

## Air-Cooled Torches

### 80 AMP 24 Series

Includes: torch, ribbed handle, power cable and insulator.

#### Rubber

Part No.	Description	Hose Length
24-12-R	Torch package	12.5'
24-25-R		25'
24-90-12-R	Torch package 90° head	12.5'
24-90-25-R		25'
24V-12-R	Torch package w/valve	12.5'
24V-25-R		25'



### 80 AMP 24 Series Component Torch

Includes: torch head, torch body, ribbed handle, power cable and insulator.

#### Rubber

Part No.	Description	Hose Length
24FMT-12-R	Torch package flex	12.5'
24FMT-25-R		25'
24FVMT-12-R	Torch package flex w/valve	12.5'
24FVMT-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
24FMT-12-2	Torch package flex	12.5'
24FMT-25-2		25'
24FVMT-12-2	Torch package flex w/valve	12.5'
24FVMT-25-2		25'

### 125 AMP 9 Series

Includes: torch, ribbed handle, power cable, insulator and medium back cap.

#### Rubber

Part No.	Description	Hose Length
9-12-R	Torch package	12.5'
9-25-R		25'
9F-12-R	Torch package flex	12.5'
9F-25-R		25'
9FV-12-R	Torch package flex w/valve	12.5'
9FV-25-R		25'
9V-12-R	Torch package w/valve	12.5'
9V-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
9-12-2	Torch package	12.5'
9-25-2		25'
9F-12-2	Torch package flex	12.5'
9F-25-2		25'
9FV-12-2	Torch package flex w/valve	12.5'
9FV-25-2		25'
9V-12-2	Torch package w/valve	12.5'
9V-25-2		25'

### 125 AMP 9 Series Pencil Torch

Includes: torch, smooth handle, power cable and insulator.

#### Rubber

Part No.	Description	Hose Length
9P-12-R	Torch package 180° machine	12.5'
9P-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
9P-12-2	Torch package 180° machine	12.5'
9P-25-2		25'

### 125 AMP 9 Series Component Torch

Includes: torch head, torch body, ribbed handle, power cable, insulator and medium back cap.

#### Rubber

Part No.	Description	Hose Length
9FMT-12-R	Torch package flex	12.5'
9FMT-25-R		25'
9FVMT-12-R	Torch package flex w/valve	12.5'
9FVMT-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
9FMT-12-2	Torch package flex	12.5'
9FMT-25-2		25'
9FVMT-12-2	Torch package flex w/valve	12.5'
9FVMT-25-2		25'

## TIG Torch Packages

### 150 AMP 17 Series

Includes: torch, ribbed handle, power cable, insulator and long back cap.

#### Rubber

Part No.	Description	Hose Length
17-12-R	Torch package	12.5'
17-25-R		25'
17F-12-R	Torch package flex	12.5'
17F-25-R		25'
17FV-12-R	Torch package flex w/valve	12.5'
17FV-25-R		25'
17V-12-R	Torch package w/valve	12.5'
17V-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
17-12-2	Torch package	12.5'
17-25-2		25'
17F-12-2	Torch package flex	12.5'
17F-25-2		25'
17FV-12-2	Torch package flex w/valve	12.5'
17FV-25-2		25'
17V-12-2	Torch package w/valve	12.5'
17V-25-2		25'

### 150 AMP 17 Series Component Torch

Includes: torch head, torch body, ribbed handle, power cable, insulator and long back cap.

#### Rubber

Part No.	Description	Hose Length
17FMT-12-R	Torch package flex	12.5'
17FMT-25-R		25'
17FVMT-12-R	Torch package flex w/valve	12.5'
17FVMT-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
17FMT-12-2	Torch package flex	12.5'
17FMT-25-2		25'
17FVMT-12-2	Torch package flex w/valve	12.5'
17FVMT-25-2		25'

### 150 AMP 150M Modular Torch

Includes: 9-70M head, 1726M head, flex coil element, solid element, torch body, power cable, handle and wrench.

#### Rubber

Part No.	Description	Hose Length
150M-12-R	Torch package	12.5'
150M-25-R		25'
150VM-12-R	Torch package w/valve	12.5'
150VM-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
150M-12-2	Torch package	12.5'
150M-25-2		25'
150VM-12-2	Torch package w/valve	12.5'
150VM-25-2		25'

### 200 AMP 26 Series

Includes: torch, ribbed handle, power cable, insulator and long back cap.

#### Rubber

Part No.	Description	Hose Length
26-12-R	Torch package	12.5'
26-25-R		25'
26F-12-R	Torch package flex	12.5'
26F-25-R		25'
26FV-12-R	Torch package flex w/valve	12.5'
26FV-25-R		25'
26V-12-R	Torch package w/valve	12.5'
26V-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
26-12-2	Torch package	12.5'
26-25-2		25'
26F-12-2	Torch package flex	12.5'
26F-25-2		25'
26FV-12-2	Torch package flex w/valve	12.5'
26FV-25-2		25'
26V-12-2	Torch package w/valve	12.5'
26V-25-2		25'

### 200 AMP 26 Series Component Torch

Includes: torch head, torch body, ribbed handle, power cable, insulator and long back cap.

#### Rubber

Part No.	Description	Hose Length
26FMT-12-R	Torch package flex	12.5'
26FMT-25-R		25'
26FVMT-12-R	Torch package flex w/valve	12.5'
26FVMT-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
26FMT-12-2	Torch package flex	12.5'
26FMT-25-2		25'
26FVMT-12-2	Torch package flex w/valve	12.5'
26FVMT-25-2		25'

## TIG Torch Packages

### 200 AMP 200M Modular Torch

Includes: 9-70M head, 1726M head, flex coil element, solid element, torch body, power cable, handle and wrench

#### Rubber

Part No.	Description	Hose Length
200M-12-R	Torch package	12.5'
200M-25-R		25'
200VM-12-R	Torch package w/valve	12.5'
200VM-25-R		25'

#### 2-Piece

Part No.	Description	Hose Length
200M-12-2	Torch package	12.5'
200M-25-2		25'
200VM-12-2	Torch package w/valve	12.5'
200VM-25-2		25'

### Water-Cooled Torches

#### 180 AMP 24 Series

Includes: torch, smooth handle, power cable, water and gas hoses, and insulator.

#### Rubber

Part No.	Description	Hose Length
24W-12-R	Torch package	12.5'
24W-25-R		25'
24W-90-12-R	Torch package 90° head	12.5'
24W-90-25-R		25'

#### Vinyl

Part No.	Description	Hose Length
24W-12	Torch package	12.5'
24W-25		25'
24W-90-12	Torch package 90° head	12.5'
24W-90-25		25'

### 200 AMP 25 Series Flex Pencil Torch

Includes: torch, smooth handle, power cable, water and gas hoses, and insulator.

#### Rubber

Part No.	Description	Hose Length
25-12-R	Torch package machine flex	12.5'
25-25-R		25'

#### Vinyl

Part No.	Description	Hose Length
25-12	Torch package machine flex	12.5'
25-25		25'

### 225 AMP 225M Series Modular Torch

Includes: 9-70M head, 1726M head, torch body, power cable, water and gas hoses, and handle.

#### Rubber

Part No.	Description	Hose Length
225M-12-R	Torch package flex braided rubber	12.5'
225M-25-R		25'

#### Vinyl

Part No.	Description	Hose Length
225M-12	Torch package flex	12.5'
225M-25		25'

### 250 AMP 20 Series

Includes: torch, smooth handle, power cable, water and gas hoses, insulator and medium back cap.

#### Rubber

Part No.	Description	Hose Length
20-12-R	Torch package	12.5'
20-25-R		25'
20F-12-R	Torch package flex	12.5'
20F-25-R		25'
20M-12-R	Torch package mechanical fittings	12.5'
20M-25-R		25'

#### Vinyl

Part No.	Description	Hose Length
20-12	Torch package	12.5'
20-25		25'
20F-12	Torch package flex	12.5'
20F-25		25'
20M-12	Torch package mechanical fittings	12.5'
20M-25		25'

### 250 AMP 20 Series Pencil Torch

Includes: torch, smooth handle, power cable, water and gas hoses, and insulator.

#### Rubber

Part No.	Description	Hose Length
20P-12-R	Torch package 180° machine	12.5'
20P-25-R		25'

#### Vinyl

Part No.	Description	Hose Length
20P-12	Torch package 180° machine	12.5'
20P-25		25'

## TIG Torch Packages

### 250 AMP 22 Series

Includes: torch, insulating boot, collet knob, power cable, water and gas hoses, and insulator.

#### Rubber

Part No.	Description	Hose Length
22A-12	Torch package 180° 7" machine	12.5'
22A-25		25'
22B-12	Torch package 180° 3" machine	12.5'
22B-25		25'

### 350 AMP 18 Series

Includes: torch, smooth handle, power cable, water and gas hoses, insulator and long back cap.

#### Rubber

Part No.	Description	Hose Length
18-12-R	Torch package	12.5'
18-25-R		25'
18F-12-R	Torch package flex	12.5'
18F-25-R		25'
18V-12-R	Torch package w/valve	12.5'
18V-25-R		25'

#### Vinyl

Part No.	Description	Hose Length
18-12	Torch package	12.5'
18-25		25'
18F-12	Torch package flex	12.5'
18F-25		25'
18V-12	Torch package w/valve	12.5'
18V-25		25'

### 500 AMP 18 Series Machine Torch

Includes: torch, barrel handle, power cable, water and gas hoses, and insulator.

#### Rubber

Part No.	Description	Hose Length
18P-12	Torch package 180° machine	12.5'
18P-25		25'

### 500 AMP 12 Series

Includes: torch, handle, power cable, water and gas hoses, and insulator and long back cap.

#### Rubber

Part No.	Description	Hose Length
12-12	Torch package	12.5'
12-25		25'

### 500 AMP 27 Series

Includes: torch, insulating boot, shaft assembly, power cable, water and gas hoses, and insulator.

#### Rubber

Part No.	Description	Hose Length
27A-12	Torch package 180° 9" machine	12.5'
27A-25		25'
27B-12	Torch package 180° 20" machine	12.5'
27B-25		25'

## Modular TIG Torch Parts

### 150 AMP Air Cooled Modular Flex TIG Torch

#### Torch Package Part Number

Torch    Hose Length    Power Cable

**150M**    **12**    **R**

Possible options for selecting a complete torch configuration from this page.



**150M**    150 AMP modular flex torch  
150VM    150 AMP modular flex torch w/valve  
200M    200 AMP modular flex torch  
200VM    200 AMP modular flex torch w/valve

**12**    12.5 feet  
25    25 feet

**R**    1-Piece Rubber power cable  
2    2-Piece Power cable

Item	Part No.	Description
1	1726M	Torch head 200 AMP 60°
2	1726PM	Torch head 200 AMP 180°
3	9-70M	Torch head 125 AMP 70°
4	9-90M	Torch head 125 AMP 90°
5	09PM	Torch head 125 AMP 180°
6	024M	Torch head 80 AMP 70°
7	24-90M	Torch head 80 AMP 90°

Item	Part No.	Description
8	150M	Torch, 150 AMP
9	150VM	Torch, 150 AMP with valve
10	VS-2	Valve stem
11	150CEM	Flex element 150 AMP
12	150SEM	Solid element 150 AMP
13	150TBM	Body 150 AMP

Item	Part No.	Description
15	105Z55R	Handle, ribbed (standard)
16	57Y01R	Power cable 12.5' 1pc
	57Y03R	Power cable 25' 2pc
17	57Y01-2	Power cable 12.5' 2pc
	57Y03-2	Power cable 25' 2pc

### 200 AMP Air Cooled Modular Flex TIG Torch



Item	Part No.	Description
1	1726M	Torch head 200 AMP 60°
2	1726PM	Torch head 200 AMP 180°
3	9-70M	Torch head 125 AMP 70°
4	9-90M	Torch head 125 AMP 90°
5	09PM	Torch head 125 AMP 180°
6	024M	Torch head 80 AMP 70°
7	24-90M	Torch head 80 AMP 90°

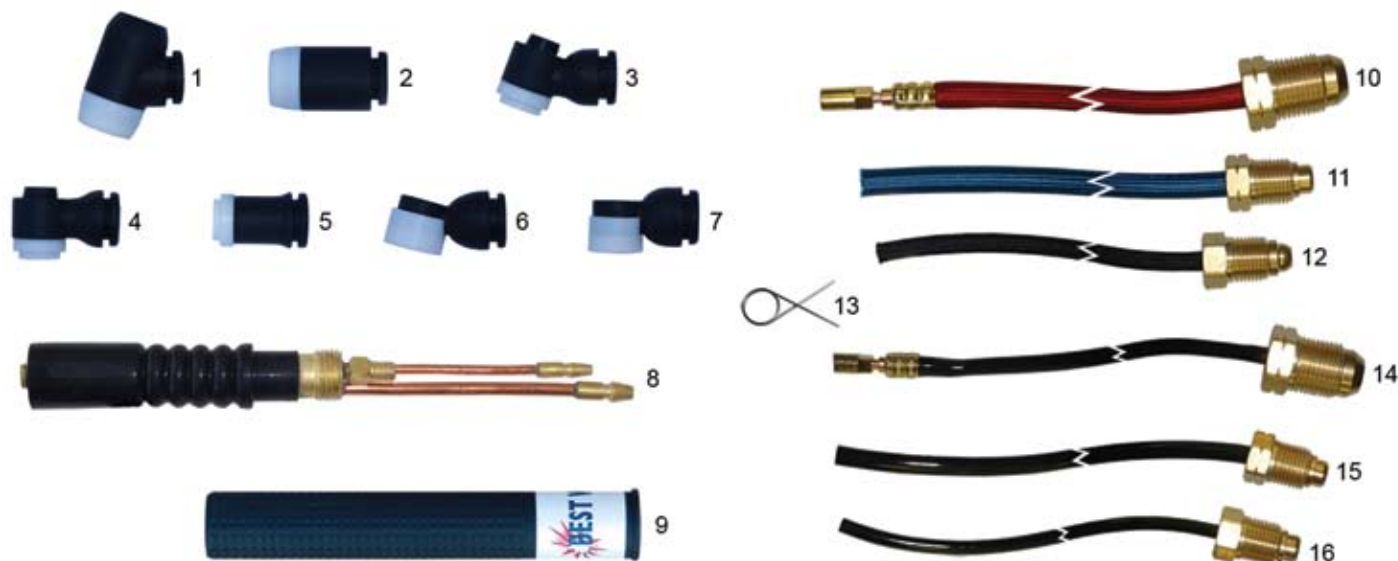
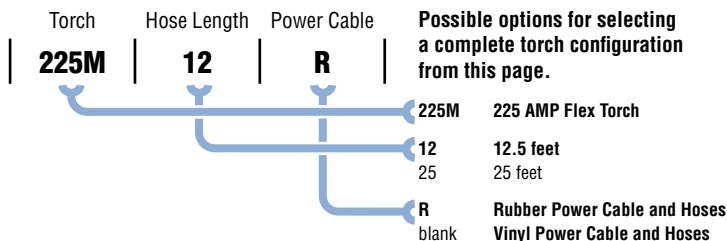
Item	Part No.	Description
18	200M	Torch, 200 AMP
19	200VM	Torch, 200 AMP with valve
20	VS-1	Valve stem
21	200CEM	Flex element 200 AMP
22	200SEM	Solid element 200 AMP
23	200TBM	Body 200 AMP
24	200VTBM	Body 200 AMP with valve

Item	Part No.	Description
25	10N15R	Handle, ribbed (std)
26	46V28R	Power cable 12.5' 1pc
	46V30R	Power cable 25' 2pc
27	46V28-2	Power cable 12.5' 2pc
	46V30-2	Power cable 25' 2pc

## Modular TIG Torch Parts

### 225 AMP Water Cooled Modular Flex TIG Torch

#### Torch Package Part Number



Item	Part No.	Description
1	1726M	Torch head 200 AMP 60°
2	1726PM	Torch head 200 AMP 180°
3	9-70M	Torch head 125 AMP 70°
4	9-90M	Torch head 125 AMP 90°
5	09PM	Torch head 125 AMP 180°
6	024M	Torch head 80 AMP 70°
7	24-90M	Torch head 80 AMP 90°
8	225M	Torch body

Item	Part No.	Description
9	53N06	Handle
10	45V03R	Power cable 12.5' rubber
	45V04R	Power cable 25' rubber
11	45V07R	Water cable 12.5' rubber
	45V08R	Water cable 25' rubber
12	45V09R	Gas cable 12.5' rubber
	45V10R	Gas cable 25' rubber
13	53N04	Hose clamp

Item	Part No.	Description
14	45V03	Power cable 12.5' vinyl
	45V04	Power cable 25' vinyl
15	45V07	Power cable 12.5' vinyl
	45V08	Power cable 25' vinyl
16	45V09	Power cable 12.5' vinyl
	45V10	Power cable 25' vinyl

### Modular Torch Head Installation



#### Torch Head Installation Procedure:

- 1 Screw element into torch head at point A – this should be **hand-tightened only**; as tight as possible.
- 2 Assure that lock nut is screwed all the way down onto the element.
- 3 Screw element into torch body at point B. Align torch head with torch body.
- 4 While keeping the torch head and body aligned, tighten lock nut.

