b>2916-BPF</b>	9580-1103
Threaded	No. 2, 4	1/0, 2/0, 3/0	1/2" - 20 Thread. Stud (12.7 mm)	<b>212-TSF</b>	9580-1104

# Manual Welding Products

Splicers, Terminals and Accessories

## 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	<b>TS-62-50</b>	9610-1105
6 thru 2	150	.461" (11.7 mm)	5	<b>TS-62</b>	9610-1101
1 thru 2/0	225	.599" (15.2 mm)	5	<b>TS-120</b>	9610-1102
3/0 thru 4/0	250	.660" (16.8 mm)	5	<b>TS-3040</b>	9610-1103
4/0 Heavy Duty	325	.776" (19.7 mm)	5	<b>TS-40HD</b>	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	<b>BP-410</b>	9605-1101
1/0 thru 3/0		Ball-Point	1	<b>BP-1030</b>	9605-1103
2/0 thru 4/0		Double Ball-Point	1	<b>BP-2040</b>	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	<b>2-SF-50</b>	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	<b>2-CLC</b>	9505-1811

### Tweco Female Terminals

Stud Hole Size 17/32" (13.5 mm)



1-AF



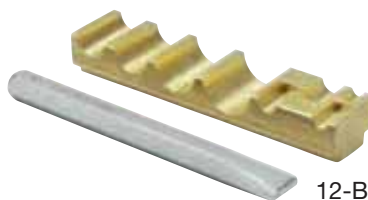
1-OF

Description	Accepts Male Ends	Standard Package	Part No.	Stock No.
45° Angle	1-MPC	1	<b>1-AF</b>	9510-1100
180° Offset	1-MPC	1	<b>1-OF</b>	9510-1101
45° Angle	2-MPC, 4-MPC	1	<b>2-AF</b>	9510-1110
180° Offset	2-MPC, 4-MPC	1	<b>2-OF</b>	9510-1111

## Accessories

### Tweco® "Lug-Set" Block & Punch

For use with TwecoLugs



12-BP

Description	Part No.	Stock No.
Block & Punch	<b>12-BP</b>	9900-1140

### Jacket Stripping Cable Cutting Hand Tool

For use with lugs with an insulated cover



T-908

Description	Part No.	Stock No.
Tweco Cable Cutting Hand Tool	<b>T-908</b>	9900-1190

MANUAL PRODUCTS

## 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 MIG Guns



		WeldSkill WM 250 Amp	WeldSkill WM 400 Amp	WeldSkill WM 500 Amp
<b>Applications</b>		Light-Medium Duty Fabrication	Medium Duty Fabrication	Heavy Duty Fabrication
<b>Standard Options</b>	Rear Connector	■	■	■
	Knucklehead™ Flexible Conductor Tube	■	■	
<b>Output Current</b>		250 Amps	400 Amps	500 Amps
<b>Duty Cycle - CO<sub>2</sub></b>		60%	60%	60%
<b>Wire Diameter</b>		Up to .045" (1.2 mm)	Up to 1/16" (1.6 mm)	Up to 1/16" (1.6 mm)
<b>Process</b>	MIG	■	■	■
	Aluminum	■	■	■



