

Tweco[®]

MIG GUNS & WELDING ACCESSORIES

CATALOG



Tweco.com

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

Tweco®



This Tweco catalog offers a range of products for different welding applications. For the professional welder who strives to excel in their craft, your work is your reputation, and Tweco offers the quality, performance and robustness that you have come to trust.

For specialized welding, Tweco's innovative solutions will help you push the envelope in those critical applications. For the high production environment, Tweco products provide higher levels of productivity, operator uptime, and performance that you depend on.

For the beginner welder, Tweco offers the versatility to help you execute like a pro for MIG, Stick or TIG welding. With this broad range of products, and with the added support from Customer Care & Technical Service, we continually strive to earn and keep your trust.

The perfect weld leaves a lasting impression. It not only combines metals, but also connects you to those who appreciate a job well done. And those are the bonds to build upon.

Tweco® Advantages

- Excellent performance with high productivity & low downtime
- Trusted brand providing superior durability & robustness
- Exceptional ease of use with operator appeal

Tweco Offers Superior Features & Benefits

- Ergonomic design to reduce operator fatigue
- Engineered for a broad range of applications
- Excellent customer support to answer all your technical questions

Tweco Trust

- Consistent high performance & highly dependable
- Pride in using cutting edge technology
- Stands behind your reputation

Visit Tweco.com



Headquartered in St. Louis, Missouri, USA, Victor Technologies is a global manufacturer dedicated to developing innovative solutions for your cutting, gas control and specialty welding applications.

With a 100-year heritage of authenticity, innovation and a deep connection with end users, our brands include Victor®, Tweco®, Victor® Arcair®, Victor® Thermal Dynamics®, Stoodly®, Victor® TurboTorch®, Firepower® and CIGWELD®.

Table of Contents

MIG Guns & Accessories

MIG Gun Selection Guide	2-3
Spray Master® MIG Gun Series	4-11
Classic No. MIG Gun Series	12-21
Tweco Fusion™ MIG Gun Series	22-27
MINI-MIG	28-29
PulseMaster™ Air-Cooled MIG Gun Series	30-35
TUFF-N-LITE MIG Gun	36-39
Supra® XT MIG Gun Series	40-43
Smoke Master® Fume Extraction MIG Gun Series	44-49
Smoke Collector	47
Tweco Spool Gun Series	50-55
PullMaster™ MIG Gun Series	56-59
PulseMaster Water-Cooled MIG Gun Series	60-65
Tweco Water Coolers	63
Supra Water-Cooled MIG Gun	66-69
Standard Water-Cooled MIG Gun	70-73
Tweco MIG Gun Direct Plug & Control Wire Jumpers	74-75

MIG Welding Consumables

Tweco Velocity™ Consumables	76-77
Contact Tips	78-80
Nozzles	81-88
Gas Diffusers	89-90
Conductor Tubes	91-95
Conduit Liners	96-99

Manual Welding Products & Accessories

Electrode Holders	100-102
Ground Clamps	103-109
Switchable Magnetic Products	107
Connectors & Lugs	110-113

Welding Helmets

WeldSkill®

MIG Guns & Consumables

WeldSkill WM MIG Gun Series	116-121
WeldSkill Consumables	122-126
Contact Tips	122
Nozzles	123-125
Gas Diffusers	125
Conductor Tubes	126
Conduit Liners	126

WeldSkill

Manual Welding Products & Accessories

Electrode Holders	127
Ground Clamps	127
Connectors & Lugs	128

Warranty

Customer Care Numbers

This information is accurate to the best of our knowledge at the time of printing and is subject to change at any time at Tweco's sole discretion.

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 ₂											Tweco Fusion™ 140	Tweco Classic No.1
	.035" (0.9 mm)		CO ₂											Tweco Fusion 180, 220, 250 & Tweco Classic No. 2	Spray Master® 250
	.045" (1.2 mm)		CO ₂											Spray Master 350 & Tweco Classic No. 4	PulseMaster™ Air-Cooled 350, Supra® XT 450, TUFF-N-LITE 350, Smoke Master 450
	.052" (1.3 mm)													Spray Master 450 & Tweco Classic No. 5	PulseMaster Air-Cooled 450, Supra XT 450, Smoke Master®450, Supra Water-Cooled 450
	1/16" (1.6 mm)													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
	.035" (0.9 mm)		Self-shielded											Tweco Fusion 180, 220, 250	Tweco Classic No. 2
	.045" (1.2 mm)		Self-shielded											Tweco Fusion 220, 250, Spray Master 350	Tweco Classic No. 2, Supra XT 450
	.052" (1.3 mm)													Spray Master 450, Tweco Classic No. 4	Supra XT 450
	1/16" - 5/64" (1.6 - 2.0 mm)													Spray Master 450, Tweco Classic No. 5	Supra XT 450
	3/32" (2.4 mm)													Tweco Classic No.6	Tweco Classic No. 5

*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
	.035" (0.9 mm)		Argon											Spool Gun 300	PulseMaster Air-Cooled 350, Tweco Classic No.2,
	3/64" (1.2 mm)													PulseMaster Air-Cooled 350 & Tweco Fusion 250	PullMaster™ 300, Classic No.3, TUFF-N-LITE 350
	1/16" (1.6 mm)													PulseMaster Air-Cooled 450 & Spray Master 350	PullMaster 300, Classic No.4, TUFF-N-LITE 350
	3/32" (2.4 mm)													PulseMaster Air-Cooled 450 & Spray Master 450	PullMaster 300, PulseMaster Water-Cooled 500, Tweco Classic No.4, Supra Water-Cooled 450

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.

Which MIG Gun Is Right For You?

Tweco® offers a broad range of MIG gun families to meet the everyday needs of the welder.

- Amperage Range
- Lengths
- Handle Design
- Rear End Connections
- Air-Cooled or Water-Cooled

	Amperage Range	Available Lengths (ft)	Handle Design	Cable/hose Connection	Rear End Connector Options	Air-Cooled/ Water-Cooled	Special Features
Spray Master®	250, 350, 450	10, 12, 15, 20, 25	Small & Ergonomic	Crimped	Tweco®, Miller®, Lincoln®, Euro-Kwik	Air	Heavy-Duty Front End Consumables
Tweco Classic No.	160, 180, 200, 300, 400, 500, 600	10, 12, 15, 20, 25	Oval/ Paddle Contour	Mechanical	Tweco, Miller, Lincoln, Euro-Kwik	Air	Wide Range of Front End Consumables
Tweco Fusion™	140, 180, 220, 250	10, 12, 15	Small & Ergonomic	Crimped	Tweco, Miller, Lincoln, Euro-Kwik	Air	Longer life Velocity consumables
PulseMaster™	350, 450	12, 15	Small & Ergonomic	Crimped	Tweco, Euro-Kwik	Air	Smart Option or Standard
TUFF-N-LITE	350	15	Straight	Mechanical	Tweco, Miller	Air	Top Trigger Capability
SUPRA® XT	450	15	Straight	Mechanical	Tweco, Miller, Lincoln	Air	Top Trigger Capability
Smoke Master®	250, 450	15	Ergonomic	Crimped	Tweco, Miller, Lincoln	Air	Fume Extraction Cam-Style Contact Tips
Tweco Spool Gun	160, 200, 300	12, 25	Pistol Grip	Mechanical	Dinse Lug	Air	Accepts Standard 4" Spools Rotatable Wire Spool Housing
PullMaster™	300	33, 50	Pistol Grip	Crimped	Tweco	Air	Smart Option or Standard
PulseMaster	400, 500	12, 15	Ergonomic	Crimped	Tweco	Water	Smart Option or Standard
SUPRA	450	10, 12, 15	Oval/ Paddle Contour	Crimped	Tweco, Miller	Water	Quick Water Connections
Standard Water-cooled	600	10, 12, 15	Ergonomic	Crimped	Tweco	Water	Inert Gas Style Fitting

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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Spray Master® MIG Gun Series

Features & Benefits

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Extended trigger length to reduce radiated heat
- Conductor tube can be rotated easily for different welding positions
- Ergonomic handle

FIELD REPAIRABLE

- Split-half handle case provides access for ease of repair
- Field repairable mechanical cable connections for Cablehoz®
- Spare trigger leads in Cablehoz

LOWER HEAT IN THE HANDLE AND CONDUCTOR TUBE

- Heavy wall conductor tube and front Cablehoz connection (crimped) for improved electrical conductivity and lower heat in the front end
- Heavy-duty contact tip and diffuser for improved performance in high heat applications

STANDARD GUN CONFIGURATIONS OPTIONS

- Standard trigger "on/off" operation
- Optional dual schedule and locking trigger

WIDE WELDING APPLICATIONS

- Spray transfer mode & pulse welding
- Straight CO₂ or mixed gases

LOWER INVENTORY CARRYING COSTS

- Interchangeable front end consumables between Tweco® Classic No. Series and Tweco Spray Master series



MODEL	OUTPUT			PROCESS				STANDARD OPTIONS						APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Flux Cored Gas Shielded	Flux Cored Self Shielded	Dual Schedule	Locking Trigger	Rear Connector	Eliminator Front End Consumables	Long Reach Conductor Tube	Knucklehead™ Flexible Conductor Tube	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
Spray Master 250 Amp	250	80%	Up to .045" (1.2 mm)	●	●	●	●			●	●			●	●	
Spray Master 350 Amp	350	80%	Up to 1/16" (1.6 mm)	●	●	●	●	●		●			●		●	●
Spray Master 450 Amp	450	80%	Up to 1/16" (1.6 mm)	●	●	●	●	●	●	●		●	●			●

Spray Master® MIG Gun Series

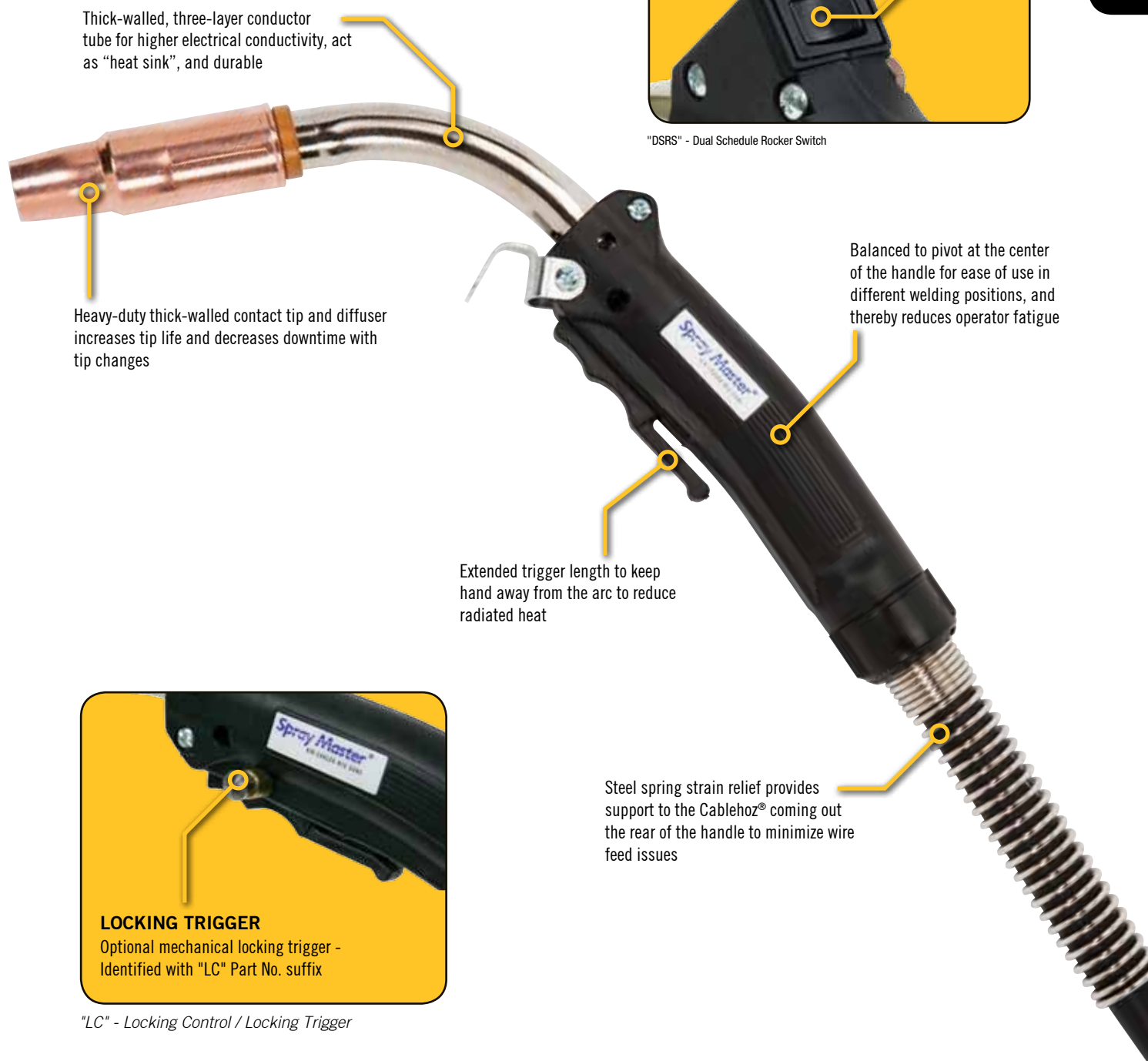
Handle Design & Style

PERFORMANCE

DURABILITY

EASE OF USE

MIG GUNS



SPRAY MASTER® SERIES

Self Shielded. Available with Rear Connector and Knucklehead™ Flexible Conductor Tube as standard Conductor Tube – Part No. MS63-60 (Stock No. 1630-1189) on all guns up to 15 ft (5 m):

6

Spray Master® 350 Amp

80% Duty Cycle,
Mixed Gases

Process – MIG, Aluminum, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Dual Schedule, Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for medium/heavy duty fabrication. Standard Conductor Tube – Part No. MS63-60 (Stock No. 1630-1189) on all guns up to 15 ft (5 m); Part No. MS63-45 (Stock No. 1630-1188) on all guns over 15 ft (5 m); Conduit Liner – 42 Series



Tweco® Style Rear Connector

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

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	MS310-116	1036-1610
	12 ft (4 m)	MS312-116	1036-1613
	15 ft (5 m)	MS315-116	1036-1615
	15 ft (5 m)	MS315-116K4	1036-1715
	15 ft (5 m)	MS315-116DSRS	1036-1721

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 (4 m)	MS312M-116	1036-1638
	15 ft (5 m)	MS315M-116	1036-1640
	15 ft (5 m)	MS315M-116K4	1036-1716
	25 ft (8 m)	MS325M-116	1036-1642

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (4 m)	MS312L-116	1036-1646
	15 ft (5 m)	MS315L-116	1036-1647
	15 ft (5 m)	MS315L-116K4	1036-1717
	15 ft (5 m)	MS315L-116DSRS	1036-1722
	15 ft (5 m)	MS315L-116DSRS	1036-1722

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.

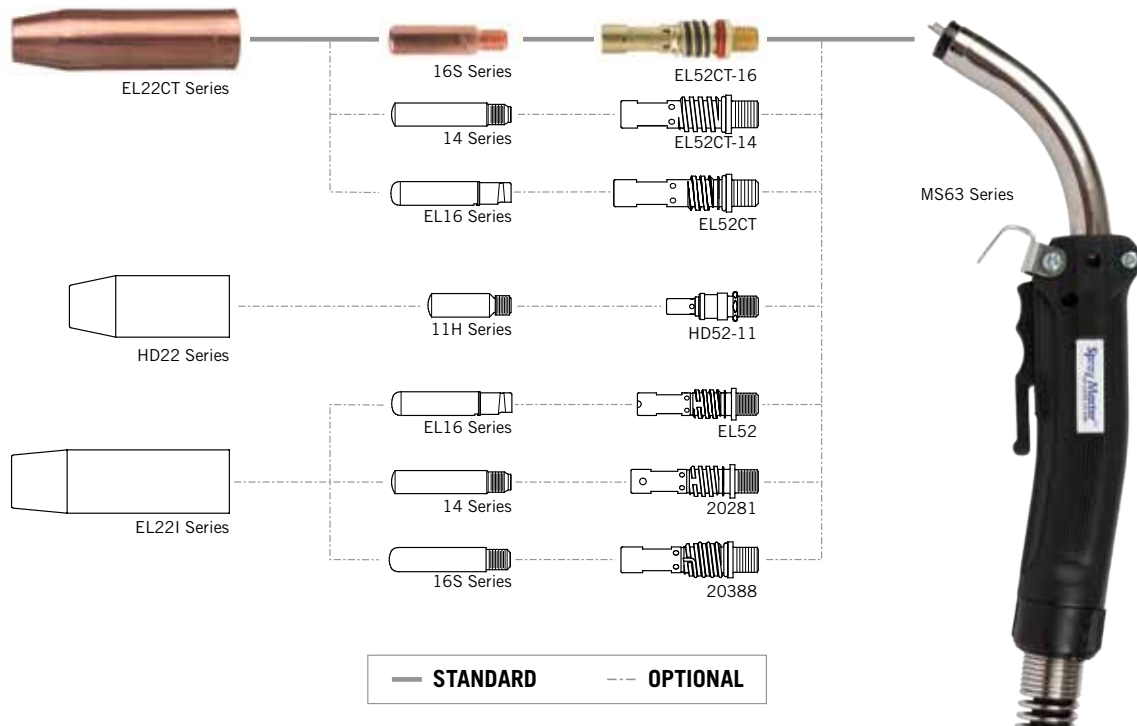
Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (5 m)	MS315X-116	1036-1623

Suffix "K4" = Knucklehead Conductor Tube – Part No. MS63SFLX4-80

(Stock No. 1630-1198);

"DSRS" = Dual Schedule Rocker Switch



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Tweco



MIG Guns

SPRAY MASTER® SERIES

Spray Master® 450 Amp

80% Duty Cycle,
Mixed Gases

Process – MIG, Aluminum, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Dual Schedule, Locking Trigger, Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for heavy duty fabrication. Standard Conductor Tube – MS64H-60 (Stock No. 1640-1319) on all guns up to 15 ft (5 m); MS64H-45 (Stock No. 1630-1318) on all gun over 15 ft (5 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 (4 m)	MS412-116	1040-1051
	15 ft (5 m)	MS415-116	1040-1052
	15 ft (5 m)	MS415-116K4	1040-1530
	15 ft (5 m)	MS415-116LM	1040-1053
	20 ft (6 m)	MS420-116	1040-1059
	25 ft (8 m)	MS425-116	1040-1058

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	MS410M-116	1040-1060
	12 ft (4 m)	MS412M-116	1040-1061
	15 ft (5 m)	MS415M-116	1040-1062
	15 ft (5 m)	MS415M-116K4	1040-1531
	15 ft (5 m)	MS415M-116DSRS	1040-1536
	15 ft (5 m)	MS415M-116LC	1040-1092
	15 ft (5 m)	MS415M-116LM	1040-1063
	20 ft (6 m)	MS420M-116	1040-1064
	25 ft (8 m)	MS425M-116	1040-1068

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

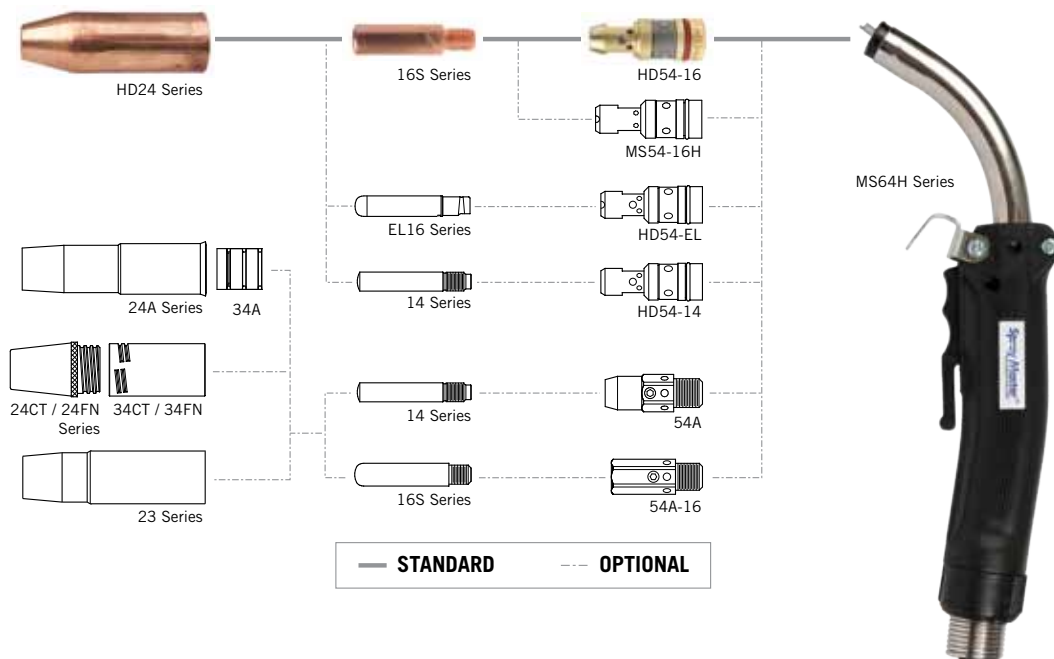
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (5 m)	MS415L-116	1040-1072
	15 ft (5 m)	MS415L-116K4	1040-1533
	15 ft (5 m)	MS415L-116DSRS	1040-1538
	15 ft (5 m)	MS415L-116LC	1040-1074
	15 ft (5 m)	MS415L-116LM	1040-1073
	25 ft (8 m)	MS425L-116	1040-1071

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

Euro-Kwik Style Rear Connector

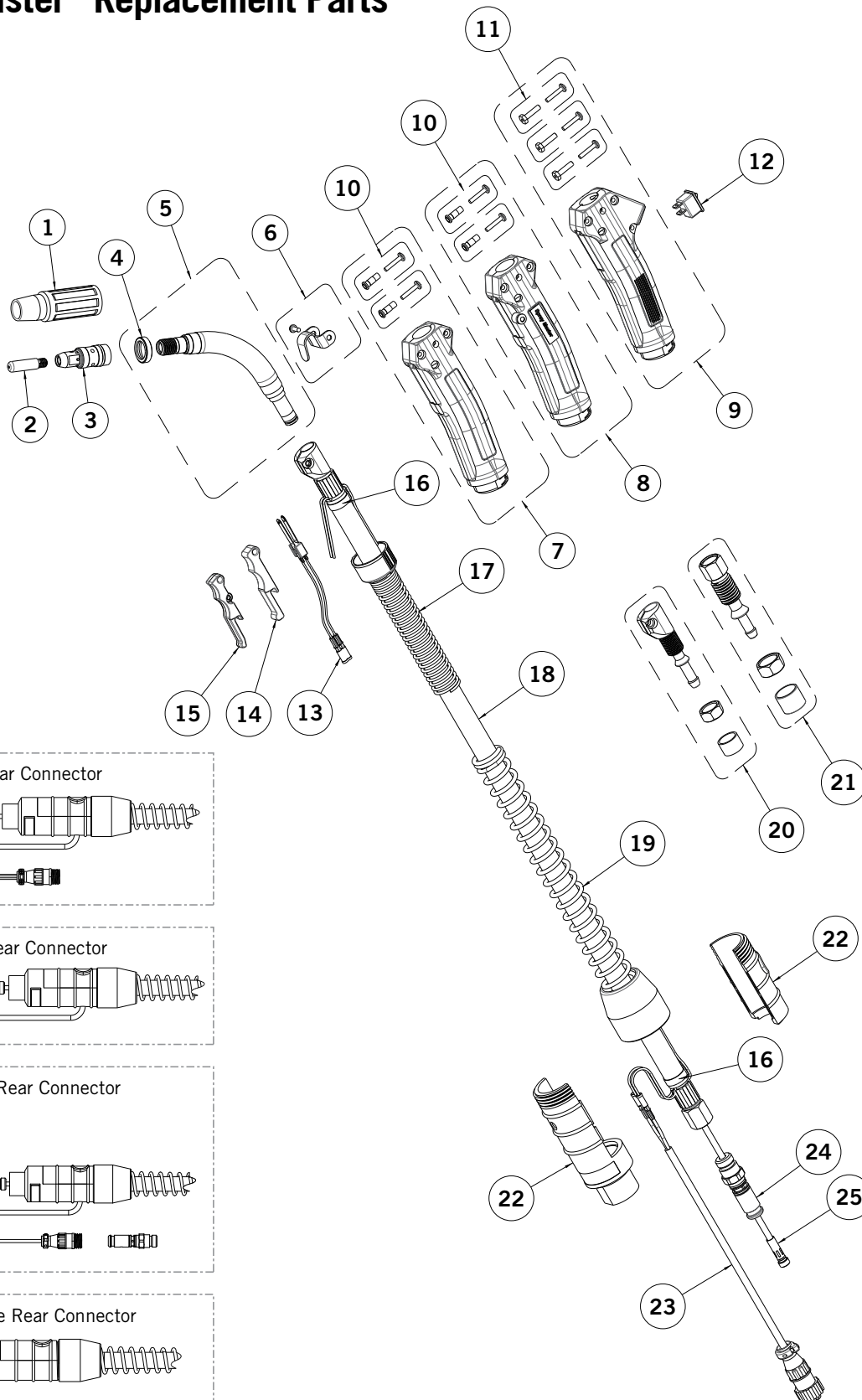
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (4 m)	MS412X-116	1040-1076
	15 ft (5 m)	MS415X-116	1040-1077

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)

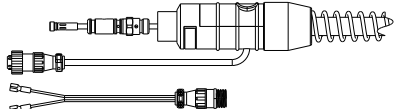


Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

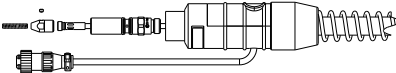
Spray Master® Replacement Parts



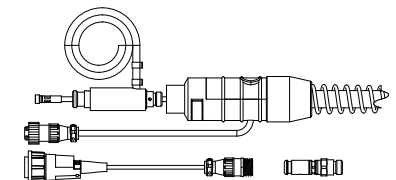
Tweco Style Rear Connector



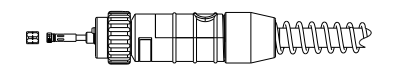
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Spray Master® Replacement Parts

#	Description	250 Amp		350 Amp		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 Cablehoz® Assembly (Direct Plug)	MS210	1720-2115	MS310	1730-2035	MS410	1740-2115
	12 ft Cablehoz Assembly (Direct Plug)	MS212	1720-2116	MS312	1730-2036	MS412	1740-2116
	15 ft Cablehoz Assembly (Direct Plug)	MS215	1720-2117	MS315	1730-2037	MS415	1740-2117
	25 ft Cablehoz Assembly (Direct Plug)	MS225	1720-2118	MS325	1730-2038	MS425	1740-2118
	10 ft Cablehoz Assembly (Euro)	MS210X	1720-2106	MS310X	1730-2010	MS410X	1740-2121
	12 ft Cablehoz Assembly (Euro)	MS212X	1720-2107	MS312X	1730-2011	MS412X	1740-2122
	15 ft Cablehoz Assembly (Euro)	MS215X	1720-2108	MS315X	1730-2012	MS415X	1740-2123
	25 ft 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 and 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 74-75		Refer to Pages 74-75		Refer to Pages 74-75	
25	Conduit Assembly	Refer to Pages 96-99		Refer to Pages 96-99		Refer to Pages 96-99	
NS	Protective Cable Wrap, 50 ft (15 m) per box	TCR50	9900-1150	TCR50	9900-1150	TCR50	9900-1150

Classic No. MIG Gun Series

Features & Benefits

OPERATOR APPEAL

- Industry standard for 40+ years
- 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

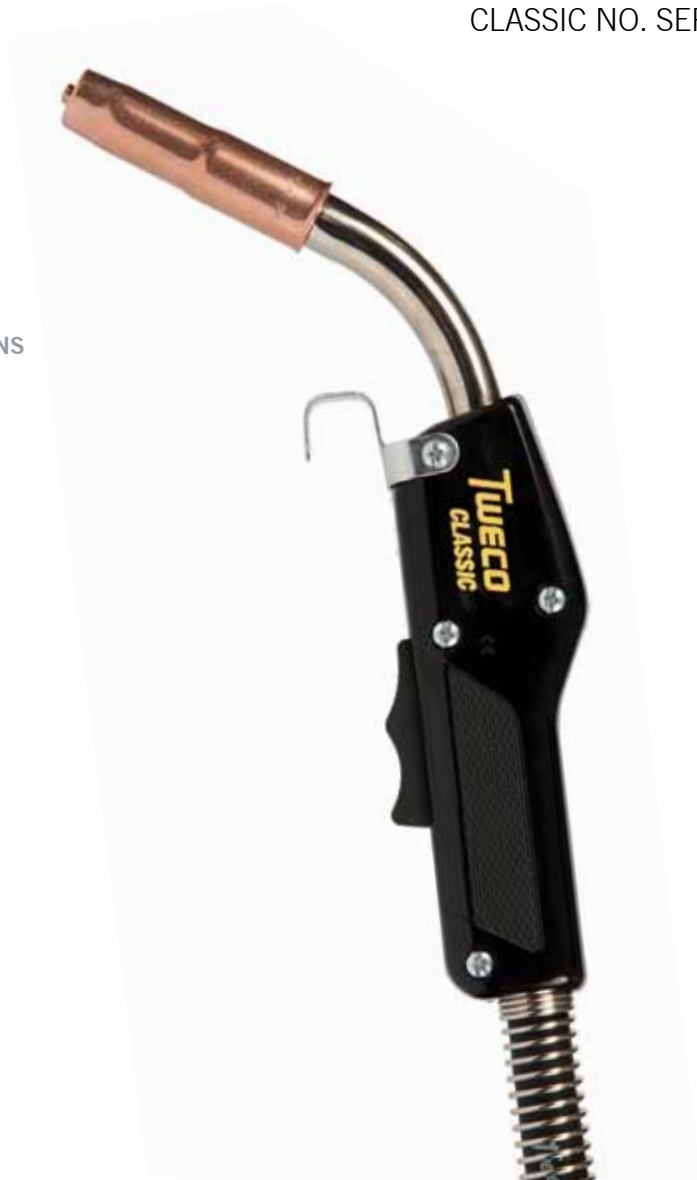
- Split-half handle case provides access for ease of repair
- Easily repair Cablehoz® - no additional connectors required

IMPROVED PERFORMANCE WITH LONGER LIFE CONSUMABLES

- Wide selection of front end consumables available
- Heavy-duty contact tips in high heat applications offered

LOWER INVENTORY CARRYING COSTS

- Interchangeable front end consumables between Tweco® Spray Master® series and Tweco Classic No. Series



MODEL	OUTPUT			PROCESS				STANDARD OPTIONS			APPLICATION		
	Current (Amps)	Duty Cycle CO2	Wire Diameter in (mm)	MIG	Aluminum	Flux Cored Gas Shielded	Flux Cored Self Shielded	Dual Schedule	Rear Connector	Knucklehead™ Flexible Conductor Tube	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
Classic No. 1	180	60%	Up to .045" (1.2 mm)	●	●				●		●		
Classic No. 2	200	60%	Up to .045" (1.2 mm)	●	●				●	●		●	
Classic No. 3	300	60%	Up to 1/16" (1.6 mm)	●	●				●			●	●
Classic No. 4	400	60%	Up to 5/64" (2.0 mm)	●	●	●		●	●	●		●	●
Classic No. 5	500	60%	Up to 3/32" (2.4 mm)	●		●	●		●				●
Classic No. 6	600	60%	Up to 3/32" (2.4 mm)	●		●	●		●				●

Classic No. Series

Handle Design & Style

PERFORMANCE

DURABILITY

EASE OF USE

Wide selection of front end consumables available to fit the needs of the application

Gun hanger located at the bottom for ease of resting gun when not in use

Industry standard for 40+ years, oval shaped handle reduces grip required to manipulate MIG gun position

Balanced to pivot at the center of the handle for ease of use in different welding positions, and thereby reduces operator fatigue

Heavy-duty design for industrial application environments using special plastic composition for high impact crush-resistant handle

Steel spring strain relief provides support to the Cablehoz® coming out the rear of the handle to minimize wire feed issues

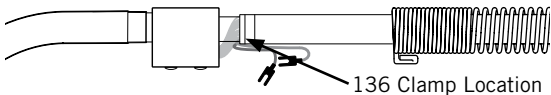
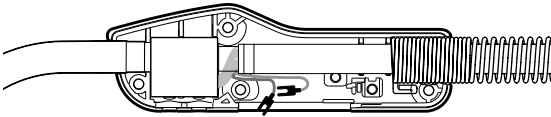
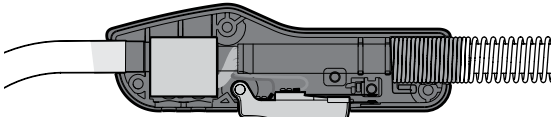
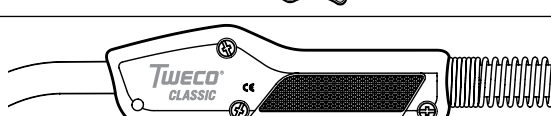
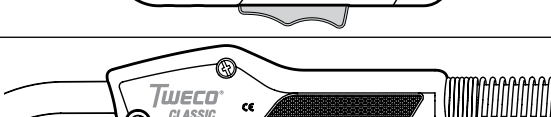
Mechanical connection of conductor tube and Cablehoz® within the handle providing excellent current path to the end of the contact tip

Two (2) ball-point screws are used to secure the Cablehoz® and conductor tube in place

Trigger contains silver plated contacts with a self cleaning action every time the trigger is engaged & disengaged

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 - 136T00L 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

Classic No. 1

180 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as a standard options Suitable for light duty fabrication. Standard Conductor Tube – 61-60 (Stock No. 1610-1102) on all guns up to 15 ft (5 m); 61-45 (Stock No. 1610-1101) on all gun over 15 ft (5 m); Conduit Liner – 42 Series



Tweco® Style Rear Connector

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

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	110-3035	1010-1111
	12 ft (4 m)	112-3035	1010-1112
	15 ft (5 m)	115-3035	1010-1113
	20 ft (6 m)	120-3035	1010-1114
Up To .045" (1.2 mm)	15 ft (5 m)	115-4045	1010-1123
	20 ft (6 m)	120-4045	1010-1124

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	M110-3035	1010-1131
	12 ft (4 m)	M112-3035	1010-1133
	15 ft (5 m)	M115-3035	1010-1135

Lincoln® Style Rear Connector

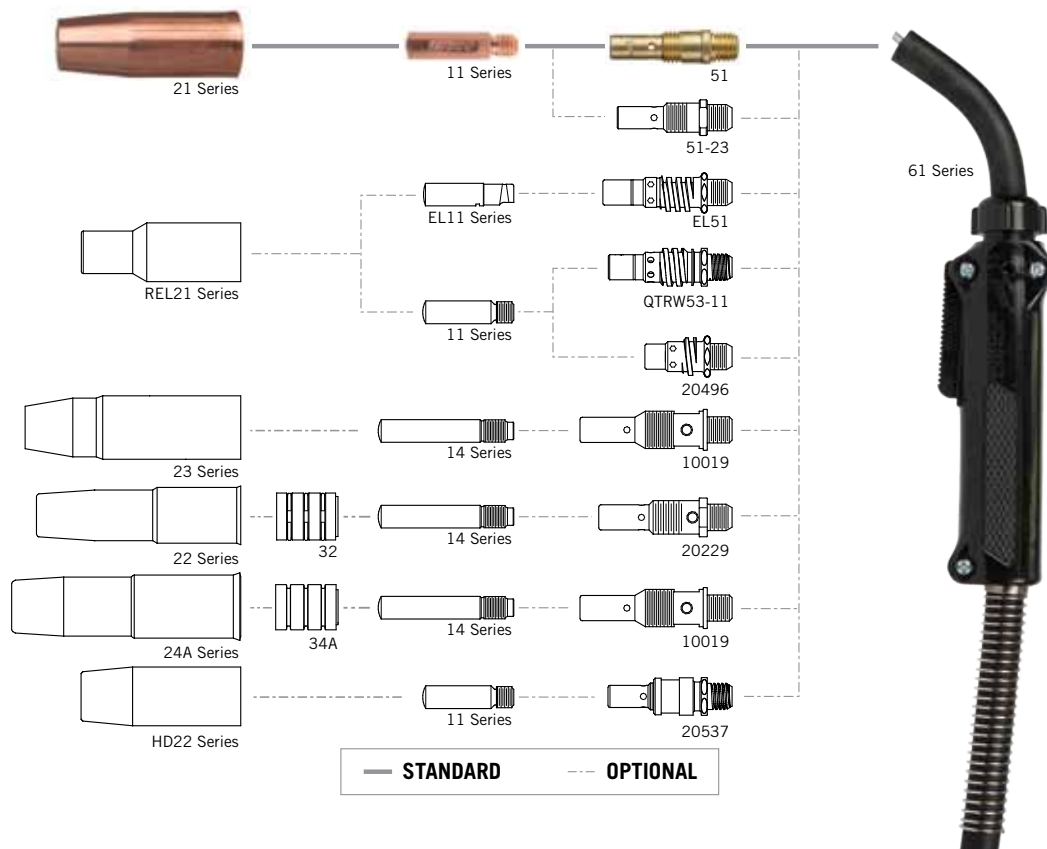
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (5 m)	L115-3035	1010-1145

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

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	X112-4045	1010-1622
	15 ft (5 m)	X115-4045	1010-1623



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Classic No. 2

200 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for medium fabrication. Standard Conductor Tube – 61-60 (Stock No. 1610-1102) on all guns up to 15 ft (5 m); 61-45 (Stock No. 1610-1101) on all gun over 15 ft (5 m); Conduit Liner – 42 Series

Tweco® Style Rear Connector

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

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	210-3035	1020-1111
	12 ft (4 m)	212-3035	1020-1112
	15 ft (5 m)	215-3035	1020-1113
	20 ft (6 m)	220-3035	1020-1114
	25 ft (8 m)	225-3035	1020-1115
Up To .045" (1.2 mm)	12 ft (4 m)	212FN-4045†	1020-1322
	15 ft (5 m)	215-4045	1020-1123
	15 ft (5 m)	215-4045K4**	1020-1660
	25 ft (8 m)	225-4045	1020-1125

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	M210-3035	1020-1130
	12 ft (4 m)	M212-3035	1020-1132
	15 ft (5 m)	M215-3035	1020-1134
Up To .045" (1.2 mm)	10 ft (3 m)	M210-4045	1020-1131
	12 ft (4 m)	M212-4045	1020-1133
	15 ft (5 m)	M215-4045	1020-1135
	15 ft (5 m)	M215-4045K4**	1020-1661

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 (4 m)	L212-3035	1020-1142
	15 ft (5 m)	L215-3035	1020-1144

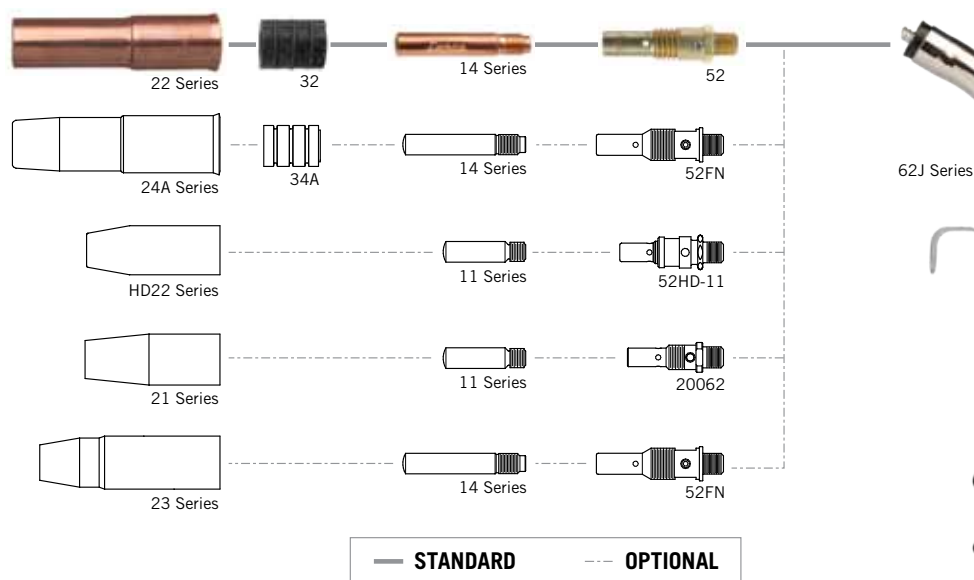
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	X212-4045	1020-1622
	12 ft (4 m)	X212FN-4045†	1020-1652
	15 ft (5 m)	X215-4045	1020-1623

† 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). Insulated conductor tube – Part No. 62A-60 (Stock No. 1620-1102). Insulated conductor tube – Part No. 62A-60 (Stock No. 1620-1102).