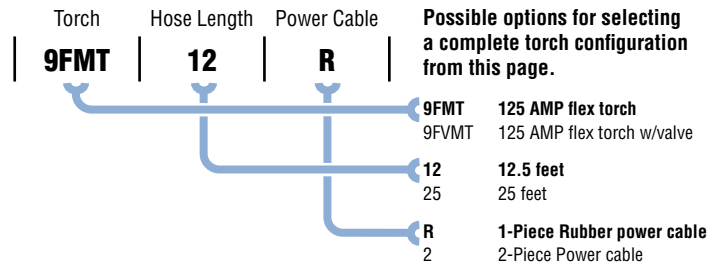
## Component TIG Torch Parts

### 125 AMP Air Cooled

#### Component Flex TIG Torch

Electrode Range: .020" - 3/32" (0.5mm - 2.4mm)  
Head Angle: 90°

#### Torch Package Part Number



Item	Part No.	Description
1	09FM	Torch head
2	9FMT	Torch, flex
3	9FVMT	Torch, flex w/valve
4	150TBM	Torch body
5	150VTBM	Torch body w/valve
6	41V24	Back cap, long
7	41V35	Back cap, medium
8	41V33	Back cap, short
9	598882	Gasket/insulator
10	set-up*	Collet
11	set-up*	Collet body

Item	Part No.	Description
12-17	set-up*	Nozzles
18	105Z55R	Handle, ribbed (standard)
19	105Z55	Handle, smooth (optional)
20	57Y01R	Power cable 12.5' 1pc
	57Y03R	Power cable 25' 1pc
21	57Y01-2	Power cable 12.5' 2pc
	57Y03-2	Power cable 25' 2pc
22	105Z57	Power cable adapter
23	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'

Item	Part No.	Description
24	BS-1	Switch boot, rubber
25	BS-1S	Switch boot, snap-on
26	SW-2	Switch, on-off
27	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
28	DA-917F	D-plug 50mm, w/18" aux. hose
29	DI-917F	D-plug 50mm, in-line
30	DP-50M	D-plug 50mm, for 2pc cable
31	DA-917FS	D-plug 50mm, w/18" aux. hose
32	DP-25M	D-plug 50mm, for 2pc cable
33	VS-2	Valve stem

\* Select proper size part from the set-up chart on page 162.

## Component TIG Torch Parts

### 150 AMP Air Cooled Component Flex TIG Torch

Electrode Range: .020" - 3/32" (0.5mm - 2.4mm)  
Head Angle: 90°

#### Torch Package Part Number

Torch | Hose Length | Power Cable  
| **17FMT** | | **12** | | **R** |

**Possible options for selecting a complete torch configuration from this page.**

17FMT 150 AMP flex torch  
17FVMT 150 AMP flex torch w/valve  
12 12.5 feet  
25 25 feet  
R 1-Piece Rubber power cable  
2 2-Piece Power cable



Item	Part No.	Description
1	17FM	Torch head
2	17FMT	Torch, flex
3	17FVMT	Torch, flex w/valve
4	150TBM	Torch body
5	150VTBM	Torch body w/valve
6	57Y02	Back cap, long
7	300M	Back cap, medium
8	57Y04	Back cap, short
9	18CG	Gasket/insulator
10	set-up*	Collet
11	set-up*	Collet body

Item	Part No.	Description
12-15	set-up*	Nozzles
16	105Z55R	Handle, ribbed (standard)
17	105Z55	Handle, smooth (optional)
18	57Y01R	Power cable 12.5' 1pc
	57Y03R	Power cable 25' 1pc
19	57Y01-2	Power cable 12.5' 2pc
	57Y03-2	Power cable 25' 2pc
20	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
21	105Z57	Power cable adapter

Item	Part No.	Description
22	BS-1	Switch boot, rubber
23	BS-1S	Switch boot, snap-on
24	SW-2	Switch, on-off
25	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
26	DA-917F	D-plug 50mm, w/18" aux. hose
27	DI-917F	D-plug 50mm, in-line
28	DP-50M	D-plug 50mm, for 2pc cable
29	DA-917FS	D-plug 50mm, w/18" aux. hose
30	DP-25M	D-plug 50mm, for 2pc cable
31	VS-2	Valve stem

\* Select proper size part from the set-up chart on page 162.

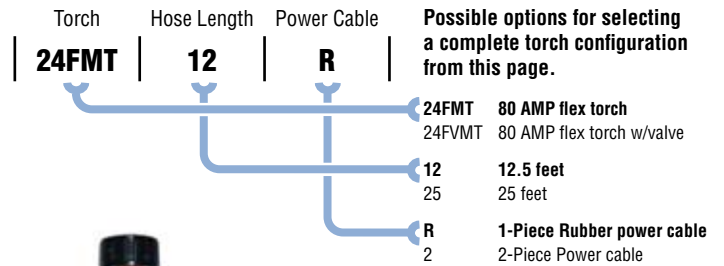


## Component TIG Torch Parts

### 80 AMP Air Cooled Component Flex TIG Torch

Electrode Range: .020" - 3/32" (0.5mm - 2.4mm)  
Head Angle: 90°

#### Torch Package Part Number



Item	Part No.	Description
1	24FM	Torch head
2	24FMT	Torch, flex
3	24FVMT	Torch, flex w/valve
4	150TBM	Torch body
5	150VTBM	Torch body w/valve
6	53N22	Gasket/insulator
7	set-up*	Collet
8	set-up*	Collet body
9-12	set-up*	Nozzles

\* Select proper size part from the set-up chart on page 164.

Item	Part No.	Description
13	H-100R	Handle, ribbed (standard)
14	H-100	Handle, smooth (optional)
15	57Y01R	Power cable 12.5' 1pc
	57Y03R	Power cable 25' 1pc
16	57Y01-2	Power cable 12.5' 2pc
	57Y03-2	Power cable 25' 2pc
17	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
18	BS-1	Switch boot, rubber
19	BS-1S	Switch boot, snap-on

Item	Part No.	Description
20	SW-2	Switch, on-off
21	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
22	105Z57	Power cable adapter
23	DA-917F	D-plug 50mm, w/18" aux. hose
24	DI-917F	D-plug 50mm, in-line
25	DP-50M	D-plug 50mm, for 2pc cable
26	DA-917FS	D-plug 50mm, w/18" aux. hose
27	DP-25M	D-plug 50mm, for 2pc cable
28	VS-2	Valve stem

## Component TIG Torch Parts

### 200 AMP Air Cooled Component Flex TIG Torch

Electrode Range: .020" - 1/8" (0.5mm - 3.2mm)  
Head Angle: 90°

#### Torch Package Part Number

Torch	Hose Length	Power Cable	Possible options for selecting a complete torch configuration from this page.
<b>26FMT</b>	<b>12</b>	<b>R</b>	



Item	Part No.	Description
1	26FM	Torch head
2	26FMT	Torch, flex
3	26FVMT	Torch, flex w/valve
4	200VTBM	Torch body w/valve
5	200TBM	Torch body
6	57Y04	Back cap, short
7	300M	Back cap, medium
8	57Y02	Back cap, long
9	18CG	Gasket/insulator
10	set-up*	Collet

Item	Part No.	Description
11	set-up*	Collet body
12-15	set-up*	Nozzles
16	10N15R	Handle, ribbed (standard)
17	10N15	Handle, smooth (optional)
18	46V28R	Power cable 12.5' 1pc
	46V30R	Power cable 25' 1pc
19	46V28-2	Power cable 12.5' 2pc
	46V30-2	Power cable 25' 2pc
20	45V62	Power cable adapter

Item	Part No.	Description
21	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
22	BL-1	Switch boot, rubber
23	BL-1S	Switch boot, snap-on
24	SW-2	Switch, on-off
	SW-1	Switch, momentary bulb
25	SW-1F	Switch, momentary flat
26	DA-26R	D-plug 50mm, w/18" gas hose
27	VS-1	Valve stem

\* Select proper size part from the set-up chart on page 166.

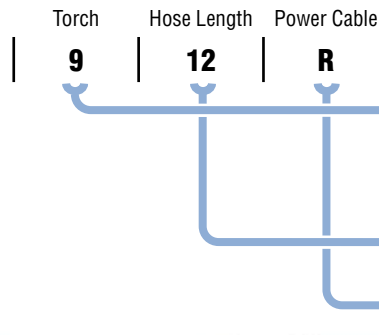
## TIG Torch Parts

### 125 AMP Air Cooled

#### 9 Series TIG Torch

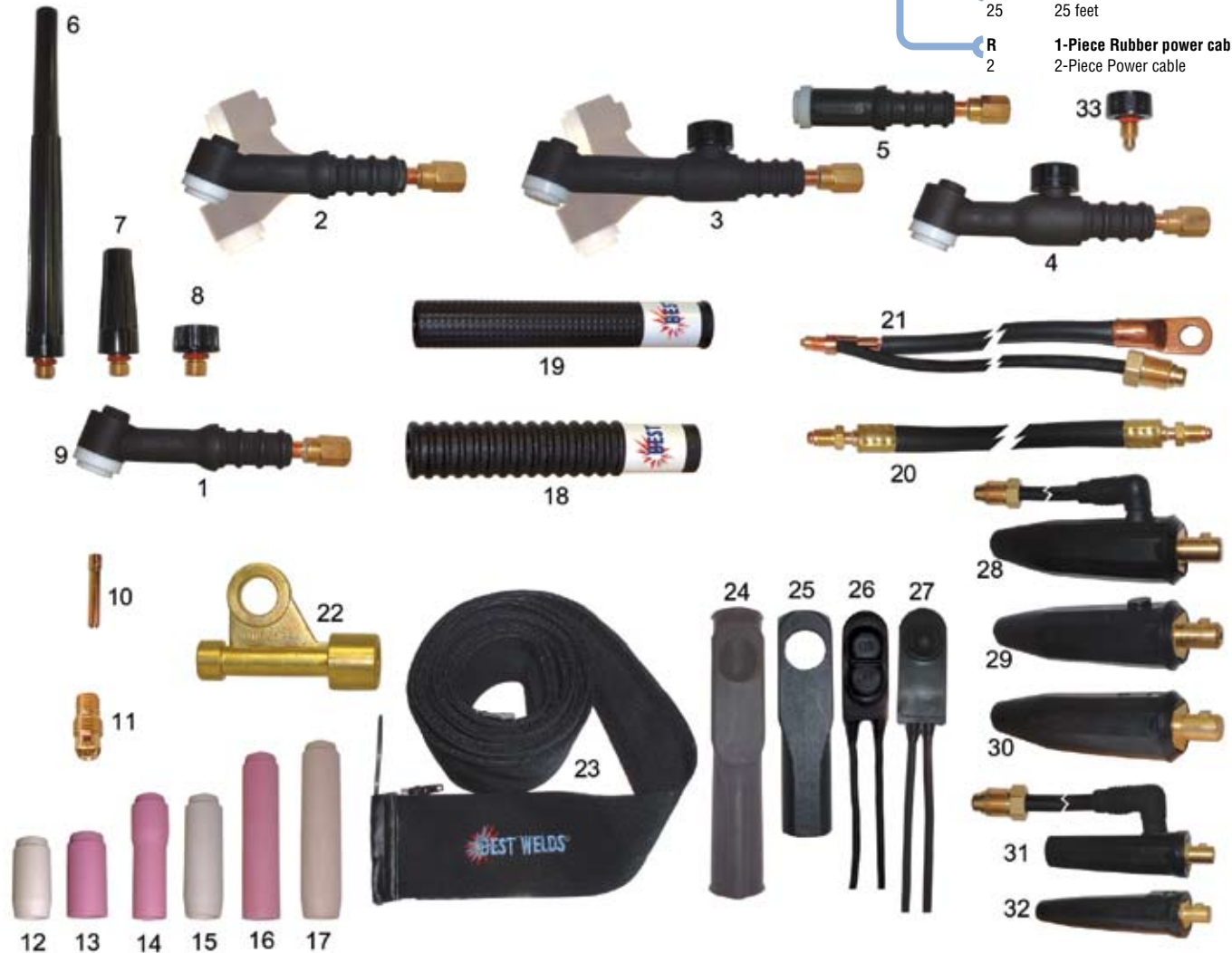
Electrode Range: .020" - 3/32" (0.5mm - 2.4mm)  
Head Angle: 60°  
180° (9P)

#### Torch Package Part Number



**Possible options for selecting a complete torch configuration from this page.**

- 9** 125 AMP torch
- 9F 125 AMP flex torch
- 9V 125 AMP flex torch w/valve
- 9P 125 AMP 180° pencil torch
- 9V 125 AMP torch w/valve
- 12** 12.5 feet
- 25 25 feet
- R** 1-Piece Rubber power cable
- 2 2-Piece Power cable



Item	Part No.	Description
1	0009	Torch body
2	009F	Torch body, flex
3	09FV	Torch body, flex w/valve
4	009V	Torch body, w/valve
5	009P	Torch body, pencil 180°
6	41V24	Back cap, long
7	41V35	Back cap, medium
8	41V33	Back cap, short
9	598882	Gasket/insulator
10	set-up*	Collet
11	set-up*	Collet body

Item	Part No.	Description
12-17	set-up*	Nozzles
18	H-100R	Handle, ribbed (standard)
19	H-100	Handle, smooth (optional)
20	57Y01R	Power cable 12.5' 1pc
	57Y03R	Power cable 25' 1pc
21	57Y01-2	Power cable 12.5' 2pc
	57Y03-2	Power cable 25' 2pc
22	105Z57	Power cable adapter
23	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
24	BS-1	Switch boot, rubber

Item	Part No.	Description
25	BS-1S	Switch boot, snap-on
26	SW-2	Switch, on-off
27	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
28	DA-917F	D-plug 50mm, w/18" aux. hose
29	DI-917F	D-plug 50mm, in-line
30	DP-50M	D-plug 50mm, for 2pc cable
31	DA-917FS	D-plug 50mm, w/18" aux. hose
32	DP-25M	D-plug 50mm, for 2pc cable
33	VS-2	Valve stem

\* Select proper size part from the set-up chart on the following page.

## TIG Torch Parts

### Set-ups for 9 Series Standard Set-up



### Gas Lens Set-up



### Large Diameter Gas Lens Set-up



**WARNING:** 1/8" and larger set-ups may exceed the operational capacity for a torch of this amperage.

Item No.	Electrode Diameter	Nozzle Size	.020"	.040"	1/16"	3/32"	1/8"	5/32"	3/16"	1/4"
			(0.5mm)	(1.0mm)	(1.6mm)	(2.4mm)	(3.2mm)	(4.0mm)	(4.8mm)	(6.4mm)
		#3 (3/16")	#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")	#12 (3/4")	#15 (15/16")
<b>Standard Set-up</b>										
9	Gasket insulator		598882	598882	598882	598882	598882			
10	Collet		13N20	13N21	13N22	13N23	13N24			
11	Collet body		13N25	13N26	13N27	13N28	13N29			
12	Alumina nozzle standard		13N08	13N09	13N10	13N11	13N12	13N13		
13	Alumina nozzle long	A796F70	A796F71	A796F72	A796F73					
14	Alumina nozzle x-long	A796F74	A796F75	A796F76	A796F77					
15	Lava nozzle standard		13N14	13N15	13N16	13N17	13N18	13N19		
16	Lava nozzle long	796F70	796F71	796F72	796F73					
17	Lava nozzle x-long	796F74	796F75	796F76	796F77					
<b>Gas Lens Set-up</b>										
34	Gas lens collet body		45V41	45V42	45V43	45V44	45V45			
35	Alumina gas lens nozzle		53N58	53N59	53N60	53N61	53N61S			
<b>Large Diameter Gas Lens Set-up</b>										
36	Gasket insulator		54N63-20	54N63-20	54N63-20	54N63-20	54N63-20			
37	Gas lens collet		13N20L	13N21L	13N22L	13N23L	13N24L			
38	Gas lens collet body		45V0204S	45V0204S	45V116S	45V64S	995795S			
39	Alumina gas lens nozzle				57N75		57N74	53N88	53N87	53N89

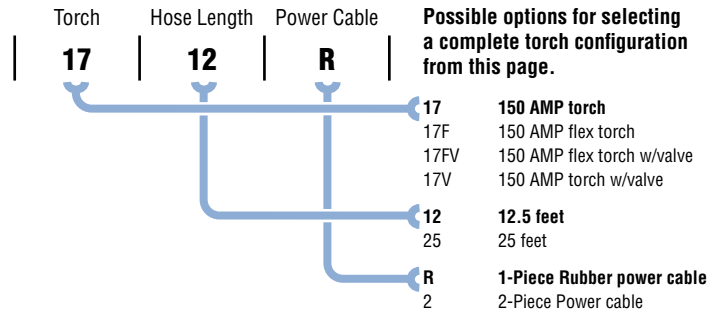
## TIG Torch Parts

### 150 AMP Air Cooled

#### 17 Series TIG Torch

Electrode Range: .020" - 3/32" (0.5mm - 2.4mm)  
Head Angle: 60°

#### Torch Package Part Number



Item	Part No.	Description
1	0017	Torch body
2	017F	Torch body, flex
3	17FV	Torch body, flex w/valve
4	017V	Torch body, w/valve
5	57Y02	Back cap, long
6	300M	Back cap, medium
7	57Y04	Back cap, short
8	18CG	Gasket/insulator
9	set-up*	Collet
10	set-up*	Collet body

Item	Part No.	Description
11-14	set-up*	Nozzles
15	H-100R	Handle, ribbed (standard)
16	H-100	Handle, smooth (optional)
17	57Y01R	Power cable 12.5' 1pc
	57Y03R	Power cable 25' 1pc
18	57Y01-2	Power cable 12.5' 2pc
	57Y03-2	Power cable 25' 2pc
19	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
20	105Z57	Power cable adapter

Item	Part No.	Description
21	BS-1	Switch boot, rubber
22	BS-1S	Switch boot, snap-on
23	SW-2	Switch, on-off
24	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
25	DA-917F	D-plug 50mm, w/18" aux. hose
26	DI-917F	D-plug 50mm, in-line
27	DP-50M	D-plug 50mm, for 2pc cable
28	DA-917FS	D-plug 50mm, w/18" aux. hose
29	DP-25M	D-plug 50mm, for 2pc cable
30	VS-2	Valve stem

\* Select proper size part from the set-up chart on the following page.