WELDSKILL

# WeldSkill® WM 250 Amp Air-Cooled MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

## 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.

## Miller® Style Rear Connector

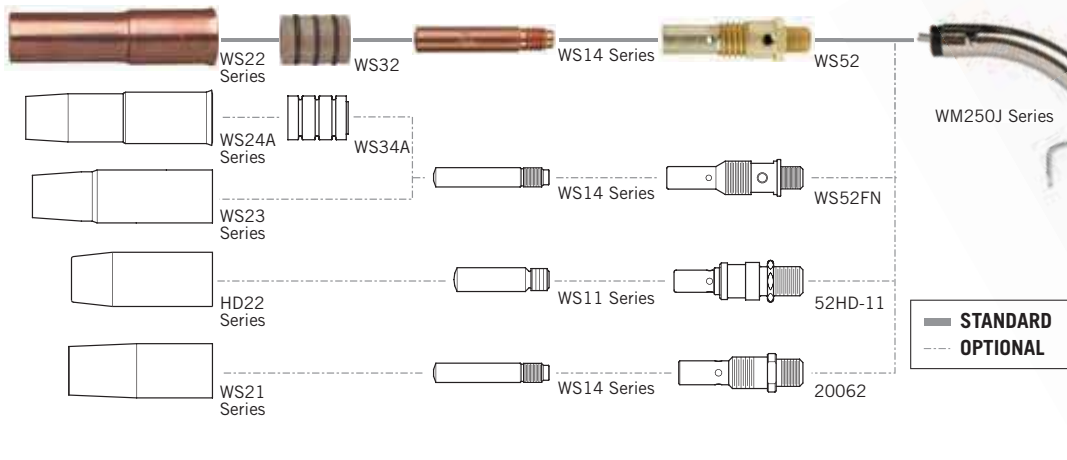
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	WM250M-10-4045	1027-1030
	12 ft (3.6 m)	WM250M-12-4045	1027-1031
	15 ft (4.6 m)	WM250M-15-4045	1027-1032
	15 ft (4.6 m)	WM250M-15-4045K4§	1027-1061
	25 ft (7.6 m)	WM250M-25-4045	1027-1023

Part No. MSAK354 (Stock No. 2642-2470) Control wire assembly furnished.

## 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

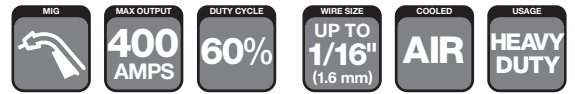
§ Suffix "K4" = Knucklehead Conductor Tube – Part No. 62SFLX480 (Stock No. 1620-1106)



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
250 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light/Medium Duty Fabrication

**EASY FIND 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.



# WeldSkill® WM 400 Amp Air-Cooled MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

## 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
	15 ft (4.6 m)	WM400L-15-116	1047-1082
Up To 1/16" (1.6 mm)	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.

## Miller® Style Rear Connector

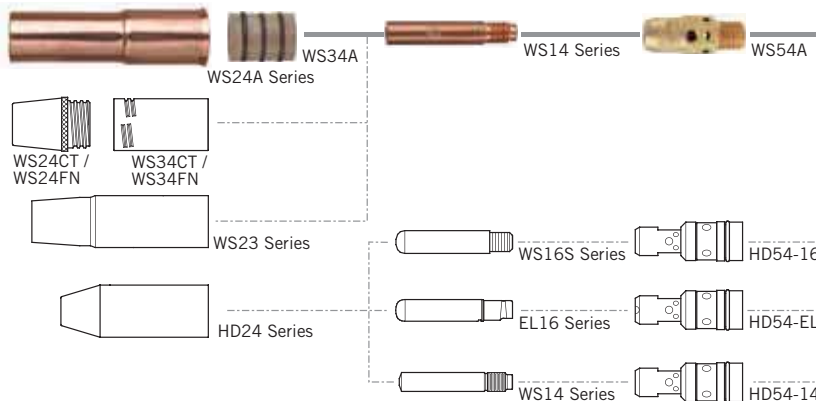
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (4.6 m)	WM400M-15-3545	1047-1027
	12 ft (3.6 m)	WM400M-12-116	1047-1031
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	WM400M-15-116	1047-1032
	15 ft (4.6 m)	WM400M-15-116K4§	1040-1171
	25 ft (7.6 m)	WM400M-25-116	1047-1019

Part No. MSAK354 (Stock No. 2642-2470) Control wire assembly furnished.