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



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Classic No. 3

300 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as standard options. Suitable for medium/heavy duty fabrication. Standard Conductor Tube – 63J-60 (Stock No. 1630-1111) on all guns up to 15 ft (5 m); 63J-45 (Stock No. 1630-1110) on all gun over 15 ft (5 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 (4 m)	312-3545	1030-1102
	15 ft (5 m)	315-3545	1030-1103
	20 ft (6 m)	320-3545	1030-1104
	25 ft (8 m)	325-3545	1030-1105
Up To 1/16" (1.6 mm)	15 ft (5 m)	315-116	1030-1113
	25 ft (8 m)	325-116	1030-1115

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	M310-3545	1030-1130
	12 ft (4 m)	M312-3545	1030-1133
	15 ft (5 m)	M315-3545	1030-1136

Lincoln® Style Rear Connector

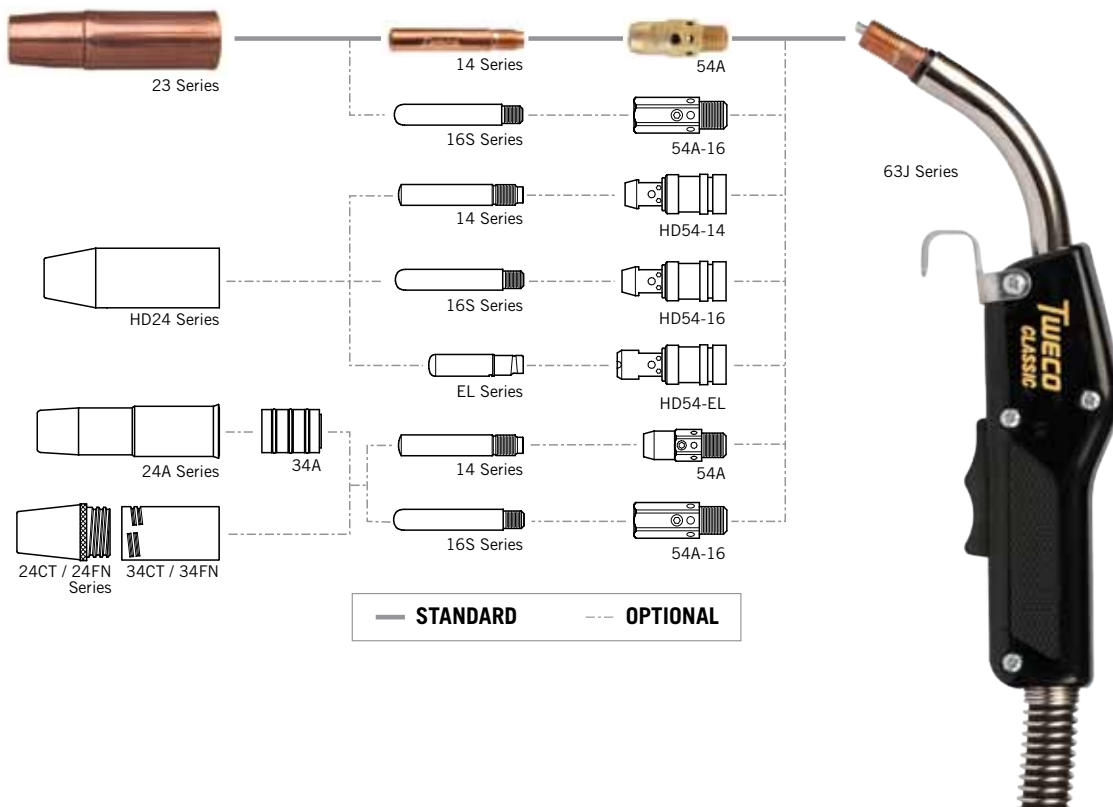
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (5 m)	L315-3545	1030-1146

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

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	X312-3545	1030-1602



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Classic No. 4

400 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum, Flux Cored Gas Shielded. Available with Dual Schedule, Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for medium/heavy duty fabrication. Standard Conductor Tube – 64J-60 (Stock No. 1640-1106) on all guns up to 15 ft (5 m); 64J-45 (Stock No. 1640-1105) on all gun over 15 ft (5 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)	410-3545	1040-1101
	12 ft (4 m)	412-3545	1040-1102
	15 ft (5 m)	415-3545	1040-1103
	15 ft (5 m)	DS415-3545	1040-1503
	20 ft (6 m)	420-3545	1040-1104
	25 ft (8 m)	425-3545	1040-1105
Up To 1/16" (1.6 mm)	10 ft (3 m)	410-116	1040-1111
	12 ft (4 m)	412-116	1040-1112
	15 ft (5 m)	415-116	1040-1113
	20 ft (6 m)	420-116	1040-1114
	25 ft (8 m)	425-116	1040-1115
5/64" (2.0 mm)	15 ft (5 m)	415-564	1040-1123

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	M410-3545	1040-1130
	12 ft (4 m)	M412-3545	1040-1133
	15 ft (5 m)	M415-3545	1040-1136
	15 ft (5 m)	M415-3545K4	1040-1688
	20 ft (6 m)	M420-3545	1040-1126
	25 ft (8 m)	M425-3545	1040-1129
Up To 1/16" (1.6 mm)	10 ft (3 m)	M410-116	1040-1131
	12 ft (4 m)	M412-116	1040-1134
	15 ft (5 m)	M415-116	1040-1137
	20 ft (6 m)	M420-116	1040-1127
	25 ft (8 m)	M425-116	1040-1128
5/64" (2.0 mm)	15 ft (5 m)	M415-564	1040-1138

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 (4 m)	L412-3545	1040-1143
	15 ft (5 m)	L415-3545	1040-1146
	15 ft (5 m)	L415-3545K4	1040-1689
Up To 1/16" (1.6 mm)	15 ft (5 m)	L415-116	1040-1147

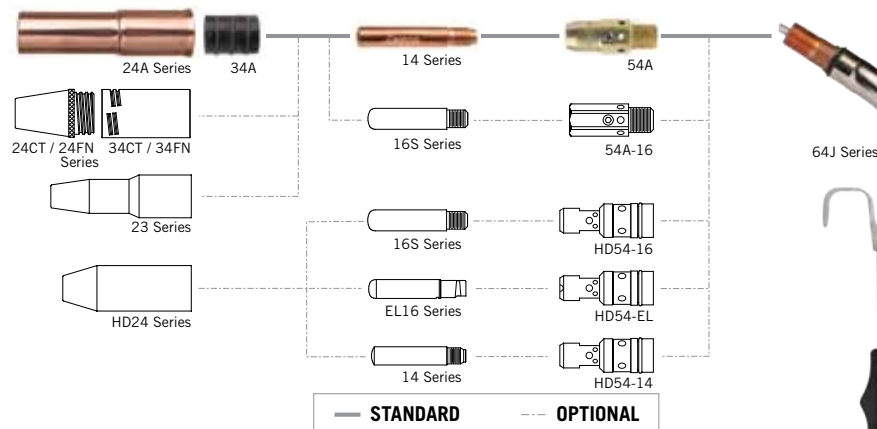
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	X412-3545	1040-1602
	15 ft (5 m)	X415-3545	1040-1603
	25 ft (8 m)	X425-3545	1040-1605
Up To 1/16" (1.6 mm)	15 ft (5 m)	X415-116	1040-1613

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

Prefix "DS" = Dual Schedule



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Classic No. 5

500 Amp

60% Duty Cycle, CO₂ (Carbon Dioxide)

Process – MIG, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Dual Schedule, Locking Trigger, and Rear Connector as standard options. Suitable for heavy duty fabrication. Standard Conductor Tube – 66J-60 (Stock No. 1660-1826); 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 (5 m)	515-116	1050-1113
	25 ft (8 m)	525-116	1050-1115
3/32" (2.4 mm)	10 ft (3 m)	510-332	1050-1131
	15 ft (5 m)	515-332	1050-1133

Lincoln® Style Rear Connector

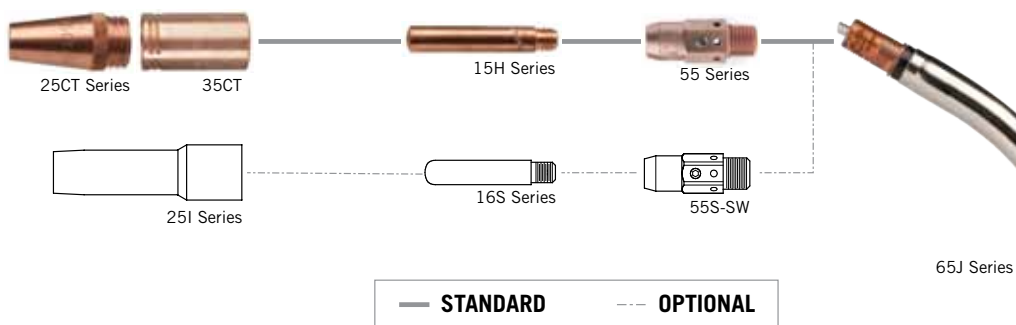
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
3/32" (2.4 mm)	15 ft (5 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 (5 m)	M515-116	1050-1173



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Classic No.6

600 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Rear Connector as a standard option. Suitable for heavy duty fabrication. Standard Conductor Tube – 66J-60 (Stock No. 1660-1826); Conduit Liner – 45 Series



MIG GUNS

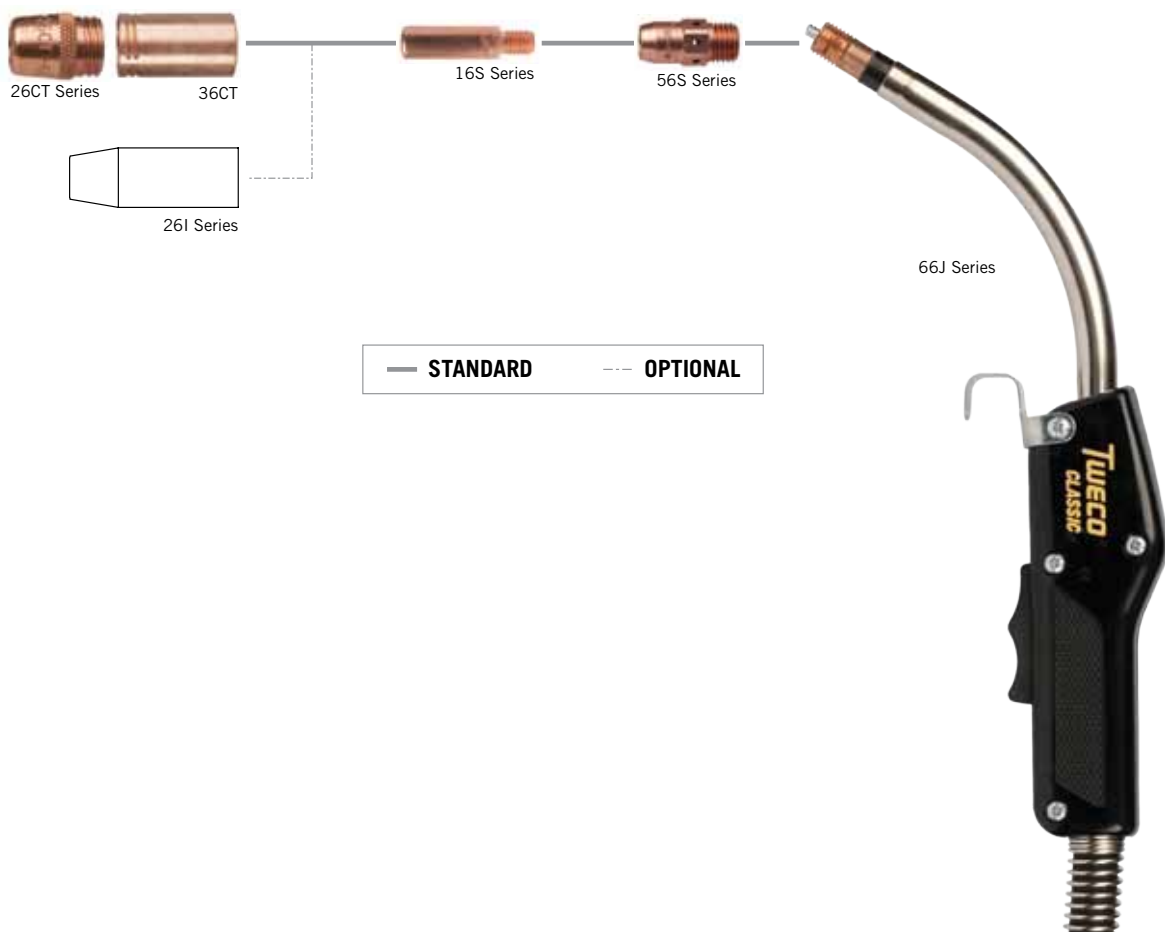
Tweco® Style Rear Connector

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

Wire Size	Length	Part No.	Stock No.
3/32" (2.4 mm)	15 ft (5 m)	615-332	1060-1217

Miller® Style Rear Connector

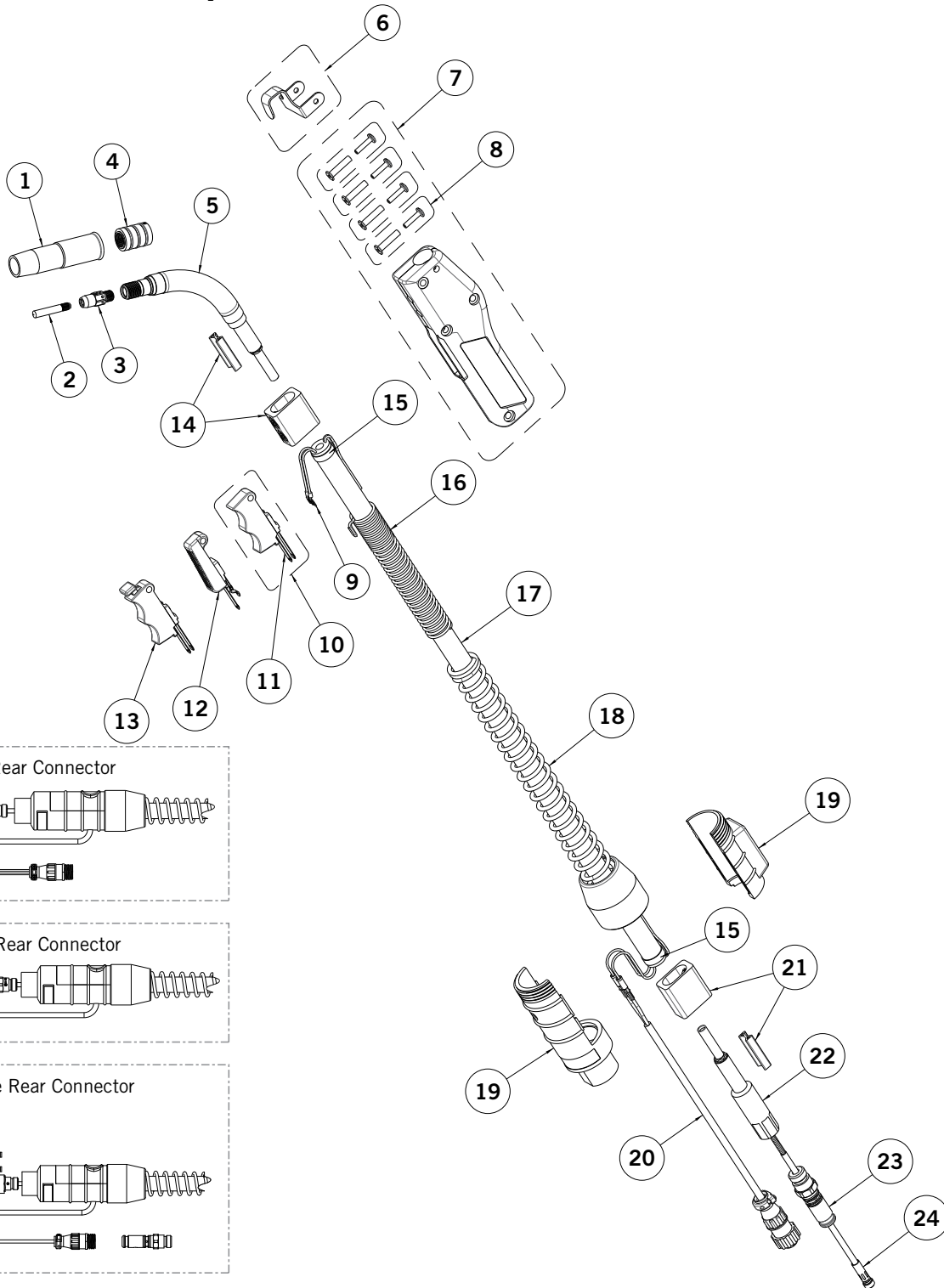
Wire Size	Length	Part No.	Stock No.
3/32" (2.4 mm)	15 ft (5 m)	M615-332	1060-1242



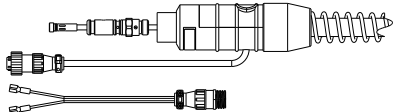
Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Classic No. Series Replacement Parts

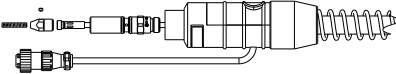
MIG GUNS



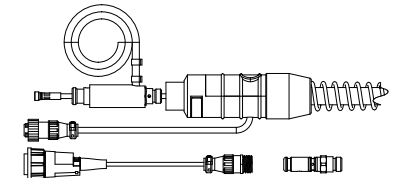
Tweco Style Rear Connector



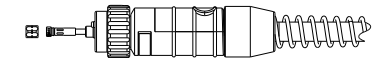
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Classic No. Series Replacement Parts

#	Description	#1 Part No./ Stock No.	#2 Part No./ Stock No.	#3 Part No./ Stock No.	#4 Part No./ Stock No.	#5 Part No./ Stock No.	#6 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 74-75					
24	Conduit Assembly	Refer to Pages 96-99					
NS	Protective Cable Wrap, 50 ft (15 m) per box	TCR50 9900-1150					

Tweco Fusion™ MIG Gun Series

Features & Benefits

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Ergonomic handle design with diamond pattern for better grip
- Easy to maneuver in various welding positions

DURABILITY & DEPENDABILITY

- High impact resistant handle and components
- Rugged design with steel spring strain relief

IMPROVED PERFORMANCE WITH NEW VELOCITY CONSUMABLES

- Comes standard with high performance Velocity consumables
- Easy to change contact tips - no threads, no tools needed
- Solid copper conductor path with fewer connections
- Optimized electrical surface contact with improved arc stability

TOTAL COST OF OWNERSHIP - COST OF USAGE

- Longer life Velocity consumables
- Fewer consumables parts to replace resulting in lower cost of ownership
- Tips can be rotated to optimize life requiring fewer changes

TYPICAL APPLICATIONS

- Light Fabrication
- Welding of HVAC
- Auto-body repair and maintenance
- Farm & ranch equipment repair
- Architectural metal work
- Building & repair of grills and metal fencing



Tweco Fusion
140 Amp
MIG Gun

Tweco Fusion
250 Amp
MIG Gun

MODEL	OUTPUT			PROCESS		STANDARD OPTIONS	APPLICATION		
	Current (Amps)	Duty Cycle, CO ₂	Wire Diameter in (mm)	MIG	Aluminum	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
Tweco Fusion 140	140	20%	Up to .035" (0.9 mm)	●	●	●	●		
Tweco Fusion 180	180	40%	Up to .035" (0.9 mm)	●	●	●	●		
Tweco Fusion 220	220	40%	Up to .035" (0.9 mm)	●	●	●		●	
Tweco Fusion 250	250	80%	Up to .045" (1.2 mm)	●	●	●		●	●

Tweco Fusion™ MIG Gun Series

Handle Design & Style

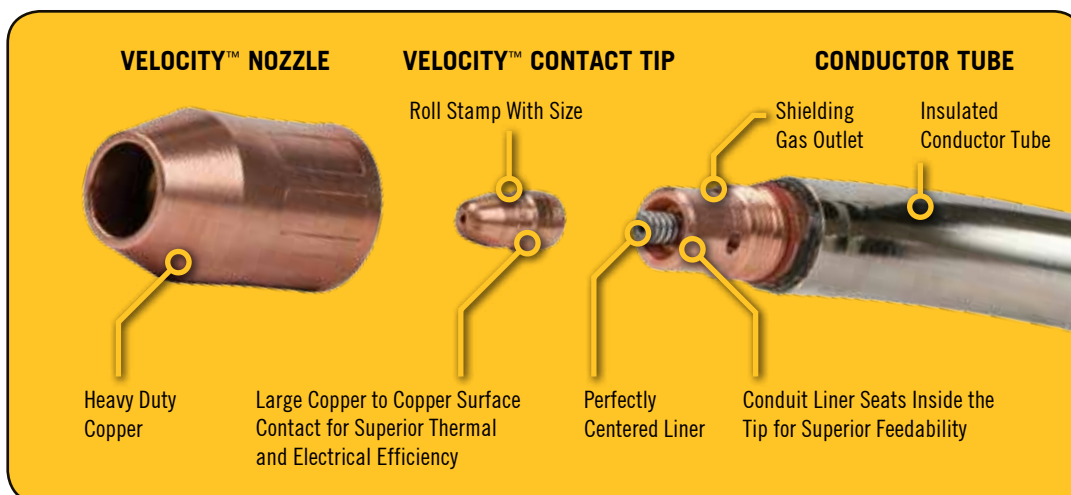
PERFORMANCE

DURABILITY

EASE OF USE



MIG GUNS



Tweco Fusion™ 140 MIG Gun

140 Amp

20% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as standard options.
Suitable for light duty fabrication.

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.
.035" (0.9 mm)	10 ft (3 m)	F140T-10-3035	1017-1320

Thermal Arc® Style (8 Pin) Rear Connector

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

Miller® Style Rear Connector

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



Lincoln® Style Rear Connector

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

Euro-Kwik Style Rear Connector

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

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

Tweco Fusion 180 MIG Gun

180 Amp

40% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as standard options.
Suitable for light duty fabrication.

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.
.035" (0.9 mm)	12 ft (4 m)	F180T-12-3035	1017-1331

Thermal Arc® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	12 ft (4 m)	F180TA-12-3035	1017-1332

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	12 ft (4 m)	F180M-12-3035	1017-1330



Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	12 ft (4 m)	F180L-12-3035	1017-1329

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	12 ft (4 m)	F180X-12-3035	1017-1334
Conduit Liner – WS42 Series			

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

Tweco Fusion™ 220 MIG Gun

220 Amp

40% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as standard options.
Suitable for medium duty fabrication.

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.
.035" (0.9 mm)	15 ft (5 m)	F220T-15-3035	1023-1260

Thermal Arc® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	12 ft (4 m)	F220TA-12-3035	1023-1261

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	15 ft (5 m)	F220M-15-3035	1023-1259



Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	15 ft (5 m)	F220L-15-3035	1023-1258

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.035" (0.9 mm)	15 ft (5 m)	F220X-15-3035	1023-1263

Conduit Liner – WS42 Series

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

Tweco Fusion 250 MIG Gun

250 Amp

80% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as standard options.
Suitable for heavy duty fabrication.

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.
.045" (1.2 mm)	15 ft (5 m)	FV215-3545	1023-1061

Thermal Arc® Style (8 Pin) Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	FV215-TA-3545	1023-1097

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	FV215-M-3545	1023-1069



Lincoln® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	FV215-L-3545	1023-1085

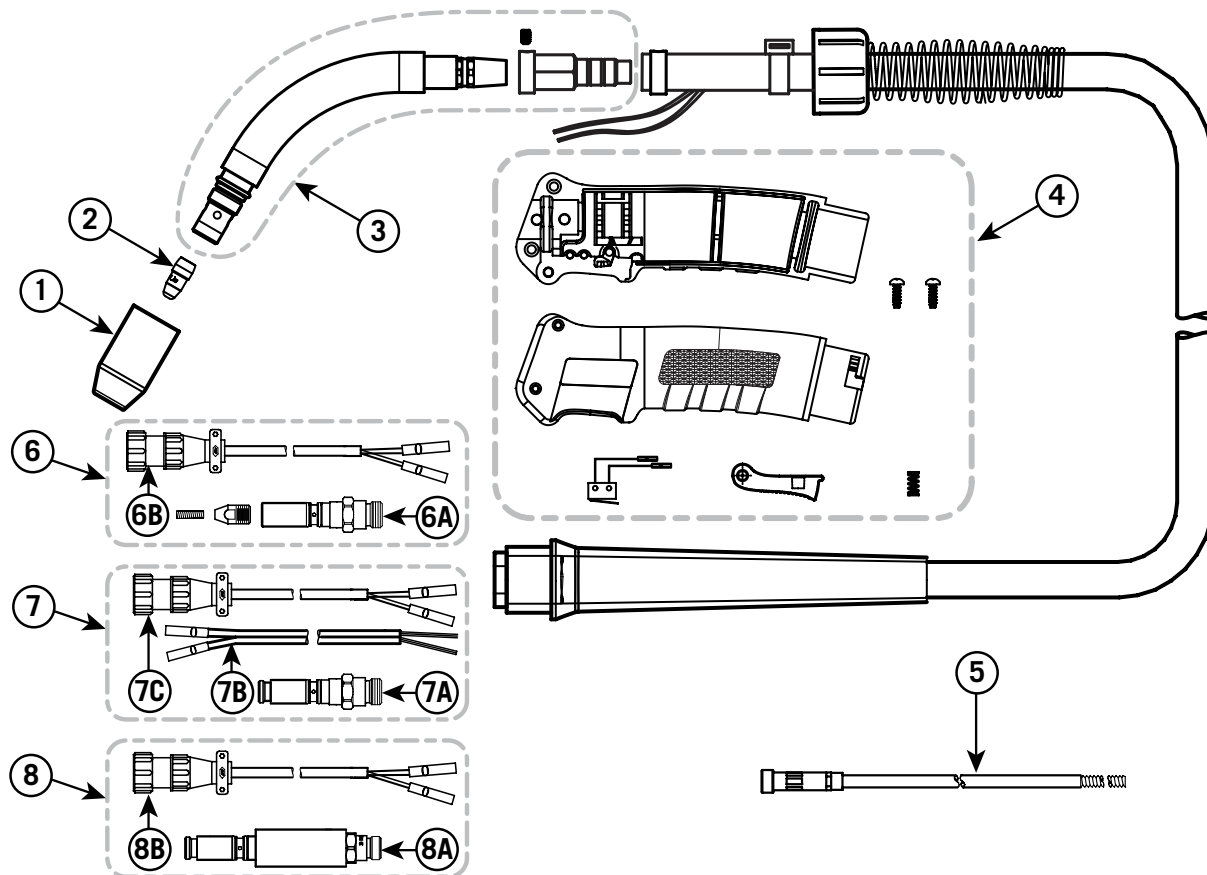
Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	FV215-X-3545	1023-1091

Conduit Liner – WS42 Series

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

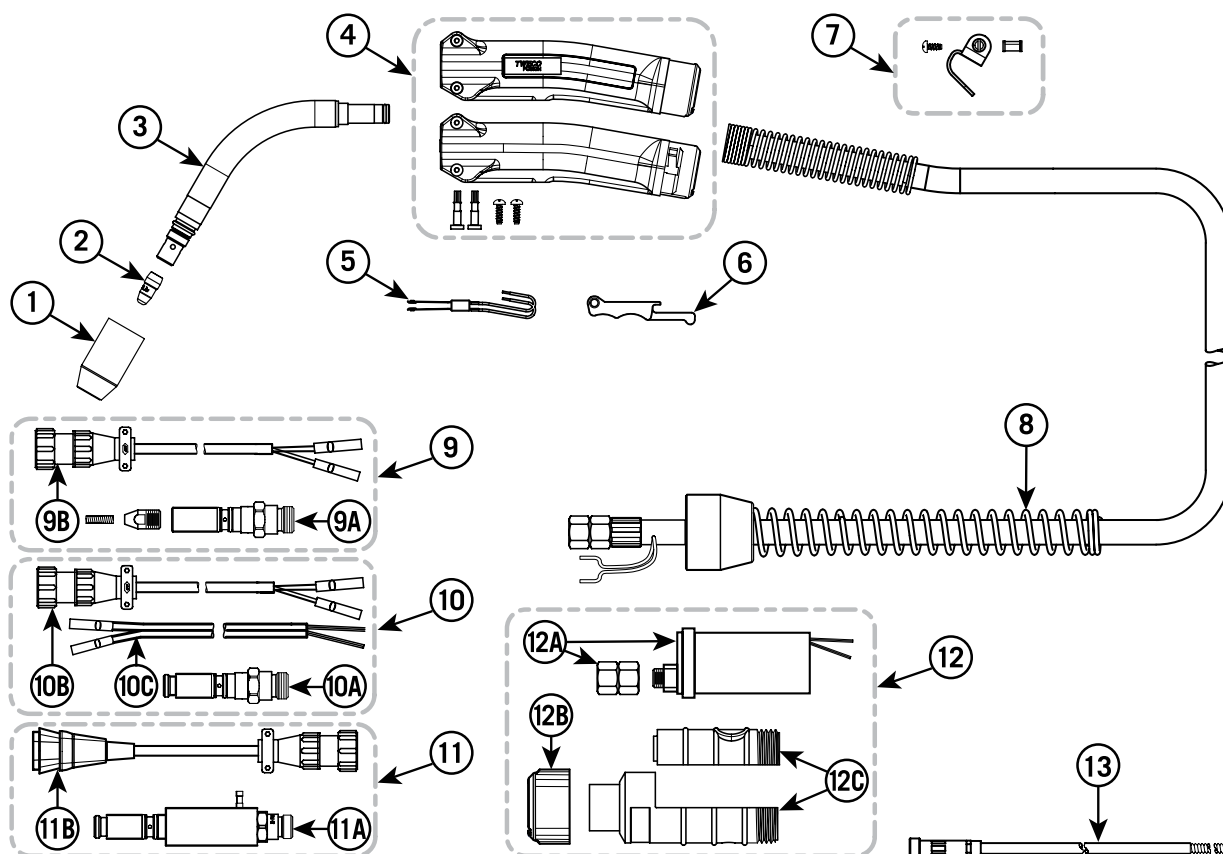
Tweco Fusion™ 140, 180 & 220 MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Velocity™ Nozzle	Refer to Page 77	
2	Velocity Contact Tip	Refer to Page 77	
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

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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

Tweco® Fusion™ 250 MIG Gun Replacement Parts



#	Description	Part No.	Stock No.
1	Velocity™ Nozzle	Refer to Page 77	
2	Velocity Contact Tip	Refer to Page 77	
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 (4 m)	MS212	1720-2116
NS	Cablehoz Assembly – 15 ft (5 m)	MS225	1720-2117
NS	Cablehoz Assembly – 25 ft (8 m)	MS225	1720-2118
NS	Cablehoz Assembly, Euro-Kwik – 12 ft (4 m)	MS212X	1720-2107
NS	Cablehoz Assembly, Euro-Kwik – 15 ft (5 m)	MS215X	1720-2108
NS	Cablehoz Assembly, Euro-Kwik – 25 ft (8 m)	MS225X	1720-2109

#	Description	Part No.	Stock No.
8A	Cablehoz Front Mechanical Connector Replacement Kit	MS102-RK	2060-2132
8B	Cablehoz Rear Mechanical Connector Replacement Kit	MS172-RK	2060-2134
8C	Cablehoz Front Mechanical Connector Replacement Kit for Euro-Style	172X-M	2060-2181
9A	Miller® Rear Connector	350-174-MH	2035-2111
9B	Miller® Control Wire & Plug	WM-354M	2030-2075
10A	Tweco® Rear Connector	350-174H	2035-2110
10B	Tweco® Control Wire & Plug	MS354-TAJ	2060-2139
10C	Thermal Arc® Control Wire & Plug	WS-354-TA-LC	2060-2141
11A	Lincoln® Rear Connector	350-174LH	2035-2112
11B	Lincoln® Control Wire & Plug	MS-354DS-LJ	2060-2137
12A	Euro-Kwik Connection Assembly	174EX-1	2040-2276
12B	Euro-Kwik Nut	174X-2	2040-2177
12C	Euro-Kwik Connector Case	X6RC	2060-2006
13	Conduit Assembly	Refer to Pages 96-99	

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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

MINI-MIG

160 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for light duty fabrication. Standard Conductor Tube – 35-60-60 (Stock No. 1600-1102); 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 (4 m)	35-12	1000-1132
	15 ft (5 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)	M35-10	1000-1211
	12 ft (4 m)	M35-12	1000-1213
	15 ft (5 m)	M35-15	1000-1215

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

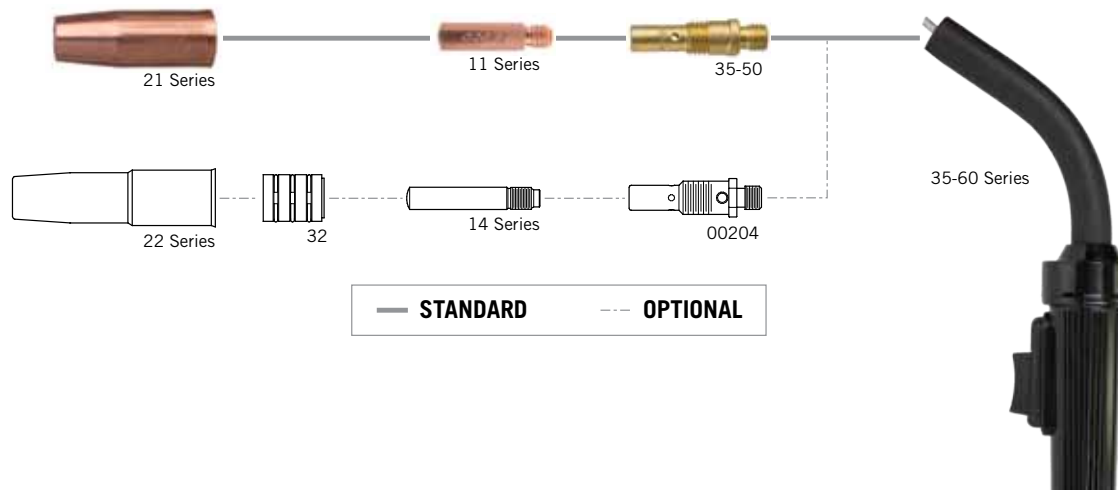
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	10 ft (3 m)	L35-10	1000-1231
	12 ft (4 m)	L35-12	1000-1232
	15 ft (5 m)	L35-15	1000-1233
	15 ft (5 m)	L35-15PM *	1000-1236

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

*Fits Lincoln Power MIG 140/180 machines.