## TIG Torch Parts

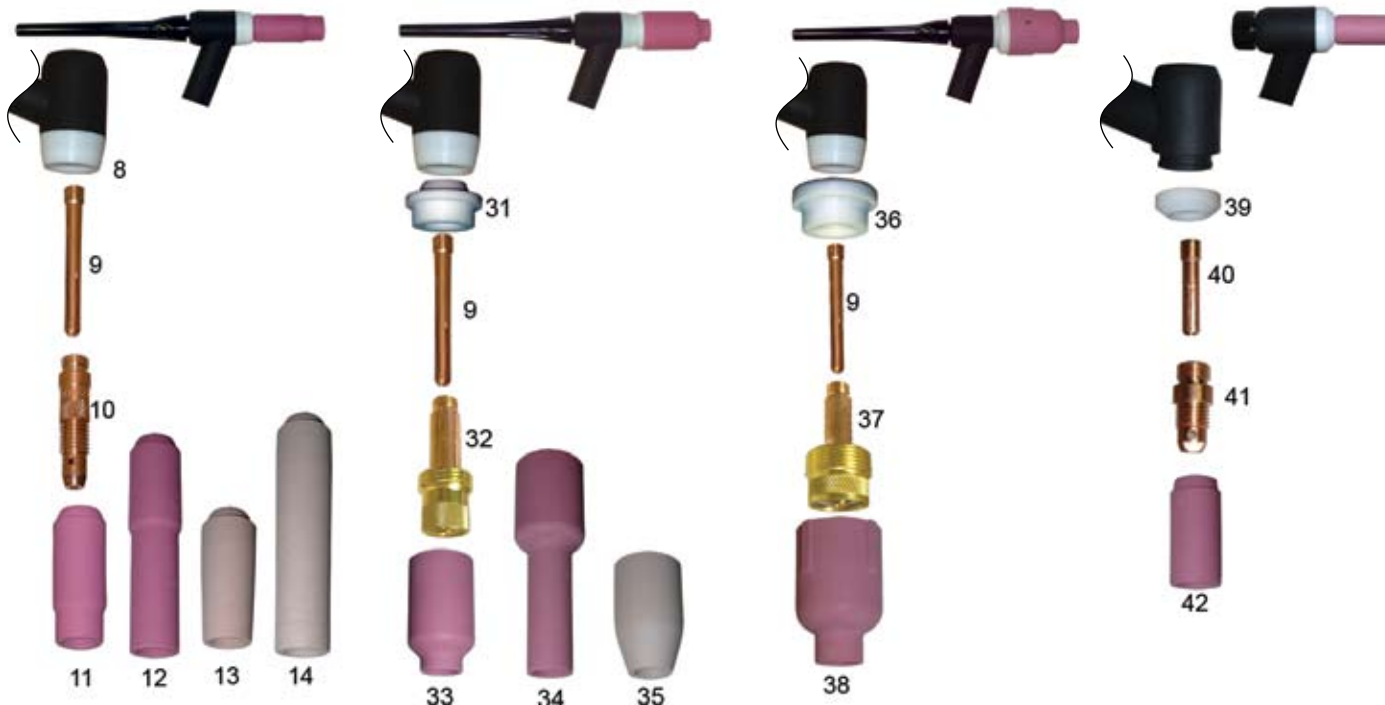
### Set-ups for 17 Series

#### Standard Set-up

#### Gas Lens Set-up

#### Large Diameter Gas Lens Set-up

#### Stubby Collet Body Set-up



**WARNING:** 1/8" and larger set-ups may exceed the operational capacity for a torch of this amperage.

Item No.	Electrode Diameter	.020"	.040"	1/16"	3/32"	1/8"	5/32"			
		(0.5mm)	(1.0mm)	(1.6mm)	(2.4mm)	(3.2mm)	(4.0mm)	#11 (11/16")	#12 (3/4")	#15 (15/16")
	Nozzle Size	#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")			
<b>Standard Set-up</b>										
8	Gasket insulator	18CG	18CG	18CG	18CG	18CG	18CG			
9	Collet	10N21	10N22	10N23	10N24	10N25	54N20			
10	Collet body	10N29	10N30	10N31	10N32	10N28	406488			
11	Alumina nozzle standard	10N50	10N49	10N48	10N47	10N46	10N45		10N44	
12	Alumina nozzle long		10N49L	10N48L	10N47L					
13	Lava nozzle standard	105Z43	105Z42	105Z44	105Z45	08Z78	08Z79		08Z80	
14	Lava nozzle long	12N03	105Z60	12N02	105Z61					
<b>Gas Lens Set-up</b>										
31	Gasket insulator	54N01	54N01	54N01	54N01	54N01	54N01			
32	Gas lens collet body	45V29	45V24	45V25	45V26	45V27	45V28			
33	Alumina gas lens nozzle	54N18	54N17	54N16	54N15	54N14	54N19*			
34	Alumina gas lens nozzle long		54N17L	54N16L	54N15L	54N14L				
35	Lava gas lens nozzle	54N35	54N34	54N33	54N32	54N31		54N36		
<b>Large Diameter Gas Lens Set-up</b>										
36	Gasket Insulator	54N63	54N63	54N63	54N63	54N63				
37	Gas lens collet body	45V0204	45V0204	45V116	45V64	995795	45V63			
38	Alumina gas lens nozzle			57N75		57N74	53N88		53N87	53N89
	Alumina gas lens nozzle long			57N75L		57N74L				
	Alumina gas lens nozzle x-long			57N75XL		57N74XL				
<b>Standard Set-up</b>										
39	Gasket insulator	18CG20	18CG20	18CG20	18CG20	18CG20				
40	Stubby collet	10N21S	10N22S	10N23S	10N24S	10N25S				
41	Stubby collet body	17CB20	17CB20	17CB20	17CB20	17CB20				
42	Alumina nozzle standard	13N08	13N09	13N10	13N11	13N12	13N13			

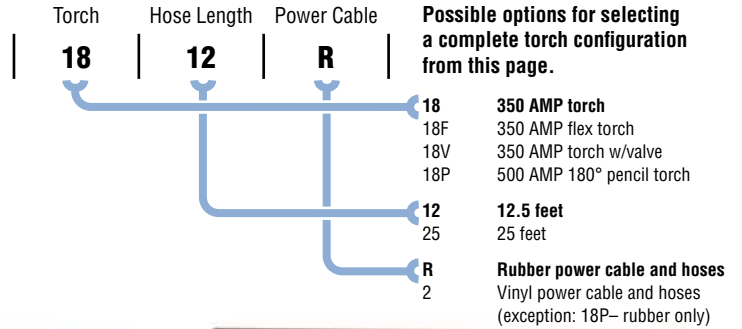
\* Part No. 54N19 is a short nozzle: .700".

## TIG Torch Parts

### 350 AMP and 500 AMP (18P) Water Cooled Torch Package Part Number

#### 18 Series TIG Torch

Electrode Range: .020" - 5/32" (0.5mm - 4.0mm)  
Head Angle: 60°  
180° (18P)



Item	Part No.	Description
1	0018	Torch body
2	018F	Torch body, flex
3	018P	Torch body, pencil 180°
4	018V	Torch body, w/valve
5	57Y02	Back cap, long
6	300M	Back cap, medium
7	57Y04	Back cap, short
8	18CG	Gasket/insulator
9	set-up*	Collet
10	set-up*	Collet body
11-14	set-up*	Nozzles
15	H-200	Handle, smooth (standard)
16	H-200R	Handle, ribbed (optional)

Item	Part No.	Description
17	18PB	Barrel Handle
18	40V64	Power cable 12.5' vinyl
	40V64R	Power cable 12.5' rubber
	41V29	Power cable 25' vinyl
	41V29R	Power cable 25' rubber
19	40V74	Water hose 12.5' vinyl
	40V74R	Water hose 12.5' rubber
	41V32	Water hose 25' vinyl
	41V32R	Water hose 25' rubber
20	40V75	Gas hose 12.5' vinyl
	40V75R	Gas hose 12.5' rubber
	41V30	Gas hose 25' vinyl
	41V30R	Gas hose 25' rubber

Item	Part No.	Description
21	53N04	Hose clamp
22	45V11	Power cable adapter
23	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
24	BL-1	Switch boot, rubber
25	BL-1S	Switch boot, snap-on
26	SW-2	Switch, on-off
27	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
28	DA-1820L	D-plug 50mm, w/18" water hose
29	VS-2	Valve stem

\* Select proper size part from the set-up chart on the following page.

## TIG Torch Parts

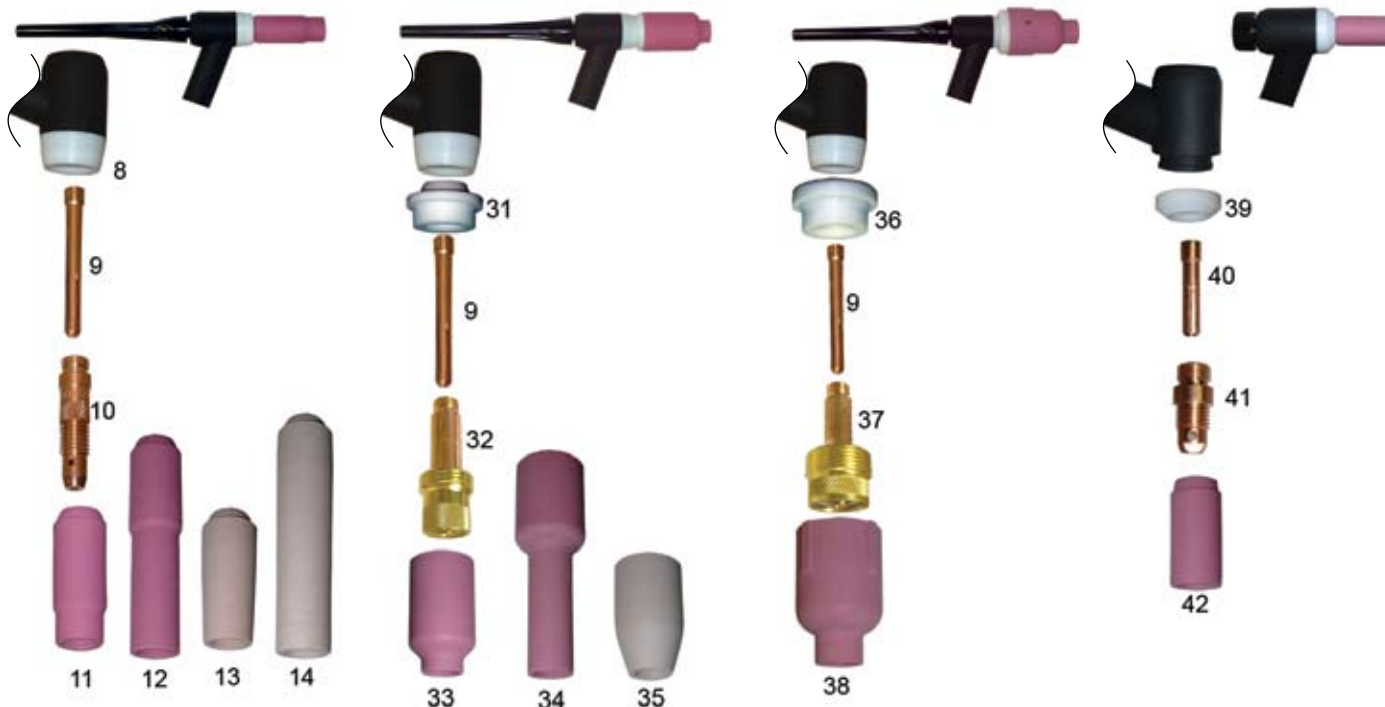
### Set-ups for 18 Series

#### Standard Set-up

#### Gas Lens Set-up

#### Large Diameter Gas Lens Set-up

#### Stubby Collet Body Set-up



**WARNING:** #11 and larger set-ups may exceed the operational capacity for a torch of this amperage.

Item No.	Electrode Diameter	.020"	.040"	1/16"	3/32"	1/8"	5/32"			
		(0.5mm)	(1.0mm)	(1.6mm)	(2.4mm)	(3.2mm)	(4.0mm)	#11 (11/16")	#12 (3/4")	#15 (15/16")
Nozzle Size		#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")			
<b>Standard Set-up</b>										
8	Gasket insulator	18CG	18CG	18CG	18CG	18CG	18CG			
9	Collet	10N21	10N22	10N23	10N24	10N25	54N20			
10	Collet body	10N29	10N30	10N31	10N32	10N28	406488			
11	Alumina nozzle standard	10N50	10N49	10N48	10N47	10N46	10N45		10N44	
12	Alumina nozzle long		10N49L	10N48L	10N47L					
13	Lava nozzle standard	105Z43	105Z42	105Z44	105Z45	08Z78	08Z79		08Z80	
14	Lava nozzle long	12N03	105Z60	12N02	105Z61					
<b>Gas Lens Set-up</b>										
31	Gasket insulator	54N01	54N01	54N01	54N01	54N01	54N01			
32	Gas lens collet body	45V29	45V24	45V25	45V26	45V27	45V28			
33	Alumina gas lens nozzle	54N18	54N17	54N16	54N15	54N14	54N19*			
34	Alumina gas lens nozzle Long		54N17L	54N16L	54N15L	54N14L				
35	Lava gas lens nozzle	54N35	54N34	54N33	54N32	54N31		54N36		
<b>Large Diameter Gas Lens Set-up</b>										
36	Gasket insulator	54N63	54N63	54N63	54N63	54N63				
37	Gas lens collet body	45V0204	45V0204	45V116	45V64	995795	45V63			
38	Alumina gas lens nozzle			57N75		57N74	53N88		53N87	53N89
	Alumina gas lens nozzle long			57N75L		57N74L				
	Alumina gas lens nozzle x-long			57N75XL		57N74XL				
<b>Stubby Collet Body Set-up</b>										
39	Gasket insulator	18CG20	18CG20	18CG20	18CG20	18CG20				
40	Stubby collet	10N21S	10N22S	10N23S	10N24S	10N25S				
41	Stubby collet body	17CB20	17CB20	17CB20	17CB20	17CB20				
42	Alumina nozzle standard	13N08	13N09	13N10	13N11	13N12	13N13			

\* Part No. 54N19 is a short nozzle: .700".



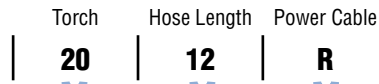
## TIG Torch Parts

### 250 AMP and 200 AMP (25) Water Cooled

#### 20 and 25 Series TIG Torch

Electrode Range: .020" - 1/8" (0.5mm - 3.2mm)  
Head Angle: 60°  
180° (20P, 25)

#### Torch Package Part Number



Possible options for selecting a complete torch configuration from this page.

- 20 250 AMP torch
- 20F 250 AMP flex torch
- 20M 250 AMP mechanical fittings
- 20P 250 AMP 180° pencil torch
- 25 200 AMP pencil flex
- 12 12.5 feet
- 25 25 feet
- R Rubber power cable and hoses
- blank Vinyl power cable and hoses



Item	Part No.	Description
1	0020	Torch body
2	0025	Torch body
3	020M	Torch body, flex pencil 180°
4	020P	Torch body, pencil 180°
5	020F	Torch body, flex
6	41V24	Back cap, long
7	41V35	Back cap, medium
8	41V33	Back cap, short
9	598882	Gasket/insulator
10	set-up*	Collet
11	set-up*	Collet body
12-17	set-up*	Nozzles
18	H-100	Handle, smooth (standard) 20F, 20M, 20P, 25
	53N06	Handle, smooth (standard) 20

Item	Part No.	Description
19	H-100R	Handle, ribbed (optional) 20F, 20M, 20P, 25
	53N06R	Handle, ribbed (optional) 20
20	45V03	Power cable 12.5' vinyl
	45V03R	Power cable 12.5' rubber
	45V04	Power cable 25' vinyl
	45V04R	Power cable 25' rubber
21	45V07	Water hose 12.5' vinyl
	45V07R	Water hose 12.5' rubber
	45V08	Water hose 25' vinyl
	45V08R	Water hose 25' rubber
22	45V09	Gas hose 12.5' vinyl
	45V09R	Gas hose 12.5' rubber
	45V10	Gas hose 25' vinyl
	45V10R	Gas hose 25' rubber

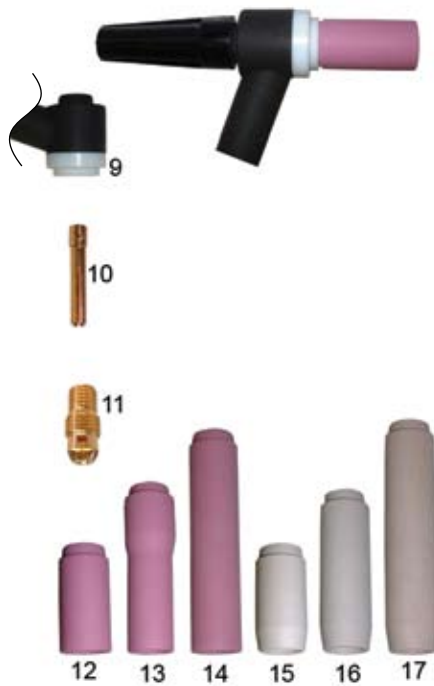
Item	Part No.	Description
23	53N04	Hose clamp
24	45V11	Power cable adapter
25	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
26	BS-1	Switch boot, rubber
27	BS-1S	Switch boot, snap-on
28	SW-2	Switch, on-off
29	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
30	DA-1820L	D-plug 50mm, w/18" water hose

\* Select proper size part from the set-up chart on the following page.