## 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
	15 ft (4.6 m)	WM400X-15-116	1047-1057

§ Suffix "K4" = Kucklehead Conductor Tube – Part No. 64SFLX480 (Stock No. 1640-1113)



Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
400 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Medium Duty Fabrication

**EASY FIND 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.

# WeldSkill® WM 500 Amp Air-Cooled MIG Gun



**60% Duty Cycle - CO<sub>2</sub> 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

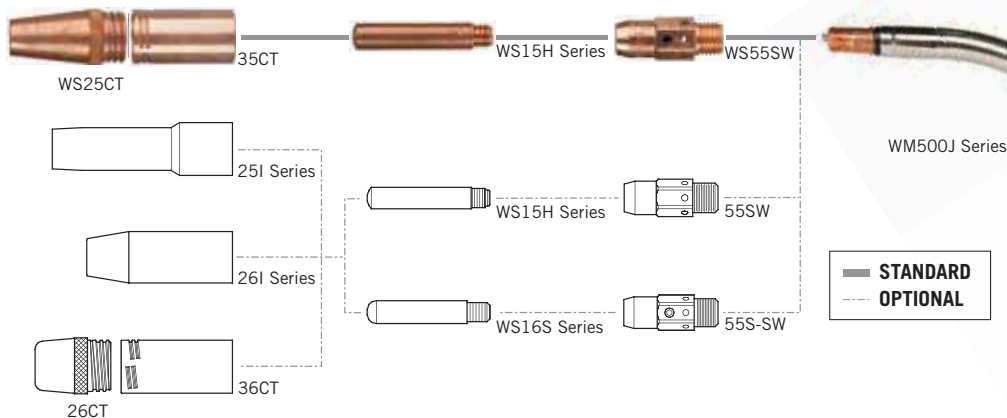
## Lincoln® Style Rear Connector

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.



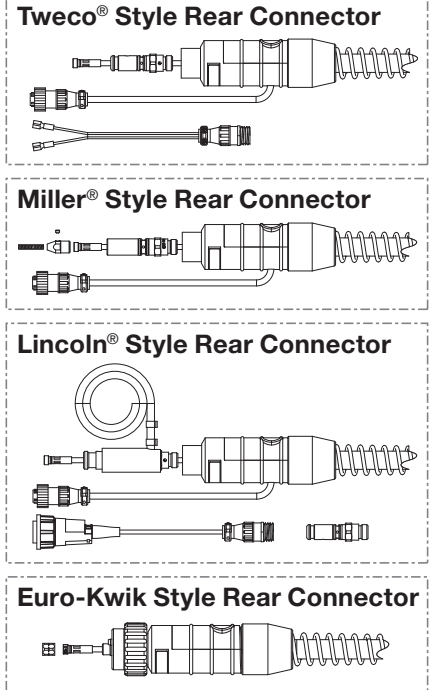
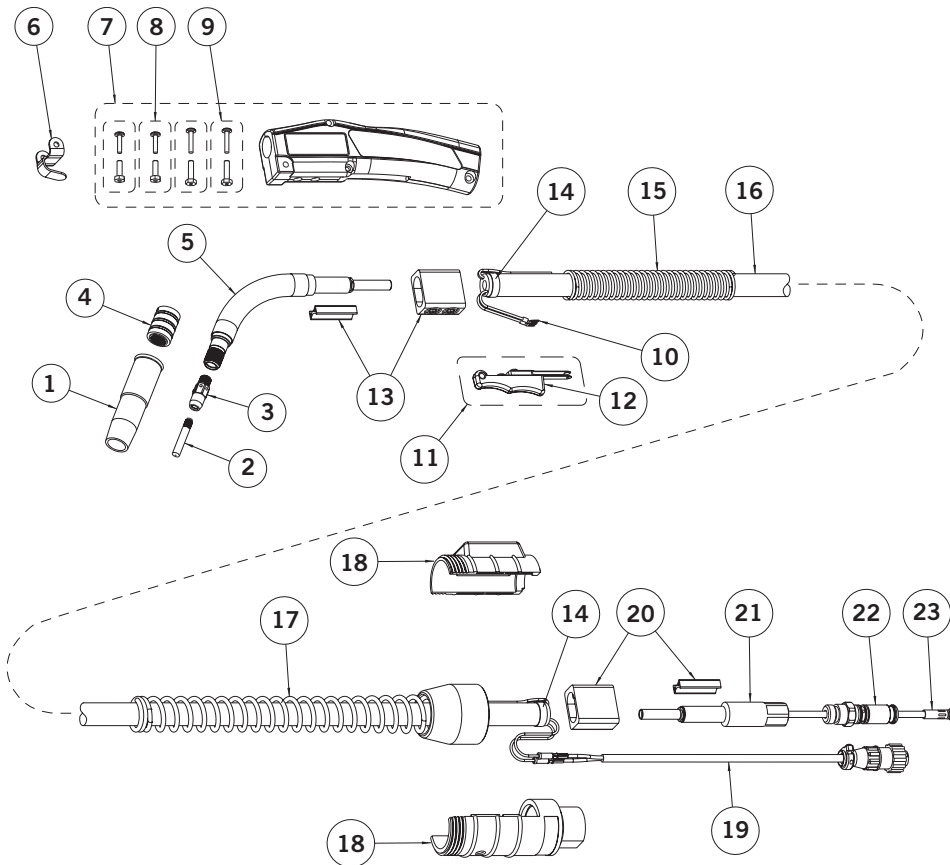
WELDSKILL

Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
500 Amps	60%	CO <sub>2</sub> Carbon Dioxide	Up To 1/16" (1.6 mm)	Air	Heavy Duty Fabrication

**EASY FIND EASY FIND GUIDE**  
See Page 149 for Replacement Parts & Optional Accessories

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# WeldSkill® WM MIG Gun Replacement Parts



#	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	

## 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)	<b>WS11-23</b>	1110-1140	--	--	<b>WS11T-23</b>	1110-1340
.030" (0.8 mm)	.038" (0.97 mm)	<b>WS11-30</b>	1110-1141	--	--	<b>WS11T-30</b>	1110-1341
.035" (0.9 mm)	.044" (1.12 mm)	<b>WS11-35</b>	1110-1142	--	--	<b>WS11T-35</b>	1110-1342
.045" (1.2 mm)	.054" (1.37 mm)	<b>WS11-45</b>	1110-1144	<b>WS11H45</b>	1110-1244	<b>WS11T-45</b>	1110-1344

### WS14, WS14H, & WS14T Series

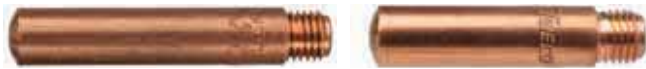
0.25" (6.35 mm) Outside Diameter - .250-28 UNF Threads - 1.50" (38.1 mm) Overall Length  
25 per pack