Euro-Kwik Style Rear Connector

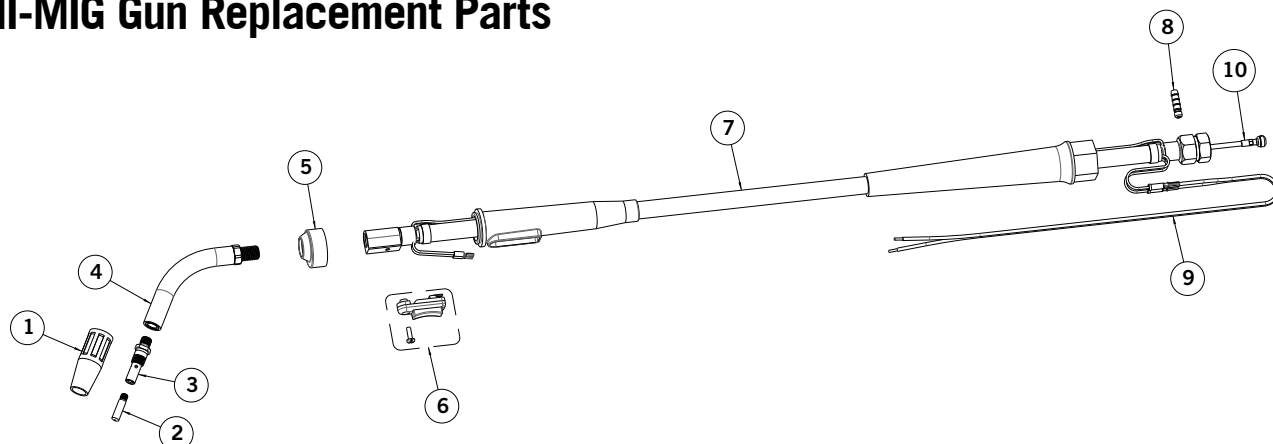
Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (4 m)	X35-12	1000-1632
	15 ft (5 m)	X35-15	1000-1633



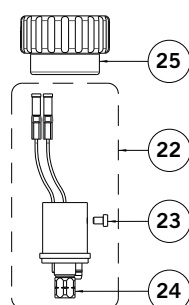
MODEL	OUTPUT			PROCESS				STANDARD OPTIONS			APPLICATION		
	Current (Amps)	Duty Cycle CO2	Wire Diameter in (mm)	MIG	Aluminum	Flux Cored Gas Shielded	Flux Cored Self Shielded	Dual Schedule	Rear Connector	Knucklehead Flexible Conductor Tube	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
MINI-MIG 160 Amp	160	60%	Up to .035" (0.9 mm)	●	●	●	●		●		●		

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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

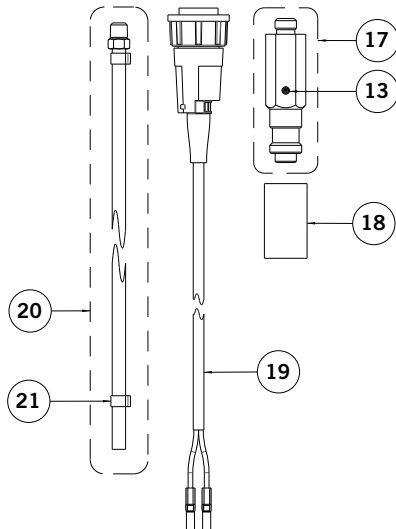
MINI-MIG Gun Replacement Parts



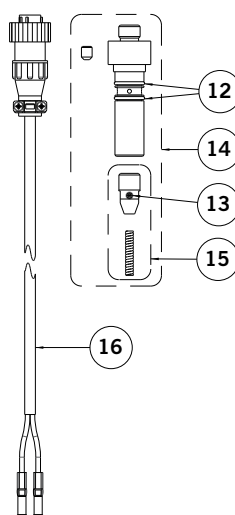
EURO



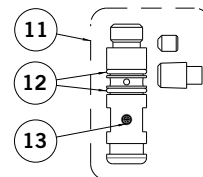
LINCOLN®



MILLER®



TWECO®



#	Description	Part No.	Stock No.
1	Nozzle	21 Series	
2	Contact Tip	11 Series	
3	Diffuser	35-50	
4	Conductor Tube	35-60 Series	
5	Handle Cap	35-80-A1	2000-2081
6	Trigger with Screw	35-90	2000-2090
7	Cablehoz® Assembly 10 ft (3 m) (Direct Plug)	35-010A	1700-2126
	Cablehoz Assembly 12 ft (4 m) (Direct Plug)	35-012A	1700-2127
	Cablehoz Assembly 15 ft (5 m) (Direct Plug)	35-015A	1700-2128
8	Gas Nipple	35-170-5	2000-2175
9	Control Wire	35K350-1	2000-2352
10	Conduit Assembly	Refer to Pages 96-99	
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

#	Description	Part No.	Stock No.
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

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

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

PulseMaster™ MIG Gun Series

Features & Benefits

ONE-TOUCH, ON-THE-FLY CONTROLS

- “Smart” capability with one-touch digital control to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim
- Standard MIG gun without “smart” capability

EXCEPTIONAL WELD BEAD

- Using twin-pulse mode, get the perfect weld bead that you want

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Ergonomic handle to reduce operator fatigue
- Tool free conductor tube change & rotation
- Low bench weight for easy to handle gun

DURABLE FOR INDUSTRIAL APPLICATIONS

- Heavy duty design for industrial application environments
- Impact resistant handle and trigger design
- Increased current capacity Cablehoz®

LOWER HEAT IN THE HANDLE AND CONDUCTOR TUBE

- Heavy duty Cablehoz and conductor tube for improved electrical conductivity and lower heat in the front end
- Heavy duty contact tip and diffuser to act as “heat sink”
- Increased interface between contact tip & gas diffuser improves electrical conductivity

IMPROVED PERFORMANCE WITH LONGER LIFE CONSUMABLES

- Heavy duty contact tips in high heat applications
- Gun drilled contact tips for exceptionally smooth surface for improved feedability, consistency and longer tip life



Tweco®
PulseMaster
Smart MIG® Gun
with digital
display - use with
Thermal Arc® SP
machines only

Tweco Standard
PulseMaster
MIG Gun

MODEL	OUTPUT			PROCESS		STANDARD OPTIONS			APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Smart Capability	Standard without “Smart” Capability	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
PulseMaster 350	350	60%	Up to .045" (1.2 mm)	●	●	●	●	●	●	●	
PulseMaster 450	450	60%	Up to .045" (1.2 mm)	●	●	●	●	●			●

PulseMaster™ MIG Gun Series

Handle Design & Style

PERFORMANCE

DURABILITY

EASE OF USE



PulseMaster™ Air-Cooled 350 Amp

60% Duty Cycle,
Mixed Gases

Process – MIG, Aluminum. Available with Smart Capability, Standard without "smart" capability, and Rear Connector. Suitable for light and medium duty fabrication. Standard Conductor Tube – PMA64EL-45 (Stock No. 1642-1130); Conduit Liner – 44 Series

Smart Gun

PulseMaster Smart MIG Guns are used only with Thermal Arc® SP machines.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA312-3545	1038-1152
	15 ft (5 m)	PMA315-3545	1038-1157

Standard Gun

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 (4 m)	PMA312M-3545	1038-1150
	15 ft (5 m)	PMA315M-3545	1038-1155

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA312M-3545	1038-1160
	15 ft (5 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 (4 m)	PMA312X-3545	1038-1153
	15 ft (5 m)	PMA315X-3545	1038-1158

Lincoln® Style Rear Connector

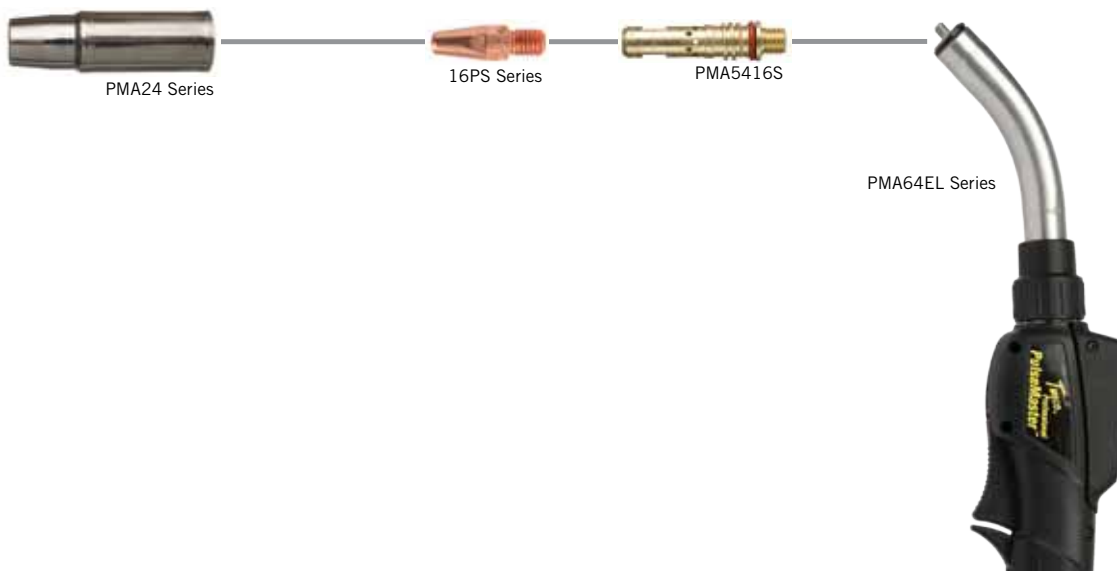
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA312L-3545	1038-1162
	15 ft (5 m)	PMA315L-3545	1038-1163

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

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA312X-3545	1038-1151
	15 ft (5 m)	PMA315X-3545	1038-1156



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

MIG Guns

PULSEMASTER™ SERIES

PulseMaster™ Air-Cooled

450 Amp

60% Duty Cycle,
Mixed Gases

Process – MIG, Aluminum. Available with Smart Capability, Standard without "smart" capability, and Rear Connector. Suitable for heavy duty fabrication. Standard Conductor Tube – PMA64EL-45 (Stock No. 1642-1130); Conduit Liner – 44 Series

Smart Gun

PulseMaster Smart MIG Guns are used only with Thermal Arc® SP machines.

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA412-3545	1041-1510
	15 ft (5 m)	PMA415-3545	1041-1511

Standard Gun

Standard without "smart" capability.

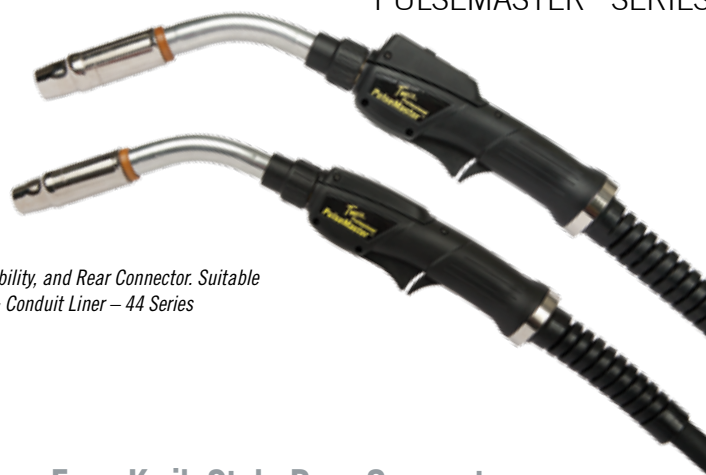
Tweco® Style Rear Connector

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 (4 m)	PMA412M-3545	1041-1500
	15 ft (5 m)	PMA415M-3545	1041-1501

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA412M-3545	1041-1502
	15 ft (5 m)	PMA415M-3545	1041-1503



MIG GUNS

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA412X-3545	1041-1515
	15 ft (5 m)	PMA415X-3545	1041-1516

Lincoln® Style Rear Connector

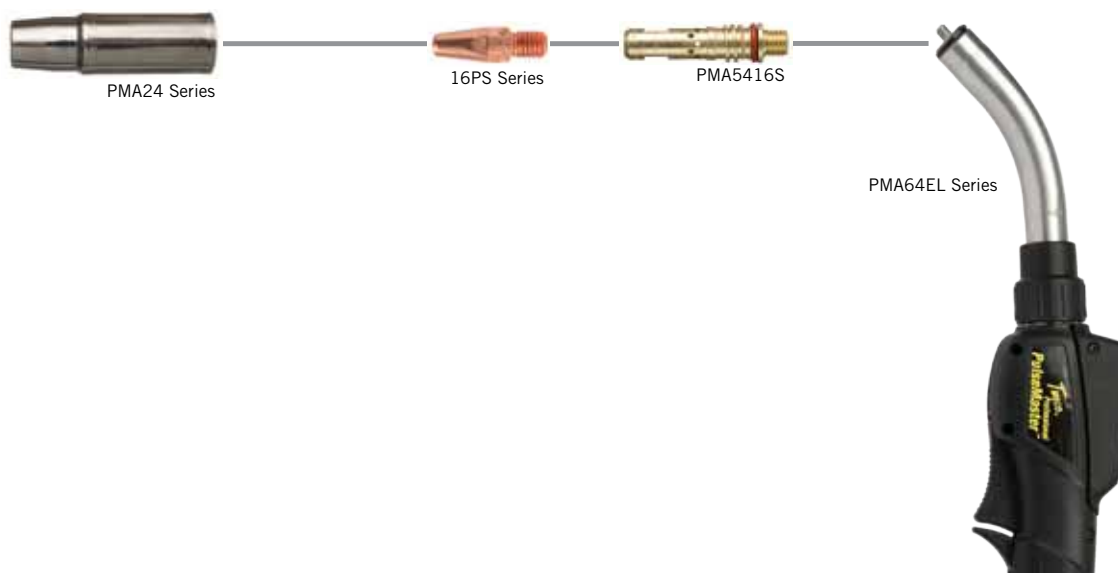
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA412L-3545	1041-1507
	15 ft (5 m)	PMA415L-3545	1041-1508

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

Euro-Kwik Style Rear Connector

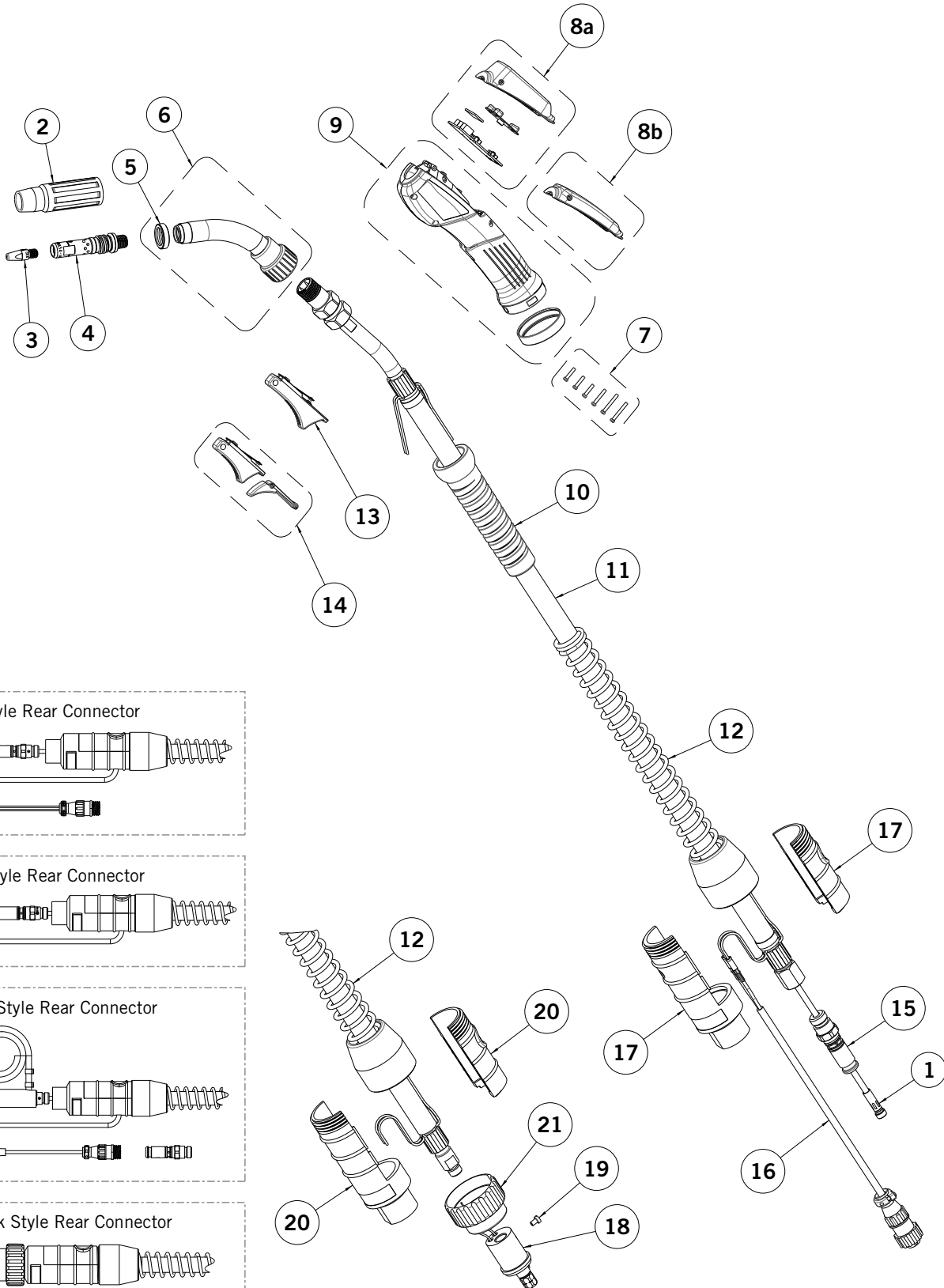
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMA412X-3545	1041-1505
	15 ft (5 m)	PMA415X-3545	1041-1506



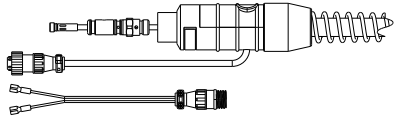
Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies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

PulseMaster™ Air-Cooled Replacement Parts

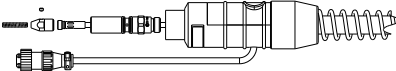
MIG GUNS



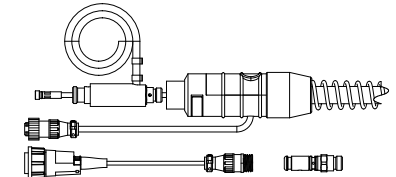
Tweco Style Rear Connector



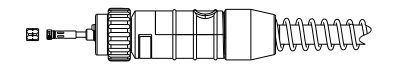
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

PulseMaster™ Air-Cooled Replacement Parts

#	Description	Part No.	Stock No.
1	Conduit Assembly	Refer to Pages 96-99	
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
14	Trigger & Guard Assembly	PM94X	2060-2713
15	Connector Plug	Refer to Pages 74-75	
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 and 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

VICTOR®

SLR 100 Surge Limiting Regulator

FOR USE WITH SHIELDING GAS

Designed to reduce gas surge at the activation of the torch or gun, which provides a more constant flow rate of shielding gas to the welding machine.

Benefit is better weld quality and more consistent gas consumption. (Especially when doing multiple short welds or spot welds)

Easily connects to shielding gas supply hose as well as inlet on welding machine.

Part No. 0781-1197

SPECIFICATIONS:

Flow:

Preset 50 SCFH (23.6 LPM)

Recommended Inlet Pressure:

100 ± 20 PSIG (6.9 ± 1.38 BAR)

Maximum Inlet Pressure:

200 PSIG (13.8 BAR)

Connections:

CGA No. 030 RH for Inert Gases, Internal Thread (Inlet), External Threat (Outlet)



NOTICE:

Note the maximum inlet pressure stamped on the regulator. Do not attach regulator to a system that has a higher pressure than the maximum rated pressure stamped on the regulator.

TUFF-N-LITE MIG Gun

Features & Benefits

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Straight handle allows the welder to locate the trigger at the bottom or top of handle
- Light-weight for ease of handling

FIELD REPAIRABLE

- Split-half handle case provides access for ease of repair
- Field repairable mechanical cable connections for Cablehoz®
- Spare trigger leads in Cablehoz

WIDE WELDING APPLICATIONS

- Spray transfer mode & pulse welding
- Straight CO₂ or mixed gases



MODEL	OUTPUT			PROCESS			STANDARD OPTIONS	APPLICATION			
	Current (Amps)	Duty Cycle CO ₂	Wire Diameter in (mm)	MIG	Aluminum	Flux Cored Gas Shielded	Flux Cored Self Shielded	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
TUFF-N-LITE 350 Amp	350	60%	Up to 1/16" (1.6 mm)								

TUFF-N-LITE

350 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Rear Connector as a standard option. Suitable for light to heavy duty fabrication. Standard Conductor Tube – 64TL-60 (Stock No. 1635-1031); Conduit Liner – 44 Series



MIG GUNS

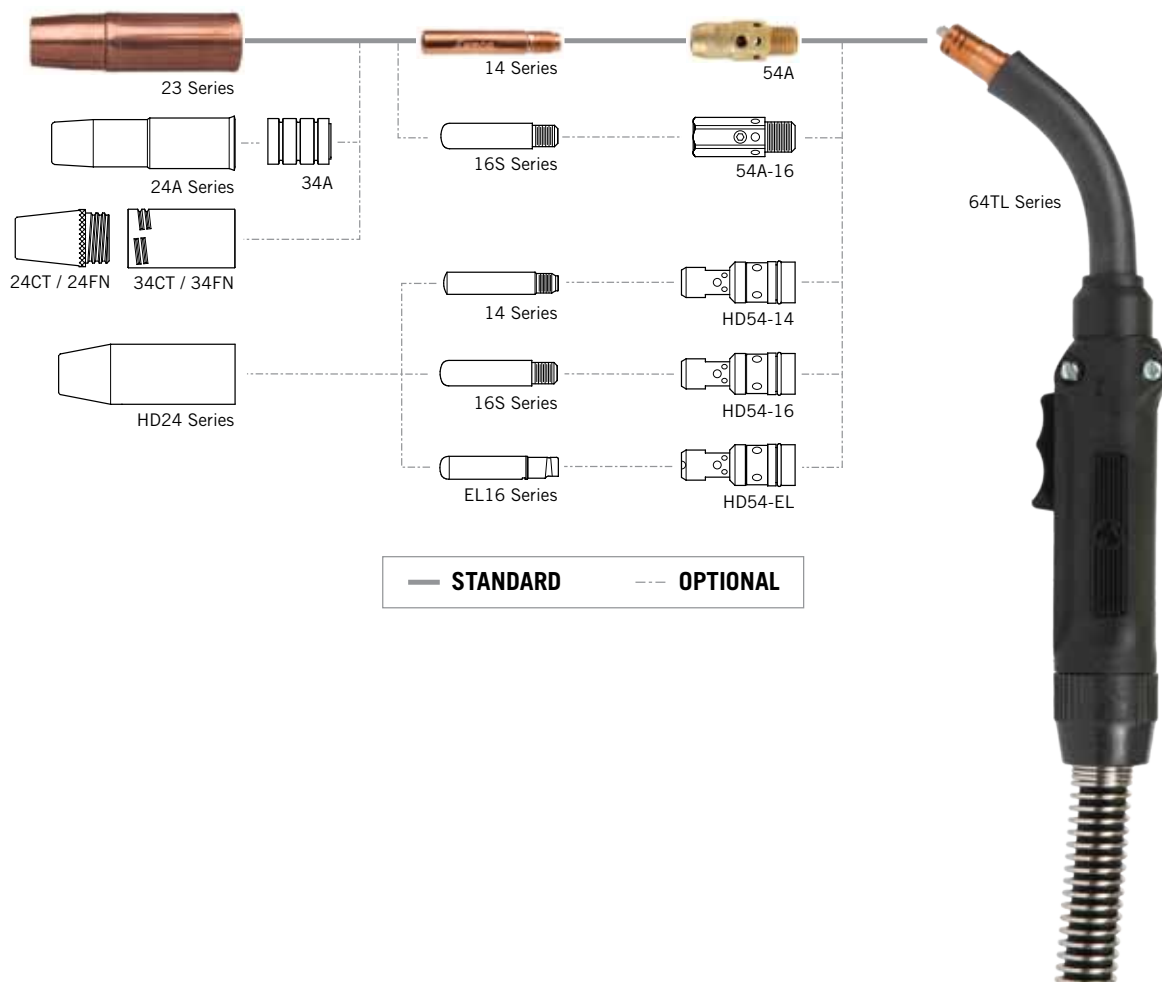
Tweco® Style Rear Connector

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

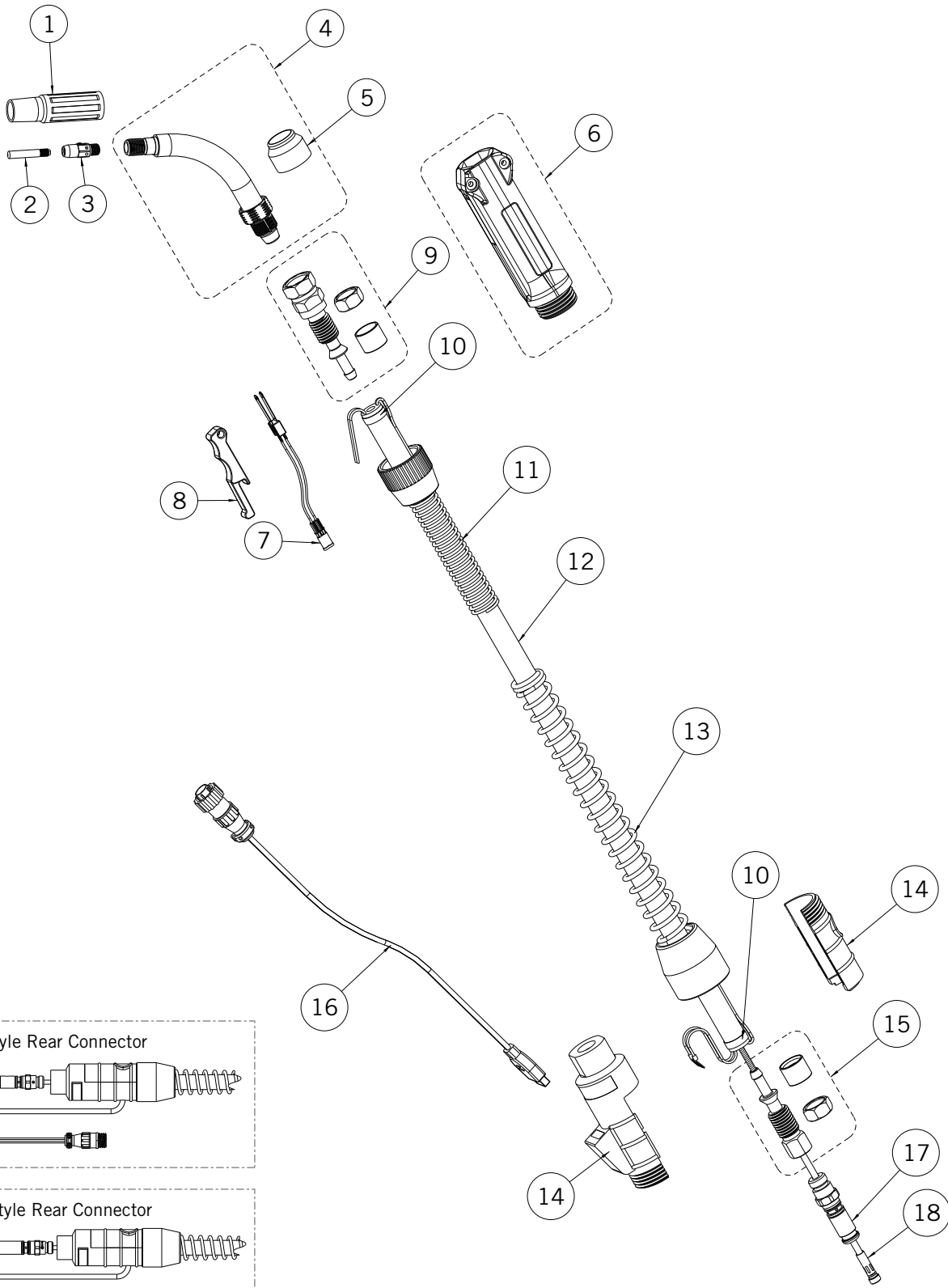
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (5 m)	TL350-15-116	1036-1037

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (5 m)	TL350M-15-116	1036-1237

Miller® Style Rear Connector



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

TUFF-N-LITE Replacement Parts

#	Description	Part No.	Stock No.
1	Nozzle	23 Series	
2	Contact Tip	14 Series	
3	Diffuser	54A	
4	Conductor Tube	64TL Series	
5	Nut Insulator	64TL-NC	2035-2128
6	Handle Assembly	TL350-86R	2035-2136
7	Trigger Blade Assembly	EL96B	2060-2606
8	Trigger	EL96	2060-2605
9	Front Cable Connector	104TL	2035-2130
10	Cable Clamp	136	2060-2690
11	Front Strain Relief Spring	TL144	2035-2138
12	Cablehoz®	300	1730-2100
13	Rear Strain Relief Spring	235RSSR	2060-2035
14	Rear Case	M6RC	2060-2018
15	Rear Cable Connector	350-170HK	2035-2169
16	Control Wire (Tweco®)	MAK-354	2642-2460
	Control Wire (Miller®)	MSAK-354	2642-2470
17	Connector Plug	Refer to Pages 74-75	
18	Conduit Assembly	Refer to Pages 96-99	
NS	Protective Cable Wrap, 50 ft (15 m)per box	TCR50	9900-1150

Tweco®

Manual Welding Products & Accessories

Tweco® offers a complete line of ground clamps, cable connectors, and cable lugs for your welding application. Refer to pages 126-136 in this catalog for more detail.



Magnetic Ground Clamps



Steel Ground Clamps



High Quality Copper Ground Clamps

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Supra® XT MIG Gun Series

Features & Benefits

FIELD REPAIRABLE

- Field repairable mechanical cable connections for Cablehoz®
- Three layer conductor tube construction (copper tube/silicon-resin glass insulator/metal jacket)
- Spare trigger leads in Cablehoz

DURABLE & DEPENDABLE

- Heavy-duty design
- High impact resistant one-piece “straight” handle
- Heavy-duty front end consumables
- Conductor tube threads into front block

MICRO-SWITCH TRIGGER DESIGN

- Incorporates a button style switch for start/stop wire feed
- Metal “paddle” style trigger lever
- Can be used as top or bottom trigger

FRONT AND REAR SPRING STRAIN RELIEF AND CABLE SUPPORT

- Provides needed support to eliminate kinking of Cablehoz
- Less downtime

RUGGED & DURABLE POWER CABLE

- Proven abrasion & heat resistant Cablehoz

WIDE WELDING APPLICATIONS

- Spray transfer mode & pulse
- Straight CO₂ or mixed gases



MODEL	OUTPUT			PROCESS				STANDARD OPTIONS			APPLICATION		
	Current (Amps)	Duty Cycle CO ₂	Wire Diameter in (mm)	MIG	Aluminum	Flux Cored Gas Shielded	Flux Cored Self Shielded	Rear Connector	Heavy Duty Front End Consumables	Eliminator Style Front End Consumables	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
SUPRA XT SEHD 450	450	60%	Up to 1/16" (1.6 mm)	●	●	●	●	●	●			●	●

SUPRA® XT SEHD

450 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum, Flux Cored Gas Shielded, Flux Cored Self Shielded. Available with Heavy Duty Front End Consumables, and Rear Connector as standard options. Suitable for medium to heavy duty fabrication. Standard Conductor Tube – SE64J-60 (Stock No. 1640-1347) on all guns up to 15 ft (5 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)	15 ft (5 m)	SEHD400-5M16	1040-1332

Miller® Style Rear Connector

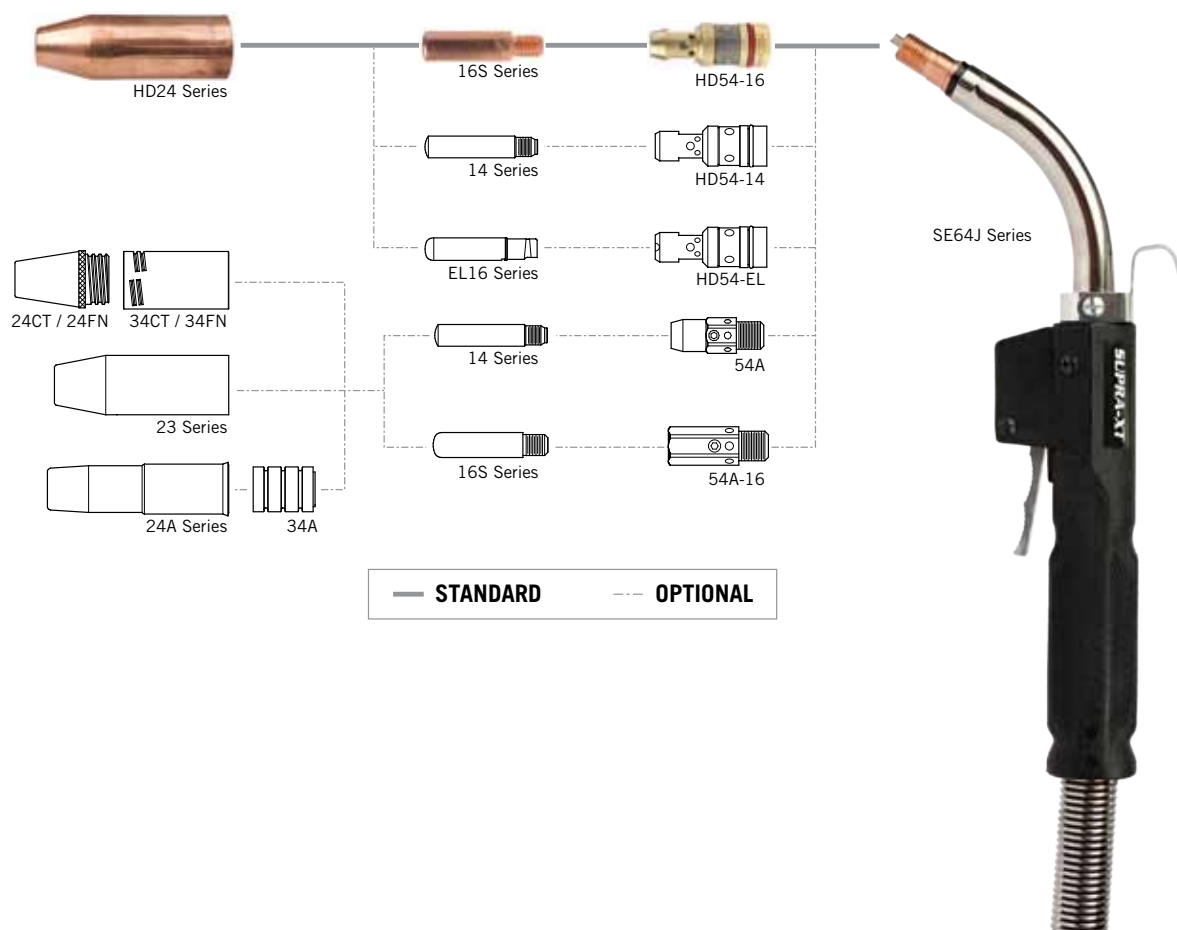
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (5 m)	SEHD400M-5M16	1040-1342

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.(5 m)	SEHD400L-5M16	1040-1432

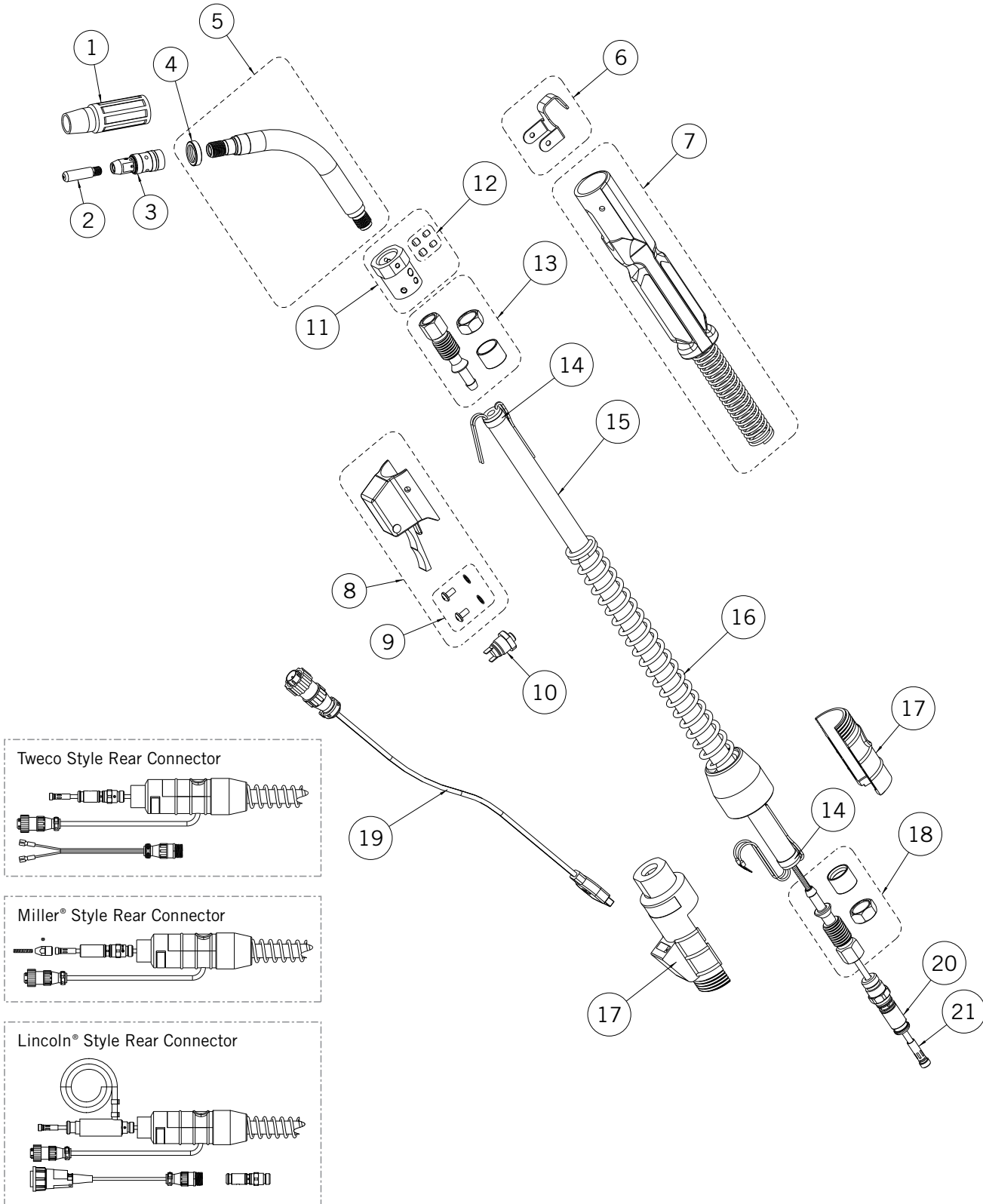
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