## TIG Torch Parts

### Set-ups for 20 and 25 Series

#### Standard Set-up



#### Gas Lens Set-up



#### Large Diameter Gas Lens Set-up



**WARNING:** #10 and larger set-ups may exceed the operational capacity for a torch of this amperage.

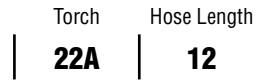
Item No.	Electrode Diameter	Nozzle Size	.020"	.040"	1/16"	3/32"	1/8"	5/32"	3/16"	1/4"
			(0.5mm)	(1.0mm)	(1.6mm)	(2.4mm)	(3.2mm)	(4.0mm)	(4.8mm)	(6.4mm)
		#3 (3/16")	#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")	#12 (3/4")	#15 (15/16")
<b>Standard Set-up</b>										
9	Gasket insulator		598882	598882	598882	598882	598882			
10	Collet		13N20	13N21	13N22	13N23	13N24			
11	Collet body		13N25	13N26	13N27	13N28	13N29			
12	Alumina nozzle standard		13N08	13N09	13N10	13N11	13N12	13N13		
13	Alumina nozzle long	A796F70	A796F71	A796F72	A796F73					
14	Alumina nozzle x-long	A796F74	A796F75	A796F76	A796F77					
15	Lava nozzle standard		13N14	13N15	13N16	13N17	13N18	13N19		
16	Lava nozzle long	796F70	796F71	796F72	796F73					
17	Lava nozzle x-long	796F74	796F75	796F76	796F77					
<b>Gas Lens Set-up</b>										
34	Gas lens collet body		45V41	45V42	45V43	45V44	45V45			
35	Alumina gas lens nozzle		53N58	53N59	53N60	53N61	53N61S			
<b>Large Diameter Gas Lens Set-up</b>										
36	Gasket insulator		54N63-20	54N63-20	54N63-20	54N63-20	54N63-20			
37	Gas lens collet		13N20L	13N21L	13N22L	13N23L	13N24L			
38	Gas lens collet body		45V0204S	45V0204S	45V116S	45V64S	995795S			
39	Alumina gas lens nozzle				57N75		57N74	53N88	53N87	53N89

## TIG Torch Parts

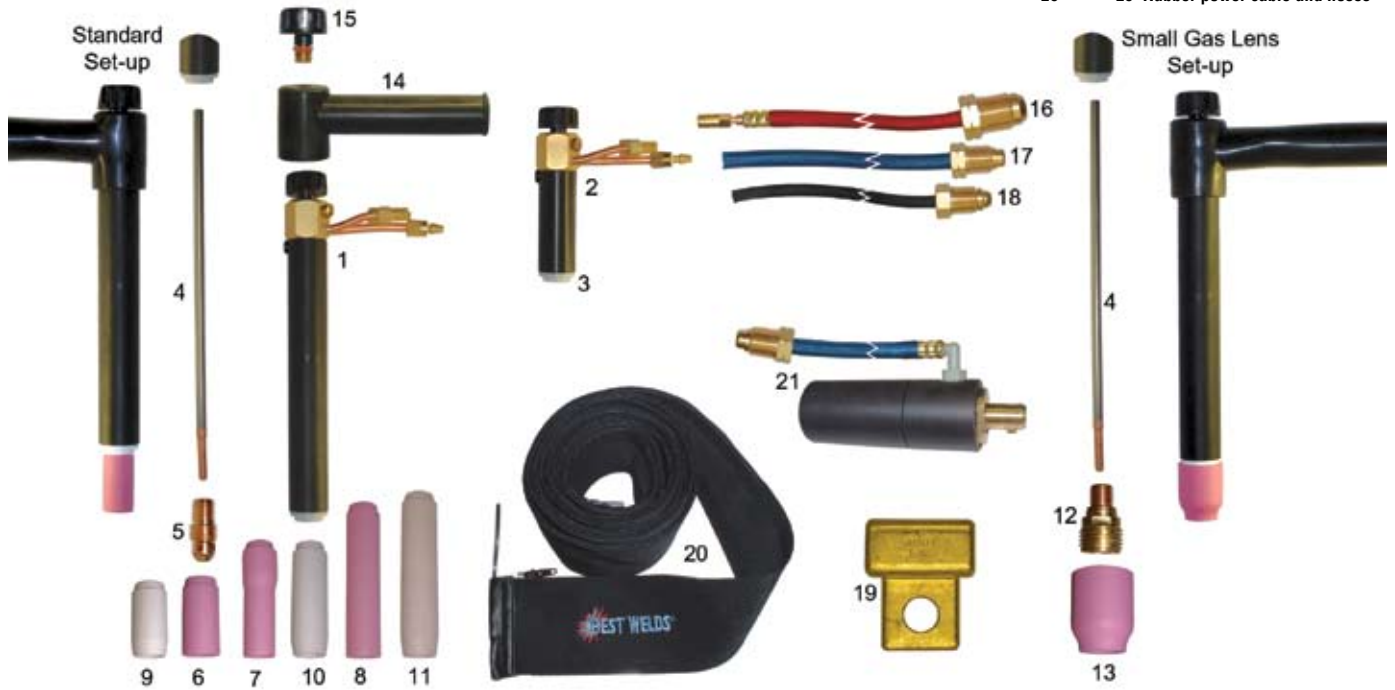
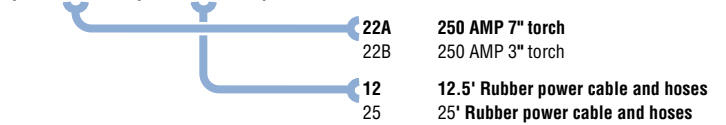
### 250 AMP Water Cooled 22 Series TIG Machine Torch

Electrode Range: .020" - 1/8" (0.5mm - 3.2mm)  
Head Angle: 180°

#### Torch Package Part Number



Possible options for selecting a complete torch configuration from this page.



**WARNING:** #5 and #10 are set-ups outside the optimal operational capacity for a torch of this amperage.

Item	Part No.	Description
1	022A	Torch body, w/ins. boot
2	022B	Torch body, w/ins. boot
3	22-10	Gasket/insulator
4	set-up*	Collet
5	set-up*	Collet body
6-11	set-up*	Nozzles
12	set-up*	Gas lens collet body
13	set-up*	Nozzles
14	22-9	Insulating boot
15	22-7	Collet knob
16	45V03R	Power cable 12.5' rubber
	45V04R	Power cable 25' rubber
17	45V07R	Water hose 12.5' rubber
	45V08R	Water hose 25' rubber
18	45V09R	Gas hose 12.5' rubber
	45V10R	Gas hose 25' rubber
19	45V11	Power cable adapter
20	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
21	DA-1820L	D-plug 50mm, w/18" water hose
22	54N63-22	Gasket/insulator
23	set-up*	Collet
24	set-up*	Gas lens collet body
25	set-up*	Nozzles

Item No.	Electrode Diameter	Nozzle Size				
		.040" (1.0mm)	1/16" (1.6mm)	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
<b>Standard Set-up</b>						
4	Collet 22A		22N22A	22N23A	22N24A	
4	Collet 22B		22N22B	22N23B	22N24B	
5	Collet body		13N27	13N28	13N29	
6	Alumina nozzle standard	13N09	13N10	13N11	13N12	13N13
For other nozzle options: see pages 161 & 162.						
<b>Gas Lens Set-up</b>						
12	Gas lens collet body	45V42	45V43	45V44	45V45	
13	Alumina gas lens nozzle	53N59	53N60	53N61	53N61S	
<b>Large Diameter Gas Lens Set-up</b>						
23	Gas lens collet 22A		22N22AL	22N23AL	22N24AL	
23	Gas lens collet 22B		22N22BL	22N23BL	22N24BL	
24	Gas lens collet body		45V116S	45V64S	995795S	
25	Alumina gas lens nozzle		57N75		57N74	53N88
For other nozzle options: see pages 161 & 162.						

\* Select proper size part from the set-up chart on the following page.

## TIG Torch Parts

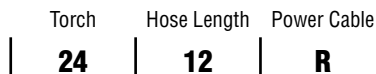
### 80 AMP Air Cooled and 180 AMP Water Cooled

#### 24 Series TIG Torch

Electrode Range: .020" - 3/32" (0.5mm - 2.4mm)

Head Angle: 60° - 90°

#### Torch Package Part Number



Possible options for selecting a complete torch configuration from this page.

- 24** 80 AMP 60° torch
- 24-90 80 AMP 90° torch
- 24V 80 AMP 60° torch w/valve
- 24W 180 AMP 60° torch
- 24W-90 180 AMP 90° torch
- 12** 12.5 feet
- 25 25 feet
- R** 1-Piece Rubber power cable (24)
- blank Rubber power cable and hoses (24W)
- 2-Piece Power cable



Item	Part No.	Description
1	024V	Torch body, 60° w/valve
2	0024	Torch body, 60°
	24-90	Torch body, 90°
3	024W	Torch body, 60°
4	24W-90	Torch body, 90°
5	56Y38R	Power cable 12.5' rubber
	56Y97R	Power cable 25' rubber
6	45V03R	Power cable 12.5' rubber
	45V04R	Power cable 25' rubber
7	45V07R	Water hose 12.5' rubber
	45V08R	Water hose 25' rubber
8	45V09R	Gas hose 12.5' rubber
	45V10R	Gas hose 25' rubber

Item	Part No.	Description
9	53N04	Hose clamp
10	45V03	Power cable 12.5' vinyl
	45V04	Power cable 25' vinyl
11	45V07	Water hose 12.5' vinyl
	45V08	Water hose 25' vinyl
12	45V09	Gas hose 12.5' vinyl
	45V10	Gas hose 25' vinyl
13	53N22	Gasket/insulator
14	set-up*	Collet
15	set-up*	Collet body
16-19	set-up*	Nozzles
20	H-100R	Handle, ribbed (standard 24)
21	H-100	Handle, smooth (standard 24W)

Item	Part No.	Description
22	53N43	Power cable adapter (24)
23	45V11	Power cable adapter (24W)
24	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
25	53N66	Gas lens gasket/insulator
26	set-up*	Collet
27	set-up*	Gas lens collet body
28	set-up*	Nozzles
29	DA-1820L	D-plug 50mm, w/18" water hose
30	DI-24F	D-plug 50mm, in-line

\* Select proper size part from the set-up chart below.

**WARNING:** #8 is a set-up outside the optimal operational capacity for a torch of this amperage.

Item No.	Electrode Diameter	Nozzle Size					
		#3 (3/16")	#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")
14	Collet		53N15	53N16	53N14	24C332	
15	Collet body		53N17	53N18	53N19	24CB332	
16	Alumina nozzle standard	A53N23	A53N24	A53N25	A53N27		
17	Alumina nozzle long				A53N26		
18	Lava nozzle standard	53N23	53N24	53N25	53N27		
19	Lava nozzle long		53N28		53N26		
26	Gas lens collet		53N62	53N63	53N64	24GLC332	
27	Gas lens collet body		45V41	45V42	45V43	45V44	
28	Alumina gas lens nozzle		53N58	53N59	53N60	53N61	53N61S

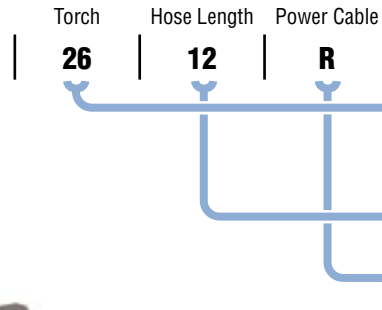
## TIG Torch Parts

### 200 AMP Air Cooled

#### 26 Series TIG Torch

Electrode Range: .020" - 5/32" (0.5mm - 4.0mm)  
Head Angle: 60°

#### Torch Package Part Number



Possible options for selecting a complete torch configuration from this page.

- 26** 200 AMP torch
- 26F 200 AMP flex torch
- 26FV 200 AMP flex torch w/valve
- 26V 200 AMP torch w/valve
- 12** 12.5 feet
- 25 25 feet
- R** 1-Piece Rubber power cable
- 2 2-Piece Power cable



Item	Part No.	Description
1	0026	Torch body
2	026F	Torch body, flex
3	26FV	Torch body, flex w/valve
4	26V	Torch body, w/valve
5	57Y04	Cap back, long
6	300M	Cap back, medium
7	57Y02	Cap back, short
8	18CG	Gasket/insulator
9	set-up*	Collet

Item	Part No.	Description
10	set-up*	Collet body
11-14	set-up*	Nozzles
15	H-200R	Handle, ribbed (standard)
16	H-200	Handle, smooth (optional)
17	46V28R	Power cable 12.5' 1pc
	46V30R	Power cable 25' 1pc
18	46V28-2	Power cable 12.5' 2pc
	46V30-2	Power cable 25' 2pc
19	45V62	Power cable adapter

Item	Part No.	Description
20	WC-3-10	Cable cover 3" x 10'
	WC-3-22	Cable cover 3" x 22'
21	BL-1	Switch boot, rubber
22	BL-1S	Switch boot, snap-on
23	SW-2	Switch, on-off
24	SW-1	Switch, momentary bulb
	SW-1F	Switch, momentary flat
25	DA-26R	D-plug 50mm, w/18" gas hose
26	VS-1	Valve stem

\* Select proper size part from the set-up chart on the following page.