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)	<b>WS14-30</b>	1140-1166	--	--	<b>WS14T-30</b>	1140-1341
.035" (0.9 mm)	.044" (1.12 mm)	<b>WS14-35</b>	1140-1167	<b>WS14H-35</b>	1140-1242	<b>WS14T35</b>	1140-1342
.040" (1.0 mm)	.048" (1.22 mm)	<b>WS14-40</b>	1140-1168	<b>WS14H-40</b>	1140-1243	--	--
.045" (1.2 mm)	.054" (1.37 mm)	<b>WS14-45</b>	1140-1169	<b>WS14H-45</b>	1140-1244	<b>WS14T-45</b>	1140-1344
.052" (1.3 mm)	.064" (1.65 mm)	<b>WS14-52</b>	1140-1170	<b>WS14H-52</b>	1140-1245	<b>WS14T-52</b>	1140-1345
1/16" (1.6 mm)	.073" (1.85 mm)	<b>WS14-116</b>	1140-1171	<b>WS14H-116</b>	1140-1246	<b>WS14T-116</b>	1140-1346
5/64" (2.0 mm)	.090" (2.29 mm)	<b>WS14-564</b>	1140-1174	<b>WS14H-564</b>	1140-1247	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	<b>WS14A364</b>	1140-1172	<b>WS14AH-364</b>	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)	<b>WS15H-35</b>	1150-1230	--	--	--	--
.045" (1.2 mm)	.054" (1.37 mm)	<b>WS15H-45</b>	1150-1232	--	--	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	<b>WS15H-116</b>	1150-1234	<b>WS15HFC-116</b>	1150-1268	--	--
5/64" (2.0 mm)	.090" (2.29 mm)	<b>WS15H-564</b>	1150-1235	--	--	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	<b>WS15H-332</b>	1150-1238	--	--	--	--
7/64" (2.8 mm)	.120" (3.05 mm)	<b>WS15H-764</b>	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)	<b>WS16S-35</b>	1160-1425	--	--	<b>WS16ST-35</b>	1160-1440
.045" (1.2 mm)	.054" (1.37 mm)	<b>WS16S-45</b>	1160-1426	--	--	<b>WS16ST-45</b>	1160-1441
.052" (1.3 mm)	.064" (1.65 mm)	<b>WS16S-52</b>	1160-1427	--	--	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	<b>WS16S-116</b>	1160-1428	--	--	<b>WS16ST-35</b>	1160-1443
5/64" (2.0 mm)	.090" (2.29 mm)	<b>WS16S-564</b>	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)	<b>WS21-37</b>	1210-1340	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	<b>WS21T-37</b>	1210-1343	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>WS21-50F</b>	1210-1346	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	<b>WS21-50</b>	1210-1341	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS21-62</b>	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)	<b>WS22-37SS</b>	1220-1345	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	<b>WS22T-37SS</b>	1220-1336	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	<b>WS22-50</b>	1220-1341	Standard	Adjustable Recess To Protruding
	1/2" (12.7 mm)	<b>WS22-50SS</b>	1220-1346	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS22-62</b>	1220-1342	Standard	Adjustable Recess To Protruding
	5/8" (15.9 mm)	<b>WS22-62SS</b>	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)	<b>WSHD22-50</b>	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)	<b>WS23-37</b>	1230-1010	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>WS23-50</b>	1230-1011	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	<b>WS23-50F</b>	1230-1016	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS23-62</b>	1230-1012	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS23H-62</b>	1230-1221	Heavy Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS23-75</b>	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)	<b>WS23T-37</b>	1230-1035	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	<b>WS23T-37F</b>	1230-1303	Tapered	Flush To 1/16" (1.6 mm) Tip Recess

# 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)	<b>WS24A-37SS</b>	1240-1559	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	<b>WS24A-50</b>	1240-1555	Standard	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	<b>WS24A-50SS</b>	1240-1560	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS24A-62</b>	1240-1556	Standard	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	<b>WS24A-62SS</b>	1240-1561	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS24AH-62SS</b>	1240-1566	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	<b>WS24A-75</b>	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)	<b>WS24CT-50S</b>	1240-1580	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS24CT-62S</b>	1240-1581	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS24CT-62R</b>	1240-1591	Tapered	1/2" (12.7 mm) Tip Recess
	3/4" (19.5 mm)	<b>WS24CT-75S</b>	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)	<b>WS24FN-50S</b>	1240-1715	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS24FN-62S</b>	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)	<b>WSHD24L-62</b>	1240-1572	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	<b>WSHD24L-62F</b>	1240-1573	Tapered	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	<b>WSHD24-62</b>	1240-1570	Standard (1)	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>WSHD24L-75</b>	1240-1574	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	<b>WSHD24-75</b>	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



Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	<b>WS25CT-50</b>	1250-1439	Standard	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	<b>WS25CT-62</b>	1250-1440	Standard	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	<b>WS25CT-75</b>	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
<b>WS35-50</b>	1500-1140	Brass	WS11 Series	WS21 Series

### WM150 Series

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>WS51</b>	1510-1140	Brass	WS11 Series	WS21 Series

### WM250 Series

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>WS52</b>	1520-1140	Brass	WS14 Series	WS22 Series
<b>WS52FN</b>	1520-1141	Brass	WS14 Series	WS24A , WS23 Series

### WM400 Series

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>WS54A</b>	1540-1145	Brass	WS14 Series	WS24A, WS24CT, & WS23 Series

### WM500 Series

5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
<b>WS55SW*</b>	1550-1140	Copper	WS15H Series	WS25CT Series
<b>WS55H**</b>	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