SUPRA® XT Replacement Parts

MIG GUNS



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

SUPRA® XT Replacement Parts

#	Description	Part No.	Stock No.
1	Nozzle	HD24 Series	
2	Contact Tip	16S Series	
3	Diffuser	HD54-16	
4	Nozzle Insulator	66J-3	1660-1836
5	Conductor Tube	SE64J Series	
6	Gun Hanger	154	2040-2154
7	Handle Assembly	SE86-H	2060-2052
8	Trigger Assembly	SE96	2060-2056
9	Trigger Housing Screws	SE96-SW	2060-2055
10	Trigger Switch	SE96-B	2060-2054
11	Front Pivot Block Assembly	SE66	2060-2051
12	Pivot Block Set Screw	SE66-B	2060-2050
13	Front Cable Connector	SE104	2060-2057
14	Cable Clamp	136	2060-2690
15	Cablehoz®	400	1740-2100
16	Rear Strain Relief Spring	235RSSR	2060-2035
17	Rear Case	M6RC	2660-2018
18	Rear Cable Connector	350-170HK	2035-2169
19	Control Wire (Tweco®)	MAK-354	2642-2460
	Control Wire (Miller®)	MSAK-354	2642-2470
	Control Wire (Lincoln®)	LAK-354	2642-2450
20	Connector Plug	Refer to Pages 74-75	
21	Conduit Assembly	Refer to Pages 96-99	
NS	Protective Cable Wrap, 50 ft (15 m) per box	TCR50	9900-1150

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Smoke Master® Fume Extraction MIG Gun Series

Features & Benefits

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Ergonomic handle to reduce operator fatigue
- Extended trigger length to reduce radiated heat
- Low bench weight for easy to handle gun

MIG GUN HANDLE INCORPORATES HANDLE SLIDE VALVE

- Allows the operator to regulate vacuum on the MIG gun
- Efficiently removes 90% of smoke from the welding zone

FIELD REPAIRABLE

- Replaceable Cablehoz® available
- Spare trigger leads in Cablehoz

RUGGED & DURABLE POWER CABLE

- Tough outer jacket made from leather protecting inner vacuum hose from weld spatter/abrasion
- Proven abrasion & heat resistant Cablehoz
- 1-3/8" inside diameter PVC reinforced vacuum hose
- Outer metal plated insulated smoke tube

VACUUM COOLS THE FRONT END CONSUMABLES

- Surrounding air is drawn over the front end consumables and conductor tube



Smoke Collection System, Part No. TSC96
(Stock No. 4500-1010)

MODEL	OUTPUT			PROCESS			STANDARD OPTIONS	APPLICATION		
	Current (Amps)	Duty Cycle CO ₂	Wire Diameter in (mm)	MIG	Aluminum	Flux Cored Gas Shielded	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
Smoke Master 250	250	60%	Up to .045" (1.2 mm)	•	•	•	•	•	•	
Smoke Master 450	450	60%	Up to 1/16" (1.6 mm)	•	•	•	•		•	•

Smoke Master®

250 Amp

60% Duty Cycle, CO₂ (Carbon Dioxide)

Process – MIG, Aluminum, Flux Cored Gas Shielded. Available with Rear Connector as a standard option. Suitable for light to medium duty fabrication. Standard Conductor Tube – 62-60 (Stock No. 2020-2006) on all guns up to 15 ft (5 m); Conduit Liner – 44 Series



MIG GUNS

Tweco® Style Rear Connector

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

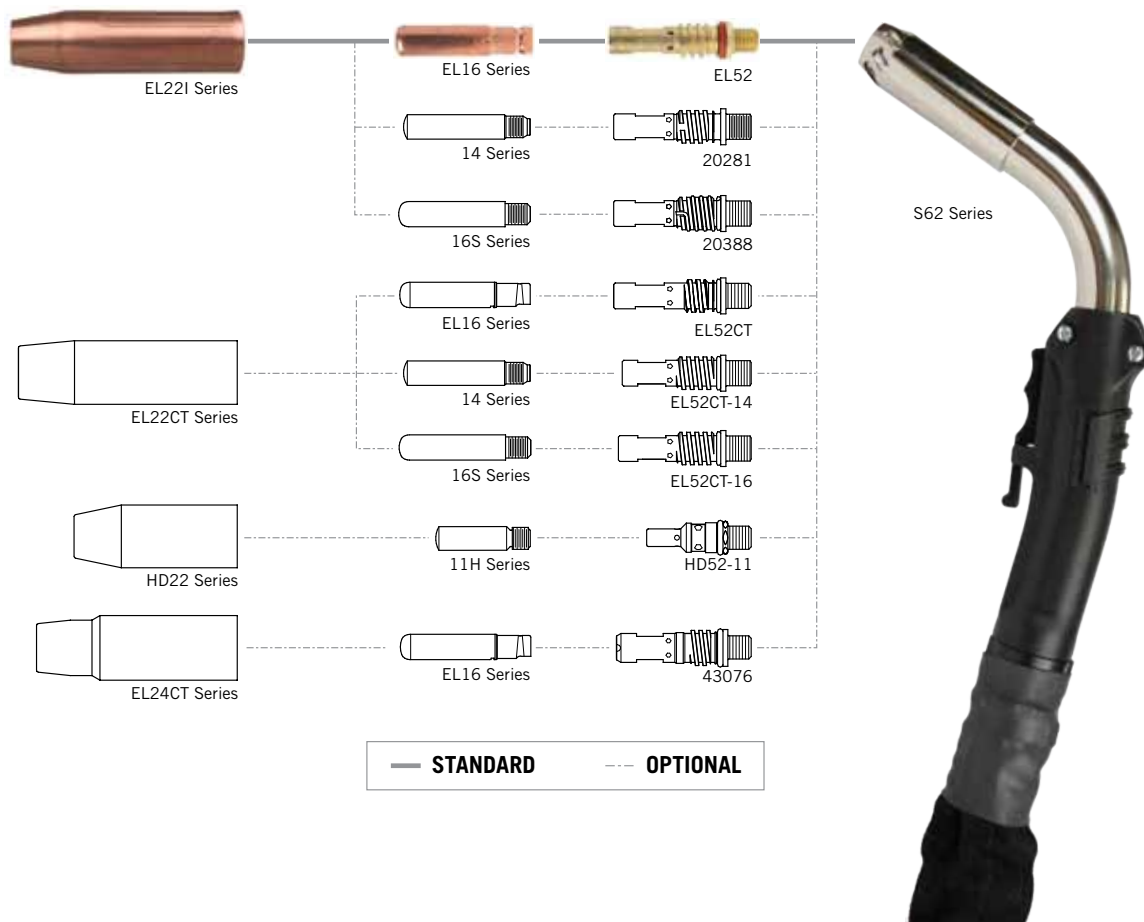
Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	S212-4045	1026-1101
	15 ft (5 m)	S215-4045	1026-1102

Euro Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (5 m)	XS215-4045	1026-1127

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	S212M-4045	1026-1106
	15 ft (5 m)	S215M-4045	1026-1107



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Smoke Master®

450 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum, Flux Cored Gas Shielded. Available with Rear Connector. Suitable for medium to heavy duty fabrication. Standard Conductor Tube – S64-60 (Stock No. 1046-2258) on all guns up to 15 ft (5 m); Conduit Liner – 44 Series



Tweco® Style Rear Connector

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

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (4 m)	S412-116	1046-1105
	15 ft (5 m)	S415-116	1046-1108

Miller® Style Rear Connector

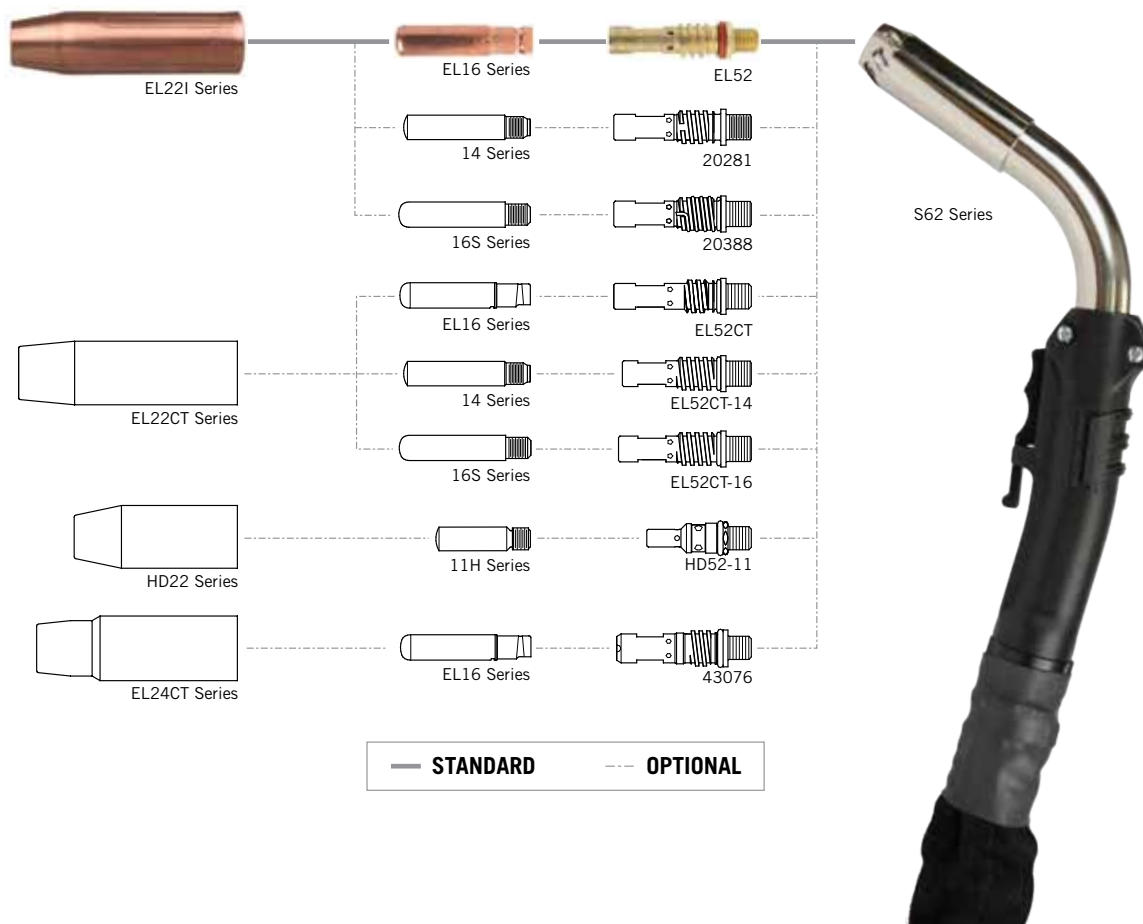
Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (4 m)	S412M-116	1046-1125
	15 ft (5 m)	S415M-116	1046-1128

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (5 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 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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Tweco® Smoke Collector

Fume Removal System

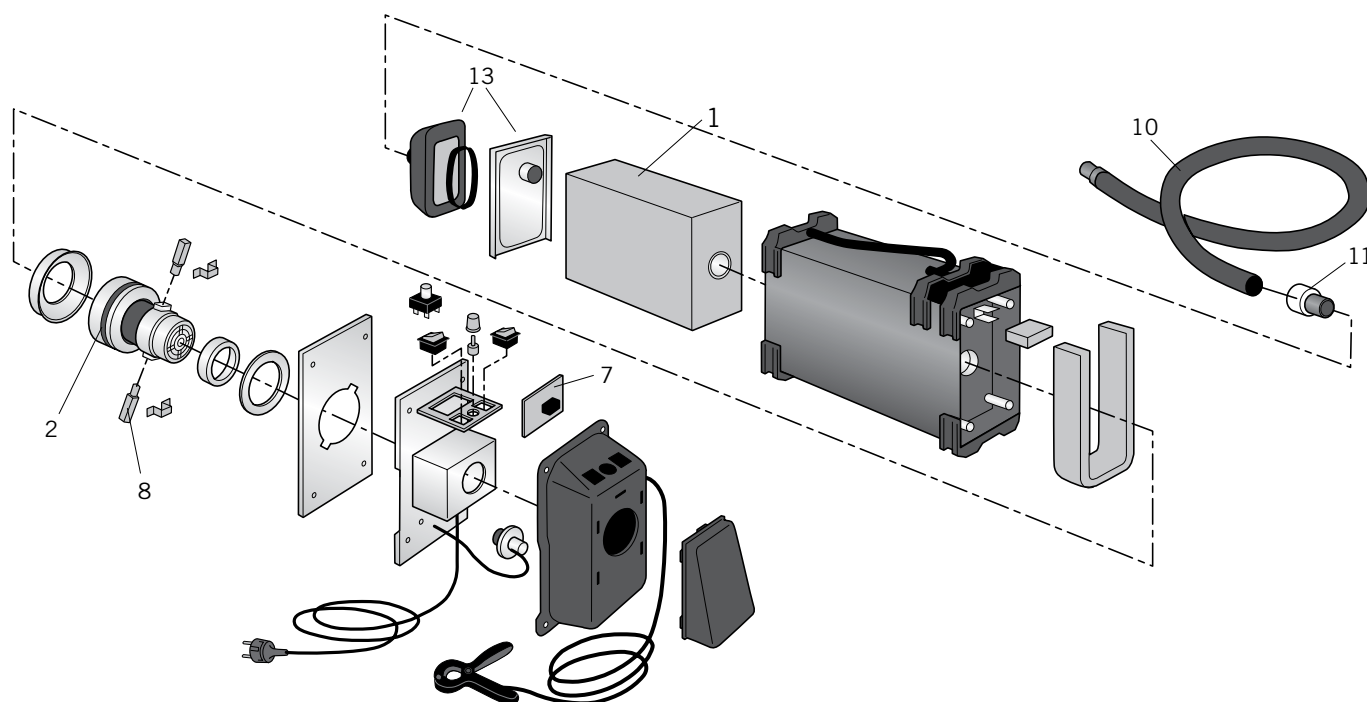
- Compatible with Tweco Smoke Master MIG Guns
- Efficiently removes welding fumes
- High efficiency filter
- Separately air-cooled motor
- Automatic start-stop function standard

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



MIG GUNS

Tweco® Smoke Collector Replacement Parts



#	Description	Part No.	Stock No.
1	Filter- particle	TSC-F	4500-2060
2	Motor 120V	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

MIG GUNS



48

Smoke Master® Replacement Parts

#	Description	250 AMP		450 AMP	
		Part No.	Stock No.	Part No.	Stock No.
1	Nozzle	EL22I Series		EL22I Series	
2	Contact Tip	EL16 Series		EL16 Series	
3	Diffuser (Slip-On)	EL52	1560-1110	EL52	1560-1110
	Diffuser (Coarse Thread)	EL52CT	1560-1109	EL52CT	1560-1109
4	Insulator Spacer	S62-60-2	2020-2013	S64-R	1046-2223
5	Smoke Tube Spacer	S62-60-2	2020-2013	S64-1	1046-2273
6	Conductor Tube (60 Degree, Standard)	S62-60	2020-2006	S64-60	1046-2258
	Conductor Tube (45 Degree, Standard)	S62-45	2020-2011	--	--
7	Handle Spacer	--	--	S64-2	1046-2271
8	Smoke Nozzle (Standard)	S22-62L	2020-2010	S24-62	1046-2225
	Smoke Nozzle (High Volume)	--	--	S24-62HV	1046-2226
9	Smoke Tube (60 Degree, Standard)	S62T-60	2020-2001	S64T-60	1046-2240
	Smoke Tube (45 Degree)	S62T-45	2020-2012	--	--
10	Handle Assembly	S82	2020-2003	S86	1046-2250
11	Handle Valve	S82-V	2020-2004	S86-V	1046-2252
12	Trigger Blade Assembly	ELC94-BL	2060-2671	ELC94-BL	2060-2671
13	Trigger	ELC94	2060-2647	EL96	2060-2605
14	Swivel Cap Assembly	S82-C	2020-2005	S86-C	1046-2254
15	Cablehoz® Assembly, 12 ft (4 m)	S212	2020-2008	S412	1046-2203
	Cablehoz Assembly, 15 ft (5 m)	S215	2020-2009	S415	1046-2206
16	Smoke Hose, 12 ft (4 m)	S412-H	1046-2214	S412-H	1046-2214
	Smoke Hose, 15 ft (5 m)	S415-H	1046-2217	S415-H	1046-2217
17	Leather Jacket, 12 ft (4 m)	SHP-12	1046-2267	SHP-12	1046-2267
	Leather Jacket, 15 ft (5 m)	SHP-15	1046-2268	SHP-15	1046-2268
18	Rear Case Assembly	M6RC	2060-2018	M6RC	2060-2018
19	Control Wire (Tweco®)	MAK-354	2642-2460	MAK-354	2642-2460
	Control Wire (Miller®)	MSAK-354	2642-2470	MSAK-354	2642-2470
	Control Wire (Lincoln®)	LAK-354	2642-2450	LAK-354	2642-2450
20	Connector Plug	Refer to Pages 74-75		Refer to Pages 74-75	
21	Conduit Assembly	Refer to Pages 96-99		Refer to Pages 96-99	

Tweco® Spool Gun Series

Features & Benefits

EXCELLENT SERVICE AND EASE OF OPERATION

- Ideal for aluminum, stainless steel and mild steel welding
- Holds standard 4" (102 mm) diameter spools
- Long cables allow operator to access hard to weld areas

COMFORTABLE HANDLE DESIGN

- Pistol grip
- With outer spool tension control
- 3-turn potentiometer for fine wire feed speed control
- 3-turn potentiometer for fine wire feed speed control found on Part No. SG200-25-3545 (Stock No. 1027-1392), SG200TA-25-3545 (Stock No. 1027-1391) and SSG225-25-3545 (Stock No. 1027-1370) Spool guns

QUICK DISCONNECT CONDUCTOR TUBE

- Three layer conductor tube construction (copper tube/silicon-resin glass insulator/metal jacket)
- Standard straight (180°) conductor tube
- Optional 30° rigid conductor tube or Knucklehead™ flexible conductor tube

ADAPTS TO MOST WELDING MACHINES

- Part No. SG200-25-3545 (Stock No. 1027-1392) and SSG225-3545 (Stock No. 1027-1370) adapts to most welding machines with the use of Control Box Part No. WSG-1 (Stock No. 1028-1295)
- Control box provides the gas solenoid with pre/post purge control and run in control for arc starting
- Part No. SG160TA-12-3035 (Stock No. 1027-1390) and SG200TA-25-3545 (Stock No. 1027-1391) is designed to work with Thermal Arc® new inverter technology machines



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

Requires Jumper Cord, Part No. SSG300-106JC
(Stock No. 2031-2150)

MODEL	OUTPUT			PROCESS		STANDARD OPTIONS	APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
Spool Gun - 160	160	20%	Up to .035" (0.9 mm)	●	●		●		
Spool Gun - 200	200	60%	Up to 3/64" (1.2 mm)	●	●		●	●	
Spool Gun - 200TA	200	60%	Up to 3/64" (1.2 mm)	●	●		●	●	
Spool Gun - 300	300	60%	Up to 1/16" (1.6 mm)	●	●		●	●	

Tweco® Spool Gun

160 Amp

20% Duty Cycle

Process - MIG, Aluminum. Suitable for light duty fabrication.
8-pin Amphenol Style Connector

Tweco Style Rear Connector

Use only on Thermal Arc® 141i, 181i and 211i power supplies only

Wire Size	Length	Part No.	Stock No.
Up to .035" (0.9 mm)	12 ft (4 m)	SG160TA-12-3035*	1027-1390



MIG GUNS

Tweco Spool Gun

200 Amp

60% Duty Cycle

Process - MIG, Aluminum. Suitable for light to medium duty fabrication.
10-pin Amphenol Style Connector

Tweco Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up to 0.045" (1.2 mm)	25 ft (8 m)	SG200-25-3545	1027-1392
Up to 0.045" (1.2 mm)	25 ft (8 m)	SG200TA-25-3545*	1027-1391

*Use only on Thermal Arc 220i and 252i power supplies only



Control Wire Jumper Cords

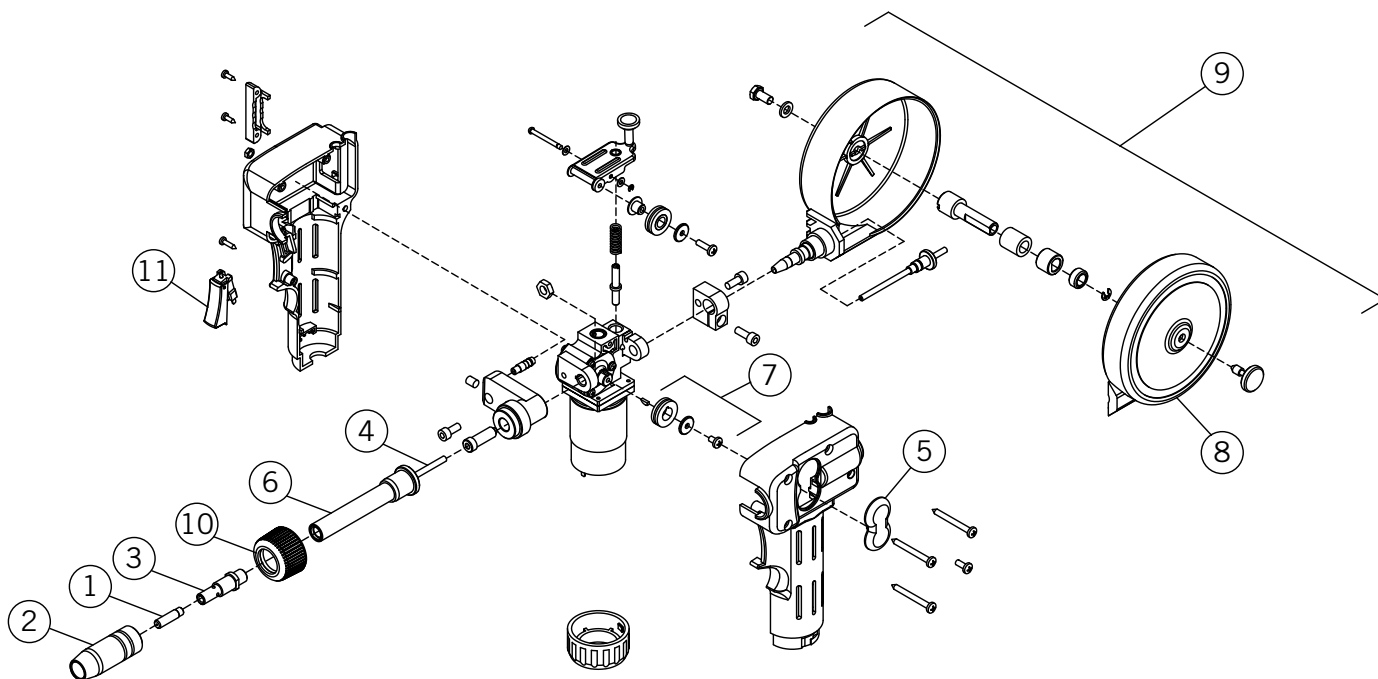
Use with Spool Gun - Part No. SG200-25-3545 (Stock No. 1027-1392)

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
Generic	See pin configuration	WSPGENJC	2031-2249

Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. ESAB and MigMaster are registered trademarks of ESAB AB. The aforementioned registered trademarks are in no way affiliated with Tweco Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Tweco® Spool Gun 160 & 200 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 1/2" (12.7 mm)	21-50F	1210-1112
	Nozzle 5/8" (15.9 mm)	21-62	1210-1120
3	Gas Diffuser	51	1510-1101
4	Conduit	SPG66065	2031-2107
5	Drive Roll Cover	WSPDRC	2031-2227
6	Conductor Tube	WSP62180	2031-2225
7	.023 Drive Roll Assembly	WSPDR023	2031-2228
	.023 Guide Roll Assembly	WSPGR023	2031-2234
	.035 Drive Roll Assembly	WSPDR035045	2031-2229
	.035 Guide Roll Assembly	WSPGR035045	2031-2235
	.023 Drive Roll Assembly - U-Shaped Smooth	WSPDRU023	2031-2250
	.023 Guide Roll Assembly - U-Shaped Smooth	WSPGRU023	2031-2251
	.035 Drive Roll Assembly - U-Shaped Smooth	WSPDRU035045	2031-2252
	.035 Guide Roll Assembly - U-Shaped Smooth	WSPGRU035045	2031-2253
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

Tweco® Spool Gun 300 Amp

60% Duty Cycle

Process - MIG, Aluminum. Suitable for light to medium duty fabrication. Requires the use of the ESG-1 (Stock No. 1028-1295) Control Box for most welding machines. Standard Conductor Tube - PMP64EL-180 (Stock No. 1642-1140)

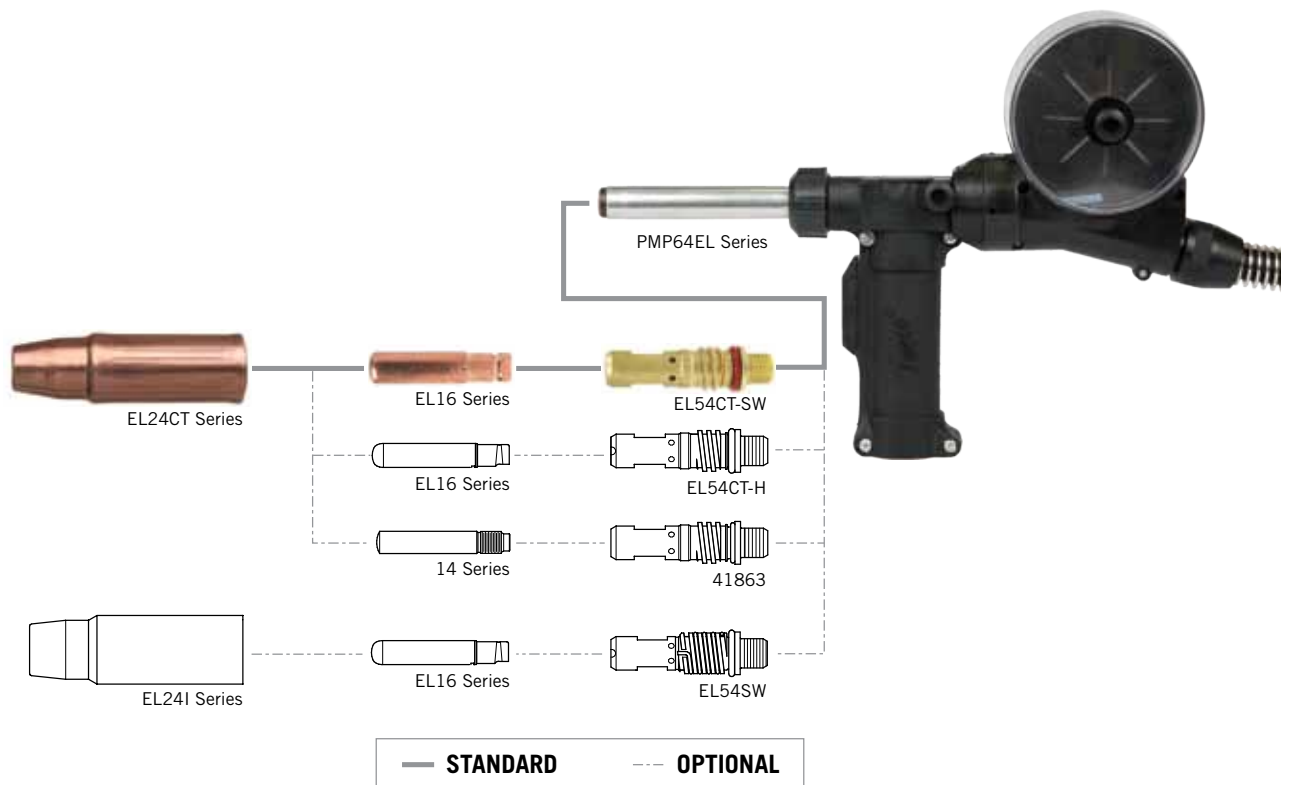
Tweco Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up to 1/16" (1.6 mm)	25 ft (8 m)	SSG225-3545	1027-1370

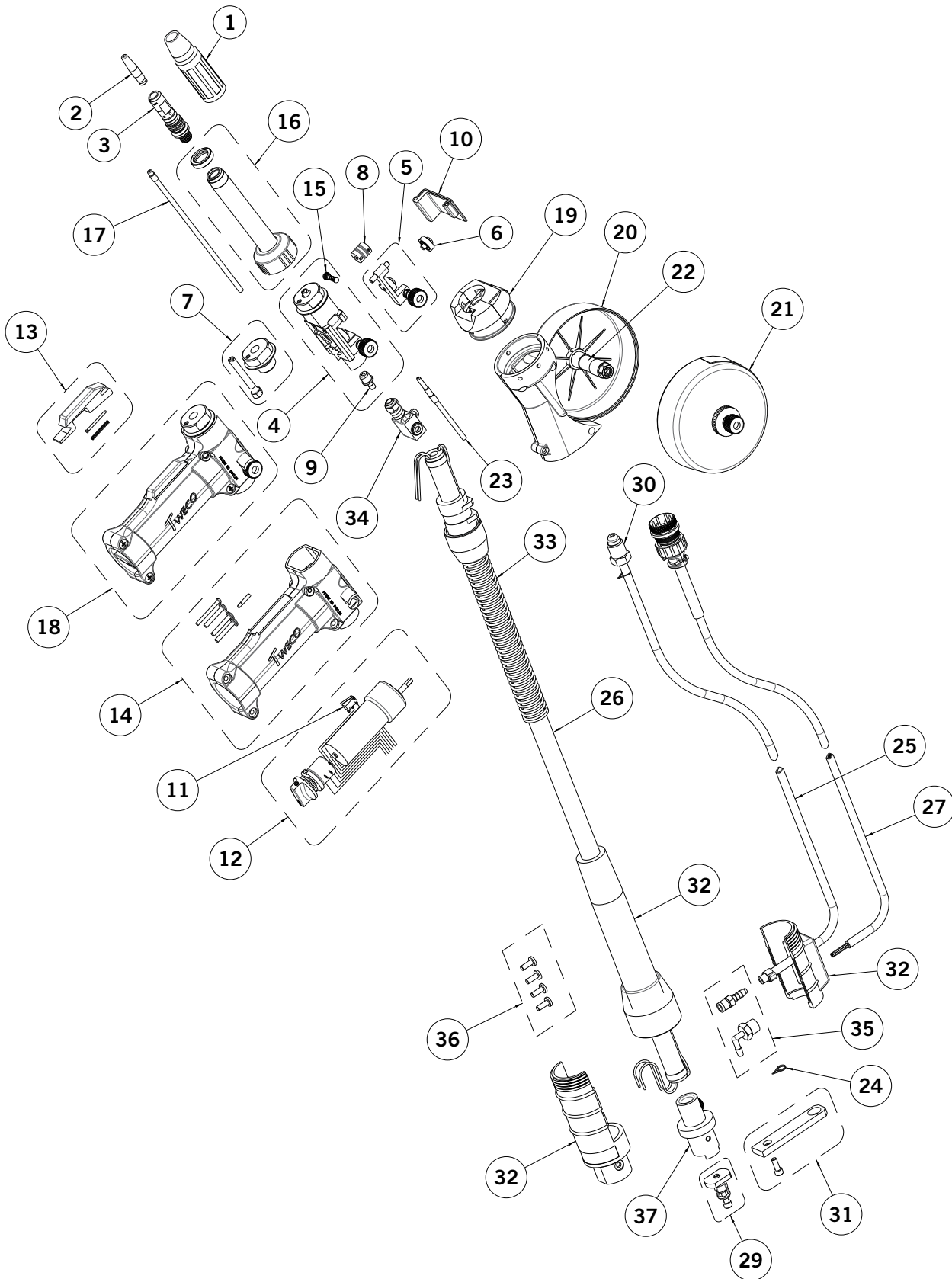
When using the 300A Spool Gun with Thermal Arc® ArcMaster® MST Series machines, use Thermal Arc SGI100 Spool Gun Interface Box, Part No. W4009115



MIG GUNS



Tweco® Spool Gun 300 Amp Replacement Parts



Tweco® Spool Gun 300 Amp Replacement Parts

#	Description	Part No.	Stock No.
1	Nozzle	EL24CT Series	
2	Contact Tip	EL16 Series	
3	Diffuser	EL54CT-SW	
4	Head Block Assembly	SPG103	2031-2100
5	Pressure Arm Assembly	SPG103-1	2060-1727
6	Idler Bearing Assembly	--	--
7	Adapter Nut & Wire Guide	EPG66-N	2031-2096
8	Drive Roll 0.030" (0.8 mm)	EPG103-2-08	2031-2091
	Drive Roll 0.035" (0.9 mm)	EPG103-2-09	2031-2077
	Drive Roll 0.040" (1.0 mm)	EPG103-2-10	2031-2023
	Drive Roll 3/64" (1.2 mm) Standard	EPG103-2-12	2031-2003
	Drive Roll 1/16" (1.6 mm)	EPG103-2-16	2031-2022
9	Gas Nipple & Wire Tie	--	--
10	Handle Cover Assembly	EPG86-2	2031-2013
11	Trigger Switch	ESG90	2025-2399
12	Motor Assembly (24VAC)	SSGM24	2031-2101
13	Trigger Lever	SPG-96TL	2060-2733
14	Handle Sub-Assembly	SSG86	2060-2739
15	Poppet Valve Assembly	PMP-PV	2060-2737
16	Conductor Tube 30 Degree	PMP64EL30	1642-1141
	Conductor Tube 180 Degree	PMP64EL180	1642-1140
	Flexible Conductor Tube	PMP64SFLX360	1642-1142
17	Jump Liner	PMP44PTF116	1644-1096
	Jump Liner Teflon	PMP-44FLX-116	1644-1095
	Jump Liner Copper	PMP-44-116	1644-1097
18	Spool Gun Assembly w/o Cable & Support	SSG300G	2031-2117
19	Pivot Assembly	ESG186	2025-2397
20	Spool Canister Assembly	ESG186S	2025-1392
21	Spool Cover Assembly	ESG186C	2025-2393
22	Friction Tube Replacement (5 PC)	ESG186S-3	2025-2385
23	Conduit Assembly	--	--
24	Wire Tie	BG-53N04	8040-1998
25	Gas Hose Assembly F/SSG Spool Gun	SSG3003GH	2060-2741
26	Extruded Spool Gun Cablehoz, 25 ft (8 m) Long	SSG30025	2060-2742
27	10 Pin Control Cable Assembly F/SSG Spool Gun	SSG300CW	2060-2744
28	Hex Wrench Set	--	--
29	25 mm Dinse Connector	SSG-DINS25	2035-2186
30	Rear Gas Nipple	EPG-RGN	2031-2083
31	Straight Lug	ESG-172SL	2031-2110
32	Rear Case Sub-Assembly	SSGT6RC	2031-2111
33	Front Strain Relief Assembly	SPG146R	2031-2112
34	Cable Connector Assembly	SPG102	2031-2113
35	Hose Barb Connector	ESG6RCUGN	2031-2114
36	10-24 X 1/2" BH Plastic Screw	SSG172PS	2031-2115
37	Rear Power Connector	ESG172	2031-2116
NS	Protective Cable Wrap, 50 ft (15 m) per box	TCR50	9900-1150

PullMaster™ MIG Gun Series

Features & Benefits

EXCELLENT SERVICE AND EASE OF OPERATION

- Ideal for aluminum, stainless steel and mild steel welding
- “Smart” capability with one-touch digital control to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim

COMFORTABLE HANDLE DESIGN

- Pistol grip

QUICK DISCONNECT CONDUCTOR TUBE

- Three layer conductor tube construction (copper tube/silicon-resin glass insulator/metal jacket)
- Standard straight (180°) conductor tube
- Optional 30° rigid conductor tube or Knucklehead™ flexible conductor tube

RUGGED & DURABLE

- Incorporates the Cablehoz® used on other Tweco® MIG guns

IMPROVED PERFORMANCE WITH LONGER LIFE CONSUMABLES

- Heavy duty contact tips in high heat applications
- Gun drilled contact tips for exceptionally smooth surface for improved feed-ability, consistency and longer tip life



Tweco PullMaster Smart MIG® Gun with digital display - use with Thermal Arc® SP machines only

Tweco PullMaster Standard MIG Gun



CONTROL BOX - Part No. EPG-CR2 (Stock No. 1028-1291)
Used to connect standard PullMaster to most welding machines and requires Jumper Cord - Part No. PMP354T (Stock No. 2031-2145)