## TIG Torch Parts

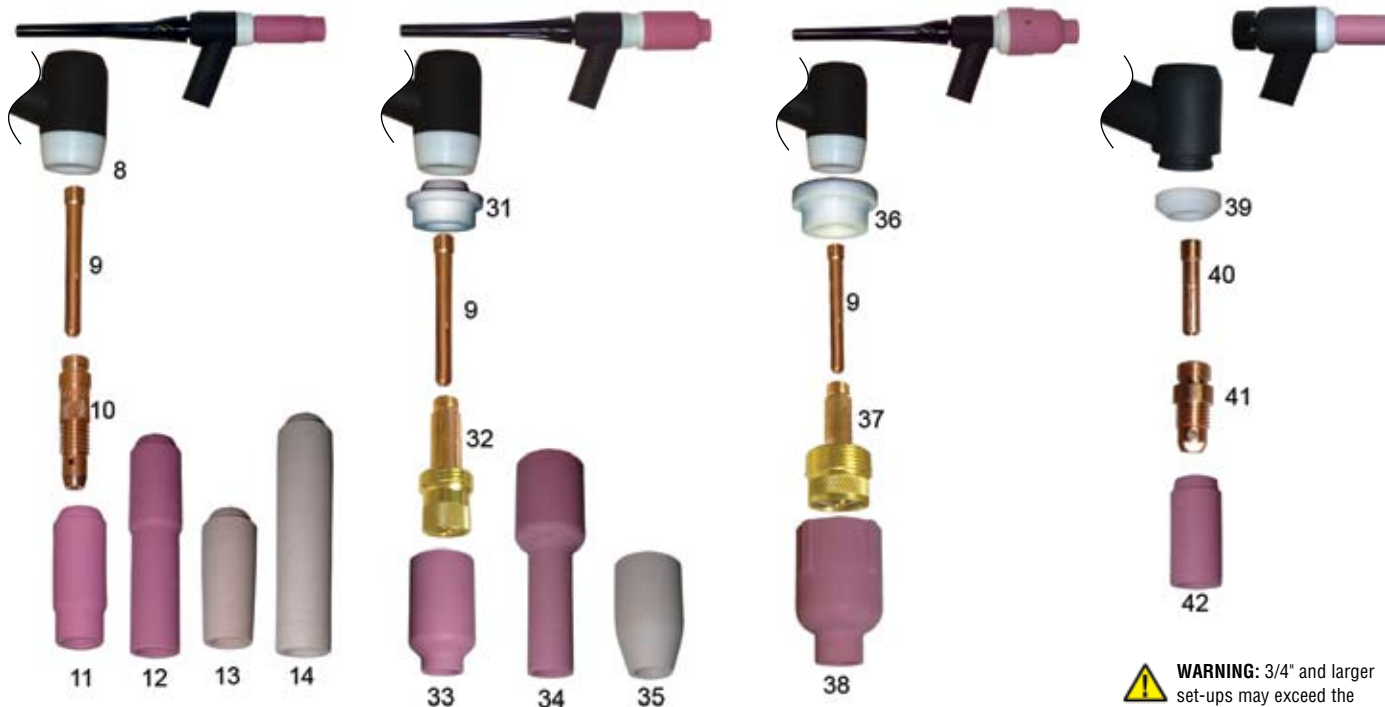
### Set-ups for 26 Series

#### Standard Set-up

#### Gas Lens Set-up

#### Large Diameter Gas Lens Set-up

#### Stubby Collet Body Set-up



**WARNING:** 3/4" and larger set-ups may exceed the operational capacity for a torch of this amperage.

Item No.	Electrode Diameter	.020"	.040"	1/16"	3/32"	1/8"	5/32"			
		(0.5mm)	(1.0mm)	(1.6mm)	(2.4mm)	(3.2mm)	(4.0mm)	#11 (11/16")	#12 (3/4")	#15 (15/16")
	Nozzle Size	#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")			
<b>Standard Set-up</b>										
8	Gasket insulator	18CG	18CG	18CG	18CG	18CG	18CG			
9	Collet	10N21	10N22	10N23	10N24	10N25	54N20			
10	Collet body	10N29	10N30	10N31	10N32	10N28	406488			
11	Alumina nozzle standard	10N50	10N49	10N48	10N47	10N46	10N45		10N44	
12	Alumina nozzle long		10N49L	10N48L	10N47L					
13	Lava nozzle standard	105Z43	105Z42	105Z44	105Z45	08Z78	08Z79		08Z80	
14	Lava nozzle long	12N03	105Z60	12N02	105Z61					
<b>Gas Lens Set-up</b>										
31	Gasket insulator	54N01	54N01	54N01	54N01	54N01	54N01			
32	Gas lens collet body	45V29	45V24	45V25	45V26	45V27	45V28			
33	Alumina gas lens nozzle	54N18	54N17	54N16	54N15	54N14	54N19*			
34	Alumina gas lens nozzle long		54N17L	54N16L	54N15L	54N14L				
35	Lava gas lens nozzle	54N35	54N34	54N33	54N32	54N31		54N36		
<b>Large Diameter Gas Lens Set-up</b>										
36	Gasket Insulator	54N63	54N63-20	54N63-20	54N63-20	54N63-20				
37	Gas lens collet body	45V0204	45V0204	45V116	45V64	995795	45V63			
38	Alumina gas lens nozzle			57N75		57N74	53N88		53N87	53N89
	Alumina gas lens nozzle long			57N75L		57N74L				
	Alumina gas lens nozzle x-long			57N75XL		57N74XL				
<b>Stubby Collet Body Set-up</b>										
39	Gasket insulator	18CG20	18CG20	18CG20	18CG	18CG20				
40	Stubby collet	10N21S	10N22S	10N23S	10N24S	10N25S				
41	Stubby collet body	17CB20	17CB20	17CB20	17CB20	17CB20				
42	Alumina nozzle standard	13N08	13N09	13N10	13N11	13N12	13N13			

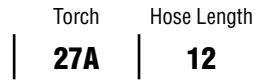
\* Part No. 54N19 is a short nozzle: .700".

## TIG Torch Parts

### 500 AMP Water Cooled 27 Series TIG Machine Torch

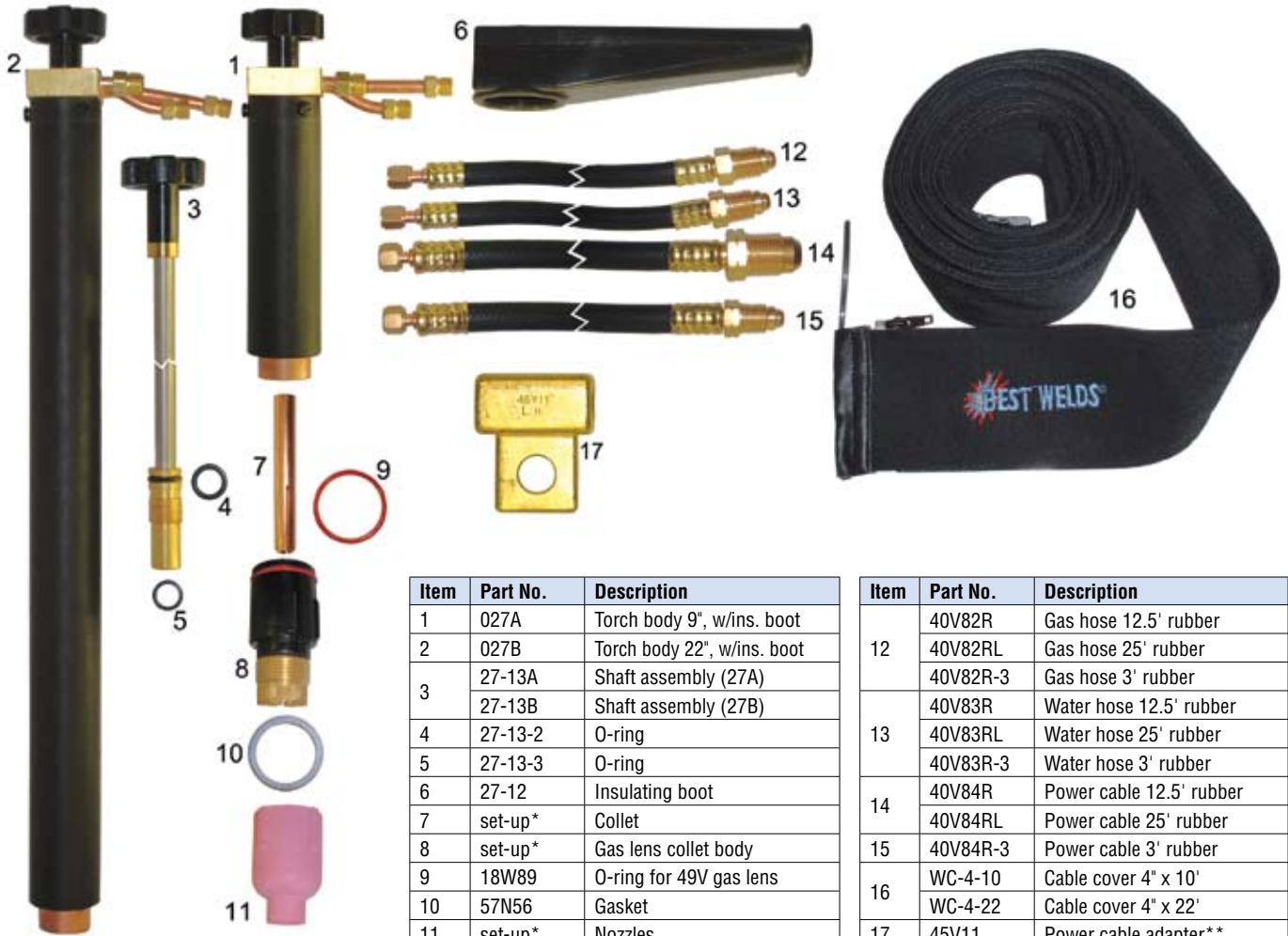
Electrode Range: .040" - 1/4" (1.0mm - 6.4mm)  
Head Angle: 180°

#### Torch Package Part Number



Possible options for selecting a complete torch configuration from this page.

- 27A 200 AMP torch
- 27B 200 AMP flex torch
- 12 12.5' Rubber power cable and hoses
- 25 25' Rubber power cable and hoses



Item	Part No.	Description
1	027A	Torch body 9", w/ins. boot
2	027B	Torch body 22", w/ins. boot
3	27-13A	Shaft assembly (27A)
	27-13B	Shaft assembly (27B)
4	27-13-2	O-ring
5	27-13-3	O-ring
6	27-12	Insulating boot
7	set-up*	Collet
8	set-up*	Gas lens collet body
9	18W89	O-ring for 49V gas lens
10	57N56	Gasket
11	set-up*	Nozzles

Item	Part No.	Description
12	40V82R	Gas hose 12.5' rubber
	40V82RL	Gas hose 25' rubber
	40V82R-3	Gas hose 3' rubber
13	40V83R	Water hose 12.5' rubber
	40V83RL	Water hose 25' rubber
	40V83R-3	Water hose 3' rubber
14	40V84R	Power cable 12.5' rubber
	40V84RL	Power cable 25' rubber
15	40V84R-3	Power cable 3' rubber
16	WC-4-10	Cable cover 4" x 10'
	WC-4-22	Cable cover 4" x 22'
17	45V11	Power cable adapter**

\* Select proper size part from the set-up chart below.

\*\*Not for use with 40V84R-3.

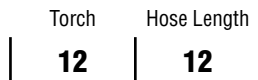
Item No.	Electrode Diameter	Nozzle Size						
		.040" (1.0mm)	1/16" (1.6mm)	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)	1/4" (6.4mm)
7	Collet	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")	#12 (3/4")	#15 (15/16")
8	Gas lens collet body	57N45	57N46	57N47	57N48	57N49	57N50	57N51
11	Alumina gas lens nozzle	49V22	49V23	49V24	49V25	49V26	49V27	49V28
	Alumina gas lens long nozzle		57N75		57N74	53N88	53N87	53N89 (short)
	Alumina gas lens x-long nozzle		57N75L		57N74L	53N88L	53N87L	
			57N75XL		57N74XL	53N88XL	53N87XL	

## TIG Torch Parts

### 500 AMP Water Cooled 12 Series TIG Torch

Electrode Range: 1/16" - 1/4" (1.6mm - 6.4mm)  
Head Angle: 60°

#### Torch Package Part Number



Possible options for selecting a complete torch configuration from this page.

- 22A 500 AMP torch
- 12 12.5' Rubber power cable and hoses
- 25 25' Rubber power cable and hoses



Item	Part No.	Description
1	0012	Torch body
2	56Y44	Back cap, long
3	56Y45	Back cap, short
4	40V82R	Gas hose 12.5' rubber
	40V82RL	Gas hose 25' rubber
5	40V83R	Water hose 12.5' rubber
	40V83RL	Water hose 25' rubber

Item	Part No.	Description
6	40V84R	Power cable 12.5' rubber
	40V84RL	Power cable 25' rubber
7	85WP13	Handle
8	12NG	Gasket/insulator
9	set-up*	Collet
10	set-up*	Collet body
11	set-up*	Nozzles

Item	Part No.	Description
12	12GLC	Gasket/insulator
13	set-up*	Gas lens collet body
14	set-up*	Nozzles
15	WC-4-10	Cable cover 4" x 10'
	WC-4-22	Cable cover 4" x 22'
16	45V11	Power cable adapter

\* Select proper size part from the set-up chart below.

**WARNING:** #12 set-up is outside the optimal operational capacity for a torch of this amperage.

Item No.	Electrode Diameter	1/16" (1.6mm)	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.0mm)	1/4" (4.0mm)	
		Nozzle Size	#4 (1/4")	#5 (5/16")	#6 (3/8")	#7 (7/16")	#8 (1/2")	#10 (5/8")
9	Collet	85Z14	85Z15	85Z16	85Z17	85Z18	85Z19	
10	Collet body	11WP65	11WP65	11WP65	11WP65	11WP65	11WP65	
11	Alumina nozzle standard	14N57	14N58	14N59	14N60	14N61	14N61-10	
13	Gas lens collet body	11GL16	11GL32	11GL18	11GL53	11GL36		
14	Alumina gas lens nozzle			57N75		57N74	53N88	53N87
	Alumina gas lens nozzle long			57N75L		57N74L	53N88L	53N87L
	Alumina gas lens nozzle X-long			57N75XL		57N74XL	53N88XL	53N87XL



## Alumina Nozzles



### Standard Nozzles

Torch Series: 17, 18, 26

Part No.	Description	Orifice	Length
10N44	#12	3/4"	1-7/8"
10N45	#10	5/8"	
10N46	#8	1/2"	
10N47	Alumina nozzle	7/16"	1-7/8"
10N47L	Long alumina nozzle		3"
10N48	Alumina nozzle	3/8"	1-7/8"
10N48L	Long alumina nozzle		3"
10N49	Alumina nozzle	5/16"	1-7/8"
10N49L	Long alumina nozzle		3"
10N50	#4	1/4"	1-7/8"

Torch Series: 9, 20, 22, 25, (Stubby: 17, 18, 26)

Part No.	Description	Orifice	Length
13N08	#4	1/4"	1-3/16"
13N09	#5	5/16"	
13N10	#6	3/8"	
13N11	#7	7/16"	
13N12	#8	1/2"	
13N13	#10	5/8"	
	Alumina nozzle		

Torch Series: 12

Part No.	Description	Orifice	Length
14N57	#4	1/4"	1-1/4"
14N58	#5	5/16"	
14N59	#6	3/8"	
14N60	#7	7/16"	
14N61	#8	1/2"	
14N61-10	#10	5/8"	
14N61-12	#12	3/4"	
	Alumina nozzle		

Torch Series: 24, 24W

Part No.	Description	Orifice	Length
A53N23	.165	.165	5/8"
A53N24	#4	1/4"	
A53N25	#5	5/16"	
A53N27	#6	3/8"	
	Alumina nozzle		

### Long Standard Nozzles

Torch Series: 9, 20, 22, 25

Part No.	Description	Orifice	Length
A796F70	#3	Alumina nozzle	3/16"
A796F71	#4	Long alumina nozzle	1/4"
A796F72	#5		5/16"
A796F73	#6		3/8"
A796F74	#3	X-long alumina nozzle	3/16"
A796F75	#4		1/4"
A796F76	#5		5/16"
A796F77	#6		3/8"
			2-1/2"

### Gas Lens Nozzles

Torch Series: 9, 20, 22, 24, 25

Part No.	Description	Orifice	Length
53N58	#4	1/4"	1"
53N59	#5	5/16"	
53N60	#6	3/8"	
53N61	#7	7/16"	
53N61S	#8	1/2"	
	Alumina nozzle		

Torch Series: 17, 18, 26

Part No.	Description	Orifice	Length
54N14	#8	Alumina nozzle	1-5/8"
54N14L		Long alumina nozzle	3"
54N15	#7	Alumina nozzle	1-5/8"
54N15L		Long alumina nozzle	3"
54N16	#6	Alumina nozzle	1-5/8"
54N16L		Long alumina nozzle	3"
54N17	#5	Alumina nozzle	1-5/8"
54N17L		Long alumina nozzle	3"
54N18	#4	Alumina nozzle	1-5/8"
54N19	.700	Short alumina nozzle	1-1/8"

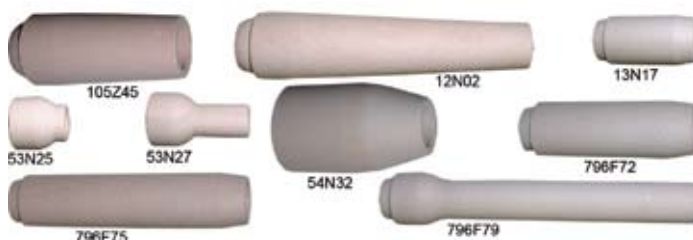
### Large Diameter Gas Lens Nozzles

Torch Series: 9, 17, 18, 20, 22, 25, 26, 27

Part No.	Description	Orifice	Length
53N87	#12	Alumina nozzle	1-7/8"
53N87L		Long alumina nozzle	2-3/4"
53N87XL		X-long alumina nozzle	3-1/4"
53N88	#10	Alumina nozzle	1-7/8"
53N88L		Long alumina nozzle	2-3/4"
53N88XL		X-long alumina nozzle	3-1/4"
53N89	#15	Short alumina nozzle	15/16"
57N74	#8	Alumina nozzle	1-7/8"
57N74L		Long alumina nozzle	2-3/4"
57N74XL		X-long alumina nozzle	3-1/4"
57N75	#6	Alumina nozzle	1-7/8"
57N75L		Long alumina nozzle	2-3/4"
57N75XL		X-long alumina nozzle	3-1/4"

## TIG Torch Parts

### Lava Nozzles



### Standard Nozzles

Torch Series: 17, 18, 26

Part No.	Description	Orifice	Length
105Z42	#5	3/4"	1-7/8"
105Z43	#4	5/8"	
105Z44	#6	1/2"	
105Z45	#7	7/16"	
08N78	#8	1/2"	
08N79	#10	5/8"	
08N80	#12	3/4"	
105Z60	#5	5/16"	
105Z61	#7	7/16"	
12N02	#6	3/8"	
12N03	#4	1/4"	

Torch Series: 9, 20, 22, 25, (Stubby: 17, 18, 26)

Part No.	Description	Orifice	Length
13N14	#4	1/4"	1-1/8"
13N15	#5	5/16"	
13N16	#6	3/8"	
13N17	#7	7/16"	
13N18	#8	1/2"	
13N19	#10	5/8"	

Torch Series: 24, 24W

Part No.	Description	Orifice	Length
53N23	.165	.165	5/8"
53N24	#4	1/4"	
53N25	#5	5/16"	
53N26	#6	Long lava nozzle	1-1/8"
53N27	#6	Lava nozzle	5/8"
53N28	#4	Long lava nozzle	1-1/8"