## 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

### 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

### 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



## 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)	<b>WS532</b>	9110-1180
250	Brass Alloy	3/16" (5.0 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	<b>WS316</b>	9110-1181
300	Brass Alloy	7/32" (5.5 mm)	2/0 (67.4 mm)	10" (253 mm)	<b>WS732</b>	9110-1182
350	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	11" (279 mm)	<b>WS350E</b>	9110-1118
400	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	12" (305 mm)	<b>WS400E</b>	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)	<b>WS200GC</b>	9205-1215
300	1-1/2" (38 mm)	3-1/2" (88 mm)	Through 2/0	8-1/4" (209 mm)	<b>WS300GC</b>	9205-1216
500	2" (50 mm)	4-7/8" (123 mm)	Through 3/0	10" (253 mm)	<b>WS500GC</b>	9205-1217

### Steel Ground Clamps



WS300SGC

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)	<b>WS180SGC</b>	9205-1245
300	2" (50 mm)	2-1/2" (63 mm)	Through 3/0	7-3/4" (196 mm)	<b>WS300SGC</b>	9205-1246
500	2-1/4" (50 mm)	3" (76 mm)	Through 4/0	9-1/2" (241 mm)	<b>WS500SGC</b>	9205-1247

# 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	<b>1-WPC</b>	9425-1125
Connector Male Half Only	4, 2, 1	2	<b>1-WPC-P</b>	9425-1126
Connector Female Half Only	4, 2, 1	2	<b>1-WPC-R</b>	9425-1127
Complete Set of Connectors	1/0, 2/0, 3/0	1	<b>2-WPC</b>	9425-1225
Connector Male Half Only	1/0, 2/0, 3/0	2	<b>2-WPC-P</b>	9425-1226
Connector Female Half Only	1/0, 2/0, 3/0	2	<b>2-WPC-R</b>	9425-1227
Complete Set of Connectors	3/0 or 4/0	1	<b>4-WPC</b>	9425-1425
Connector Male Half Only	3/0 or 4/0	2	<b>4-WPC-P</b>	9425-1246
Connector Female Half Only	3/0 or 4/0	2	<b>4-WPC-R</b>	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	<b>WDC-25</b>	9425-1445
Connector Male Half Only	4, 2, 1	2	<b>WDC-25-P</b>	9425-1446
Connector Female Half Only	4, 2, 1	2	<b>WDC-25-R</b>	9425-1447
Complete Set of Connectors	1/0, 2/0, 3/0	1	<b>WDC-50</b>	9425-1430
Connector Male Half Only	1/0, 2/0, 3/0	2	<b>WDC-50-P</b>	9425-1431
Connector Female Half Only	1/0, 2/0, 3/0	2	<b>WDC-50-R</b>	9425-1432
Complete Set of Connectors	3/0 or 4/0	1	<b>WDC-75</b>	9425-1435
Connector Male Half Only	3/0 or 4/0	2	<b>WDC-75-P</b>	9425-1436
Connector Female Half Only	3/0 or 4/0	2	<b>WDC-75-R</b>	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	<b>WDP-25</b>	9580-1129
Panel fitting accepts WDC-50-P & WDC-75-P	1/0 through 4/0	1	<b>WDP-50</b>	9580-1130

## Miscellaneous Connectors

Description	Part No.	Stock No.
50 mm Dinse Male to Tweco #2 & #4 Positive Cam Connectors	<b>2MDC-CK</b>	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	<b>WS-3040H</b>	9520-1128
225	1 through 2/0	17/32" (13.5 mm)	.559" (14.2 mm)	5	<b>WS-120H</b>	9520-1127
150	6 through 2	17/32" (13.5 mm)	.461" (11.7 mm)	5	<b>WS-62H</b>	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 SENS),

\*\*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**  
an ESAB Brand

**THERMAL  
DYNAMICS**  
an ESAB Brand

**TWECO**  
an ESAB Brand

**STOODY**  
an ESAB Brand

**ARCAIR**  
an ESAB Brand

**TURBOTORCH**  
an ESAB Brand

**Firepower**  
an ESAB Brand

**CIGWELD**  
an ESAB Brand

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.

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## The Americas

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**Sales Office, Latin America**

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**Customer Care**

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# TWECO®

AN ESAB® BRAND



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64-2103 / NA / English / 03-20-17 / Note: Specifications subject to change without notice. Products may vary from those pictured.