MODEL	OUTPUT			PROCESS		STANDARD OPTIONS			APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Smart Capability	Standard without “Smart” Capability	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
PullMaster 300 Amp	300	60%	Up to 1/16" (1.6 mm)	●	●	●	●	●	●	●	

PullMaster™ Air-Cooled

300 Amp

60% Duty Cycle, Mixed Gases

Process – MIG, Aluminum. Available with Smart Capability, Standard without "smart" capability, and Rear Connector as standard options. Suitable for light to heavy duty fabrication. Standard Conductor Tube – PMP64EL-180 (Stock No. 1642-1140)

Smart Gun

PullMaster™ Smart MIG Guns are used only with Thermal Arc® SP machines

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

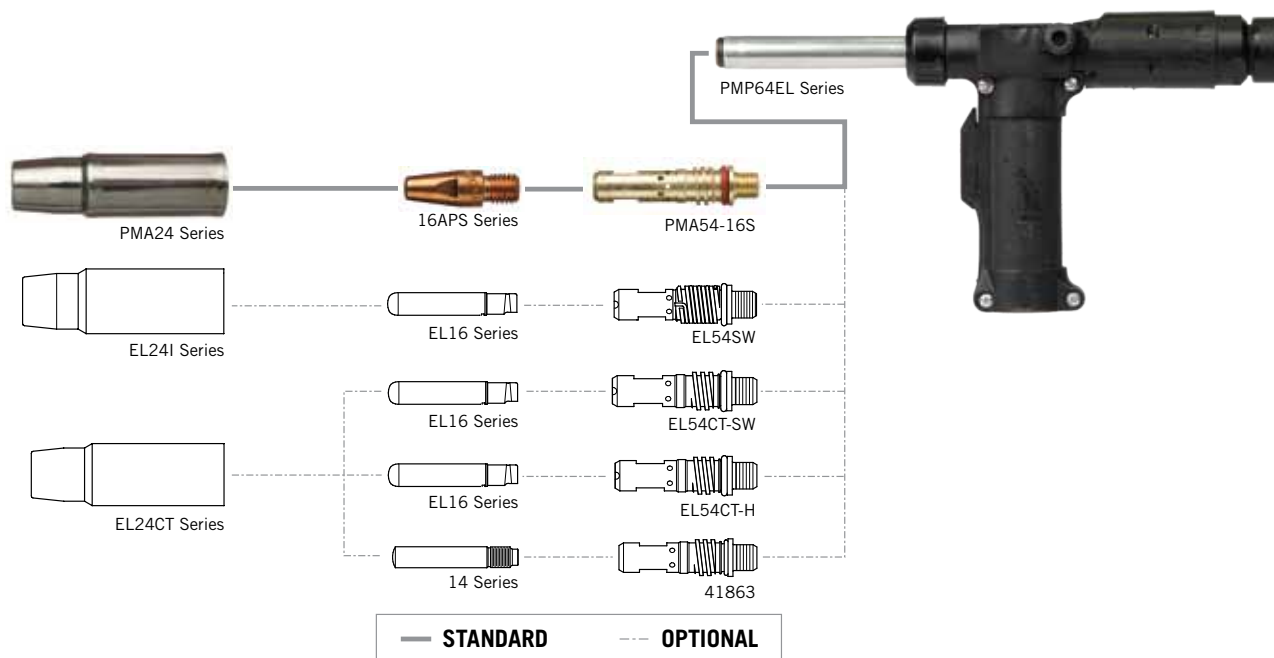
Standard Gun

Standard without "smart" capability

Tweco Style Rear Connector

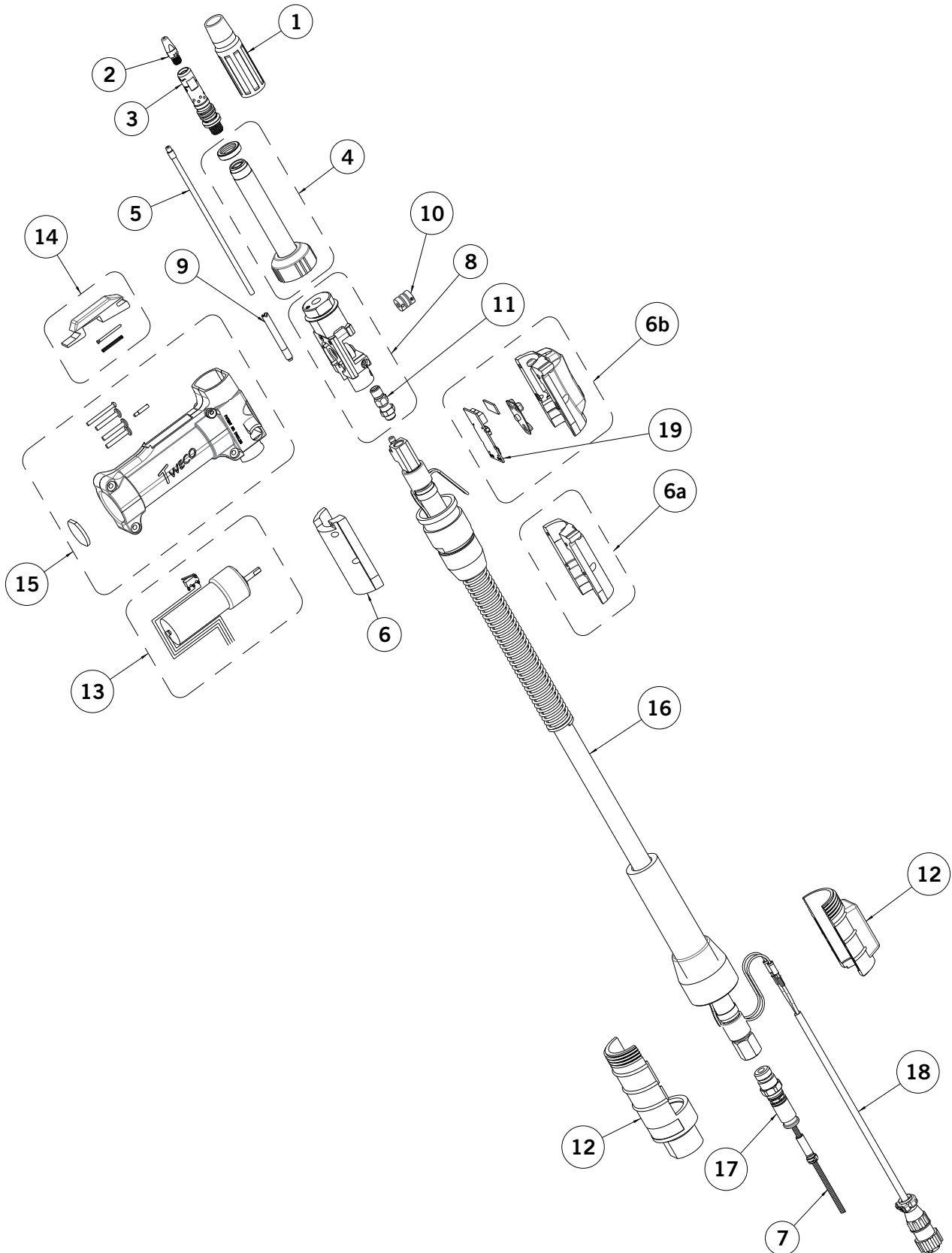
Adapter kits are available to fit Tweco rear connection to most wire feeders

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



PullMaster™ Air-Cooled Replacement Parts

MIG GUNS



PullMaster™ Air-Cooled Replacement Parts

#	Description	Part No.	Stock No.
1	Nozzle	PMA24 Series	
2	Contact Tip	16APS Series	
3	Diffuser	PMA54-16S	1543-1106
4	Conductor Tube	PMP64EL Series	
5	Teflon Jump Liner, Flex Tube	PMP-44FLX-116	1644-1095
	Teflon Jump Liner, Rigid Tubes	PMP-44PTF-116	1644-1096
	Bronze Jump Liner for Steel Wires, Rigid Tubes	PMP-44-116	1644-1097
6a	Support Assembly Front (Std.)	EPG186	2031-2046
6b	Support Assembly Front (Including Smart Cover, PCB Membrane, Lens & Lower Support)	PMPS186	2060-2725
7	33 ft (10 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Wire	PMP44-116-33	1441-1125
	50 ft (15 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Wire	PMP44-116-50	1441-1126
	33 ft (10 m) Conduit Assembly, .035" - .045" (0.9 mm - 1.1 mm) Wire	PMP44-3545-33	1441-1127
	33 ft (10 m) Conduit Assembly, 3/64" - 1/16" (1.2 mm - 1.6 mm) Steel Wire	PMPS44-116-33	1441-1129
	33 ft (10 m) Conduit Assembly, .035" - .045" (0.9 mm - 1.1 mm) Steel Wire	PMPS44-3545-33	1441-1131
8	Head Block Assembly	PMP103	2060-1726
NS	Pressure Arm Assembly	SPG103-1	2060-1727
9	Front Wire Guide Assembly	PMPS-106TA	2060-1729
10	Drive Roll .030" (0.8 mm) Wire	EPG103-2-0.8	2031-2091
	Drive Roll .035" (0.9 mm) Wire	EPG103-2-0.9	2031-2077
	Drive Roll .040" (1.0 mm) Wire	EPG103-2-1.0	2031-2023
	Drive Roll 3/64" (1.2 mm) Wire	EPG103-2-1.2	2031-2003
	Drive Roll 1/16" (1.6 mm) Wire	EPG103-2-1.6	2031-2022
	Drive Roll V-Groove 1/16" (1.6 mm) Steel Wire	EPG103-2-1.6V	2031-2134
	Drive Roll V-Groove 3/64" (1.2 mm) Steel Wire	EPG103-2-1.2V	2031-2135
	Drive Roll V-Groove .035" (0.9 mm) Steel Wire	EPG103-2-0.9V	2031-2136
11	Power Cable Connector Assembly	--	--
NS	Handle Cover Assembly	EPG86-2	2031-2013
12	Rear Case Assembly	PMP-T6RC	2060-2731
13	Motor Assembly (24VDC)	PMP-M24	2060-2732
14	Trigger Lever	SPG-96TL	2060-2733
15	Handle Assembly	SPG86	2060-2734
16	Cablehoz® Assembly 33 ft (10 m) Standard	PMP300-33	2060-2750
	Cablehoz Assembly 50 ft (15 m) Standard	PMP300-50	2060-2751
17	Connector Plug	Refer to Pages 74-75	
18	Control Wire (Standard)	MS354-DSM	2060-2140
19	Replacement PCB	PM85-PCB	2060-2738
NS	Hose Clamp (Package of 5)	BG-53N04	2031-2088
	Poppet Valve Assembly	PMP-PV	2060-2737
	Miller® Control Wire	EPG354M	2031-2086
	EPG-CR2 Jumper Wire	PMP354T	2031-2145
	Protective Cable Wrap, 50 ft (15 m) per box	TCR50	9900-1150

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

PulseMaster™ Water-Cooled MIG Gun Series

Features & Benefits

ONE-TOUCH, ON-THE-FLY CONTROLS

- “Smart” capability with one-touch digital control to adjust primary parameters such as welding current, material thickness, wire feed speed or arc length trim
- Standard MIG gun without “smart” capability

EXCEPTIONAL WELD BEAD

- Using twin-pulse mode, get the perfect weld bead that you want

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Ergonomic handle to reduce operator fatigue
- Low bench weight for easy to handle gun

DURABLE FOR INDUSTRIAL APPLICATIONS

- Heavy duty design for industrial application environments
- Impact resistant handle and trigger design

LOWER HEAT IN THE HANDLE AND CONDUCTOR TUBE

- Heavy duty contact tip and diffuser to act as “heat sink”
- Increased interface between contact tip & gas diffuser improves electrical conductivity

IMPROVED PERFORMANCE WITH LONGER LIFE CONSUMABLES

- Heavy duty contact tips in high heat applications
- Gun drilled contact tips for exceptionally smooth surface for improved feedability, consistency and longer tip life



Tweco®
PulseMaster
Smart MIG® Gun
with digital
display - use with
Thermal Arc® SP
machines only

Tweco Standard
PulseMaster
MIG Gun

MODEL	OUTPUT			PROCESS		STANDARD OPTIONS			APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Smart Capability	Standard without “Smart” Capability	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
PulseMaster 400	400	100%	Up to .045" (1.2 mm)	●	●	●	●	●	●	●	
PulseMaster 500	500	100%	Up to .045" (1.2 mm)	●	●	●	●	●			●

MIG Guns

PULSEMASTER™ WATER-COOLED SERIES

PulseMaster™ Water-Cooled 400 Amp

100% Duty Cycle,
Mixed Gases

Process – MIG, Aluminum. Available with Smart Capability, Standard without "smart" capability, and Rear Connector as standard options. Suitable for heavy duty fabrication. Standard Conductor Tube – PMP64EL-180 (Stock No. 1642-1140); Conduit Liner – 44 Series

Smart Gun

PulseMaster Smart MIG Guns are used only with Thermal Arc® SP machines

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMWS412-3545	1042-1510
	15 ft (5 m)	PMWS415-3545	1042-1511

Standard Gun

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 (4 m)	PMW412-3545	1042-1500
	15 ft (5 m)	PMW415-3545	1042-1501

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	15 ft (5 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 (4 m)	PMWS312X-3545	1042-1515

Lincoln® Style Rear Connector

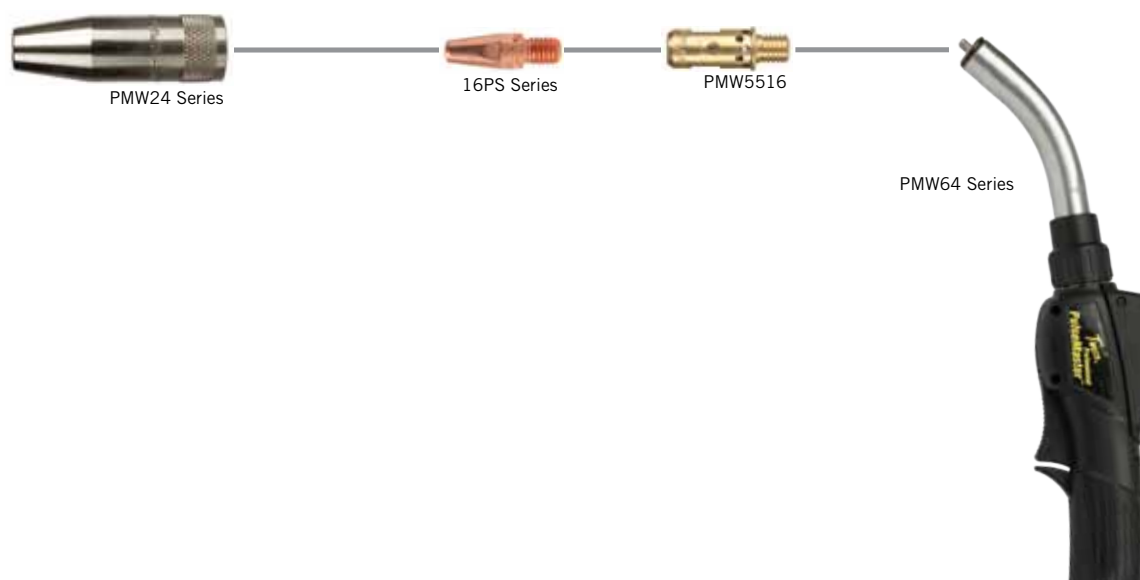
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMW412L-3545	1042-1503

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

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMW412X-3545	1042-1505



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

PulseMaster™ Water-Cooled 500 Amp

100% Duty Cycle,
Mixed Gases

Process – MIG, Aluminum. Available with Smart Capability, Standard without "smart" capability, and Rear Connector as standard options. Suitable for heavy duty fabrication. Standard Conductor Tube – PMP64EL-180 (Stock No. 1642-1140); Conduit Liner – 44 Series

Smart Gun

PulseMaster Smart MIG Guns are used only with Thermal Arc® SP machines

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMWS512-3545	1042-1535

Standard Gun

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 (4 m)	PMW512-3545	1042-1525
	15 ft (5 m)	PMW515-3545	1052-1526

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 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 (4 m)	PMWS512X-3545	1042-1540

Lincoln® Style Rear Connector

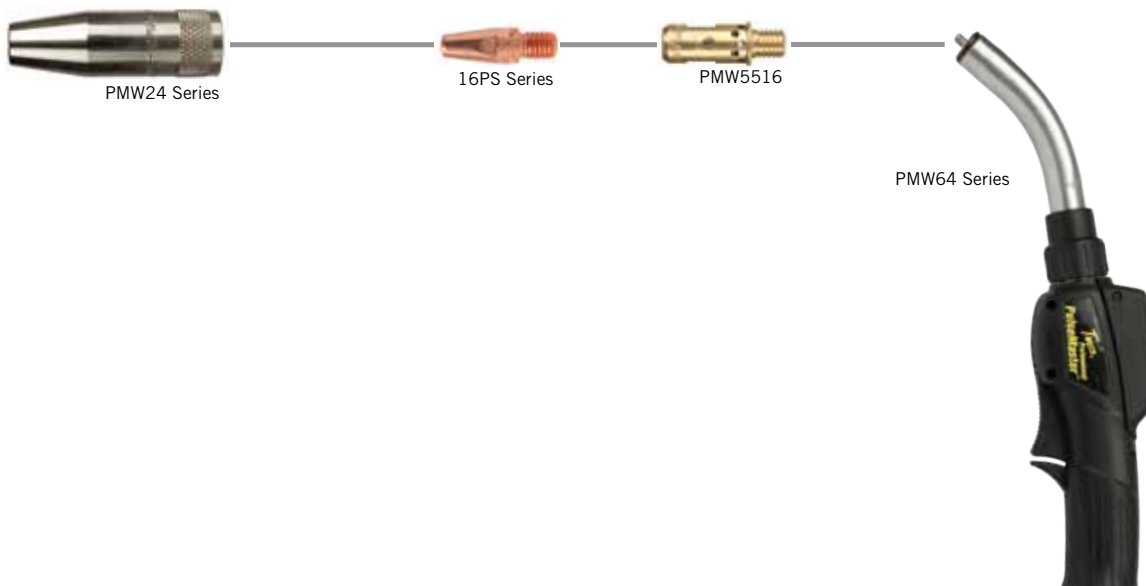
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMW512L-3545	1042-1528

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

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (4 m)	PMW512X-3545	1042-1530
	15 ft (5 m)	PMW515X-3545	1042-1531



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Tweco® Water Coolers

TC900 & TCV900

- Vertical or horizontal models available
- Designed for MIG guns up to 500A and TIG torches up to 500A
- 2 gallon reservoir
- 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
- Available with either Gear or Vane pumps
- 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



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

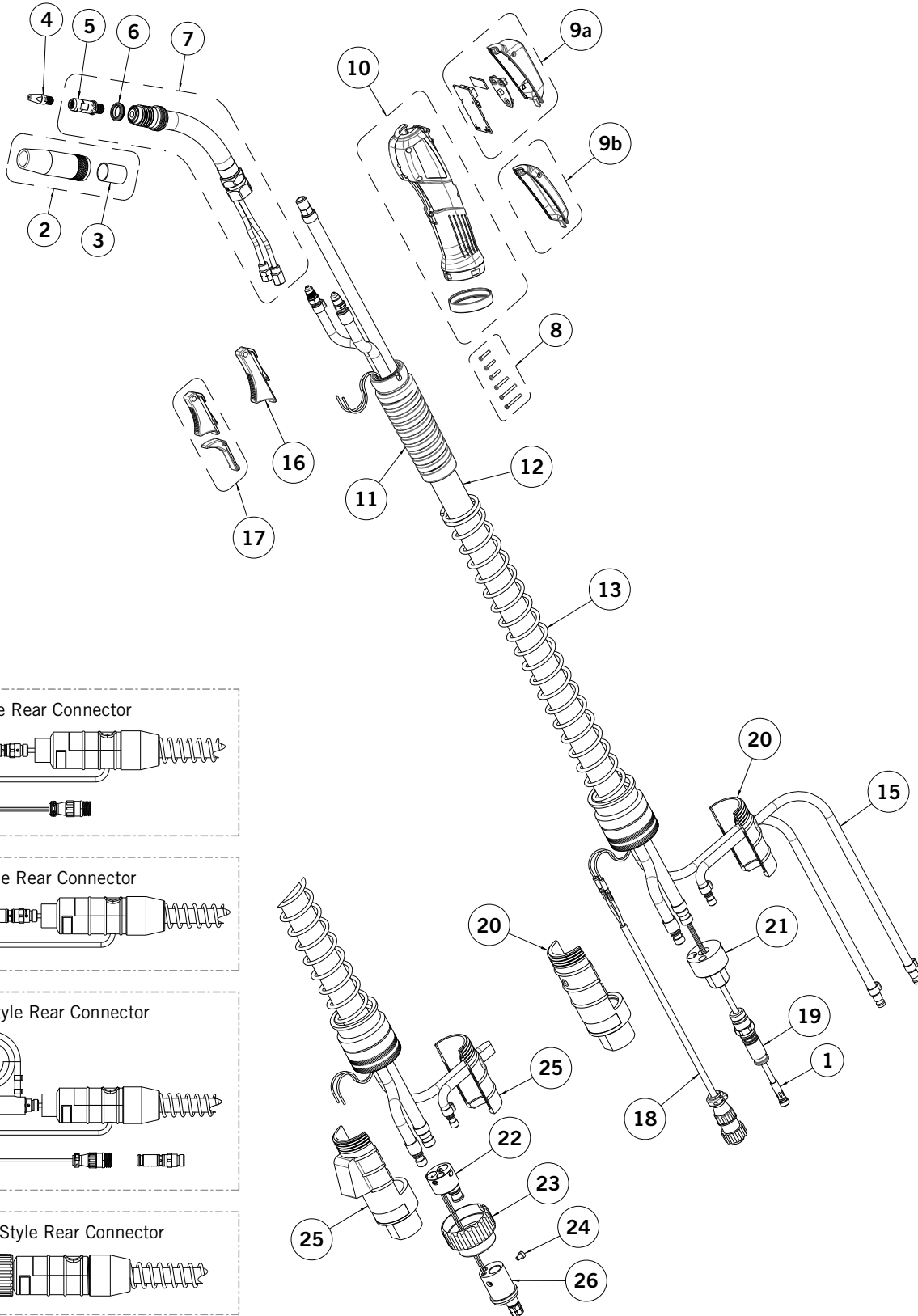


TCV900 Water Cooler

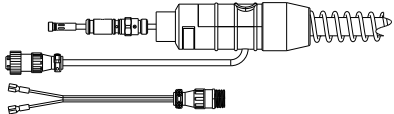
Description	Part No.	Stock No.
Cooler w/ Gear Pump 110V - 50/60 Hz	TCV900-G	4010-1035
Cooler w/ Vane Pump 110V - 50/60 Hz	TCV900-V	4010-1036

PulseMaster™ Water-Cooled Replacement Parts

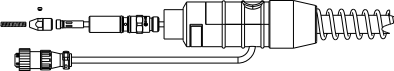
MIG GUNS



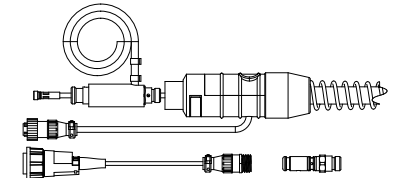
Tweco Style Rear Connector



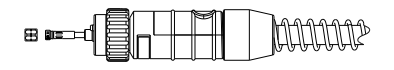
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

PulseMaster™ Water-Cooled Replacement Parts

#	Description	Part No.	Stock No.
1	Conduit Assembly	Refer to Pages 96-99	
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
12	12 ft (4 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

SUPRA® Water-Cooled MIG Gun

Features & Benefits

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Ergonomic handle to reduce operator fatigue
- Low bench weight for easy to handle gun

PROVIDES COOLING BENEFITS FOR THE FRONT END CONSUMABLES

- Cool running for maximum efficiency and comfort
- Increase “weld” life of front end consumables
- Large water lines for maximum cooling
- High water flow rates

INCREASED DUTY CYCLE AT HIGH AMPERAGE APPLICATIONS

- 450A series MIG guns @ 100% duty cycle

RUGGED & DURABLE

- Outer cover protects the power cable, water lines and gas hose from weld spatter/abrasion

FIELD REPAIRABLE

- Replacement cable assemblies available – power cable, water-lines, and gas hose
- Color coded water lines for easy identification to water-in & water-out

EASE OF USE

- Quick water line connections making hook-up easy (Euro style)
- Simplified direct rear plug connections
- Adapts easily to Miller® and Lincoln® style machines



MODEL	OUTPUT			PROCESS		STANDARD OPTIONS	APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
SUPRA 450	450	100%	Up to 1/16" (1.6 mm)	●	●	●		●	●

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

SUPRA® Water-Cooled 450 Amp

Up to 1/16" (1.6 mm)

100% Duty Cycle, CO₂

Process – MIG, Aluminum. Available with Rear Connector as a standard option. Suitable for medium to heavy duty fabrication. Standard Conductor Tube – SW64-60 (Stock No. 1644-1125); Conduit Liner – 44 Series



MIG GUNS

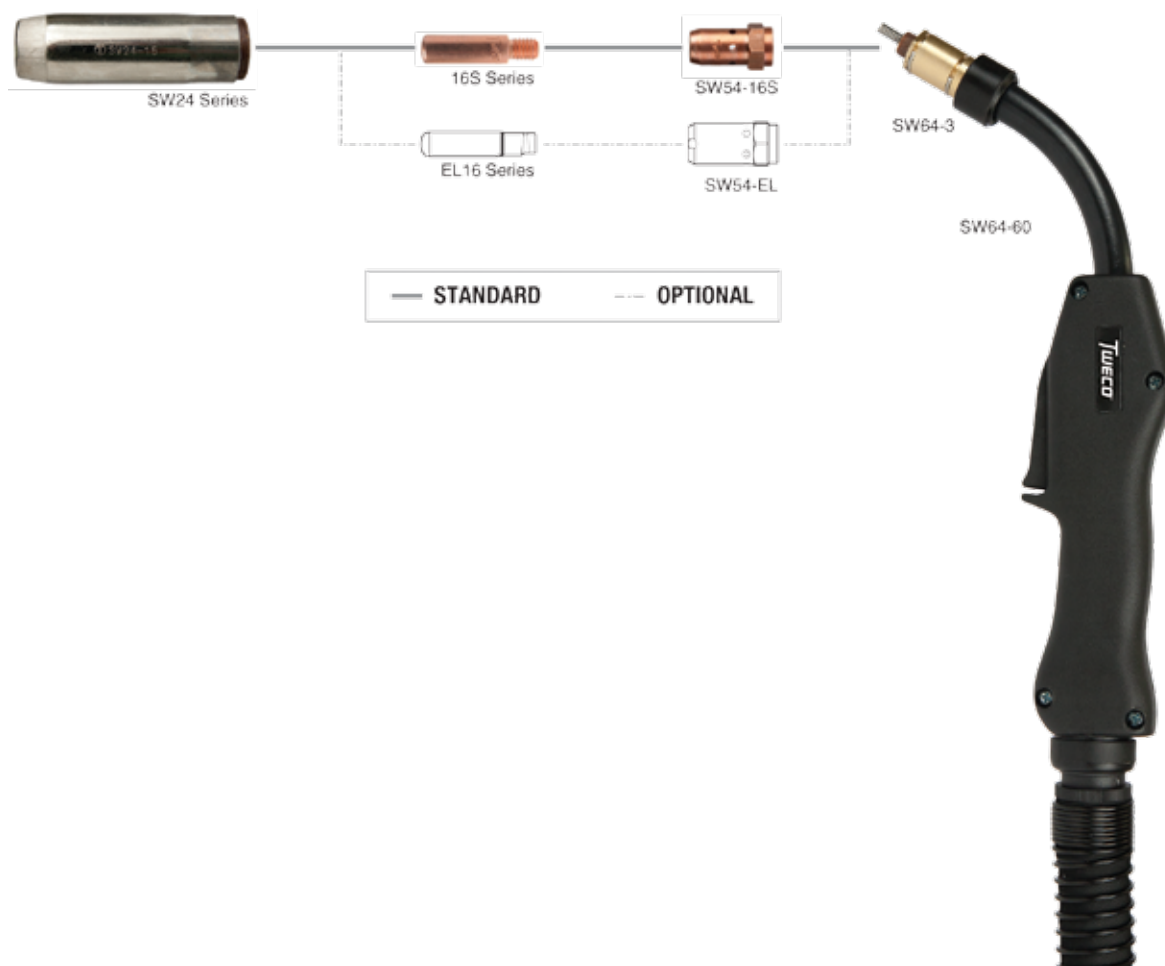
Tweco® Style Rear Connector

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)	15 ft (5 m)	SW415-3545	1044-1152
Up To 1/16" (1.6 mm)	15 ft (5 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 (5 m)	SW415M-116	1044-1182



MIG GUNS



SUPRA® Water-Cooled 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 80	
	16S Series Contact Tip	Refer to Page 79	
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
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 with Screws	SW184	2044-1011
27	Water Outlet Hose (sold per foot)	SW400-WHO	1742-2243
28	Male Wire Terminal	SW194-M	2044-1003
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 Pages 96-99	
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

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Standard Water-Cooled MIG Gun

Features & Benefits

OPERATOR APPEAL AND REDUCES OPERATOR FATIGUE

- Ergonomic handle to reduce operator fatigue
- Low bench weight for easy to handle gun

PROVIDES COOLING BENEFITS FOR THE FRONT END CONSUMABLES

- Cool running for maximum efficiency and comfort
- Increase "weld" life of front end consumables
- Large water lines for maximum cooling
- High water flow rates

INCREASED DUTY CYCLE AT HIGH AMPERAGE APPLICATIONS

- 600A series MIG guns @ 100% duty cycle
- Large diameter wire capacity up to 7/64"

RUGGED & DURABLE

- Outer cover protects the power cable, water lines and gas hose from weld spatter/abrasion

FIELD REPAIRABLE

- Replacement cable assemblies available – power cable, water-lines, and gas hose
- Color coded water lines for easy identification to water-in & water-out

EASE OF USE

- Threaded water line connections making hook-up easy (LH CGA)
- Simplified direct rear plug connections
- Adapts easily to Miller® and Lincoln® style machines



MODEL	OUTPUT			PROCESS		STANDARD OPTIONS	APPLICATION		
	Current (Amps)	Duty Cycle Mixed Gases	Wire Diameter in (mm)	MIG	Aluminum	Rear Connector	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
Standard 600	600	100%	Up to 3/32" (2.4 mm)	●	●	●		●	●

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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

Standard Water-Cooled 600 Amp

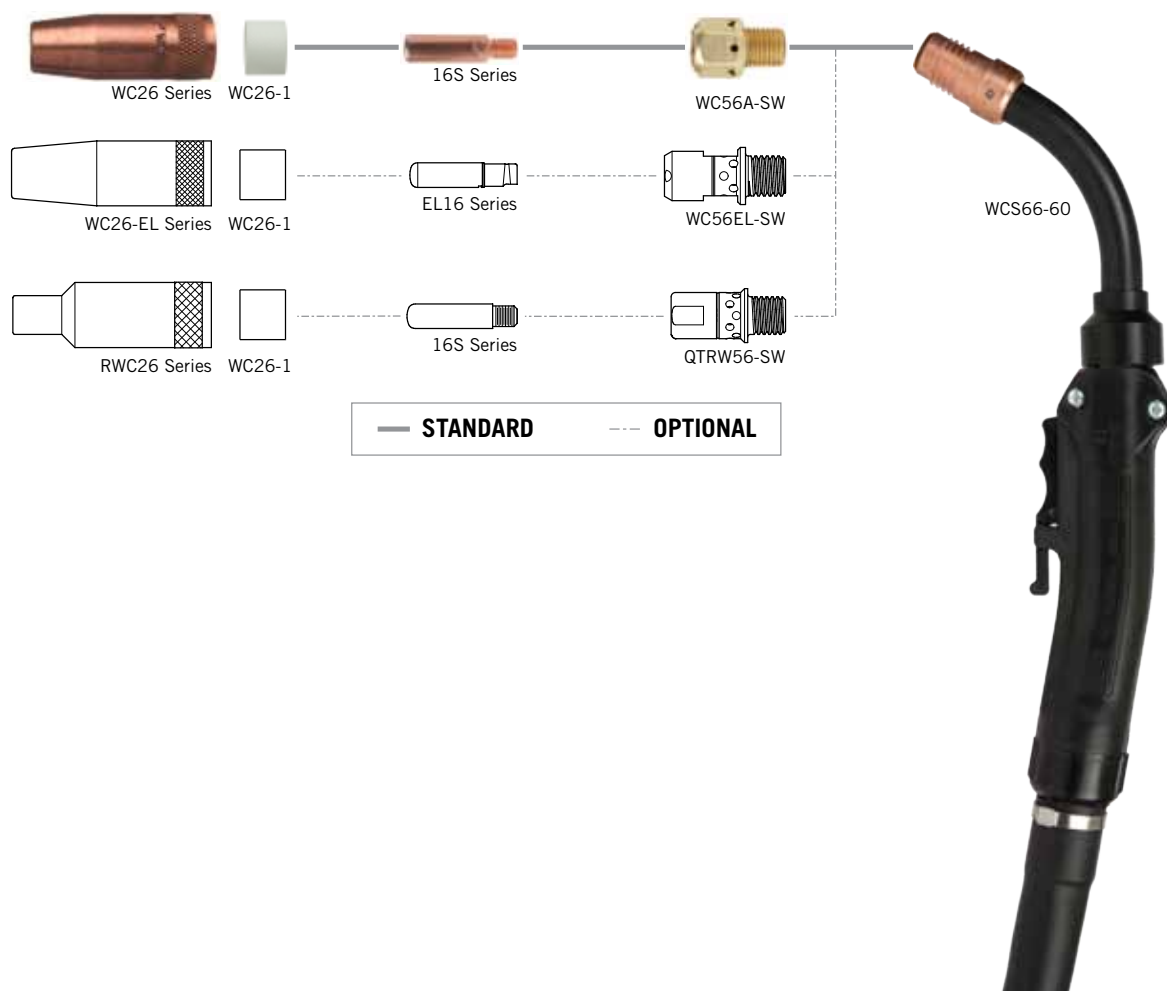
100% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector. Suitable for medium to heavy duty fabrication. Standard Conductor Tube – WCS66-60 (Stock No. 1664-1106); Conduit Liner – 45 Series

Tweco® Style Rear Connector

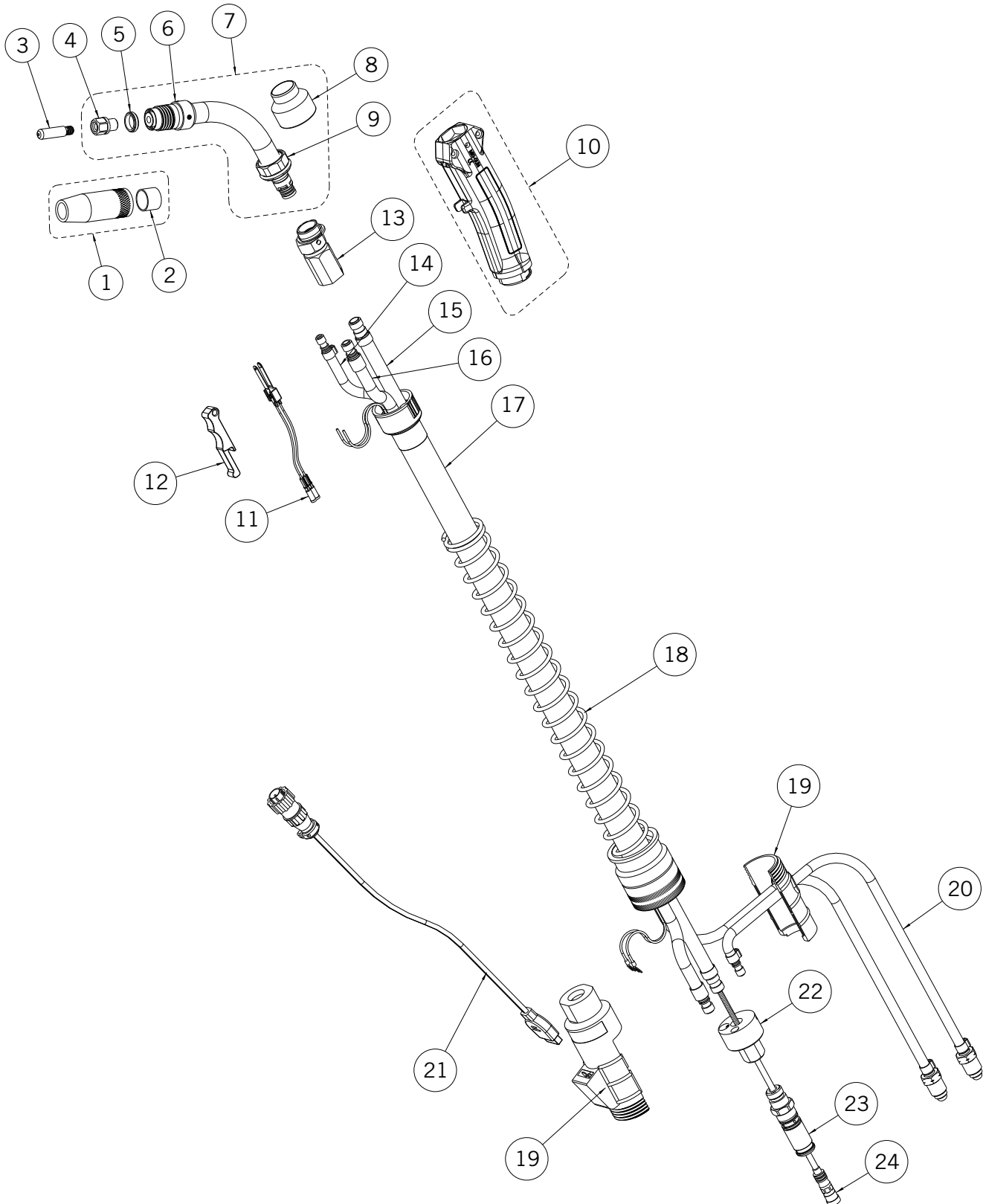
Adapter kits are available to fit Tweco rear connection to most wire feeders