### Long Standard Nozzles

Torch Series: 9, 20, 22, 25, (Stubby: 17, 18, 26)

Part No.	Description	Orifice	Length
796F70	#3	3/16"	1-7/8"
796F71	#4	1/4"	
796F72	#5	5/16"	
796F73	#6	3/8"	
796F74	#3	3/16"	2-5/8"
796F75	#4	1/4"	
796F76	#5	5/16"	
796F77	#6	3/8"	3-1/2"
796F79	#4	1/4"	
796F80	#5	3/8"	

### Gas Lens Nozzles

Torch Series: 17, 18, 26

Part No.	Description	Orifice	Length
54N31	#8	1/2"	1-11/16"
54N32	#7	7/16"	
54N33	#6	3/8"	
54N34	#5	5/16"	
54N35	#4	1/4"	
54N36	#11	11/16"	1-1/8"

### Back Caps

Torch Series: 9, 10



Part No.	Description	Length
41V24	Long back cap	5-3/4"
41V33	Short back cap	5/8"
41V35	Medium back cap	1-7/8"
98W77	O-ring	

Torch Series: 17, 18, 20



Part No.	Description	Length
57Y02	Long back cap	4-3/4"
57Y04	Short back cap	1"
300M	Medium back cap	2-1/4"
98W18	O-ring	

Torch Series: 12



Part No.	Description	Length
56Y44	Long back cap	4-1/2"
56Y45	Short back cap	1-3/16"

## Collets



### 10N Collets

Torch Series: 17, 18, 26

Part No.	Description	Size	
		Inches	mm
10N21	Collet	.020	0.5
10N21S	Stubby collet		
10N22	Collet	.040	1.0
10N22S	Stubby collet		
10N23	Collet	1/16	1.6
10N23S	Stubby collet		
10N24	Collet	3/32	2.4
10N24S	Stubby collet		
10N25	Collet	1/8	3.2
10N25S	Stubby collet		
54N20	Collet	5/32	4.0
54N20S	Stubby collet		

### 13N Collets

Torch Series: 9, 20, 25

Part No.	Description	Size	
		Inches	mm
13N20	Collet	.020	0.5
13N20L	Lg. dia. gas lens collet		
13N21	Collet	.040	1.0
13N21L	Lg. dia. gas lens collet		
13N22	Collet	1/16	1.6
13N22L	Lg. dia. gas lens collet		
13N23	Collet	3/32	2.4
13N23L	Lg. dia. gas lens collet		
13N24	Collet	1/8	3.2
13N24L	Lg. dia. gas lens collet		

### 22N Collets

Torch Series: 22A, 22B

Part No.	Description	Size	
		Inches	mm
22N22A	Collet	1/16	1.6
22N22AL	Lg. dia. gas lens collet		
22N22B	Collet	1/16	1.6
22N22BL	Lg. dia. gas lens collet		
22N23A	Collet	3/32	2.4
22N23AL	Lg. dia. gas lens collet		
22N23B	Collet	3/32	2.4
22N23BL	Lg. dia. gas lens collet		
22N24A	Collet	1/8	3.2
22N24AL	Lg. dia. gas lens collet		
22N24B	Collet	1/8	3.2
22N24BL	Lg. dia. gas lens collet		

### 57N Collets

Torch Series: 27A, 27B

Part No.	Description	Size	
		Inches	mm
57N45	Collet	.040	1.0
57N46		1/16	1.6
57N47		3/32	2.4
57N48		1/8	3.2
57N49		5/32	4.0
57N50		3/16	4.8
57N51		1/4	6.4

### 53N Collets

Torch Series: 24, 24W

Part No.	Description	Size	
		Inches	mm
24C332	Collet	3/32	2.4
24GLC332	Gas lens collet		
53N14	Collet	1/16	1.6
53N15		.020	0.5
53N16		.040	1.0
53N62		.020	0.5
53N63	Gas lens collet	.040	1.0
53N64		1/16	1.6

### 85Z Collets

Torch Series: 12

Part No.	Description	Size	
		Inches	mm
85Z14	Collet	1/16	1.6
85Z15		3/32	2.4
85Z16		1/8	3.2
85Z17		5/32	4.0
85Z18		3/16	4.8
85Z19		1/4	6.4

## Collet Bodies



### 13N Collet Bodies

Torch Series: 9, 20, 22, 25

Part No.	Description	Size	
		Inches	mm
13N25	Collet body	.020	0.5
13N26		.040	1.0
13N27		1/16	1.6
13N28		3/32	2.4
13N29		1/8	3.2

### 53N Collet Bodies

Torch Series: 24, 24W

Part No.	Description	Size	
		Inches	mm
53N17	Collet body	.020	0.5
53N18		.040	1.0
53N19		1/16	1.6
24CB332		3/32	2.4

### 10N Collet Bodies

Torch Series: 17, 18, 26

Part No.	Description	Size	
		Inches	mm
10N28	Collet body	1/8	3.2
10N29		.020	0.5
10N30		.040	1.0
10N31		1/16	1.6
10N32		3/32	2.4
406488		5/32	4.0

### Special Collet Bodies

Part No.	Description	Size	
		Inches	mm
<b>Torch Series: 17, 18, 26</b>			
17CB20	Stubby collet body	All	All
<b>Torch Series: 12</b>			
24CB332	Collet body	All	All

## TIG Torch Parts

### Gas Lens Collet Bodies



#### Gas Lens Collet Bodies

Torch Series: 17, 18, 26

Part No.	Description	Size	
		Inches	mm
45V24	Gas lens collet body	.040	1.0
45V25		1/16	1.6
45V26		3/32	2.4
45V27		1/8	3.2
45V28		5/32	4.0
45V29		.020	0.5

Torch Series: 27A, 27B

Part No.	Description	Size	
		Inches	mm
49V22	Gas lens collet body	.040	1.0
49V23		1/16	1.6
49V24		3/32	2.4
49V25		1/8	3.2
49V26		5/32	4.0
49V27		3/16	4.8
49V28		1/4	6.4

Torch Series: 9, 20, 22, 25

Part No.	Description	Size	
		Inches	mm
45V41	Gas lens collet body	.020	0.5
45V42		.040	1.0
45V43		1/16	1.6
45V44		3/32	2.4
45V45		1/8	3.2

### Large Diameter Gas Lens Collet Bodies

Torch Series: 17, 18, 26

Part No.	Description	Size	
		Inches	mm
45V0204	Large diameter gas lens collet body	.020 - .040	0.5 - 1.0
45V116		1/16	1.6
45V63		5/32	4.0
45V64		3/32	2.4
995795		1/8	3.2

Torch Series: 12

Part No.	Description	Size	
		Inches	mm
11GL16	Gas lens collet body	1/16	1.6
11GL18		1/8	3.2
11GL32		3/32	2.4
11GL53		5/32	4.0
11GL36		3/16	4.8

Torch Series: 9, 20, 22, 25

Part No.	Description	Size	
		Inches	mm
45V0204S	Large diameter gas lens collet body	.020 - .040	0.5 - 1.0
45V116S		1/16	1.6
45V64S		3/32	2.4
995795S		1/8	3.2

### Power Cable Adapters

Torch Series: 9, 17

- Threads: 3/8" - 24RH, 5/8" - 18RH
- Part No. 105Z57



Torch Series: 26

- Threads: 7/8" - 14RH, 5/8" - 18RH
- Part No. 45V62



Torch Series: 12, 18, 20, 22A, 22B, 24W, 25, 27

- Threads: 7/8" - 14LH, 5/8" - 18LH
- Part No. 45V11



Torch Series: 24

- Threads: 3/8" - 24RH, 5/8" - 18RH
- Part No. 53N43



## TIG Torch Parts

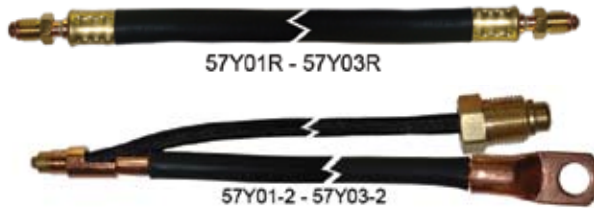
### Handles



Torch	Part No.	Description
18P	18PB	Barrel handle
18, 26	H-200	Smooth push-on
	H-200R	Ribbed push-on
HP 18, HP 26	10N15	Smooth threaded
	10N15R	Ribbed threaded
9, 17, 20M, 20F, 24	H-100	Smooth push-on
	H-100R	Ribbed push-on
20, HP9, HP20	53N06	Smooth threaded
HP17, HP24	105Z55	Smooth threaded
	105Z55R	Ribbed threaded
12	85WP13	Smooth handle

### Power Cables, Air Cooled

Torch Series: 9, 17



Part No.	Description	Length
57Y01R	1-Piece, Rubber power cable	12.5'
57Y03R		25'
57Y01-2	2-Piece, 4 ga. welding cable w/braided rubber gas hose	12.5'
57Y03-2		25'

Torch Series: 26



Part No.	Description	Length
46V28R	1-Piece, Rubber power cable	12.5'
46V30R		25'
46V28RS	Rubber; for use with DI-26F	12.5'
46V30RS		25'
46V28-2	2-Piece, 2 ga. welding cable w/braided rubber gas hose	12.5'
46V30-2		25'

Torch Series: 24



Part No.	Description	Length
56Y38R	1-Piece, Rubber power cable	12.5'
56Y97R		25'

### Ground Clamp Cables



Part No. GCD-15



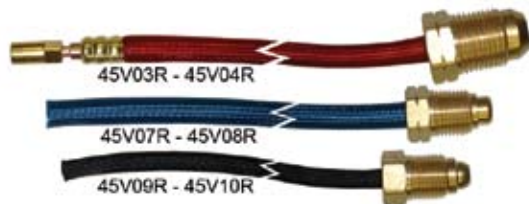
Part No. GCS-15

Part No.	Description	Length
GCD-15	Ground cable for machines with D-plugs	15'
GCS-15	Ground cable for machines with stud terminal	

## TIG Torch Parts

### Power Cables, Water And Gas Hoses

Torch Series: 20, 22, 24W, 25



#### Power Cables

Part No.	Description	Length
45V03	Vinyl	12.5'
45V04		25'
45V03R	Braided rubber	12.5'
45V04R		25'
45V04R-50		50'

#### Water Hoses

Part No.	Description	Length
45V07	Vinyl	12.5'
45V08		25'
45V07R	Braided rubber	12.5'
45V08R		25'
45V08R-50		50'

#### Gas Hoses

Part No.	Description	Length
45V09	Vinyl	12.5'
45V10		25'
45V09R	Braided rubber	12.5'
45V10R		25'
45V10R-50		50'

**For Torches 20M, 20F with Mechanical Fittings**

45V07M	Vinyl	12.5'
45V08M		25'
45V07RM	Braided rubber	12.5'
45V08RM		25'

### Torch Series: 18



#### Power Cables

Part No.	Description	Length
40V64	Vinyl	12.5'
41V29		25'
40V64R	Rubber	12.5'
41V29R		25'
41V29R-50		50'
40V64P	Rubber (18P torch)	12.5'
41V29P		25'

#### Water Hoses

Part No.	Description	Length
40V74	Vinyl	12.5'
41V32		25'
40V74R	Braided rubber	12.5'
41V32R		25'
41V32R-50		50'

#### Gas Hoses

Part No.	Description	Length
40V75	Vinyl	12.5'
41V30		25'
40V75R	Braided rubber	12.5'
41V30R		25'
41V30R-50		50'

### Torch Series: 12, 27



#### Power Cables

Part No.	Description	Length
40V84R-3	Rubber	3'
40V84R		12.5'
40V84RL		25'

#### Water Hoses

Part No.	Description	Length
40V83R-3	Rubber	3'
40V83R		12.5'
41V83RL		25'

#### Gas Hoses

Part No.	Description	Length
40V82R-3	Rubber	3'
40V82R		12.5'
40V82RL		25'

## Accessory Kits

### Modular Torch Kits Model M-150-R TIG Torches



#### Torch Kit Includes:

- (1) 150 AMP air cooled torch package, 25', 1-pc. cable
- (5) Modular torch heads
- (2) Torch bodies with and without valve
- (2) Elements: flex coil and solid
- (1) Consumables kit with collets, collet bodies, nozzles and back caps to fit all heads and tungsten sizes .040", 1/16" & 3/32".
- (1) Tungsten kit with (3) pure and (3) 1.5% Lanthanated tungsten sizes .040", 1/16" & 3/32" each.
- (1) Reusable aluminum attaché case

Accessory Kit: AK-150

Part No. M-150-R

### Model M-200-R TIG Torches



#### Torch Kit Includes:

- (1) 200 AMP air cooled torch package, 25', 1-pc. cable
- (5) Modular torch heads
- (2) Torch bodies with and without valve
- (2) Elements: flex coil and solid
- (1) Consumables kit with collets, collet bodies, nozzles and back caps to fit all heads and tungsten sizes 1/16", 3/32" and 1/8".
- (1) Tungsten kit with (3) pure and (3) 1.5% Lanthanated tungsten sizes 1/16", 3/32" and 1/8" each.
- (1) Reusable aluminum attaché case

Accessory Kit: AK-200

Part No. M-200-R

### Model M-225-R TIG Torches



#### Torch Kit Includes:

- (1) 225 AMP air cooled torch package, 25', 1-pc. cable
- (5) Modular torch heads
- (1) Consumables kit with collets, collet bodies, nozzles and back caps to fit all heads and tungsten sizes 1/16", 3/32" and 1/8".
- (1) Tungsten kit with (3) pure and (3) 1.5% Lanthanated tungsten sizes 1/16", 3/32" and 1/8" each.
- (1) Reusable aluminum attaché case

Accessory Kit: AK-225

Part No. M-225-R

## Accessory Kits

### Accessory Kits

Torch Series: 9 (standard), 20 (optional)



Part No.	Qty.	Description	Sizes
AK-1	1	Back cap	Long
	2	Collets	.040", 1/16"
	2	Collet bodies	.040", 1/16"
	3	Alumina nozzles	#4, 5, 6
	2	Tungsten 7"	.040", 1/16"

Torch Series: 17 (standard), 18, 26 (optional)



Part No.	Qty.	Description	Sizes
AK-2	1	Back cap	Short
	3	Collets	.040", 1/16", 3/32"
	3	Collet bodies	.040", 1/16", 3/32"
	3	Alumina nozzles	#4, 5, 6
	3	Tungsten 7"	.040", 1/16", 3/32"

Torch Series: 8, 26



Part No.	Qty	Description	Sizes
AK-3	1	Back cap	Short
	3	Collets	1/16", 3/32", 1/8"
	3	Collet bodies	1/16", 3/32", 1/8"
	3	Alumina nozzles	#5, 6, 8
	3	Tungsten 7"	1/16", 3/32", 1/8"

Torch Series: 20 (standard), 9 (optional)



Part No.	Qty	Description	Sizes
AK-4	1	Back cap	Long
	3	Collets	1/16", 3/32", 1/8"
	3	Collet bodies	1/16", 3/32", 1/8"
	3	Alumina nozzles	#5, 6, 7
	3	Tungsten 7"	1/16", 3/32", 1/8"

Torch Series: 24, 24W



Part No.	Qty	Description	Sizes
AK-5	2	Collets	.040", 1/16"
	2	Collet bodies	.040", 1/16"
	3	Lava nozzles	#4, 5, 6
	2	Tungsten 7"	.040", 1/16"

### Master Accessory Kits

Torch Series: 9, 20



Part No.	Qty	Description	Sizes
MAK-1S	4	Back caps	(1) Short, (2) Medium (1) Long
	12	Collets	(2).040", (4)1/16", (4)3/32", (2)1/8"
	7	Collet bodies	(1).040", (2)1/16", (2)3/32", (2)1/8"
	4	Gas lenses	.040", 1/16", 3/32", 1/8"
	1	Cup gasket	
	4	O-ring for back caps	
	10	Wire clamps	

Torch Series: 17, 18, 26



Part No.	Qty.	Description	Sizes
MAK-2S	2	Back caps	(1) Short, (1) Long
	10	Collets	(1).040", (3)1/16", (3)3/32", (2)1/8", (1)5/32"
	8	Collet bodies	(1).040", (2)1/16", (2)3/32", (2)1/8", (1)5/32"
	4	Gas lenses	.040", 1/16", 3/32", 1/8"
	2	Cup gaskets	
	4	O-ring for back caps	



**Accessory Kits**

**Extension Kits**

**Torch Series: 18, 20, 20F, 24W, 25**  
Water-Cooled, Vinyl



Part No.	Qty	Description
EK-1-25	1	40V78L - 25' Extension power cable
	1	40V76L - 25' Water hose
	1	40V77L - 25' Gas hose
	1	11N19 - Power cable coupler
	1	11N18 - Water hose coupler
	1	11N17 - Gas hose coupler
	1	11N19IS - Insulator sleeve

Water-Cooled, Rubber



Part No.	Qty	Description
EK-1-25-R	1	40V78L - 25' Ext. power cable
	1	40V76L - 25' Water hose
	1	40V77L - 25' Gas hose
	1	11N19 - Power cable coupler
	1	11N18 - Water hose coupler
	1	11N17 - Gas hose coupler
	1	11N19IS - Insulator sleeve

**Torch Series: 26**  
Air-Cooled, Rubber



Part No.	Qty	Description
EK-26-25-R	1	46V30EK-R - 25' Extension power cable
	1	11N20 - Power cable coupler
	1	11N19IS - Insulator sleeve

**Torch Series: 9, 17**  
Air-Cooled, Rubber



Part No.	Qty	Description
EK-2-25-R	1	57Y03R - 25' Extension power cable
	1	430A - Power cable coupler
	1	430AIS - Insulator sleeve

**Hook-up Kits**

**Torch Series: 18, 20, 20F, 24W, 25**  
Water-Cooled, Vinyl



Part No.	Qty	Description
HK-1	1	45V11 - power cable adapter
	2	40V76 - 12.5' Water hoses
	2	AW-15 - Water adapters
	1	40V77 - 12.5' Gas hoses

**Torch Series: 9, 17, 24, 26**  
Air-Cooled, Vinyl



Part No.	Qty	Description
HK-2	1	40V77 - 12.5' Gas hose
	1	11N17 - Argon coupler extension



Part No.	Qty	Description
HK-3	1	40V77 - 12.5' Gas hose
	1	18" Gas hose (solenoid to P/C)

**Note:** The correct power cable adapter must be ordered.

## Connectors

### International D-plug Connectors

#### Torch Series: 9, 17

- Size: 9.0mm / .355"
- Set screw fitting for connection to welding cable.
- Connection to power cables: 57Y01-2, 57Y03-2.