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	WCS610-116	1064-1114
Up To .045" (1.2 mm)	15 ft (5 m)	WCS615-3545	1064-1106
Up To 1/16" (1.6 mm)	15 ft (5 m)	WCS615-116	1064-1116



Standard Water-Cooled Replacement Parts

MIG GUNS

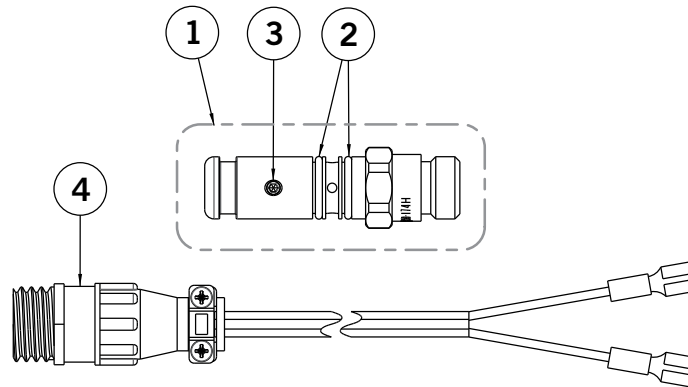


Standard Water-Cooled Replacement Parts

#	Description	Part No.	Stock No.
1	Nozzle	WC26 Series	
2	Spatter Shield	WC26-1	1264-1009
3	Contact Tip	16S Series	
4	Diffuser	WC56A-SW	
5	Pressure Ring Insulator	WC36-R	2064-1036
6	Conductor Tube Housing	WCS36-H	1344-1145
7	Conductor Tube	WCS66-60	
8	Nut Cover Insulation	--	--
9	Locking Nut	WC66-N	2064-2067
10	Handle Assembly	W6R-H	2064-2031
11	Trigger Blade Assembly	EL96-B	2060-2606
12	Trigger	EL96	2060-2605
13	Front Connector Block	WC106	2064-2106
14	Water Hose IN, 10 ft (3 m)	WC610-WH	1764-2131
	Water Hose IN, 12 ft (4 m)	WC612-WH	1764-2132
	Water Hose IN, 15 ft (5 m)	WC615-WH	1764-2133
15	Gas Hose, 10 ft (3 m)	WC610-GH	1764-2121
	Gas Hose, 12 ft (4 m)	WC612-GH	1764-2122
	Gas Hose, 15 ft (5 m)	WC615-GH	1764-2123
16	Power Cable, 10 ft (3 m)	WC610-PC	1764-2111
	Power Cable, 12 ft (4 m)	WC612-PC	1764-2112
	Power Cable, 15 ft (5 m)	WC615-PC	1764-2113
17	Complete Cable Assembly, 10 ft (3 m)	WC600-10	1764-2101
	Complete Cable Assembly, 12 ft (4 m)	WC600-12	1764-2102
	Complete Cable Assembly, 15 ft (5 m)	WC600-15	1764-2103
18	Rear Strain Relief Spring	QR-SPHD	3045-1178
19	Rear Case	W6RC	2064-2600
20	Water Hose Out	WC603-WH	1764-2130
21	Control Wire (Tweco®)	MAK-354	2642-2460
	Control Wire (Miller®)	MSAK-354	2642-2470
	Control Wire (Lincoln®)	LAK-354	2642-2450
22	Rear Connector Block (Direct Plug)	WC6-170H	2064-2171
	Rear Connector Block (Euro Plug)	WC174X-B	2044-2182
23	Connector Plug	Refer to Pages 74-75	
24	Conduit Assembly	Refer to Pages 96-99	

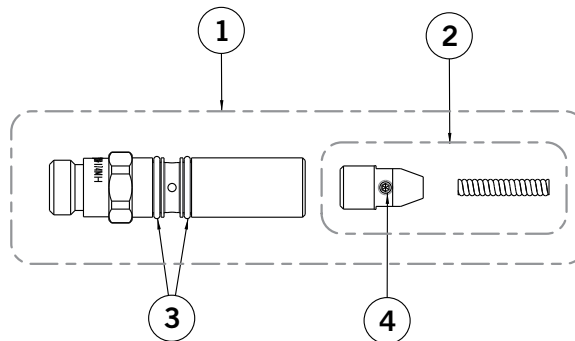
Tweco® MIG Gun Direct Plug & Control Wire Jumpers

MIG GUNS



Tweco Style

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

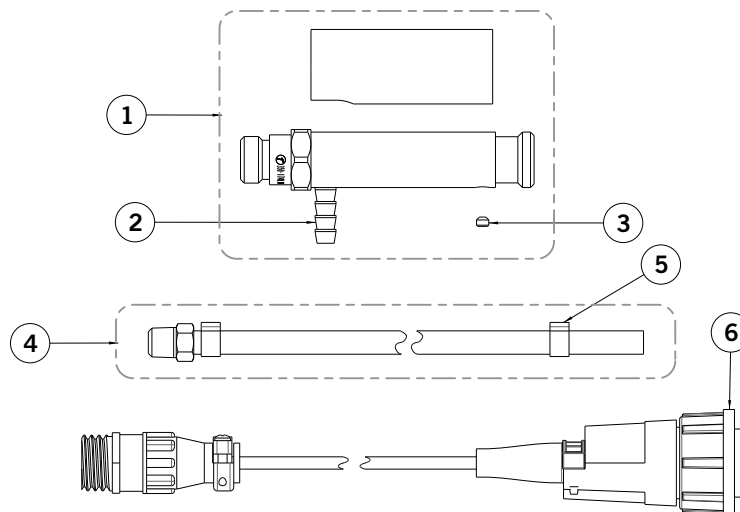


Miller® Style

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

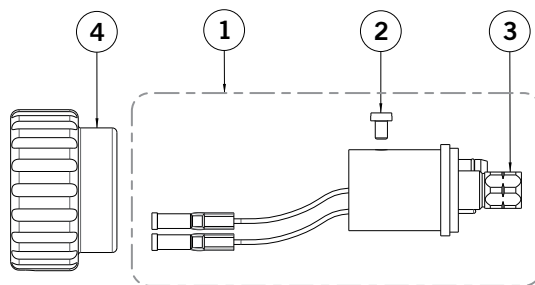
Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies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

Tweco® MIG Gun Direct Plug & Control Wire Jumpers



Lincoln® Style

#	Description	100 - 450A		500 - 600A	
		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 - 450A		500 - 600A	
		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

Enhanced Design of VELOCITY™ Front-end Consumables

Velocity Has One Less Connection in Conductor Path

... Has 2 Less Thread Sets

... Has 2 Less Parts

VELOCITY NOZZLE



Heavy Duty
Copper

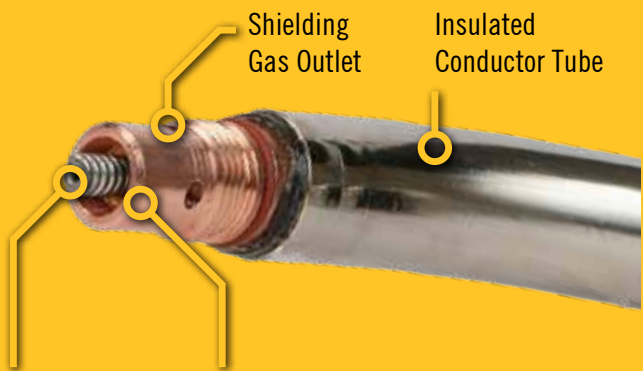
VELOCITY CONTACT TIP

Roll Stamp With Size



Large Copper to Copper Surface
Contact for Superior Thermal
and Electrical Efficiency

CONDUCTOR TUBE



Perfectly
Centered Liner

Conduit Liner Seats Inside the
Tip for Superior Feedability

Features and Benefits

- Direct Copper to Copper Connection Provides Superior Conductivity
- Conduit Liner Centered and Seated Directly into Back of the Contact Tip Provides Superior Feed-Ability
- Fewer Connections in the Conductor Path (One Fewer than Typical) Means Superior Conductivity
- Fewer Threads (One Set versus Two or Three) Means Less Seizing or Cross-Threading
- No Threads on the Contact Tip Means a Burn-Back Will Not Lock Up for Easier Replacement
- No Threads on the Contact Tip Allows for 'Clocking' to a Different Wear Pattern – Longer Tip Life
- A Cooler Running Contact Tip Means A More Stable Arc and Less Spatter Adherence
- Less Spatter Means Longer Tip Life and Less Cleaning
- Finally, A More Stable Arc Means Easier, More Forgiving Welding

Tweco® VELOCITY™ Consumables

VELOCITY Contact Tips

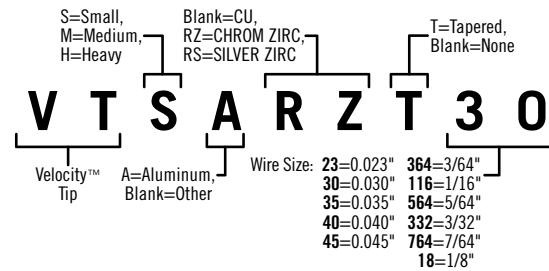
25 per pack

Wire Size (in / mm)	Standard Part No.
.023" (0.6 mm)	VTS-23
.030" (0.8 mm)	VTS-30
.035" (0.9 mm)	VTS-35
.040" (1.0 mm)	VTS-40
.045" (1.2 mm)	VTS-45
3/64" AL (1.2 mm)	VTSA-364
.052" (1.3 mm)	VTS-52
1/16" (1.6 mm)	VTS-116
1/16" AL (1.6 mm)	VTSA-116
5/64" (2.0 mm)	VTS-564

Note: Only for use with Tweco Fusion MIG Guns



VELOCITY™ CONTACT TIP IDENTIFICATION



CONSUMABLES

VELOCITY Nozzles

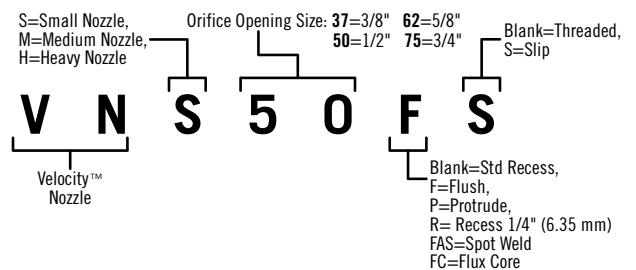
Self Insulated Nozzles. 2 per pack

Nozzle Style	Bore Diameter	Part No.	Nozzle/ Contact Tip Relationship
Slip-On	1/2" (12.7 mm)	VNS-50F	Flush
	1/2" (12.7 mm)	VNS-50	Std Recess
	3/8" (9.5 mm)	VNS-37F	Flush
	3/8" (9.5 mm)	VNS-37	Std Recess
	5/8" (15.9 mm)	VNS-62F	Flush
	5/8" (15.9 mm)	VNS-62	Std Recess
	3/4" (19.5 mm)	VNS-75FAS	--
	Flux Cored	VNS-FC	--

Note: Only for use with Tweco Fusion MIG Guns



VELOCITY™ NOZZLE IDENTIFICATION



Standard Threaded Style Contact Tips

11, 11H & 11T Series

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

25 per pack



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

14, 14H, & 14T Series

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

25 per pack



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

15H & 15HFC Series

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

25 per pack



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

Standard Threaded Style Contact Tips

16S & 16ST Series

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

25 per pack



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

Long Life Threaded Style Contact Tips

11RZ 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		Tapered	
		Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.041" (1.04 mm)	11RZ-35	1110-1220	--	--

14RZ & 14RZT Series

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

25 per pack



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

16RZ & 16RZT Series

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

25 per pack



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

Long Life PulseMaster® Threaded Style Contact Tips

16PS Series

0.375" (9.5 mm) Outside Diameter - M8 x 1.25 Threads - 1.181" (30 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" (0.9 mm)	16PS-30	1160-1543	--	--
.035" (0.9 mm)	.041" (1.04 mm)	16PS-35	1160-1535	--	--
.045" (1.2 mm)	.051" (1.30 mm)	16PS-45	1160-1537	--	--
.047" (1.2 mm)	.064" (1.63 mm)	16APS-364	1160-1538	--	--
.052" (1.3 mm)	.058" (1.50 mm)	16PS-52	1160-1541	--	--

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

Eliminator® Style Contact Tips

EL16 & EL16T Series

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

25 per pack



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

Long Life Eliminator Style Contact Tips

EL16RZ & EL16RZT Series

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

25 per pack



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

Air-Cooled Nozzles and Nozzle Insulators

21 Series

3-Piece Nozzle Design - 0.750" (19.05 mm) Outside Diameter

Self Insulated Nozzles. 2 per pack



21 Series

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

REL 21 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. 2 per pack



REL 21 Series

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

22 Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter

Use with Nozzle Insulator Part No. 32 (Stock No. 1320-1100). 2 per pack



22 Series



32 Insulator
(sold separately)

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

HD22 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. 2 per pack



HD22 Series

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

Air-Cooled Nozzles and Nozzle Insulators

23 Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. 2 per pack



23 Series

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

23T Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. 2 per pack



23T Series

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

23H Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. 2 per pack



23H Series

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

24A Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter

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



24A Series



34A Insulator
(sold separately)

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

Air-Cooled Nozzles and Nozzle Insulators

24CT Series

Coarse Thread Nozzle - 1.070" (27.2 mm) Outside Diameter at the knurled flat section

Use with Nozzle Insulator Part No. 34CT (Stock No. 1340-1400). 2 per pack



24CT Series

34CT Insulator
(sold separately)

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

24FN Series

Fine Thread Nozzle - 1.070" (27.2 mm) Outside Diameter at the knurled flat section

Use with Nozzle Insulator Part No. 34FN (Stock No. 1340-1401). 2 per pack



24FN Series

34FN Insulator
(sold separately)

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

HD24 Series

3-Piece Nozzle Design - 1.117" (28.4 mm) Outside Diameter

Self Insulated Nozzles. Use with HD54 Series Gas Diffusers. 2 per pack



HD24 Series

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

†Outer shell made from red brass Alloy 230

Air-Cooled Nozzles and Nozzle Insulators

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)	PMA24-50F	1260-1710	Straight	Flush To 1/16" (1.6 mm)
	1/2" (12.7 mm)	PMA24-50	1260-1711	Straight	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	PMA24-62F	1260-1712	Straight	Flush To 1/16" (1.6 mm)
	5/8" (15.9 mm)	PMA24-62	1260-1713	Straight	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	PMA24H-62	1260-1720	Straight	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	PMA24-75F	1260-1714	Straight	Flush To 1/16" (1.6 mm)
	3/4" (19.5 mm)	PMA24-75	1260-1715	Straight	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	PMA24H-75	1260-1721	Straight	0.156" (3.9 mm) Tip Recess

25CT Series

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)	25CT-50	1250-1410	Standard	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	25CT-62	1250-1420	Standard	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	25CT-75	1250-1430	Standard	1/8" (3.2 mm) Tip Recess

25I Series

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)	25I-62	1250-1120	Standard	5/32" (3.97 mm) Tip Recess
	3/4" (19.5 mm)	25I-75	1250-1130	Standard	5/32" (3.97 mm) Tip Recess

26CT Series

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)	26CT-62	1260-1420	Standard	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	26CT-75	1260-1430	Standard	1/8" (3.2 mm) Tip Recess

26I Series

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)	26I-62	1260-1120	Standard	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	26I-75	1260-1130	Standard	1/8" (3.2 mm) Tip Recess

Air-Cooled Flat Arc Spot Nozzles

FAS Series

Self Insulated Nozzle. 2 per pack



21-62FAS

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

FAS Series

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



24A-100FAS



34A Insulator
(sold separately)

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

FAS Series

Use with Nozzle Insulator Part No. 35CT (Stock No. 1350-1400).
2 per pack



25CT-162FAS



35CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1-5/8" (41.3 mm)	25CT-162FAS	1250-1570	--	--

Air-Cooled Eliminator Nozzles

EL22I Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. Use with Part No. EL52 (Stock No. 1560-1110) Gas Diffuser. 2 per pack



EL21I Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	EL22I-37	1260-1601	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	EL22I-50	1260-1602	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	EL22I-50P	1260-1686	Standard	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	EL22I-62	1260-1603	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	EL22I-75	1260-1604	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

EL22CT Series

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Self Insulated Nozzles. Use with Part No. EL52CT Series Gas Diffuser. 2 per pack



EL22CT Series

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

Air-Cooled Eliminator Nozzles

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)	EL24I-37	1260-1606	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	EL24I-50	1260-1607	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	EL24I-62	1260-1608	Tapered	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	EL24I-62R	1260-1677	Tapered	3/8" (9.5 mm) Tip Recess
	5/8" (15.9 mm)	EL24I-62H	1260-1631	Tapered, Heavy-Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	EL24I-75	1260-1609	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	EL24I-75H	1260-1632	Tapered, Heavy-Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

EL24CT SERIES

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)	EL24CT-37	1260-1650	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	EL24CT-50	1260-1651	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	EL24CT-50P	1260-1701	Standard	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	EL24CT-62	1260-1652	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	EL24CT-62F	1260-1667	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	EL24CT-62R	1260-1682	Standard	3/8" (9.5 mm) Tip Recess
	5/8" (15.9 mm)	EL24CT-62H	1260-1657	Standard, Heavy-Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	EL24CT-75	1260-1653	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	EL24CT-75H	1260-1658	Standard, Heavy-Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

REL24 SERIES

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)	REL24CT-50	1240-1305	Straight	5/32" (3.97 mm) Tip Recess
	1/2" (12.7 mm)	REL24CT-50F	1240-1315	Straight	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	REL24CT-50P	1240-1310	Straight	5/32" (3.97 mm) Tip Protruding
	5/8" (15.9 mm)	REL24CT-62	1240-1306	Straight	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	REL24CT-62F	1240-1316	Straight	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	REL24CT-62P	1240-1311	Straight	5/32" (3.97 mm) Tip Recess
	3/4" (19.5 mm)	REL24CT-75F	1240-1317	Straight	Flush To 1/16" (1.6 mm) Tip Recess
	3/4" (19.5 mm)	REL24CT-75P	1240-1312	Straight	5/32" (3.97 mm) Tip Protruding



Water-Cooled Nozzles

SW24 SERIES

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



SW24 Series



SW64-3
(sold separately)

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

WC26 SERIES - STANDARD

3-Piece Nozzle Design - 1.062" (30 mm) Outside Diameter

Use with Spatter Shield Part No. WC26-1 (Stock No. 1264-1009).
2 per pack



WC26 Series



WC26-1
(sold separately)

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

*Use with Eliminator style contact tips

RWC26 SERIES

Nickel plated nozzles. Use with Insulator Ring Part No. SW64-2 (Stock No. 2044-1020). 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)	RWC26-50	1264-1430	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	RWC26-62	1264-1431	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	RWC26-75	1264-1432	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

PMW24 SERIES PulseMaster™ Water-Cooled Nozzles

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)	PMW24-50F	1260-1735	Standard	Flush To 1/2" (12.5 mm)
	1/2" (12.7 mm)	PMW24-50	1260-1736	Standard	0.156" (3.9 mm) Tip Recess
	5/8" (15.9 mm)	PMW24-62F	1260-1737	Standard	Flush to 5/8" (16 mm)
	5/8" (15.9 mm)	PMW24-62	1260-1738	Standard	0.156" (3.9 mm) Tip Recess
	3/4" (19.5 mm)	PMW24-75F	1260-1739	Standard	Flush To 3/4" (19 mm)
	3/4" (19.5 mm)	PMW24-75	1260-1740	Standard	0.156" (3.9 mm) Tip Recess

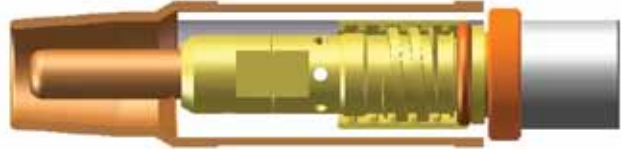
MIG Gun Nozzle to Tip Relationship

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.

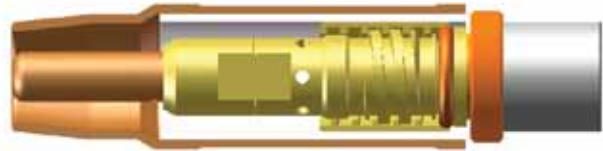
Recessed Tips

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.



Air-Cooled Standard Gas Diffusers

MINI-MIG SERIES 5 per pack



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

51 SERIES 5 per pack



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

52 SERIES 5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
52	1520-1101	Brass	14 Series	22 Series
52FN	1520-1102	Brass	14 Series	24A or 23 Series
MS52T-11	1520-1133	Brass	11 Series	22 Series

54 SERIES 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 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 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

Air-Cooled Eliminator® Style Gas Diffusers



EL52 SERIES 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 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)



EL54 SERIES 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

Water-Cooled Style Gas Diffusers



400 AMP 5 per pack

QTRW56-SW

Part No.	Stock No.	Material	Contact Tip	Nozzle
SW54-16S	1540-1115	Brass	16S Series	SW24 Series
SW54-EL	1540-1116	Brass	EL16 Series	SW24 Series
QTRW54	1544-1125	Brass	14H Series	RWC24 Series
QTRW54-16	1544-1126	Brass	16S Series	RWC24 Series



WC56A-SW



WC56EL-H

600 AMP 5 per pack

Part No.	Stock No.	Material	Contact Tip	Nozzle
WC56A-SW	1564-1145	Brass	16S Series	WC26 or RWC26 Series
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

Knucklehead™ Flexible Conductor Tubes

Engineered to Last Longer

Patent Pending mechanical connections engineered to last 50x 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 no.

Heavy Duty performance even on your 80% Duty Cycle guns



Bend up to an 60° Angle

- Specially engineered to bend while minimizing restrictions on wire feeding
- Get that same consistent angle and firm feel that any comparable bent rigid tube offers
- Bend to the right feel and comfort. The engineers at Tweco® have designed the Knucklehead to work with the following Tweco MIG guns: Spray Master® Series, Classic No. Series, Eliminator® Series and Standard WeldSkill® Series

Spray Master® Series

Amp/Model	Bend Angle	Stand. Cons.*	EL Cons.**	Long Reach†	Part No.	Stock No.
250	60°	x			MS62SFLX3-60	1620-1341
	80°	x			MS62SFLX4-80	1620-1342
350	60°	x			MS63SFLX3-60	1630-1197
	80°	x			MS63SFLX4-80	1630-1198
450	60°	x			MS64SFLX3-60	1640-1307
	80°	x			MS64SFLX4-80	1640-1308
	60°	x		x	MS64SFLX3-60LR	1640-1309
	80°	x		x	MS64SFLX4-80LR	1640-1310
	60°		x		MS64SFLX3-60EL	1640-1370
	80°		x		MS64SFLX4-80EL	1640-1371

Eliminator® Series

Amp/Model	Bend Angle	Stand. Cons.*	EL Cons.**	Long Reach†	Part No.	Stock No.
250	60°		x		EL62SFLX3-60	1620-1115
	80°		x		EL62SFLX4-80	1620-1116
450	60°		x		EL64SFLX3-60	1640-1143
	80°		x		EL64SFLX4-80	1640-1144
	80°		x	x	EL64SFLX4-80LR	1640-1149

*Standard Style Consumables

**Eliminator Style Consumables

†Long Reach Conductor Tube (2" longer)

Classic No. Series

Amp/Model	Bend Angle	Stand. Cons.*	EL Cons.**	Long Reach†	Part No.	Stock No.
Mini	60°	x			3560SFLX3-60	1600-1139
	80°	x			3560SFLX4-80	1600-1141
No. 1	80°	x			61SFLX4-80	1610-1105
	60°	x			62SFLX3-60	1620-1105
No. 2	80°	x			62SFLX4-80	1620-1106
	60°	x			64SFLX3-60	1640-1112
No. 3	80°	x			64SFLX4-80	1640-1113
	60°	x			64SFLX3-60	1640-1112
	80°	x			64SFLX4-80	1640-1113
No. 4	60°	x		x	64SFLX3-60LR	1640-1121
	80°	x		x	64SFLX4-80LR	1640-1122

Standard WeldSkill® Series

Amp/Model	Bend Angle	Stand. Cons.*	EL Cons.**	Long Reach†	Part No.	Stock No.
250	60°	x			62SFLX3-60	1620-1105
	80°	x			62SFLX4-80	1620-1106
400	60°	x			64SFLX3-60	1640-1112
	80°	x			64SFLX4-80	1640-1113
	60°	x		x	64SFLX3-60LR	1640-1121
	80°	x		x	64SFLX4-80LR	1640-1122

Outer Jacket Repair Kit

250A - Part No. FLXSJ-RK (Stock No. 1620-1345)

350/450A - Part No. FLXLJ-RK (Stock No. 1640-1385)

(Repair Kits include the neoprene outer jacket and stainless steel straps)

Conductor Tubes Air-Cooled

MINI-MIG

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/4" (57 mm) Radius	35-60-60	1600-1102	Neoprene Rubber	O.D. M12 x 1.5-6g	I.D. M9 x 1.25-6g
45 Degree with 1-3/4" (44.5 mm) Radius	35-60-45	1600-1101	Neoprene Rubber	O.D. M12 x 1.5-6g	I.D. M9 x 1.25-6g

Classic No. 1

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2-1/2" (63.5 mm) Radius	61-60	1610-1102	Neoprene Rubber	--	I.D. M10 x 1.5-6H
180 Degree, Straight	61-180	1610-1104	Neoprene Rubber	--	I.D. M10 x 1.5-6H

Classic No. 2

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	62J-60	1620-1301	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B
60 Degree with 2" (50.5 mm) Radius	62A-60	1620-1102	Fiber	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B
80 Degree with 2" (50.5 mm) Radius	62ELJ-80	1620-1307	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H
180 Degree, Straight	62ELJ-180	1620-1308	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H

Classic No. 3

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	63J-60	1630-1111	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	63J-45	1630-1110	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
180 Degree, Straight	63ELJ-180	1630-1118	Metal	I.D. 3/8"-24 UNF-2B	I.D. M11 x 1.5-6H

Classic No. 4

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	64J-60	1640-1106	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	64J-45	1640-1105	Metal	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
60 Degree with 3" (76.2 mm) Radius	64A-60	1640-1102	Fiber	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	64A-45	1640-1101	Fiber	I.D. 3/8"-24 UNF-2B	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18 UNF-2A
Eliminator 60 Degree with 3" (76.2 mm) Radius	64ELJ-60	1640-1117	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	64ELJ-45	1640-1116	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 80 Degree with 2" (50.5 mm) Radius	64ELJ-80	1640-1118	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H
Eliminator 180 Degree, Straight	64ELJ-180	1640-1119	Metal	I.D. 3/8"-24 UNF-2B	I.D. M12 x 1.5-6H

Classic No. 5

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 5" (127 mm) Radius	65J-60	1650-1111	Metal	I.D. 7/16"-20 UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A
45 Degree with 5" (127 mm) Radius	65J-45	1650-1110	Metal	I.D. 7/16"-20 UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A
180 Degree, Straight	65J-180	1650-1113	Metal	I.D. 7/16"-20 UNF-2B	I.D. 7/16"-20 UNF-2B O.D. 5/8"-18 UNF-2A

Conductor Tubes Air-Cooled

Classic No. 6

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 5" (127 mm) Radius	66J-60	1660-1826	Metal	I.D. 7/16"-20 UNF-2B	I.D. M12 x 1.5-6H O.D. M17 x 2.0-6G

Spray Master® 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 2" (50.5 mm) Radius	MS63-60S	1630-1196	Metal	--	I.D. M11 x 1.5-6H
60 Degree with 3" (76.2 mm) Radius	MS63-60	1630-1189	Metal	--	I.D. M11 x 1.5-6H
60 Degree with 2" (50.5 mm) Radius	MS62A-60	1620-1340	Metal	--	I.D. 3/8" 24 UNF-2B

Spray Master 350

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	MS63-60	1630-1189	Metal	--	I.D. M11 x 1.5-6H
45 Degree with 3" (76.2 mm) Radius	MS63-45	1630-1188	Metal	--	I.D. M11 x 1.5-6H
180 Degree, Straight	MS63-180	1630-1187	Metal	--	I.D. M11 x 1.5-6H

Spray Master 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Heavy Duty 60 Degree with 3" (76.2 mm) Radius	MS64H-60	1640-1319	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Heavy Duty 45 Degree with 3" (76.2 mm) Radius	MS64H-45	1640-1318	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Long Reach 60 Degree with 3" (76.2 mm) Radius	MS64H-60LM *	1640-1317	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Long Reach 45 Degree with 3" (76.2 mm) Radius	MS64H-45LM *	1640-1323	Metal	--	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
60 Degree with 3" (76.2 mm) Radius	MS64-60S **	1640-1342	Metal	--	I.D. M12 x 1.5-6H

* Long reach conductor tube – 2" longer than standard

** Comes standard on all 450 Amp Spray Master MIG guns with the suffix "EL"

Compact Eliminator® 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	EL63J-60	1630-1137	Metal	--	I.D. M11 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	EL63J-45	1630-1136	Metal	--	I.D. M11 x 1.5-6H

Compact Eliminator 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	EL64J-60	1640-1137	Metal	--	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	EL64J-45	1640-1136	Metal	--	I.D. M12 x 1.5-6H
60 Degree with 2-1/4" (57 mm) Radius	EL64-60	1640-1110	Fiber	--	I.D. M12 x 1.5-6H

Standard Eliminator 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 60 Degree with 3" (76.2 mm) Radius	EL64J-60	1640-1137	Metal	--	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	EL64J-45	1640-1136	Metal	--	I.D. M12 x 1.5-6H
180 Degree, Straight	EL64J-180	1640-1135	Metal	--	I.D. M12 x 1.5-6H
60 Degree with 2-1/4" (57 mm) Radius	EL64-60	1640-1110	Fiber	--	I.D. M12 x 1.5-6H
45 Degree with 2-1/4" (57 mm) Radius	EL64-45	1640-1111	Fiber	--	I.D. M12 x 1.5-6H

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 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
45 Degree with 3" (76.2 mm) Radius	SEL64J-45	1640-1321	Metal	O.D. 9/16"-18UNF-2A	I.D. M12 x 1.5-6H

PulseMaster® 350 & 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 45 Degree with 3" (76.2 mm) Radius	PMA64EL-45	1642-1130	Metal	--	I.D. M12 x 1.5-6H

SSG Spool

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 180 Degree, Straight	PMP64EL-180	1642-1140	Metal	--	I.D. M12 x 1.5-6H
Eliminator 30 Degree with 3" (76.2 mm) Radius	PMP64EL-30	1642-1141	Metal	--	I.D. M12 x 1.5-6H

PMP Push/Pull

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
Eliminator 180 Degree, Straight	PMP64EL-180	1642-1140	Metal	--	I.D. M12 x 1.5-6H
Eliminator 30 Degree with 3" (76.2 mm) Radius	PMP64EL-30	1642-1141	Metal	--	I.D. M12 x 1.5-6H

Smoke Master® 250

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 1.5" (38 mm) Radius	S62-60	2020-2006	Powder Coat	O.D. M11 x 1.5-6G	I.D. M11 x 1.5-6H
45 Degree with 1.5" (38 mm) Radius	S62-45	2020-2011	Powder Coat	O.D. M11 x 1.5-6G	I.D. M11 x 1.5-6H

Smoke Master 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	S64-60	1046-2258	Teflon	I.D. M12 x 1.5-6G	I.D. M11 x 1.5-6H

Flux Cored 350

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3.1" (79 mm) Radius	64FC-60	1641-1127	Thermo Flex	--	I.D. 5/16"-18 UNC-2B O.D. 1/2"-13 UNC-2A

Flux Cored 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3.6" (92 mm) Radius	66FC-60	1661-1127	Thermo Flex	--	I.D. 3/8"-16 UNC-2B O.D. 5/8"-11 UNC-2A



Conductor Tubes Water-Cooled

PulseMaster® 400 & 500

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
45 Degree with 4" (101.6 mm) Radius	PMW64-45	1644-2925	Metal	--	I.D. 3/8"-16 UNC-2B

SUPRA® 450

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 4" (101.6 mm) Radius	SW64-60	1644-1125	Neoprene	--	O.D. M11 x 1.0-6G

Standard 600

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	WCS66-60	1664-1106	Neoprene	--	I.D. 7/16"-20 UNF-2B

Rigid Conductor Tubes Extensions

For Traditional Style Guns

No. 3 & 4 Straight 180° Extension

Description	Part No.	Stock No.
Extension 80°	64A-8EX	1640-1303

No. 5 Straight 180° Extension

Description	Part No.	Stock No.
Extension 60°	65-6EX	1650-1302



Universal Conduit Liner

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

ADAPTER

TWECO UNIVERSAL CONDUIT LINER



Replace Multiple
Conduit Liner Brands



With One Tweco®
Universal Brand



Tweco Universal Conduit Liner

(comes fitted with Tweco Adapter)

Adapters for major MIG Gun Brands



Universal Conduit Liner

Steps to pick the correct conduit liner and adapter.

Refer to the Adapter Compatibility Chart below:

1. What wire size are you using?
2. Pick the related Tweco® liner, 15 ft or 25 ft.
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 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 (5 m)					
	42-3035-25	25 ft (8 m)					
.040" – .045" (1.0 – 1.1 mm)	42-4045-15	15 ft (5 m)					
	42-4045-25	25 ft (8 m)					
.035" – .045" (0.9 – 1.1 mm)	44-3545-15	15 ft (5 m)					
	44-3545-25	25 ft (8 m)					
1/16" (1.6 mm)	44-116-15	15 ft (5 m)	44U-TWE 14401235 (1 each) 14401240 (25 each)	44U-MIL-M 4401238 (1 each) 14401245 (25 each)	44U-BER 14401236 (1 each) 14401242 (25 each)	44U-MIL-C 4401248 (1 each) 14401249 (25 each)	44U-TRE 14401219 (1 each) 14401220 (25 each)
	44-116-25	25 ft (8 m)					
5/64" (2.0 mm)	44-564-15	15 ft (5 m)	44U-TWE-H 14401239 (1 each)	44U-MIL-H 14401246 (1 each)	44U-BER-H 14401243 (1 each)	44U-MIL-C-H 14401217 (1 each)	44U-TRE-H 14401221 (1 each)
	44-564-25	25 ft (8 m)					
3/32" (2.4 mm)	44-332-15	15 ft (5 m)					
	44-332-25	25 ft (8 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 Co. Profax is a registered trademark of Profax. Bernard, Miller, Migmatic, Hobart, Roughneck and Tregaskiss are registered trademarks of Illinois Tool Works, Inc. The aforementioned trademarks and their respective owners are in no way affiliated with Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

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 (5 m)	23-40-15	1400-1123
.030" - .035" (0.8 mm - 0.9 mm)	15 ft (5 m)	35-40-15	1400-1133
.030" - .035" (0.8 mm - 0.9 mm)	20 ft (6 m)	35-40-20	1400-1134
.040" - .045" (1.0 mm - 1.2 mm)	15 ft (5 m)	45-40-15	1400-1143

180-250 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 mm - 0.9 mm)	15 ft (5 m)	42-3035-15	1420-1113
.030" - .035" (0.8 mm - 0.9 mm)	25 ft (8 m)	42-3035-25	1420-1115
.040" - .045" (1.0 mm - 1.2 mm)	15 ft (5 m)	42-4045-15	1420-1123
.040" - .045" (1.0 mm - 1.2 mm)	25 ft (8 m)	42-4045-25	1420-1125
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	42-116-15	1420-1124

300-450 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	15 ft (5 m)	44-3545-15	1440-1103
.035" - .045" (0.9 mm - 1.2 mm)	25 ft (8 m)	44-3545-25	1440-1105
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	44-116-15	1440-1113
.052" - 1/16" (1.3 mm - 1.6 mm)	25 ft (8 m)	44-116-25	1440-1115
5/64" (2.0 mm)	15 ft (5 m)	44-564-15	1440-1123
5/64" (2.0 mm)	25 ft (8 m)	44-564-25	1440-1125
3/32" (2.4 mm)	15 ft (5 m)	44-332-15	1440-1127

500-650 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	15 ft (5 m)	45-3545-15	1450-1103
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	45-116-15	1450-1113
.052" - 1/16" (1.3 mm - 1.6 mm)	25 ft (8 m)	45-116-25	1450-1115
5/64" (2.0 mm)	15 ft (5 m)	45-564-15	1450-1123
5/64" (2.0 mm)	25 ft (8 m)	45-564-25	1450-1125
3/32" (2.4 mm)	15 ft (5 m)	45H-332-15	1450-1133
7/64" (2.8 mm)	15 ft (5 m)	45H-764-15	1450-1143
1/8" (3.2 mm)	15 ft (5 m)	45-18-15	1450-1153



Tweco Universal Conduit Liner

Conduit Liners

For Use With Aluminum Welding Wires

160 Amp - Teflon

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 mm - 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 mm - 1.2 mm)	15 ft (5 m)	42N-3545-15	1420-1003

300-450 Amp - Nylon

Wire Size	Length	Part No.	Stock No.
.030" - 3/64" (0.8 mm - 1.2 mm)	15 ft (5 m)	44N-3545-15	1440-1003
1/16" (1.6 mm)	15 ft (5 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 (5 m)	45N-116-15	1450-1013

PulseMaster® MIG Gun Conduit Liners

For Use With Aluminum/Steel Welding Wires

Steel Wrapped / Teflon

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	12 ft (4 m)	44PSTF-3545-12	1441-1138
.035" - .045" (0.9 mm - 1.2 mm)	15 ft (5 m)	44PSTF-3545-15	1441-1137
.052" - 1/16" (1.3 mm - 1.6 mm)	12 ft (4 m)	44PSTF-116-12	1441-1136
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	44PSTF-116-15	1441-1135

Bronze Jump Liner

Wire Size	Length	Part No.	Stock No.
max .045" (1.2 mm)	10-1/4" (260 mm)	44JT-3545	1644-1088
max .062" (1.6 mm)	10-1/4" (260 mm)	44JT-116	1644-1086

PullMaster™ MIG Gun Conduit Liners

For Use With Aluminum/Steel Welding Wires

Steel Wrapped / Teflon

Wire Size	Length	Part No.	Stock No.
3/64" - 1/16" (1.2 mm - 1.6 mm)	33 ft (10 m)	PMP44-116-33	1441-1125
3/64" - 1/16" (1.2 mm - 1.6 mm)	50 ft (15 m)	PMP44-116-50	1441-1126
.035" - .045" (0.9 mm - 1.2 mm)	33 ft (10 m)	PMP44-3545-33	1441-1127
3/64" - 1/16" (1.2 mm - 1.6 mm)	33 ft (10 m)	PMP44-116-33	1441-1129
.035" - .045" (0.9 mm - 1.2 mm)	33 ft (10 m)	PMP44-3545-33	1441-1131

Teflon Jump Liner for Flex Tube

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

Bronze Jump Liner

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	--	PMP-44-116	1644-1097

R44 Series & R45 Series Conduit Liners

- Tapered lead in angle on the machined conduit stop making the transition of the welding wire into the MIG gun smoother
- Tin/Zinc plated wire

For Use With Steel Welding Wires

300-450 Amp - Steel Wound

(Including No. 5 Euro-Kwik Series)

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	8 ft (2.4 m)	R44-3545-8	1440-1225
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	R44-116-15	1440-1231

500-650 Amp - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	4 ft (1.2 m)	R45-3545-4	1450-1024
.035" - .045" (0.9 mm - 1.2 mm)	8 ft (2.4 m)	R45-3545-8	1450-1025
.052" - 1/16" (1.3 mm - 1.6 mm)	8 ft (2.4 m)	R45-116-8	1450-1030
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	R45-116-15	1450-1031

For Use With Aluminum Welding Wires

500-650 Amp - Wire Nylon Wrap

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	15 ft (5 m)	R45WN-116-15	1450-1045

Electrode Holder Selection Guide

Electrode Holders	Style	Amperage Range							Recommended
		200	250	300	350	400	450	500	
	High Profile								A-532
									A-316
									A-732
	TITE								4TT
	Low Profile								A-14
									A-14-HD
									A-38-HD

TwecoTong®



Tweco-Tite



MODEL	OUTPUT			APPLICATION			
	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)	●			
TwecoTong A-316	250	3/16" (4.8 mm)	2/0 (67.4 mm)	●	●		
TwecoTong A-732	300	7/32" (5.6 mm)	2/0 (67.4 mm)		●	●	
TwecoTong A-14	350	1/4" (6.4 mm)	2/0 (67.4 mm)		●	●	
TwecoTong A-14-HD	400	1/4" (6.4 mm)	4/0 (107 mm)			●	●
TwecoTong A-38-HD	500	3/8" (9.5 mm)	4/0 (107 mm)				●
Tweco-Tite 4TT	400	1/4" (6.4 mm)	3/0 (85 mm)	●	●	●	

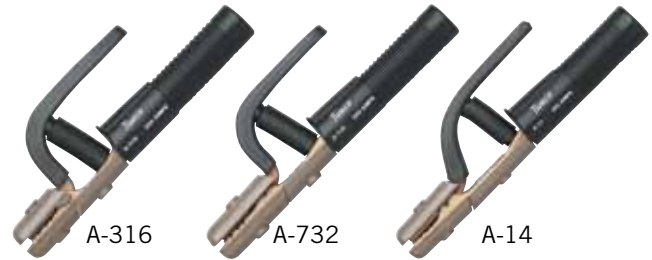
Manual Welding Products

ELECTRODE HOLDERS

Electrode Holders

TwecoTong® Electrode Holders

TwecoTong Electrode Holders are designed to mechanically hold a welding electrode in position. They are manufactured from heavy duty copper alloy and feature reversible top and bottom insulators, efficient 6-position jaw pattern, ball-point cable connections and fully insulated and protected springs.



TwecoTong Electrode Holders

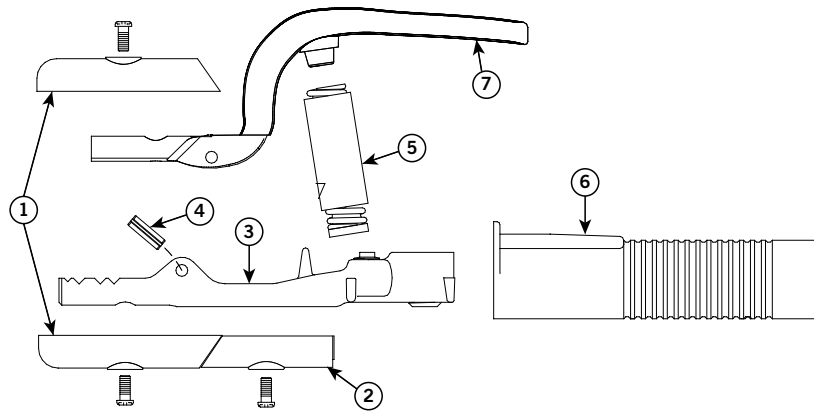
Amperage	Body Alloy	Electrode	Cable	Length	Part No.	Stock No.
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/2" (216 mm)	A-532*	9110-1101
200	Copper Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/2" (216 mm)	A532-MC**	9110-1109
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	A-316*	9110-1102
250	Copper Alloy	3/16" (4.8 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	A316-MC**	9110-1110
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	A-732*	9110-1103
300	Copper Alloy	7/32" (5.6 mm)	2/0 (67.4 mm)	10" (254 mm)	A732-MC**	9110-1111
350	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	11" (279 mm)	A-14	9110-1104
400	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	12" (305 mm)	A-14-HD	9110-1105
500	Copper Alloy	3/8" (9.5 mm)	4/0 (107 mm)	13-1/4" (336 mm)	A-38-HD	9110-1106

* Clamshell packaging. Sold individually or master packed in quantities of 12 each.

** Sold in Master Pack Boxed Quantities of 24.

TwecoTong

Replacement Parts



#	Description	A-532 Part No./Stock No.	A-316 Part No./Stock No.	A-732 Part No./Stock No.	A-14 Part No./Stock No.	A-14-HD Part No./Stock No.	A-38-HD Part No./Stock No.
1	Tip Insulation	A-532-1P 9910-2102	A-532-1P 9910-2102	A-732-1P 9910-2302	A-732-1P 9910-2302	A-732-1P 9910-2302	A-38-HD-1P 9910-2602
2	Body Insulation	A-532-3 9910-2103	A-532-3 9910-2103	A-532-3 9910-2103	A-14-3 9910-2403	A-14-3 9910-2403	A-38-HD-3 9910-2603
3	Lower Body Tong w/o Insulation	A-316-4R 9910-2204	A-316-4R 9910-2204	A-732-4 9910-2304	A-14-4 9910-2404	A-14-HD-4 9910-2504	A-38-HD-4 9910-2604
4	Hinge Pin	A-532-11 9910-2111	A-532-11 9910-2111	A-532-11 9910-2111	A-532-11 9910-2111	A-532-11 9910-2111	FGC-200-5 9910-2610
5	Spring with Insulation	A-532-6 9910-2106	A-316-6 9910-2206	A-316-6 9910-2206	N/A	N/A	N/A
6	Molded Handle	A-532-7 9910-2107	A-316-7 9910-2207	A-732-7 9910-2307	A-14-7 9910-2407	A-14-HD-7 9910-2507	A-38-HD-7 9910-2607
NS	Handle Screws	AL-300-12 9910-2712	AL-300-12 9910-2712	AL-300-12 9910-2712	AL-300-12 9910-2712	AL-300-12 9910-2712	AL-300-12 9910-2712
NS	Cable Connection Screw	A-532-24 9910-2124	A-532-24 9910-2124	A-532-24 9910-2124	A-14-24 9910-2424	A-14-24 9910-2424	A-14-24 9910-2424

Electrode Holders

Tweco-Tite Electrode Holders

The Tweco-Tite Electrode Holder is fully insulated with a 45 degree head and a 400 amp capacity. Designed for effortless installation of electrodes up to 1/4" (6.4 mm)



4TT

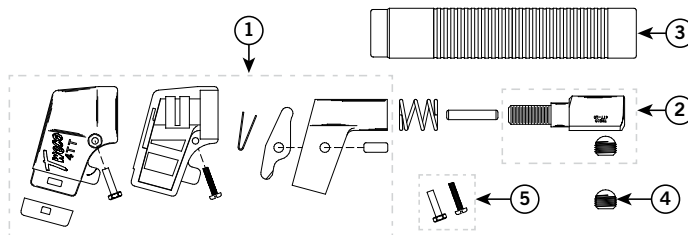
4TT Tweco-Tite Electrode Holder

Amperage	Electrode	Cable	Part No.	Stock No.
400	1/4" (6.4 mm)	3/0 (85 mm)	4TT	9120-1000

Tweco-Tite

Replacement Parts

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



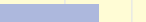
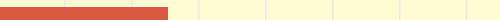
TWECO®

Metal Working Chemicals

Metal working chemicals are available from Victor® / Arcair®. Full line of anti-spatter compounds, aluminum cleaners, and zinc-rich cold galvanizing compound. Contact Tweco® Customer Care at 800-426-1888 for more details.

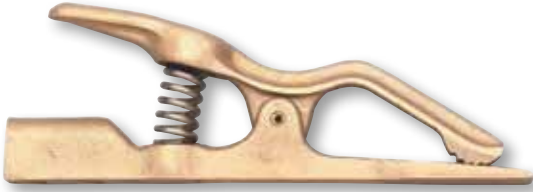


Ground Clamps Selection Guide

	Application	Amperage Range								Recommended		
		200	300	400	500	600	700	800	1500		2000	
Ground Clamps	Plate											FGC 200
												FGC 300
												FGC 500
												SGC 300
												SGC 500
	Pipe											GC 200
												GC 300
												GC 500
												SMGC 200
												SMGC 300
												SMGC 600
	Rotary											GCRG 140
												RG 140
												RG 230
												RG 240
												RG 440
												RG 640

MODEL	OUTPUT				PROCESS			APPLICATION			
	Current (Amps)	Jaw Opening	No. of Heads	Cable Connection	Plate	Pipe	Rotary	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab	Extra Heavy Duty Fab
FGC 200	200	2" (50.8 mm)	--	Ball-Point thru 1/0	●			●			
FGC 300	300	3-1/2" (88.9 mm)	--	Ball-Point thru 3/0	●			●	●		
FGC 500	500	3-3/4" (95.3 mm)	--	Ball-Point thru 4/0	●				●	●	
SGC 300	300	2" (50.8 mm)	--	1/2" Stud	●			●	●		
SGC 500	500	2" (50.8 mm)	--	1/2" Stud	●				●	●	
GC 200	200	3" (76.2 mm)	--	Ball-Point thru 1/0		●		●			
GC 300	300	4" (101.0 mm)	--	Ball-Point thru 3/0		●		●	●		
GC 500	500	5-1/4" (133.0 mm)	--	Ball-Point thru 4/0		●			●	●	
SMGC 200	200	--	--	Ball-Point thru 1/0		●		●			
SMGC 300	300	--	--	Ball-Point thru 3/0		●		●	●		
SMGC 600	600	--	--	Ball-Point thru 4/0		●				●	
GCRG 140	400	--	1	1 thru 4/0			●		●	●	
RG 140	400	--	1	1 thru 4/0			●		●	●	
RG 230	600	--	1	2 thru 3/0			●			●	
RG240	800	--	1	2 thru 4/0			●			●	●
RG 440	1500	--	2	4 thru 4/0			●				●
RG 640	2000	--	3	6 thru 4/0			●				●

Flat-Jaw Copper Ground Clamp



Steel Ground Clamp



Copper Ground Clamp



Switchable Magnetic Ground Clamp



Rotary Ground Clamps



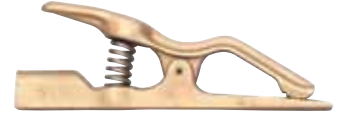
Ground Clamps

Steel and Copper Ground Clamps

Ideal for most light to medium duty fabrication needs.

Flat Jaw Copper Ground Clamps

Ideal for plate grounding.



Amperage	Jaw Opening	Cable	Length	Part No.	Stock No.
200	5/8" - Depth 2" (15.9 mm - 50.8 mm)	Ball-Point thru 1/0	5" (127 mm)	FGC-200	9205-1320
300	1" - Depth 3-1/2" (25.4 mm - 88.9 mm)	Ball-Point thru 3/0	7-14" (184 mm)	FGC-300	9205-1330
500	1-1/4" - Depth 3-3/4" (31.8 mm - 95.3 mm)	Ball-Point thru 4/0	9-1/4" (234 mm)	FGC-500	9205-1350

Steel Ground Clamps

Ideal for plate grounding and lower amperage needs.



Amperage	Jaw Opening	Cable	Length	Part No.	Stock No.
300	2" - Depth 1-3/4" (50.8 mm - 44.4 mm)	1/2" Stud Connection	9" (228 mm)	SGC-300	9205-1230
500	2" - Depth 1-3/4" (50.8 mm - 44.4 mm)	1/2" Stud Connection	9" (228 mm)	SGC-500	9205-1250

Steel Ground Clamp Replacement Parts

Description	Part No.	Stock No.
Cone Head Replacement Jaw - for SGC-300 and SGC-500	SGC-500-4	9920-2504

Copper Ground Clamps

Ideal for pipe grounding.



Amperage	Jaw Opening	Cable	Length	Part No.	Stock No.
200	1" - Depth 3" (25.4 mm - 76.2 mm)	Ball-Point thru 1/0	6" (157 mm)	GC-200	9205-1120
300	1-1/2" - Depth 4" (38.1 mm - 101.0 mm)	Ball-Point thru 3/0	8-1/2" (216 mm)	GC-300*	9205-1130
300	1-1/2" - Depth 4" (38.1 mm - 101.0 mm)	Ball-Point thru 3/0	8-1/2" (216 mm)	GC-300MC**	9205-1131
500	2" - Depth 5-1/4" (50.8 mm - 133.0 mm)	Ball-Point thru 4/0	10" (254 mm)	GC-500	9205-1150

* Clamshell packaging. Sold individually or master packed in quantities of 12 each.

** Sold in Master Pack Boxed Quantities of 24.

Copper Ground Clamp Replacement Parts

Description	Part No.	Stock No.
Insulated Spring - for GC-300	GC-300-2	9920-2302
Cable Support Ring - for GC-300	GC-300-11	9920-2311
Cable Connection Screw - for GC-300	GC-300-12	9920-2312

Ground Clamps

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, these ground clamps are designed to save welders time and money.

- Saves welders time and money
- Cuts set up time
- Convenient tab to easily attach ground line
- Clamp can be used to ground on flat, round, and irregular surfaces
- 200, 300, and 600 Amp clamps to meet any welding need
- Magnetic field is simple to turn on and off, making use and clean up quick and easy
- Easy to mount: simply attach your ground line to bolt connector tab
- Can withstand heat up to 176°F (80°C)
- Magnetic switch is easy to operate: a simple turn of the knob



Easy Connect & Easy Release On/Off Knob



SMGC200

Just Turn Off & Wipe Away Debris



SMGC300

Cuts Set Up Time



SMGC600

Amperage	Height	Width	Length	Weight	Std. Pkg.	Part No.	Stock No.
200	2.5" (63.5 mm)	1.58" (40.1 mm)	2.19" (55.6 mm)	0.38 lbs	10	SMGC200	9255-1060
300	2.26" (57.4 mm)	1.58" (40.1 mm)	2.7" (68.6 mm)	0.61 lbs	10	SMGC300	9255-1061
600	2.6" (66.0 mm)	2.83" (71.9 mm)	4.09" (103.9 mm)	2.0 lbs	5	SMGC600	9255-1062

Manual Welding Products

SWITCHABLE MAGNETIC PRODUCTS

TWECO® Switchable Magnetic Work Holding Products

Switchable Magnetic Right-Angle (90-degree) Clamp

- 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



SMRA 400

Description	Capacity/Power	Part No.	Stock No.
Switchable Magnetic Right Angle 400	Holding Power : 400 lbs	SMRA 400	9255-1067

Switchable Magnetic Multi-Angle Clamps

- Work-holding switchable magnetic products
- Holds flat, round, odd shaped products
- Perfect for cutting, drilling, grinding, beveling



SMMA 300

SMMA 400

Description	Capacity/Power	Part No.	Stock No.
Switchable Magnetic Multi Angle 300 GC	Magnetic Power : 150 lbs	SMMA 300	9255-1064
Switchable Magnetic Multi Angle 400	Holding Power : 400 lbs	SMMA 400	9255-1063

Switchable Magnetic Pick & Pack Lifters & Hooks

- 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



SMLM 60



SMLH 600

Description	Capacity/Power	Part No.	Stock No.
Switchable Magnetic Lifter Manual 60	Recommended Lift Capacity : 60 lbs	SMLM 60	9255-1065
Switchable Magnetic Lifter Hook 600	Lift Capacity : 200 lbs	SMLH 600	9255-1066



MANUAL WELDING

Ground Clamps

Heavy Duty Rotary Ground Devices

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.



RG-440



GCRG-140

Roto-Ground Clamps

Ideal for high amperage grounding.

Amperage	Cable	Number of Heads	Shaft Stud	Length	Part No.	Stock No.
400	1 - 4/0	1	3/4" NC	--	GCRG-140	9210-1314
400	1 - 4/0	1	3/4" NC	8" (203 mm)	RG-140	9250-1114
600	2 - 3/0	1	1-1/8" NC	10-1/4" (260 mm)	RG-230	9250-1123
800	2 - 4/0	1	1-3/8" NC	10-5/8" (270 mm)	RG-240	9250-1124
1500	4 - 4/0	2	1-3/8" NC	10-5/8" (270 mm)	RG-440	9250-1144
2000	6 - 4/0	3	1-3/8" NC	10-5/8" (270 mm)	RG-640	9250-1164

Roto-Ground Accessories

Description	Part Number	Stock Number
Lubricating Cup	RG-240-11	9922-2129
Ball-Point Cable Connection Screw	A-14-24	9910-2424
Special Shaft Lubricant	1Z-L	9900-1123
Fibre Cover Screw	2-5	9940-2125



2-5



A-14-24



RG-240-11

Roto-Ground Replacement Parts

Description	RG-140 Part No. / Stock No.	RG-230 Part No. / Stock No.	RG-240 Part No. / Stock No.	RG-440 Part No. / Stock No.	RG-640 Part No. / Stock No.
Head	RG-140-2-0 9922-2103	--	RG-240-4-0 9922-2124	RG-240-4-0 9922-2124	RG-240-4-0 9922-2124
Head Shaft	RG-140-2 9922-2102	RG-230-2 9922-2112	RG-240-2 9922-2122	RG-440-2 9922-2132	RG-640-2 9922-2142
Work Attachment Nut	RG-140-5 9922-2105	RG-230-5 9922-2115	RG-240-5 9922-2125	RG-240-5 9922-2125	RG-240-5 9922-2125
Fibre Cover	--	RG-240-7 9922-2127	RG-240-7 9922-2127	RG-240-7 9922-2127	RG-240-7 9922-2127

Tweco Shaft Lubricant

An electrical conductive grease to be used as a lubricant for roto-grounds and may be used when making mechanical connections with copper or aluminum cables. Effective as a lubricant on sliding or moving electrical contacts such as switches and rotating grounding devices. Apply generously to contact area from 1 oz (29.6 mL) or 8 oz (237.0 mL) plastic bottles. Reduce electrical resistance by as much as 40 to 50%.

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



8Z-L

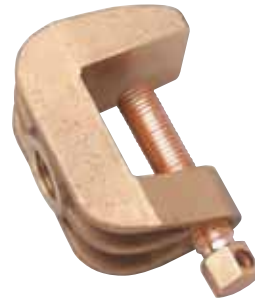
1Z-L

Ground Clamps

Tweco® Roto-Work Grounding Clamps

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 rotating 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.



WCRG-1200



GC-600-75

Tweco Roto-Work Ground Clamps

Amperage	Fits Roto-Ground	Clamp Contact	Throat Height	Throat Depth	Over-All Height	Over-All Width	Tapped For	Part No.	Stock No.
600	RG-230	6-1/4 sq in	2-1/2" (63.5 mm)	2-1/2" (63.5 mm)	5-3/4" (146.0 mm)	2-1/2" (63.5 mm)	1-1/8" NC	WCRG-600	9255-1106
1200	RG-240/440	9 sq in	3" (76.2 mm)	3" (76.2 mm)	6-3/4" (171.0 mm)	3" (76.2 mm)	1-3/8" NC	WCRG-1200	9255-1112
2000	RG-440/640	12 sq in	3" (76.2 mm)	3" (76.2 mm)	6-3/4" (171.0 mm)	4" (102.0 mm)	1-3/8" NC	WCRG-2000	9255-1120
Clamp Only - Tapped 3/4" for RG-140 Roto-Ground Only								GC-600-75	9255-1075

Amperage	Jaw Opening	Cable	Part No.	Stock No.
500	2-1/2" - Depth 1-3/8" (63.5 mm - 41.3 mm)	1/2" Cap Screw	GC-600-50	9210-1150
600	2-1/2" - Depth 1-3/8" (63.5 mm - 34.9 mm)	Double Ball-Point	GC-600-DBP	9210-1201
600	2-1/2" - Depth 1-3/8" (69.5 mm - 34.9 mm)	Tweco Male Plug	GC-600-TMP	9210-1202

Work Clamp Adapter

Description	Part No.	Stock No.
Work Clamp Adapter W/ 1-1/8"-7 UNC 2A OD Thread & 5/8"-11 UNC-2A ID Thread - Fits WCRG-600 Roto-Work Clamp	118	9922-2018
Work Clamp Adapter W/ 1-3/8"-6 UNC 2A OD Thread & 5/8"-11 UNC-2A ID Thread - Fits WCRG-1200 & WCRG-2000 Roto-Work Clamps	138	9922-2038



138

"C" Type Clamp Parts

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

Cable Lugs Selection Guide

	Style	Amperage Range						Recommended
		50	75	150	225	250	325	
Cable Lugs	Crimp Lugs for Welding Cable							T-62
								T-120
								T-3040
								T-40HD
	Crimp Lugs for Power Cable							T-810
								T-68
								T-46
	Ball-Point Lugs w/o Insulated Cover							10-45
								10-180
								40-45
								40-180
	Ball-Point Lugs with Insulated Cover							10-45C
								10-180C
								40-45C
								40-180C
	Heavy Duty Lugs							140-HD-180
								140-HD-180C
								240-HD-180

Crimp Lugs



Ball-Point Lugs



Heavy Duty Lugs



Manual Welding Products

CABLE LUGS

Crimp Lugs

TwecoLugs® Crimp or Solder Type

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



TwecoLugs (Crimp Lugs) for Power Cable

Cable	Amp Rating	Stud Hole	I.D. Solder Socket	Std Pkg	Part No.	Stock No.
8 thru 10	50	13/64" (5.2 mm)	.238" (6.1 mm)	10	T-810	9520-1101
6 thru 8	70	21/64" (8.3 mm)	.289" (7.3 mm)	10	T-68	9520-1102
4 thru 6	90	21/64" (8.3 mm)	.347" (8.8 mm)	10	T-46	9520-1103

Ball-Point Lugs

Ball-Point Lugs w/o Insulated Cover



Description	Cable	Amp Rating	Stud Hole	Std Pkg	Part No.	Stock No.
45° Angle	thru 1/0	150	17/32" (13.5 mm)	1	10-45	9515-1100
180° Offset	thru 1/0	150	17/32" (13.5 mm)	1	10-180	9515-1102
45° Angle	thru 4/0	325	17/32" (13.5 mm)	1	40-45	9515-1110
180° Offset	thru 4/0	325	17/32" (13.5 mm)	1	40-180	9515-1112

Ball-Point Lugs with Insulated Cover



Description	Cable	Amp Rating	Stud Hole	Std Pkg	Part No.	Stock No.
45° Angle	thru 1/0	150	17/32" (13.5 mm)	1	10-45C	9515-1101
180° Offset	thru 1/0	150	17/32" (13.5 mm)	1	10-180C	9515-1103
45° Angle	thru 4/0	325	17/32" (13.5 mm)	1	40-45C	9515-1111
180° Offset	thru 4/0	325	17/32" (13.5 mm)	1	40-180C	9515-1113

Heavy-Duty Lugs

Mechanical Ball-Point



Description	Cable	Amp Rating	Stud Hole	Length	Part No.	Stock No.
180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	4-3/8" (111 mm)	140-HD-180	9515-1120
With Insulated Cover - 180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	5-1/2" (140 mm)	140-HD-180C	9515-1121
180° Offset	3/0 & 4/0	325	21/32" (16.7 mm)	4-5/8" (131 mm)	240-HD-180	9515-1122

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 Number	Stock Number
Complete Connection	Single Ball-Point	4, 2, 1	1 ea. Male/Female	1-MPC	9425-1100
Male Half	Single Ball-Point	4, 2, 1	Pkg. 2 ea. Male	1-MPC-1	9425-1110
Female Half	Single Ball-Point	4, 2, 1	Pkg. 2 ea. Female	1-MPC-2	9425-1120
Complete Connection	Single Ball-Point	1/0, 2/0, 3/0	1 ea. Male/Female	2-MPC ‡	9425-1200
Complete Connection	Single Ball-Point	1/0, 2/0, 3/0	1 ea. Male/Female	2-MPC-MC**	9425-1201
Male Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Male	2-MPC-1 †	9425-1210
Male Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Male	2-MPC-1-MC*	9425-1211
Female Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Female	2-MPC-2 †	9425-1220
Female Half	Single Ball-Point	1/0, 2/0, 3/0	Pkg. 2 ea. Female	2-MPC-2-MC*	9425-1221
Complete Connection	Double Ball-Point	3/0 or 4/0	1 ea. Male/Female	4-MPC ‡	9425-1400
Complete Connection	Double Ball-Point	3/0 or 4/0	1 ea. Male/Female	4-MPC-MC**	9425-1401
Male Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Male	4-MPC-1 †	9425-1410
Male Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Male	4-MPC-1-MC*	9425-1411
Female Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Female	4-MPC-2 †	9425-1420
Female Half	Double Ball-Point	3/0 or 4/0	Pkg. 2 ea. Female	4-MPC-2-MC*	9425-1422
Whip Connection	Single Ball-Point	4, 2, 1, 1/0	Pkg. 2 ea.	2-1-MPC	9425-1140

*Sold in Master Pack Boxed Quantities of 48.

**Sold in Master Pack Quantities of 24.

† Clamshell packaging. Sold individually or master packed in quantities of 24 each.

‡ Clamshell packaging. Sold individually or master packed in quantities of 12 each.

Replacement Tapered Machine Plugs

Ball-Point Connection



Taper Length	Taper Dimensions	Cable	Part No.	Stock No.
1-1/8" (28.6 mm)	21/64" to 23/64" (8.3 mm x 9.1 mm)	4 thru 1	1-M-T	9505-1800
1-1/8" (28.6 mm)	21.64" to 23/64" (8.3 mm x 9.1 mm)	1/0 thru 3/0	2-M-T	9505-1801

Cable Connector Replacement Parts

MPC Series Positive-CAM - Zinc plated type cable & cover screws

Description	Part No.	Stock No.
Insulating Cover Only, All 1-MPC	1R-C	9940-2103
Insulating Cover Only, All 2 & 4 MPC	24R-MBP	9940-2124
Cable Connection Screw, Zinc Plated, All 2-MPC	A-532-24	9910-2124
Cable Connection Screw, Zinc Plated, All 4-MPC	A-14-24	9910-2424
Cover Screw, Zinc Plated, All MPC Connectors	2-5	9940-2125



Panel Receptacles

For use with MPC Connectors

Cable Fitting Type	Fits Tweco Connector	For Cable Size	Cable Attachment	Part No.	Stock No.
Ball-Point	No. 1	4, 2, 1	5/16" Ball-Point (7.9 mm)	1516-BPF	9580-1100
Threaded	No. 1	4, 2, 1, 1/0	5/16" Thread. Stud (7.9 mm)	114-TSF	9580-1101
Threaded	No. 2, 4	1/0, 2/0, 3/0	3/8" Thread. Stud (9.5 mm)	238-TSF	9580-1102
Ball-Point	No. 2, 4	1/0, 2/0, 3/0	9/16" Ball-Point (14.3 mm)	2916-BPF	9580-1103
Threaded	No. 2, 4	1/0, 2/0, 3/0	1/2" - 20 Thread. Stud (12.7 mm)	212-TSF	9580-1104

Manual Welding Products

SPLICERS, TERMINALS AND ACCESSORIES

Cable Splicers



TS-3040

Copper Cable Splicers

Cable	Amp Rating	Tube I.D.	Std Pkg	Part No.	Stock No.
6 thru 2	150	.461" (11.7 mm)	50	TS-62-50	9610-1105
6 thru 2	150	.461" (11.7 mm)	5	TS-62	9610-1101
1 thru 2/0	225	.599" (15.2 mm)	5	TS-120	9610-1102
3/0 thru 4/0	250	.660" (16.8 mm)	5	TS-3040	9610-1103
4/0 Heavy-Duty	325	.776" (19.7 mm)	5	TS-40HD	9610-1104



BP-1030

Ball-Point Cable Splicers

Cable	Amp Rating	Cable Fitting Type	Std Pkg	Part No.	Stock No.
4 thru 1/0		Ball-Point	1	BP-410	9605-1101
1/0 thru 3/0		Ball-Point	1	BP-1030	9605-1103
2/0 thru 4/0		Double Ball-Point	1	BP-2040	9605-1105

Tweco® Terminals



2-SF-50

Tweco Terminals and TwecoLugs

Tweco Screw-On Terminals Fits Terminal Size 1/2" (12.7 mm) NC

Accepts Tweco Connector Number	Part No.	Stock No.
No. 2 & No. 4 Male Half	2-SF-50	9505-1152

Receptacle Conversion Adapters



2-CLC

Fits Cam Locking Machine Receptacle	Fits Tweco Male Plug Ends	Part No.	Stock No.
Large - 11/16" I.D. (17.5 mm)	No. 2-MPC, 4-MPC	2-CLC	9505-1811

Tweco Female Terminals

Stud Hole Size 17/32" (13.5 mm)



1-AF



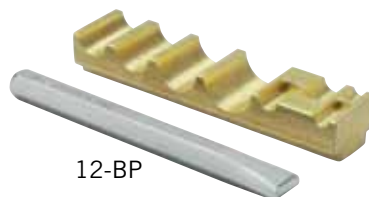
1-OF

Description	Accepts Male Ends	Std Pkg	Part No.	Stock No.
45° Angle	1-MPC	1	1-AF	9510-1100
180° Offset	1-MPC	1	1-OF	9510-1101
45° Angle	2-MPC, 4-MPC	1	2-AF	9510-1110
180° Offset	2-MPC, 4-MPC	1	2-OF	9510-1111

Accessories

Tweco® "Lug-Set" Block & Punch

For use with TwecoLugs



12-BP

Description	Part No.	Stock No.
Block & Punch	12-BP	9900-1140

Jacket Stripping Cable Cutting Hand Tool

For use with lugs with an insulated cover



Description	Part No.	Stock No.
Tweco Cable Cutting Hand Tool	T-908	9900-1190

Welding Helmets

The new Tweco® Auto-darkening welding helmet provides enhanced performance with 4 arc sensors at an affordable price. It offers operator comfort due to its lightweight construction and versatility. With superior performance, durability and flexibility, Tweco helmets offer exceptional value in personal welding protection.