**Part No. DP-25M**

- Size: 9.0mm / .355"
- Includes an 18" gas auxiliary hose with 5/8"-18RH nut, 3/8"-24RH power cable connection.
- Connection to power cables: 57Y01-2, 57Y03-2.

**Part No. DA-917FS**

- Size: 12.9mm / .508"
- Includes an in-line gas hole for use with machines equipped with gas solenoids, 3/8"-24RH power cable connection.
- Connection to power cables: 57Y01-2, 57Y03-2.

**Part No. DI-917F**

- Size: 12.9mm / .508"
- Includes an 18" gas auxiliary hose with 5/8"-18RH nut, 3/8"-24RH power cable connection.
- Connection to power cables: 57Y01R, 57Y03R.

**Part No. DA-917F**



#### Torch Series: 9, 17, 26

- Size: 12.9mm / .508"
- Set screw fitting for connection to welding cable.
- Connection to power cables: 57Y01-2, 57Y03-2, 46V28-2, 46V30-2.

**Part No. DP-50M**



#### Torch Series: 26

- Size: 12.9mm / .508"
- Includes an in-line gas hole for use with machines equipped with gas solenoids, 5/8"-18RH power cable connection (special power cable required).
- Connection to power cables: 46V28RS, 46V30RS.

**Part No. DI-26F**

- Size: 12.9mm / .508"
- Includes an 18" gas auxiliary hose with 5/8"-18RH nut, 7/8"-14RH power cable connection.
- Connection to power cables: 46V28R, 46V30R.

**Part No. DA-26R**



#### Torch Series: 24

- Size: 12.9mm / .508"
- Includes an in-line gas hole for use with machines equipped with gas solenoids, 3/8"-24RH power cable connection.
- Connection to power cables: 56Y38R, 56Y97R.

**Part No. DI-24F**



#### Torch Series: 18, 20, 22A, 22B, 24W, 25, 27

- Size: 12.9mm / .508"
- Includes an 18" water auxiliary hose with 5/8"-18LH nut, 7/8"-14LH power cable connection.
- Connection to power cables: 40V64, 40V64R, 41V29, 41V29R, 45V03, 45V03R, 45V04, 45V04R

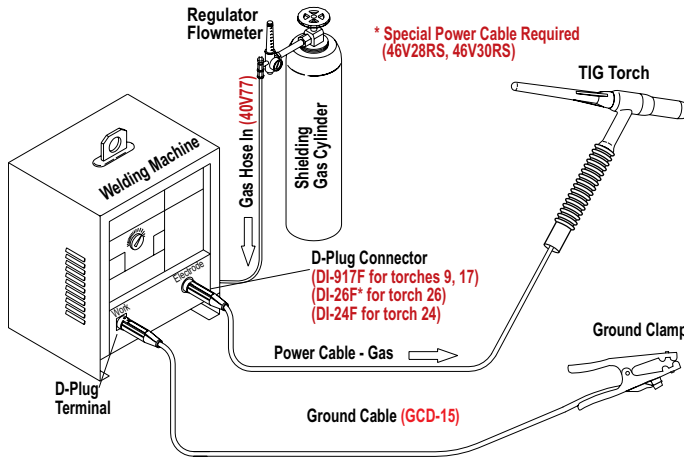
**Part No. DA-1820L**



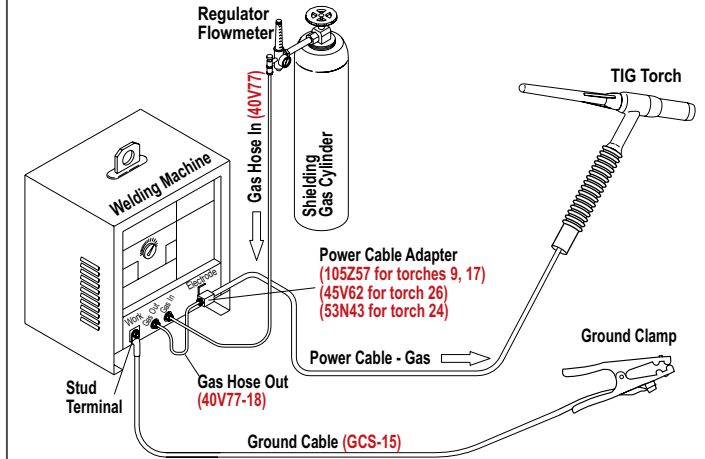
## TIG Torch Welding Machines

### Air-Cooled, 1-Piece Power Cable

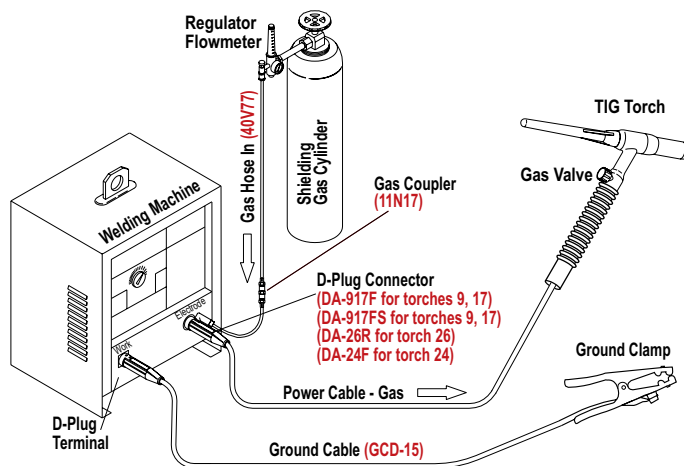
- D-plug connection
- Gas solenoid
- No valve



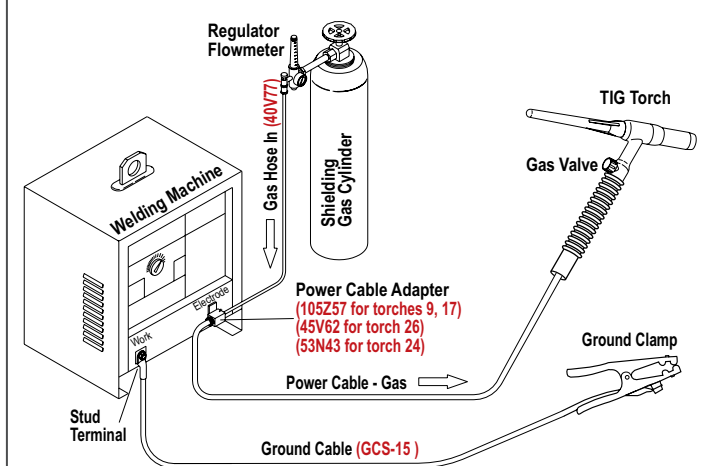
- Stud connection
- Gas solenoid
- No valve



- D-plug connection
- No gas solenoid
- With valve



- Stud connection
- No gas solenoid
- With valve

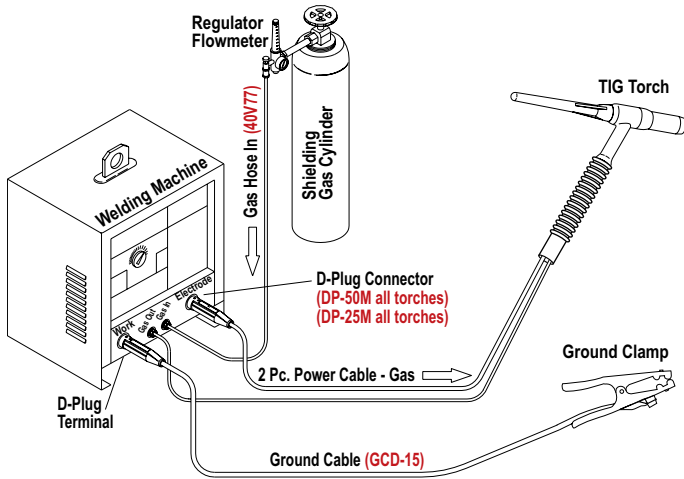


## Hook-up Installation Diagrams

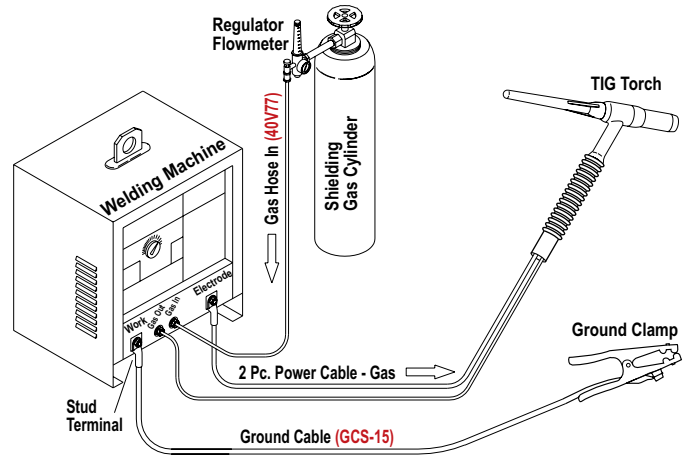
### TIG Torch Welding Machines

#### Air-Cooled, 2-Piece Power Cable

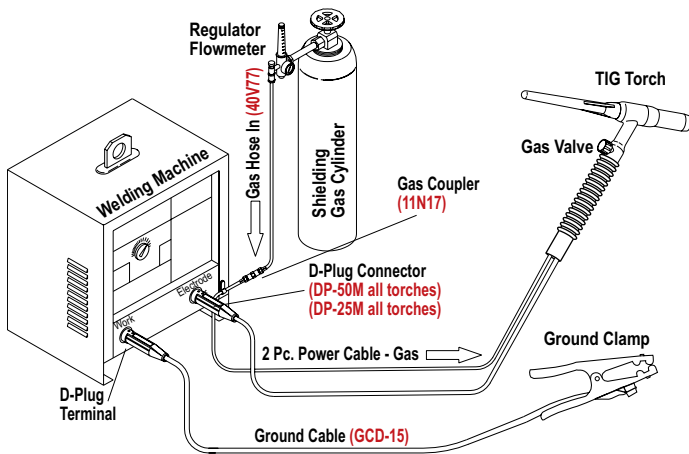
- D-plug connection
- Gas solenoid
- No valve



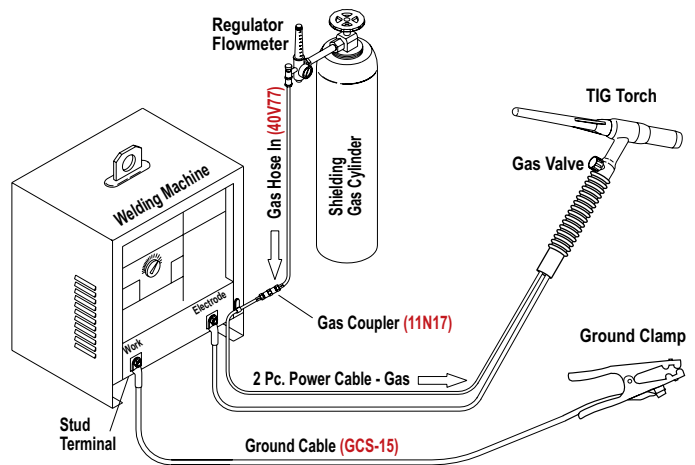
- Stud connection
- Gas solenoid
- No valve



- D-plug connection
- No gas solenoid
- With valve



- Stud connection
- No gas solenoid
- With valve

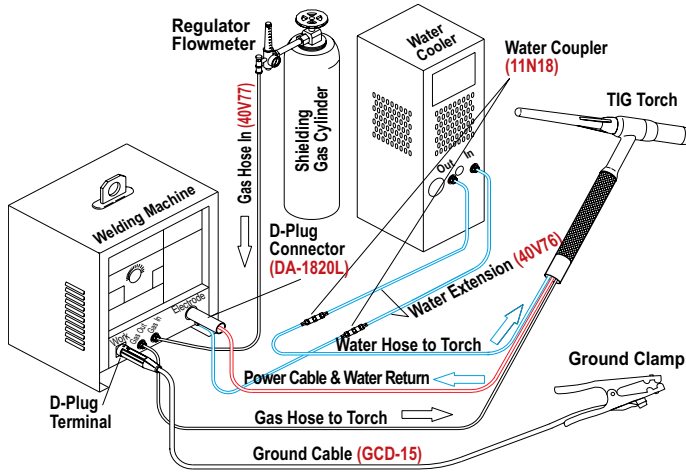


## Hook-up Installation Diagrams

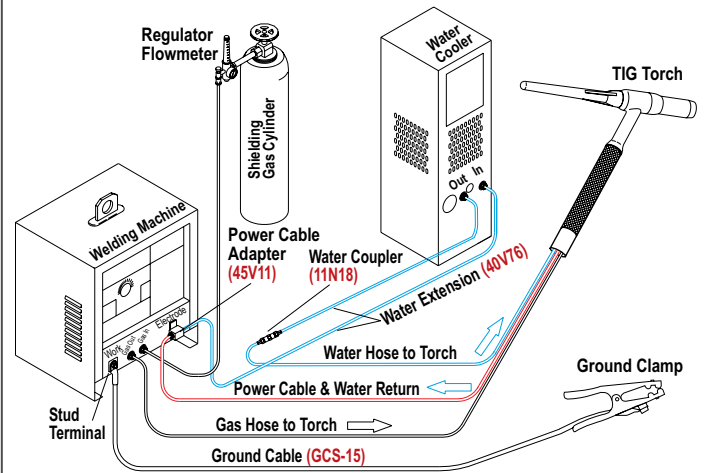
### TIG Torch Welding Machines

#### Water-Cooled Power Cable

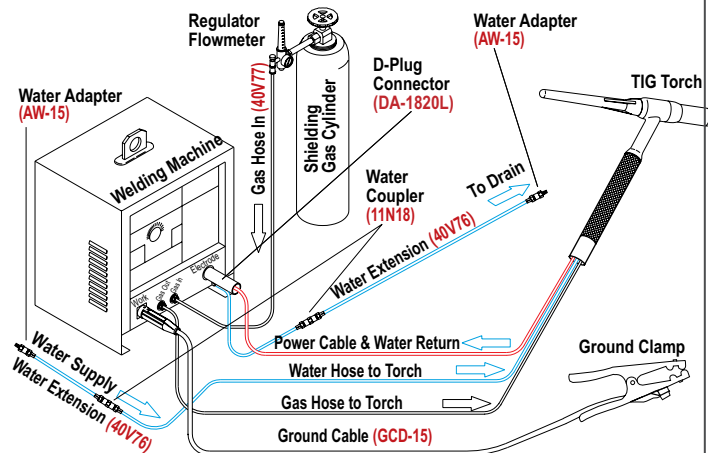
- Water cooler
- D-plug connection
- No gas solenoid



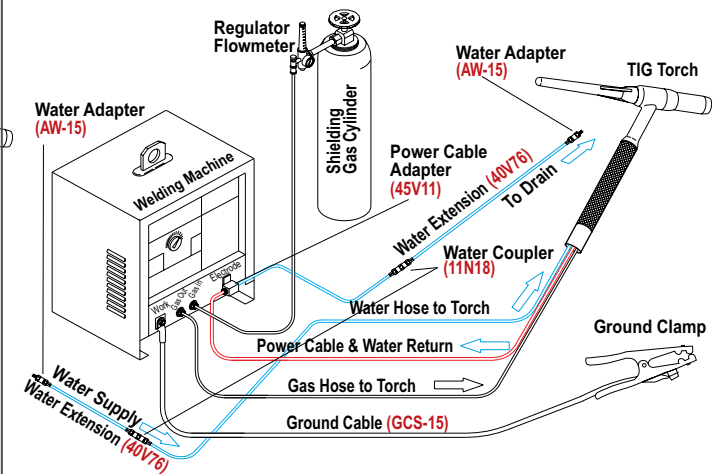
- Water cooler
- Stud connection
- No gas solenoid



- City water supply
- D-plug connection
- Gas solenoid



- City water supply
- Stud connection
- Gas solenoid



## MIG Welding - General Information

### Welding Benefits

- Easiest to learn.
- Better control on thin metals.
- Out-of-position welding.
- Same power source for solid and flux cored (gasless) wire.