- Enhanced performance – Four arc sensors for high response
- Auto-darkening – Automatically turns from light to dark and dark to light
- Lightweight – 16 oz (450 g)
- Variable shade – From 9 to 13
- Light shade DIN level – Level shade 4
- UV/IR Protection – Level shade 16 (DIN)
- “Sensitivity” control range
- Responsive lens switching speed – up to 1/30,000 sec (33 µs)
- “Delay” adjustable controls
- “Welding” or “Grinding” mode
- Large viewing area – 3.86" x 1.69" (98 mm x 43 mm)
- Solar-powered
- Affordable
- Certified – ANSI Z87.1, CE EN 379 and EN 175
- Support – 2-year warranty

Description	Part No.	Stock No.
Patriot Eagle	WHE41002	4100-1002
Skull & Fire	WHS41004	4100-1004
Dragon	WHDR41008	4100-1008



Patriot Eagle
WHE41002

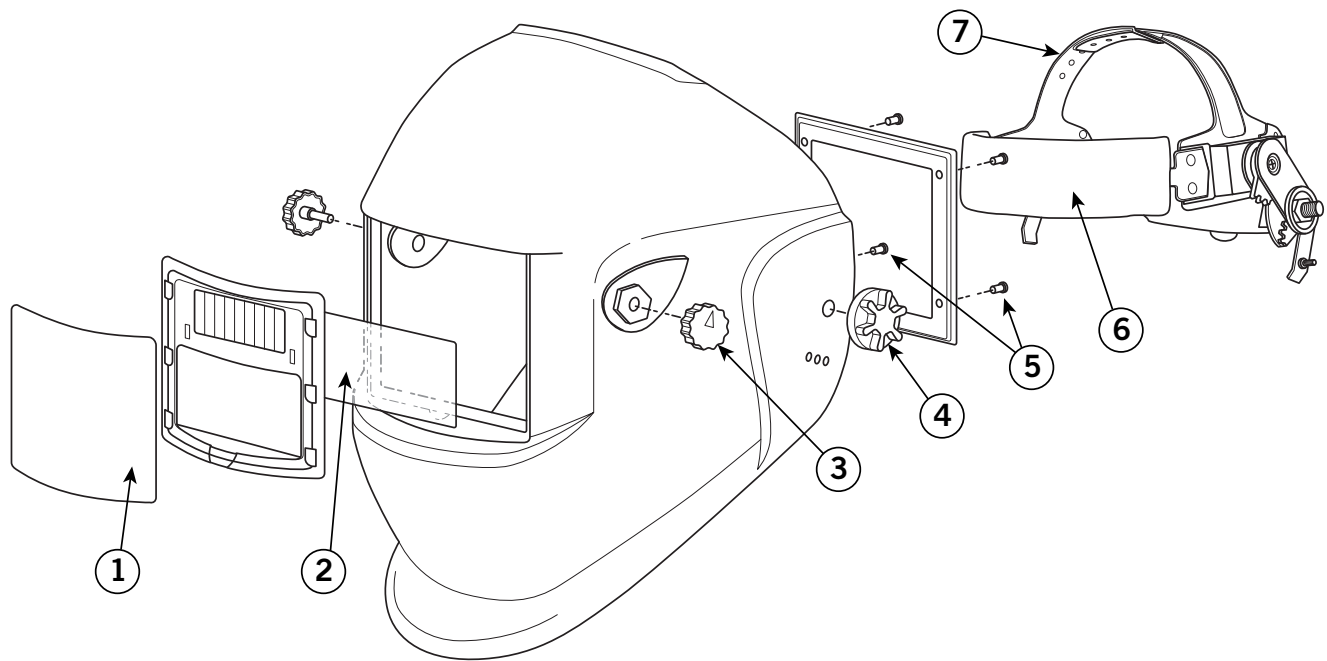


Dragon
WHDR41008



Skull & Fire
WHS41004

Welding Helmet Replacement Parts



#	Description	Qty/Pkg	Part No.	Stock No.
1	Front Cover Lens	2	WH41001-FL	2089-1010
2	Inside Cover Lens	2	WH41001-IL4	2089-1026
3	Shade/Sensitivity Knob	2	WH41001-KB	2089-1013
4	Headgear Knob	2	WH41001-BN	1089-1017
5	Filter Frame w/Screws	1	WH41001-FF	2089-1018
6	Headband	1	WH41001-HB	2089-1020
7	Headgear Assembly	1	WH41001-HG	2089-1023
NS	Hard Hat Fixtures	1	WH41001-HH	2089-1024
NS	Magnifying Lens Kit (2x Magnification)	1	WH41001-ML	2089-1025

WeldSkill® WM MIG Gun Series

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



MODEL	OUTPUT			PROCESS		STANDARD OPTIONS		APPLICATION		
	Current (Amps)	Duty Cycle CO ₂	Wire Diameter in (mm)	MIG	Aluminum	Rear Connector	Knucklehead™ Flexible Conductor Tube	Light Duty Fab	Medium Duty Fab	Heavy Duty Fab
WM250	250	60%	Up to .045" (1.2 mm)	●	●	●	●	●	●	
WM400	400	60%	Up to 1/16" (1.6 mm)	●	●	●	●		●	
WM500	500	60%	Up to 1/16" (1.6 mm)	●	●	●				●

WeldSkill® WM250

250 Amp

60% Duty Cycle, CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for light/medium duty fabrication. Standard Conductor Tube – WM250J-60 (Stock No. 1620-1310) on all guns up to 15 ft (5 m); Conduit Liner – WS42 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.
.045" (1.2 mm)	15 ft (5 m)	WM250-15-4045	1027-1007
	15 ft (5 m)	WM250-15-4045K4	1027-1060

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	10 ft (3 m)	WM250M-10-4045	1027-1030
	12 ft (4 m)	WM250M-12-4045	1027-1031
	15 ft (5 m)	WM250M-15-4045	1027-1032
	15 ft (5 m)	WM250M-15-4045K4	1027-1061
	25 ft (7,6 m)	WM250M-25-4045	1027-1023

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

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	WM250L-15-4045	1027-1082

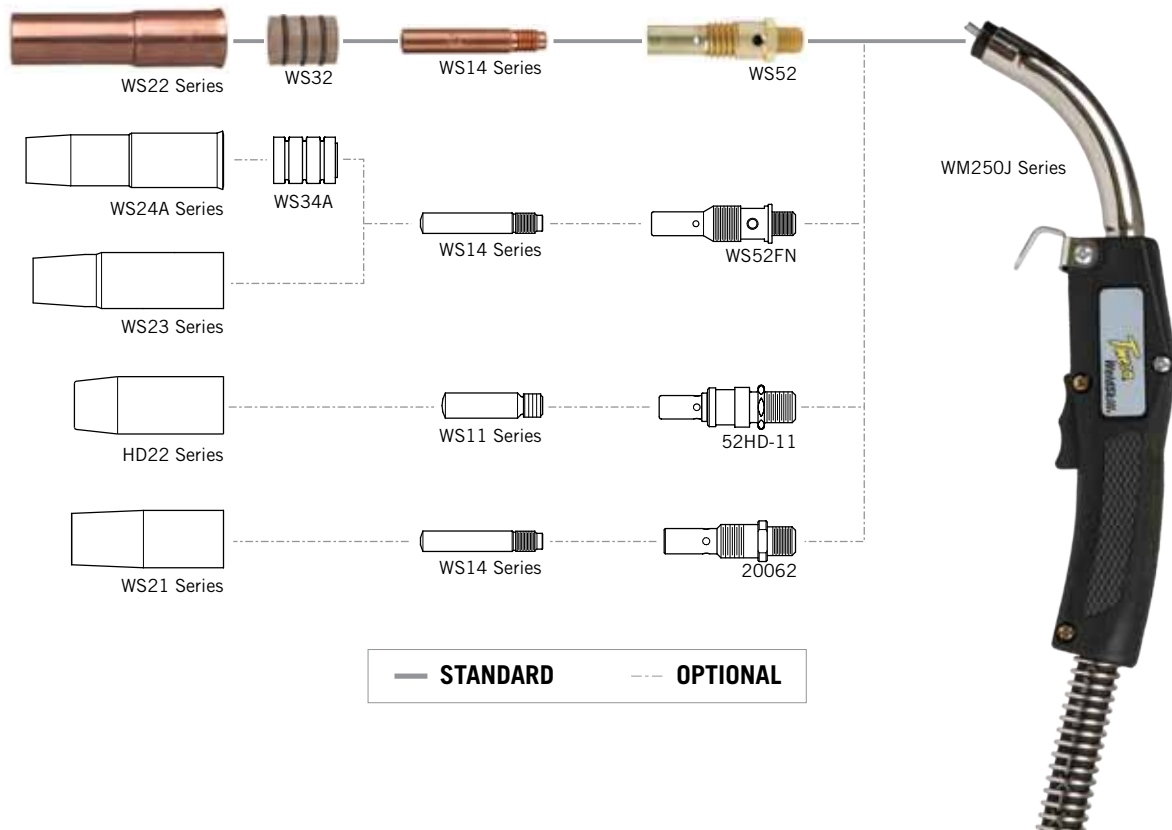
Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Part No. LAK354 (Stock No. 2642-2450) Control wire assembly furnished

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	WM250X-15-4045	1027-1057

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



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

WeldSkill® WM400 400 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector and Knucklehead™ Flexible Conductor Tube as standard options. Suitable for light/medium duty fabrication. Standard Conductor Tube – WM400J-60 (Stock No. 1640-1305) on all guns up to 15 ft (5 m); Conduit Liner – WS44 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.
.045" (1.2 mm)	12 ft (4 m)	WM400-12-3545	1047-1001
	15 ft (5 m)	WM400-15-3545	1047-1002
1/16" (1.6 mm)	15 ft (5 m)	WM400-15-116	1047-1007
	15 ft (5 m)	WM400-15-116K4\$	1040-1170
	25 ft (7.6 m)	WM400-25-116	1047-1016

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	WM400M-15-3545	1047-1027
	12 ft (4 m)	WM400M-12-116	1047-1031
1/16" (1.6 mm)	15 ft (5 m)	WM400M-15-116	1047-1032
	15 ft (5 m)	WM400M-15-116K4\$	1040-1171
	25 ft (7.6 m)	WM400M-25-116	1047-1019

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

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

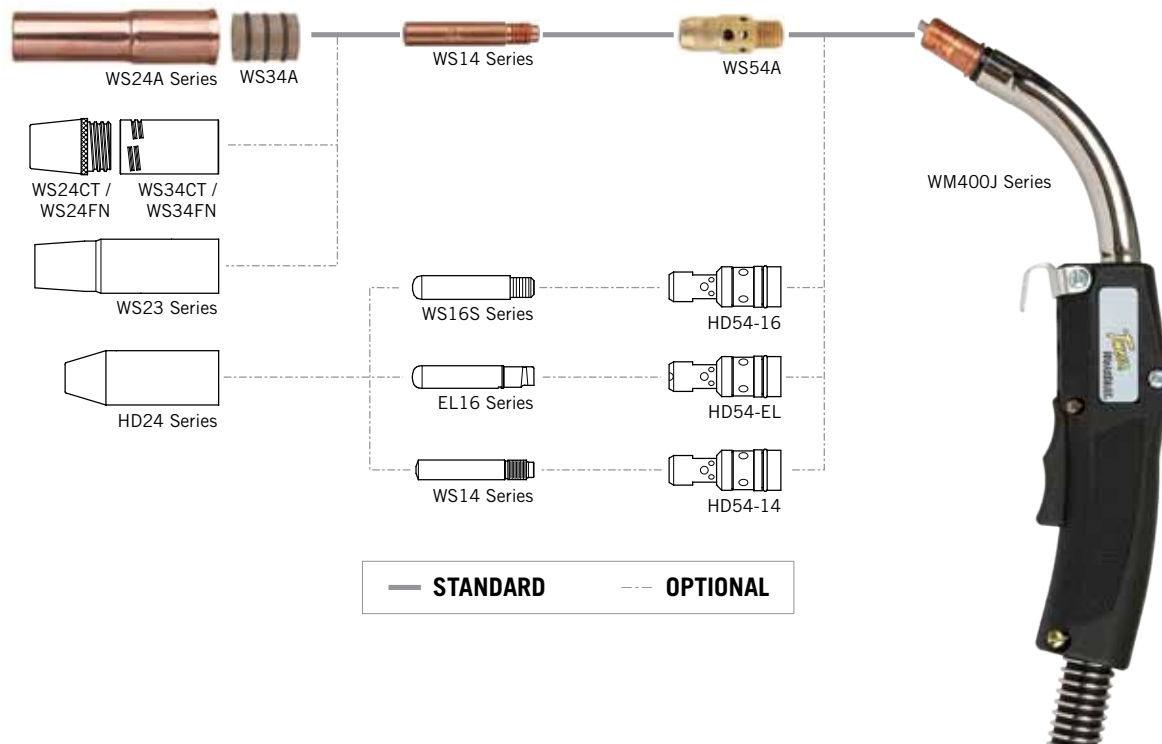
Wire Size	Length	Part No.	Stock No.
.045" (1.2 mm)	15 ft (5 m)	WM400L-15-3545	1047-1077
	15 ft (5 m)	WM400L-15-116	1047-1082
1/16" (1.6 mm)	15 ft (5 m)	WM400L-15-116K4\$	1040-1172
	25 ft (7.6 m)	WM400L-25-116	1047-1022

Some Lincoln wire feeders are assembled with their K1500-2 gun receiving bushing that will accept Tweco Style MIG Guns direct from the factory. Control wire Part No. MS354-DSLJ (Stock No. 2060-2137) Must be ordered separately. Part No. LAK354 (Stock No. 2642-2450) Control wire assembly furnished.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	15 ft (5 m)	WM400X-15-116	1047-1057

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



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 Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

WeldSkill® WM500

500 Amp

60% Duty Cycle,
CO₂ (Carbon Dioxide)

Process – MIG, Aluminum. Available with Rear Connector as a standard option. Suitable for light/medium duty fabrication.
Standard Conductor Tube – WM500J-60 (Stock No. 1650-1120) on all guns up to 15 ft (5 m); Conduit Liner – WS45 Series



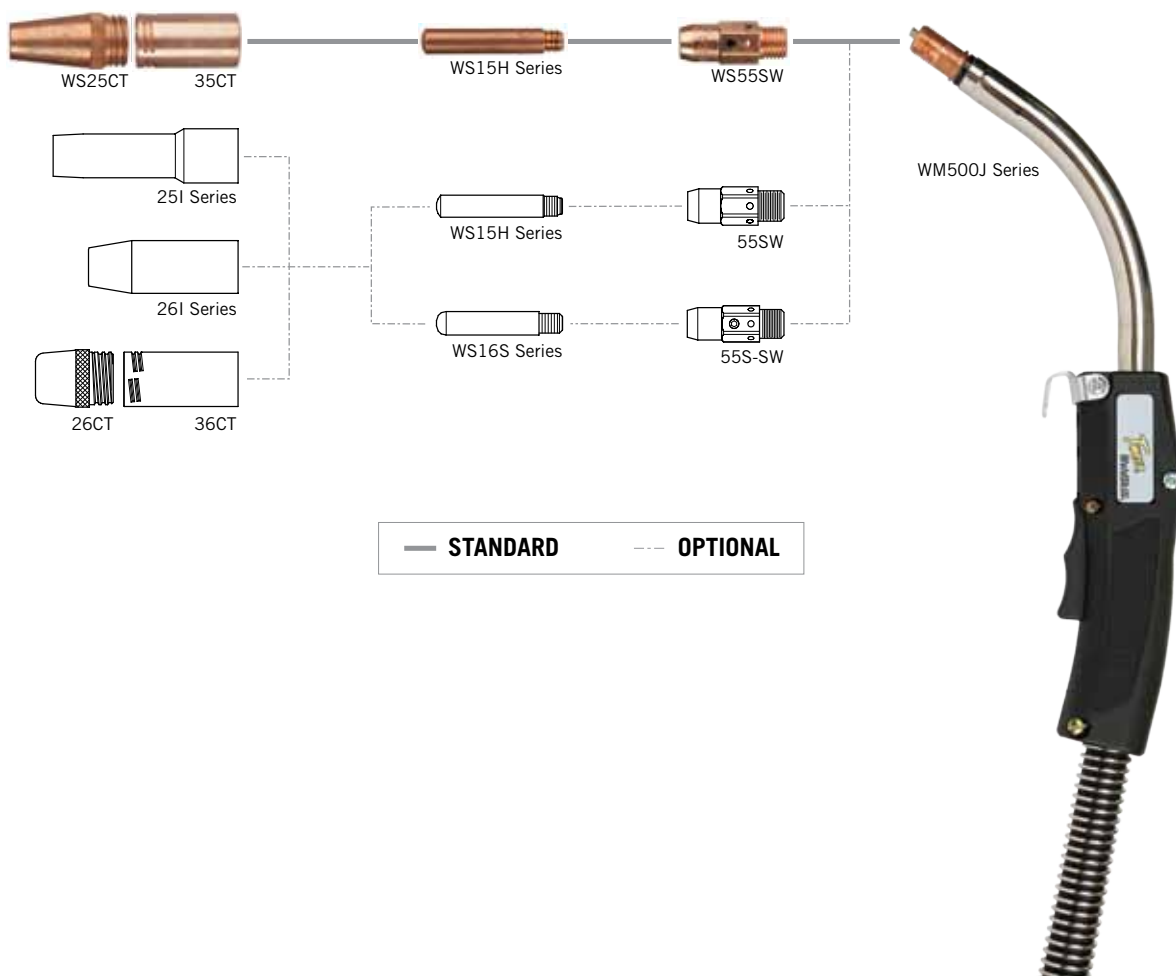
Tweco® Style Rear Connector

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

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	15 ft (5 m)	WM500-15-116	1057-1007

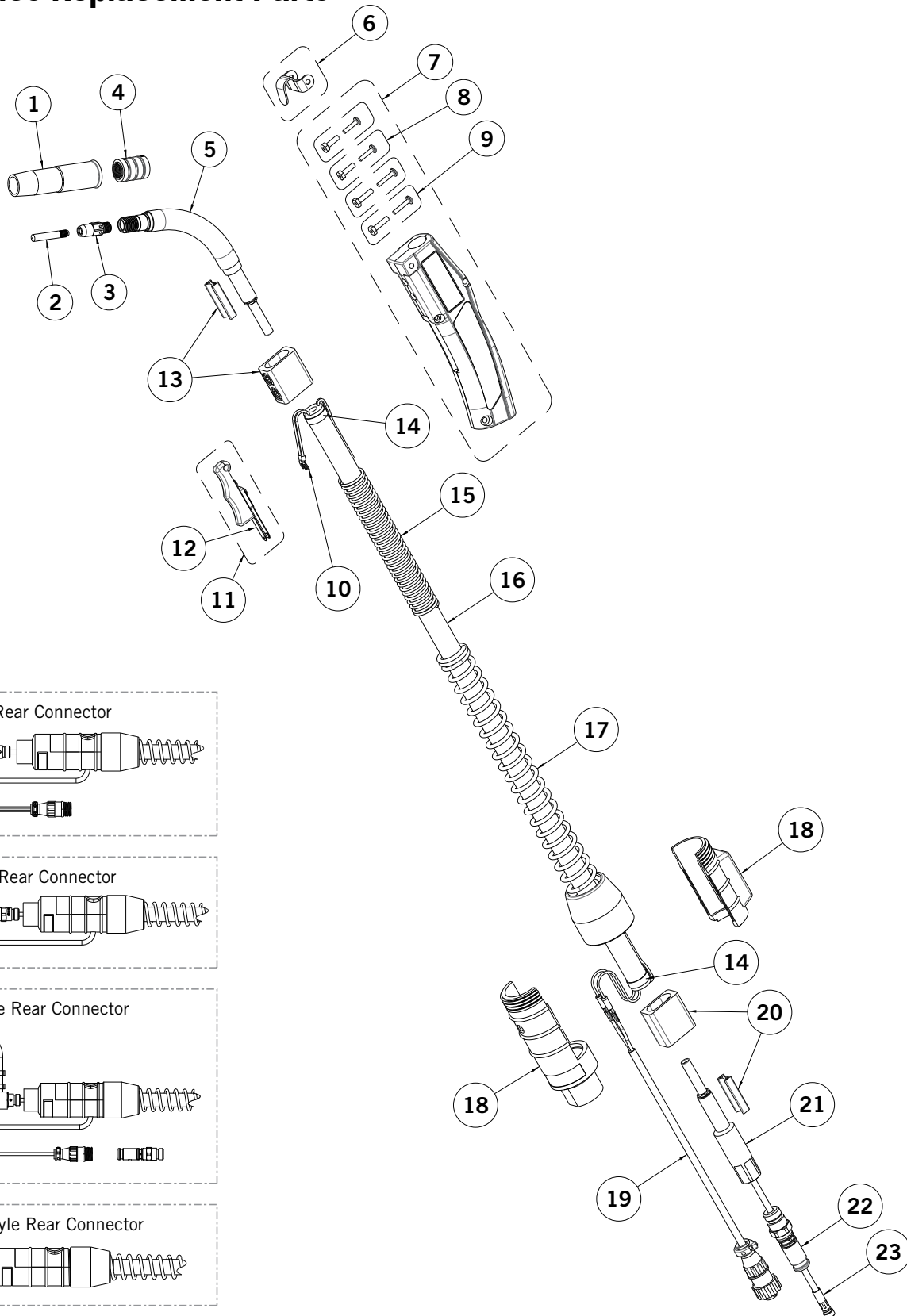
Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
1/16" (1.6 mm)	15 ft (5 m)	WM500M-15-116	1057-1032

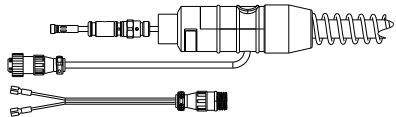


Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The aforementioned registered trademarks are in no way affiliated with Tweco Products, Inc. Tweco is registered trademark of Victor Technologies International, Inc.

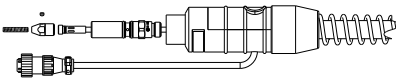
WM Series Replacement Parts



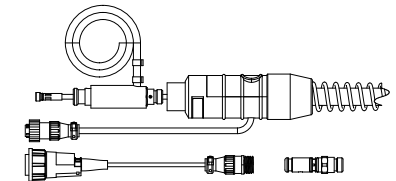
Tweco Style Rear Connector



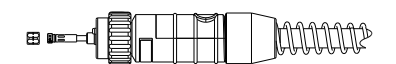
Miller® Style Rear Connector



Lincoln® Style Rear Connector



Euro-Kwik Style Rear Connector



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 Robotics or Victor Technologies International, Inc. Tweco is a registered trademark of Victor Technologies International, Inc.

WM Series Replacement Parts

#	Description	250 Amp		400 Amp		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 74-75		Refer to Pages 74-75		Refer to Pages 74-75	
23	Conduit Liners	Refer to Page 126		Refer to Page 126		Refer to Page 126	

Standard Threaded Style Contact Tips

WS11, WS11H & WS11T Series

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

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy-Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.023" (0.6 mm)	.031" (0.79 mm)	WS11-23	1110-1140	--	--	WS11T-23	1110-1340
.030" (0.8 mm)	.038" (0.97 mm)	WS11-30	1110-1141	--	--	WS11T-30	1110-1341
.035" (0.9 mm)	.044" (1.12 mm)	WS11-35	1110-1142	--	--	WS11T-35	1110-1342
.045" (1.2 mm)	.054" (1.37 mm)	WS11-45	1110-1144	WS11H45	1110-1244	WS11T-45	1110-1344

WS14, WS14H, & WS14T Series

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

25 per pack



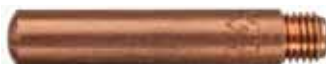
Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy-Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.030" (0.8 mm)	.038" (0.97 mm)	WS14-30	1140-1166	--	--	WS14T-30	1140-1341
.035" (0.9 mm)	.044" (1.12 mm)	WS14-35	1140-1167	WS14H-35	1140-1242	WS14T35	1140-1342
.040" (1.0 mm)	.048" (1.22 mm)	WS14-40	1140-1168	WS14H-40	1140-1243	--	--
.045" (1.2 mm)	.054" (1.37 mm)	WS14-45	1140-1169	WS14H-45	1140-1244	WS14T-45	1140-1344
.052" (1.3 mm)	.064" (1.65 mm)	WS14-52	1140-1170	WS14H-52	1140-1245	WS14T-52	1140-1345
1/16" (1.6 mm)	.073" (1.85 mm)	WS14-116	1140-1171	WS14H-116	1140-1246	WS14T-116	1140-1346
5/64" (2.0 mm)	.090" (2.29 mm)	WS14-564	1140-1174	WS14H-564	1140-1247	--	--
3/64" AL (1.2 mm)	.059" (1.50 mm)	WS14A364	1140-1172	WS14AH-364	1140-1248	--	--

WS15H & WS15HFC Series

0.345" (8.8 mm) Outside Diameter - .3125-24 UNF Threads - 1.970" (50 mm) Overall Length / HFC 1.590" (40.4 mm)

Overall Length

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy-Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.044" (1.12 mm)	WS15H-35	1150-1230	--	--	--	--
.045" (1.2 mm)	.054" (1.37 mm)	WS15H-45	1150-1232	--	--	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	WS15H-116	1150-1234	WS15HFC-116	1150-1268	--	--
5/64" (2.0 mm)	.090" (2.29 mm)	WS15H-564	1150-1235	--	--	--	--
3/32" (2.4 mm)	.106" (2.67 mm)	WS15H-332	1150-1238	--	--	--	--
7/64" (2.8 mm)	.120" (3.05 mm)	WS15H-764	1150-1237	--	--	--	--

16S & 16ST SERIES

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

25 per pack



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy-Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.035" (0.9 mm)	.044" (1.12 mm)	WS16S-35	1160-1425	--	--	WS16ST-35	1160-1440
.045" (1.2 mm)	.054" (1.37 mm)	WS16S-45	1160-1426	--	--	WS16ST-45	1160-1441
.052" (1.3 mm)	.064" (1.65 mm)	WS16S-52	1160-1427	--	--	--	--
1/16" (1.6 mm)	.073" (1.85 mm)	WS16S-116	1160-1428	--	--	WS16ST-35	1160-1443
5/64" (2.0 mm)	.090" (2.29 mm)	WS16S-564	1160-1429	--	--	--	--

Air-Cooled Nozzles and Nozzle Insulators

WS21 SERIES

3-Piece Nozzle Design - 0.750" (19.05 mm) Outside Diameter

Standard Alloy Copper. Self Insulated Nozzles. 2 per pack



WS21 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	WS21-37	1210-1340	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	WS21T-37	1210-1343	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	WS21-50F	1210-1346	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	1/2" (12.7 mm)	WS21-50	1210-1341	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	WS21-62	1210-1342	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WS22 SERIES

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter

Standard Alloy Copper. Use with Nozzle Insulator Part No. WS32 (Stock No. 1320-1100). 2 per pack



WS22 Series



WS32 Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	WS22-37SS	1220-1345	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	WS22T-37SS	1220-1336	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	WS22-50	1220-1341	Standard	Adjustable Recess To Protruding
	1/2" (12.7 mm)	WS22-50SS	1220-1346	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	WS22-62	1220-1342	Standard	Adjustable Recess To Protruding
	5/8" (15.9 mm)	WS22-62SS	1220-1347	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess

WSHD22 SERIES

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Standard Alloy Copper. Use with HD52 Series Gas Diffusers. Self-Insulated Nozzle. 2 per pack



WSHD22 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	1/2" (12.7 mm)	WSHD22-50	1220-1330	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WS23 SERIES

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Standard Alloy Copper. Self-Insulated Nozzles. 2 per pack



WS23 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	WS23-37	1230-1010	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	WS23-50	1230-1011	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	1/2" (12.7 mm)	WS23-50F	1230-1016	Standard	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	WS23-62	1230-1012	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	WS23H-62	1230-1221	Heavy-Duty	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	WS23-75	1230-1013	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

WS23T SERIES

3-Piece Nozzle Design - 0.875" (22.2 mm) Outside Diameter

Standard Alloy Copper. Self-Insulated Nozzles. 2 per pack



WS23T Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	3/8" (9.5 mm)	WS23T-37	1230-1035	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/8" (9.5 mm)	WS23T-37F	1230-1303	Tapered	Flush To 1/16" (1.6 mm) Tip Recess

Air-Cooled Nozzles and Nozzle Insulators

WS24A Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter

Use with Nozzle Insulator Part No. WS34A
(Stock No. 1340-1125). 2 per pack



WS24A Series



WS34A Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	WS24A-37SS	1240-1559	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	WS24A-50	1240-1555	Standard	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	WS24A-50SS	1240-1560	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	WS24A-62	1240-1556	Standard	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	WS24A-62SS	1240-1561	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	WS24AH-62SS	1240-1566	Standard Short Stop	Flush to 1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	WS24A-75	1240-1557	Standard	Adjustable Tip Recess - Tip Protruding

WS24CT Series

Coarse Thread Nozzle

Use with Nozzle Insulator Part No. WS34CT (Stock No. 1340-1126).
2 per pack



WS24CT Series



WS34CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	WS24CT-50S	1240-1580	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	WS24CT-62S	1240-1581	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	WS24CT-62R	1240-1591	Tapered	1/2" (12.7 mm) Tip Recess
	3/4" (19.5 mm)	WS24CT-75S	1240-1582	Standard Short Stop	5/32" (3.97 mm) Tip Recess

WS24FN Series

Fine Thread Nozzle

Use with Nozzle Insulator Part No. WS34FN (Stock No. 1340-1127).
2 per pack



WS24FN Series



WS34FN Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On	1/2" (12.7 mm)	WS24FN-50S	1240-1715	Standard Short Stop	5/32" (3.97 mm) Tip Recess
	5/8" (15.9 mm)	WS24FN-62S	1240-1727	Standard Short Stop	5/32" (3.97 mm) Tip Recess

WSHD24 Series

3-Piece Nozzle Design - 1.125" (28.6 mm) Outside Diameter

Use with HD54 Series Gas Diffusers. 2 per pack



WSHD24 Series

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On (A)	5/8" (15.9 mm)	WSHD24L-62	1240-1572	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	5/8" (15.9 mm)	WSHD24L-62F	1240-1573	Tapered	Flush To 1/16" (1.6 mm) Tip Recess
	5/8" (15.9 mm)	WSHD24-62	1240-1570	Standard (1)	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	WSHD24L-75	1240-1574	Tapered	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess
	3/4" (19.5 mm)	WSHD24-75	1240-1571	Standard	1/8" - 5/32" (3.2 mm - 3.97 mm) Tip Recess

Air-Cooled Nozzles and Nozzle Insulators

25CT Series

Coarse Thread Nozzle

Use with Nozzle Insulator Part No. WS35CT (Stock No. 1350-1425).
2 per pack



WS25CT Series

WS35CT Insulator
(sold separately)

Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Thread-On (A)	1/2" (12.7 mm)	WS25CT-50	1250-1439	Standard	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	WS25CT-62	1250-1440	Standard	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	WS25CT-75	1250-1441	Standard	1/8" (3.2 mm) Tip Recess

Air-Cooled Standard Gas Diffusers

MINI-MIG Series 5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
WS35-50	1500-1140	Brass	WS11 Series	WS21 Series

WM150 Series 5 per pack



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

WM250 Series 5 per pack



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

WM400 Series 5 per pack



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

WM500 Series 5 per pack



Part No.	Stock No.	Material	Contact Tip	Nozzle
WS55SW*	1550-1140	Copper	WS15H Series	WS25CT Series
WS55H**	1550-1141	Copper	WS15H Series	WS25CT Series

*Use with WS45-3545, WS45-116, and WS45N-3545 Series Conduit Liners

**Use with WS45H-332, 45H-764, and 45-18 Series Conduit Liners

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		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 mm - 0.9 mm)	15 ft (5 m)	WS42-3035-15	1420-1140
.030" - .035" (0.8 mm - 0.9 mm)	25 ft (8 m)	WS42-3035-25	1420-1145
.040" - .045" (1.0 mm - 1.2 mm)	15 ft (5 m)	WS42-4045-15	1420-1141
.040" - .045" (1.0 mm - 1.2 mm)	25 ft (8 m)	WS42-4045-25	1420-1146

WM400 Series - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	15 ft (5 m)	WS44-3545-15	1440-1140
.035" - .045" (0.9 mm - 1.2 mm)	25 ft (8 m)	WS44-3545-25	1440-1145
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	WS44-116-15	1440-1141
.052" - 1/16" (1.3 mm - 1.6 mm)	25 ft (8 m)	WS44-116-25	1440-1146
5/64" (2.0 mm)	15 ft (5 m)	WS44-564-15	1440-1142
5/64" (2.0 mm)	25 ft (8 m)	WS44-564-25	1440-1147

WM500 Series - Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (0.9 mm - 1.2 mm)	15 ft (5 m)	WS45-3545-15	1450-1104
.052" - 1/16" (1.3 mm - 1.6 mm)	15 ft (5 m)	WS45-116-15	1450-1114
3/32" (2.4 mm)	15 ft (5 m)	WS45H-332-15	1450-1134

Conduit Liners

For Use With Aluminum Welding Wires

WM150 & WM250 Series - Teflon

Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 mm - 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 mm - 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



WeldSkill® Electrode Holders

Amperage	Body Alloy	Electrode	Cable	Length	Part No.	Stock No.
200	Brass Alloy	5/32" (4.0 mm)	2/0 (67.4 mm)	8-1/4" (209 mm)	WS532	9110-1180
250	Brass Alloy	3/16" (5.0 mm)	2/0 (67.4 mm)	9-1/4" (235 mm)	WS316	9110-1181
300	Brass Alloy	7/32" (5.5 mm)	2/0 (67.4 mm)	10" (253 mm)	WS732	9110-1182
350	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	11" (279 mm)	WS350E	9110-1118
400	Copper Alloy	1/4" (6.4 mm)	4/0 (107 mm)	12" (305 mm)	WS400E	9110-1119

WeldSkill "Hold-Tite" Electrode Holder

Amperage	Electrode	Cable	Part No.	Stock No.
400	1/4" (6.4 mm)	3/0 (85 mm)	WHT-400	9120-1010



Ground Clamps



WS300GC

Copper Ground Clamps

Amperage	Jaw Opening	Jaw Depth	Cable	Length	Part No.	Stock No.
200	1" (24 mm)	2-1/2" (63 mm)	Through 1/0	6" (152 mm)	WS200GC	9205-1215
300	1-1/2" (38 mm)	3-1/2" (88 mm)	Through 2/0	8-1/4" (209 mm)	WS300GC	9205-1216
500	2" (50 mm)	4-7/8" (123 mm)	Through 3/0	10" (253 mm)	WS500GC	9205-1217



WS300SGC

Steel Ground Clamps

Amperage	Jaw Opening	Jaw Depth	Cable	Length	Part No.	Stock No.
180	1-3/4" (44 mm)	2" (50 mm)	Through 1/0	6-1/2" (165 mm)	WS180SGC	9205-1245
300	2" (50 mm)	2-1/2" (63 mm)	Through 3/0	7-3/4" (196 mm)	WS300SGC	9205-1246
500	2-1/4" (50 mm)	3" (76 mm)	Through 4/0	9-1/2" (241 mm)	WS500SGC	9205-1247

Cable Connectors



4-WPC

Positive-CAM Mechanical Cable Connectors

Description	Cable	Std Pkg	Part No.	Stock No.
Complete Set of Connectors	4, 2, 1	1	1-WPC	9425-1125
Connector Male Half Only	4, 2, 1	2	1-WPC-P	9425-1126
Connector Female Half Only	4, 2, 1	2	1-WPC-R	9425-1127
Complete Set of Connectors	1/0, 2/0, 3/0	1	2-WPC	9425-1225
Connector Male Half Only	1/0, 2/0, 3/0	2	2-WPC-P	9425-1226
Connector Female Half Only	1/0, 2/0, 3/0	2	2-WPC-R	9425-1227
Complete Set of Connectors	3/0 or 4/0	1	4-WPC	9425-1425
Connector Male Half Only	3/0 or 4/0	2	4-WPC-P	9425-1246
Connector Female Half Only	3/0 or 4/0	2	4-WPC-R	9425-1247



WDC-75

Dinse Style Mechanical Cable Connectors

Description	Cable	Std Pkg	Part No.	Stock No.
Complete Set of Connectors	4, 2, 1	1	WDC-25	9425-1445
Connector Male Half Only	4, 2, 1	2	WDC-25-P	9425-1446
Connector Female Half Only	4, 2, 1	2	WDC-25-R	9425-1447
Complete Set of Connectors	1/0, 2/0, 3/0	1	WDC-50	9425-1430
Connector Male Half Only	1/0, 2/0, 3/0	2	WDC-50-P	9425-1431
Connector Female Half Only	1/0, 2/0, 3/0	2	WDC-50-R	9425-1432
Complete Set of Connectors	3/0 or 4/0	1	WDC-75	9425-1435
Connector Male Half Only	3/0 or 4/0	2	WDC-75-P	9425-1436
Connector Female Half Only	3/0 or 4/0	2	WDC-75-R	9425-1437

Panel Receptacles

To Fit Dinse Style Male Connectors



WDP-25

Fits WeldSkill Connector	Cable	Std Pkg	Part No.	Stock No.
Panel fitting accepts WDC-25-P	4,2,1	1	WDP-25	9580-1129
Panel fitting accepts WDC-50-P & WDC-75-P	1/0 through 4/0	1	WDP-50	9580-1130

Miscellaneous Connectors

Description	Part No.	Stock No.
50 mm Dinse Male to Tweco #2 & #4 Positive Cam Connectors	2MDC-CK	9425-1240



WS-120H

Hammer-on Cable Lugs

Amperage	Cable	Stud Hole Size	I.D. Cable Socket	Std Pkg	Part No.	Stock No.
250	3/0 through 4/0	17/32" (13.5 mm)	.660" (16.8 mm)	5	WS-3040H	9520-1128
225	1 through 2/0	17/32" (13.5 mm)	.559" (14.2 mm)	5	WS-120H	9520-1127
150	6 through 2	17/32" (13.5 mm)	.461" (11.7 mm)	5	WS-62H	9520-1125

LIMITED WARRANTY: VICTOR TECHNOLOGIES™ 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 VICTOR TECHNOLOGIES products as stated below, VICTOR TECHNOLOGIES shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with VICTOR TECHNOLOGIES's specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at VICTOR TECHNOLOGIES's sole option, of any components or parts of the product determined by VICTOR TECHNOLOGIES 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: VICTOR TECHNOLOGIES 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 VICTOR TECHNOLOGIES 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 VICTOR TECHNOLOGIES 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 VICTOR TECHNOLOGIES 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 VICTOR TECHNOLOGIES delivered the product to the authorized distributor.



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™ MIG Guns & PullMaster™, Spray Master®, Eliminator®, Supra™, Classic No. #, SEFC, 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:
Fusion™ MIG Guns
WeldSkill® MIG and Spool Guns (No Labor)
(from the date sold by authorized distributor to purchaser)



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 product

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



1 YEAR PARTS AND LABOR UNLESS SPECIFIED

Arcair® N7500 (No Labor)

30 DAYS PARTS / NO LABOR

All Other Products



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



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 PCBs.
* 3 years on Power Supply Components

2 YEARS PARTS AND LABOR UNLESS SPECIFIED

Auto-Darkening Welding Helmet (Electronic Lens),
** 1 Month Harness Assembly
Victor® Regulator for Fabricator® 181i (No Labor)

1 YEARS PARTS AND LABOR UNLESS SPECIFIED

95S, Water Recirculators
All Plasma Welding Consoles (i.e 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 **STOOBY** representative for warranty information on this product.

Victor Technologies 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 VICTOR TECHNOLOGIES repair facility within thirty (30) days of the repair.

* No employee, agent, or representative of VICTOR TECHNOLOGIES is authorized to change this warranty in any way or grant any other warranty, and VICTOR TECHNOLOGIES shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfillment of VICTOR TECHNOLOGIES'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 VICTOR TECHNOLOGIES's sole judgment, impaired the safety or performance of any VICTOR TECHNOLOGIES product. Purchaser's rights under this warranty are void if the product is sold to purchaser by unauthorized persons.

THE AMERICAS

Denton, TX USA U.S. Customer Care

Ph: 1-800-426-1888 (tollfree)
Fax: 1-800-535-0557 (tollfree)

Miami, FL USA Sales Office, Latin America

Ph: 1-954-727-8371
Fax: 1-954-727-8376

Oakville, Ontario, Canada Canada Customer Care

Ph: 1-905-827-4515
Fax: 1-800-588-1714 (tollfree)

International Customer Care

Ph: 1-940-381-1212
Fax: 1-940-483-8178

EUROPE

Chorley, United Kingdom Customer Care

Ph: +44 1257-261755
Fax: +44 1257-224800

Milan, Italy Customer Care

Ph: +39 0236546801
Fax: +39 0236546840

Neuweied, Germany Customer Care

Ph: +49 (0) 2631 9999 60
Fax: +49 (0) 2631 9999 610

ASIA / PACIFIC

Cikarang, Indonesia Customer Care

Ph: 6221-8990-6095
Fax: 6221-8990-6096

Melbourne, Australia Australia Customer Care

Ph: 1300-654-674 (tollfree)
Ph: 61-3-9474-7400
Fax: 61-3-9474-7391

Shanghai, China Sales Office

Ph: +86 21-64072626
Fax: +86 21-64483032

Rawang, Malaysia Customer Care

Ph: +603 6092-2988
Fax: +603 6092-1085

International

Ph: 61-3-9474-7508
Fax: 61-3-9474-7488

Singapore Sales Office

Ph: +65 6832-8066
Fax: +65 6763-5812



THE AMERICAS

Denton, TX USA
U.S. Customer Care
Ph: 1-800-426-1888 (tollfree)
Fax: 1-800-535-0557 (tollfree)
International Customer Care
Ph: 1-940-381-1212
Fax: 1-940-483-8178

Miami, FL USA
Sales Office, Latin America
Ph: 1-954-727-8371
Fax: 1-954-727-8376

Oakville, Ontario, Canada
Canada Customer Care
Ph: 1-905-827-4515
Fax: 1-800-588-1714 (tollfree)

EUROPE

Chorley, United Kingdom
Customer Care
Ph: +44 1257-261755
Fax: +44 1257-224800

Milan, Italy
Customer Care
Ph: +39 0236546801
Fax: +39 0236546840

Neuweied, Germany
Customer Care
Tel: +49 (0) 2631 9999 60
Fax: +49 (0) 2631 9999 610

ASIA/PACIFIC

Cikarang, Indonesia
Customer Care
Ph: 6221-8990-6095
Fax: 6221-8990-6096

Rawang, Malaysia
Customer Care
Ph: +603 6092-2988
Fax: +603 6092-1085

Melbourne, Australia
Australia Customer Care
Ph: 1300-654-674 (tollfree)
Ph: 61-3-9474-7400
Fax: 61-3-9474-7391
International
Ph: 61-3-9474-7508
Fax: 61-3-9474-7488

Shanghai, China
Sales Office
Ph: +86 21-64072626
Fax: +86 21-64483032

Singapore
Sales Office
Ph: +65 6832-8066
Fax: +65 6763-5812

ISO 9001 REGISTERED FIRM

The Quality System of
Victor Technologies™ at our
Denton, Roanoke and
Hermosillo locations
is registered to meet the
requirements of ISO 9001



INNOVATION TO SHAPE THE WORLD™

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