### Welding Guns

Guns come rated for use with CO<sub>2</sub>-shielding gas at 60% duty cycle. Welding under 200 AMP, match the gun rating to the power supply rating. For argon shielding gas mixtures, welding at 200-350 AMPs and less than 60% duty cycle, select a 400 AMP air-cooled gun. At 200 AMP and higher at duty cycles over 60%, use water-cooled gun. Up to 350 AMP at duty cycles less than 60%, use a 600 AMP gun, air-cooled.<sup>1</sup>

### Shielding Gases

Gases that protect the weld puddle from the atmosphere include carbon dioxide, argon, and helium, used singly and in mixtures that may also include oxygen. Used for short-circuiting transfer to 200 AMP, carbon dioxide (CO<sub>2</sub>) gives a stable arc and reduce spatter. Argon shielding of nonferrous metals and alloys give a stable arc, good penetration, and smooth beads. Adding oxygen to argon increases arc stability, and smooths wetting and weld-face contour. Mixtures of more than two gases satisfy critical applications, such as welding of high-strength steel out-of-position and of stainless steels.<sup>2</sup>

### Safety Practice

Eye damage and skin burns are the most common injuries resulting from gas-metal-arc welding. Hazards include fume and gaseous emissions and electrical shock.<sup>2</sup>



## Welding Wire Thickness Chart<sup>3</sup>

Material Thickness	Recommended Wire Sizes						
	MIG Solid Wire				Gasless Flux-Cored Wire		
	.024"	.030"	.035"	.045"	.030"	.035"	.045"
24 gauge (.025)	•						
22 gauge (.031)	•				•		
20 gauge (.037)	•	•			•	•	
18 gauge (.050)	•	•	•		•	•	
16 gauge (.063)		•	•		•	•	•
14 gauge (.078)		•	•	•	•	•	•
1/8" (.125)		•	•	•		•	•
3/16" (.188)			•	•		•	•
1/4" (.25)			•	•			•
5/16" (.313)			•	•			•
3/8" (.375)			•	•			•
1/2" (.5)			•	•			•

• recommended wire sizes shown by gray box with dot

### Good Safety for Safe Welding!

- Arc rays can burn eyes and skin.
- Breathing welding fumes can be hazardous to your health. Use proper air ventilation or local exhaust.
- Use a welding helmet with the correct shade of filter.
- Wear safety glasses with side shields and welder's cap.
- Use ear protection when welding out-of-position or in a confined space.
- Use a button-down shirt collar.
- Wear complete body protection: oil-free protective clothing such as heavy shirt, leather gloves, pants without cuffs, and high boots.

<sup>1</sup> *Welding & Fabricating Data Book*. American Welding Society, 1996.

<sup>2</sup> "Miller - Improving Your Skills - MIG Welding". <http://millerwelds.com/resources/improving-your-skills/mig/>.

<sup>3</sup> "Miller - MIG Welding Tips - Intro". [http://millerwelds.com/education/tech\\_tips/MIG\\_tips/](http://millerwelds.com/education/tech_tips/MIG_tips/).

## 135 AMP MIG Gun



### Available Best Welds 135 MIG Guns

Part No.	Connector/Style	Wire Size	Length
		Inches	Feet
T135-10-3035	Tweco®/MIG	.030-.035	10
M135-10-3035	Miller®/MIG	.030-.035	10
FC135-10-3545	Tweco®/flux core	.035-.045	10

### Diffusers, Contact Tips and Nozzles MIG Gun Set-up



### Flux Core Set-up



Item	Part No.	Description	Tip Size	
			Inches	mm
1	35-50	Diffuser		
2	11-23	Contact tip, standard	.023	0.6
	11-30		.030	0.8
	11-35		.035	0.9
	11-45		.045	1.2
2a	11T-23	Contact tip, tapered	.023	0.6
	11T-30		.030	0.8
	11T-35		.035	0.9
3	21-37	Nozzle, self-insulated 1/8" recess 3/8"		
	21-50	Nozzle, self-insulated 1/8" recess 1/2"		
	21-50F	Nozzle, self-insulated flush		
	21-62	Nozzle, self-insulated 1/8" recess 5/8"		
	21T-37	Nozzle, self-insulated tapered		
4	KP1939-1	Nozzle, gasless (flux core)		

Best Welds® is not affiliated with Lincoln®, Miller®, Tweco®, Bernard® or Tregaskiss®. The parts shown in this catalog are not genuine brand name parts and are manufactured for Best Welds®. References to the above named brands, machines or part numbers are for convenience only.

## MIG Gun Parts

### 135 AMP MIG Gun



Item	Part No.	Description
1	35-50	Diffuser
2	see previous page	Contact tip
3		Nozzle (MIG)
4	KP1939-1	Nozzle, gasless (flux core)
5	13SR	Strain relief
6	25HR	Handle locking ring
7	13HD	Handle 2 pcs w/screws
8	25GH	Gun hanger
9	13BK	Tube block
10	13CT	Conductor tube

Item	Part No.	Description
11	25TB	Trigger blade
12	25TR	Comfort grip trigger
13	13TC	Connector (Tweco®)
14	13MC	Connector (Miller®)
15	13PC	Power cable assembly
16	35-40-15	Wire conduit (MIG)
	45-40-15	Wire conduit (flux cored)
17	13TA	Trigger connector (Tweco®)
18	25MA	Trigger connector (Miller®)

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## MIG Gun Parts

### 250 AMP MIG Gun



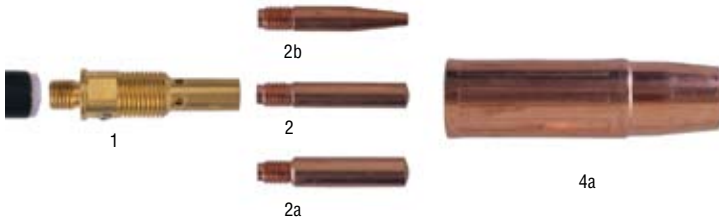
#### Available Best Welds 250 MIG Guns

Part No.	Connector	Wire Size	
		Inches	Feet
T250-15-3035	Tweco®	.030-.035	15
T250-15-4045		.040-.045	
M250-12-3035	Miller®	.030-.035	12
M250-15-3035		.040-.045	15
M250-15-4045		.040-.045	15
L250-15-3035	Lincoln®	.030-.035	15
L250-15-4045		.040-.045	

#### Diffusers, Contact Tips and Nozzles Standard MIG Gun Set-up



#### Optional MIG Gun Set-up



Item	Part No.	Description	Tip Size	
			Inches	mm
1	0052	Diffuser		
1a	52FN			
2	14-23	Contact tip, standard	.023	0.6
	14-30		.030	0.8
	14-35		.035	0.9
	14-45		.045	1.2
	14-52		.052	1.3
	14-116		1/16	1.6
	14-564		5/64	2.0
2a	14H-35	Contact tip, heavy duty	.035	0.9
	14H-45		.045	1.2
	14H-52		.052	1.3
	14H-116		1/16	1.6
	14H-564		5/64	2.0
2b	14T-30	Contact tip, tapered	.030	0.8
	14T-35		.035	0.9
	14T-45		.045	1.2
	14T-52		.052	1.3
	14T-116		1/16	1.6
3	0032	Nozzle insulator/retainer		
4	22-37SS	Nozzle, short stop 1/8" recess 3/8" bore		
	22-50	Nozzle, adjustable 1/2" bore		
	22-50SS	Nozzle, short stop 1/8" recess 1/2" bore		
	22-62	Nozzle, adjustable 5/8" bore		
	22-62SS	Nozzle, short stop 1/8" recess 5/8" bore		
4a	23-37	Nozzle, self-insulated 1/8" recess 3/8" bore		
	23-50	Nozzle, self-insulated 1/8" recess 1/2" bore		
	23-62	Nozzle, self-insulated 1/8" recess 5/8" bore		
	23-75	Nozzle, self-insulated 1/8" recess 3/4" bore		
	23T-37	Nozzle, self-insulated tapered 3/8" bore		
	23T-37F	Nozzle, self-insulated tapered flush 3/8" bore		

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## MIG Gun Parts

### 250 AMP MIG Gun



Item	Part No.	Description
1	see previous page	Diffuser
2	see previous page	Contact tip
3	0032	Nozzle insulator/retainer
4	see previous page	Nozzle
5	25SR	Strain relief
6	25HR	Handle locking ring
7	25HD	Handle 2pcs w/screws
8	25GH	Gun hanger
9	25TB	Trigger blade
10	25TR	Comfort grip trigger
11	25BK	Tube block
12	25CT	Conductor tube

Item	Part No.	Description
13	25MA	Trigger connector (Miller®)
14	25LA	Trigger connector (Lincoln®)
15	25CA	Connector case assembly
16	40HR	Connector locking ring
17	25LC	Connector (Lincoln®)
18	25TC	Connector (Tweco®)
19	25MC	Connector (Miller®)
20	25CB	Connector body
21	25PC	Power cable assembly
22	42-23-15	Wire conduit, .023" x 15'
23	42-3035-15	Wire conduit, .030 - .035" x 15'
24	42-4045-15	Wire conduit, .040 - .045" x 15'

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## 400 AMP MIG Gun



### Available Best Welds 400 MIG Guns

Part No.	Connector	Wire Size	Length
		Inches	Feet
T400-15-3545	Tweco®	.035-.045	15
T400-15-116		.045-1/16	
M400-15-3545	Miller®	.035-.045	12
M400-15-116		.045-1/16	
L400-15-3545	Lincoln®	.035-.045	15
L400-15-116		.045-1/16	

### Diffusers, Contact Tips and Nozzles Standard MIG Gun Set-up



### Optional MIG Gun Set-up 1



### Optional MIG Gun Set-up 2

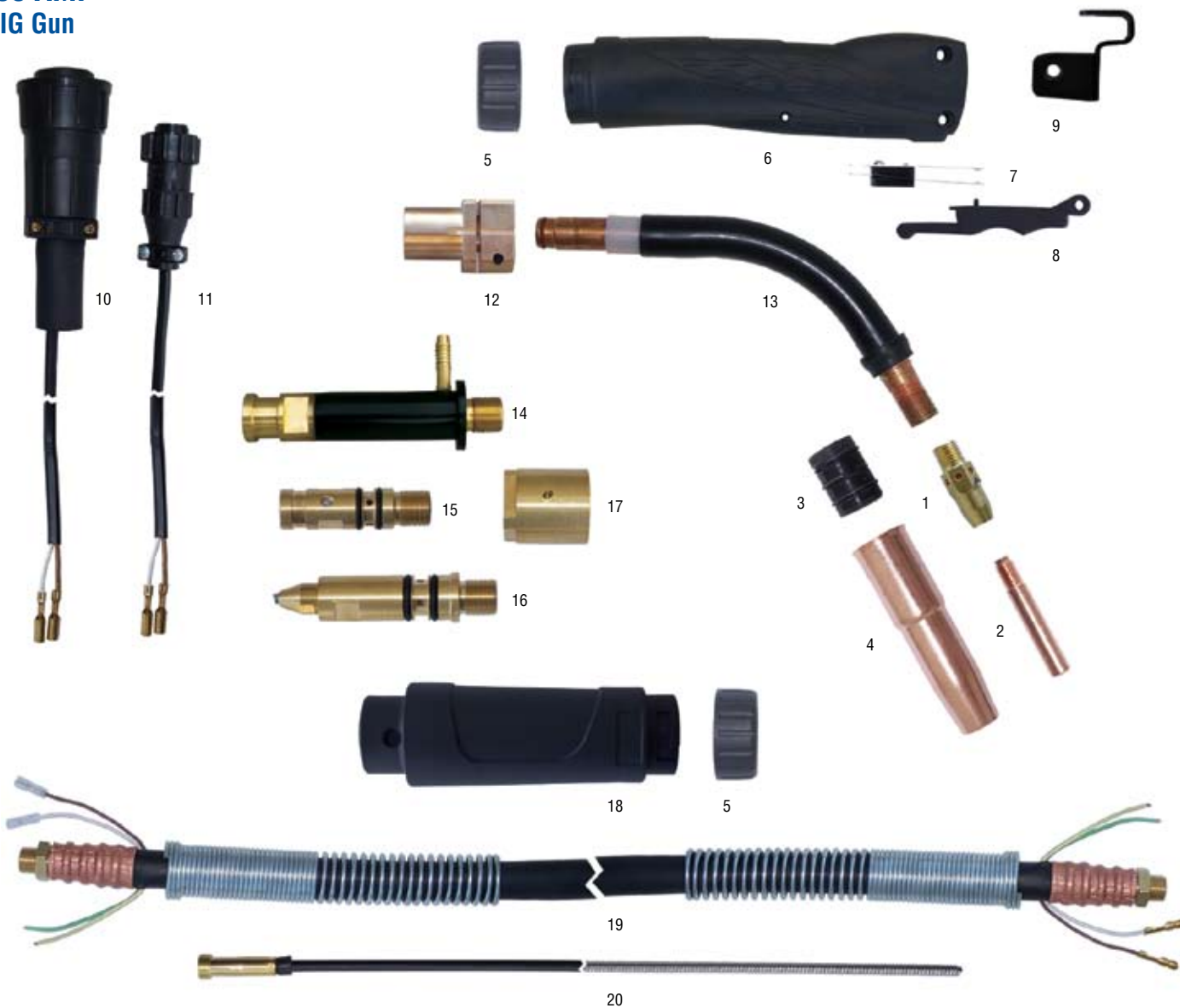


Item	Part No.	Description	Tip Size	
			Inches	mm
1	054A	Diffuser, brass		
	054P	Diffuser, copper		
2	14-23	Contact tip, standard	.023	0.6
	14-30		.030	0.8
	14-35		.035	0.9
	14-45		.045	1.2
	14-52		.052	1.3
	14-116		1/16	1.6
	14-564		5/64	2.0
2a	14H-35	Contact tip, heavy duty	.035	0.9
	14H-45		.045	1.2
	14H-52		.052	1.3
	14H-116		1/16	1.6
	14H-564		5/64	2.0
2b	14T-30	Contact tip, tapered	.030	0.8
	14T-35		.035	0.9
	14T-45		.045	1.2
	14T-52		.052	1.3
	14T-116		1/16	1.6
3	34A	Nozzle insulator/retainer		
4	24A-50	Nozzle, adjustable 1/2" bore		
	24A-50SS	Nozzle, short stop 1/8" recess 1/2" bore		
	24A-62	Nozzle, adjustable 5/8" bore		
	24A-62SS	Nozzle, short stop 1/8" recess 5/8" bore		
	24A-75	Nozzle, adjustable 3/4" bore		
	24A-75SS	Nozzle, short stop 1/8" recess 3/4" bore		
4a	23-37	Nozzle, self-insulated 1/8" recess 3/8" bore		
	23-50	Nozzle, self-insulated 1/8" recess 1/2" bore		
	23-62	Nozzle, self-insulated 1/8" recess 5/8" bore		
	23-75	Nozzle, self-insulated 1/8" recess 3/4" bore		
	23T-37	Nozzle, self-insulated tapered 3/8" bore		
	23T-37F	Nozzle, self-insulated tapered flush 3/8" bore		
	3a	34CT	Insulator, coarse thread	
4b	24CT-50S	Nozzle, coarse thread 1/8" recess 1/2"		
	24CT-62S	Nozzle, coarse thread 1/8" recess 5/8"		
	24CT-75S	Nozzle, coarse thread 1/8" recess 3/4"		

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## MIG Gun Parts

### 400 AMP MIG Gun



Item	Part No.	Description
1	see previous page	Diffuser
2	see previous page	Contact tip
3	034A	Nozzle insulator/retainer
4	see previous page	Nozzle
5	40HR	Handle locking ring
6	40HD	Handle 2pcs w/screws
7	25TB	Trigger blade
8	25TR	Comfort grip trigger
9	25GH	Gun hanger
10	25LA	Trigger connector (Lincoln®)
11	25MA	Trigger connector (Miller®)

Item	Part No.	Description
12	40BK	Tube block
13	40CT	Conductor tube
14	25LC	Connector (Lincoln®)
15	25TC	Connector (Tweco®)
16	25MC	Connector (Miller®)
17	40CB	Connector body
18	25CA	Connector case assembly
19	40PC	Power cable assembly
20	44-3545-15	Wire conduit, .035" -.045" x 15'
	44-116-15	Wire conduit, .052" -.1/16" x 15'
	44-564-15	Wire conduit, 5/64" x 15'

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## Replacement MIG Parts

### Tweco® Style Consumables Nozzles

#### 135 AMP, Mini®, No.1



Part No.	Description	Bore Dia.
21-37	Nozzle, self-insulated 1/8" recess	3/8"
21-50		1/2"
21-62		5/8"
21-50F	Nozzle, self-insulated flush	1/2"



Part No.	Description	Bore Dia.
21T-37	Nozzle, self-insulated 1/8" recess	3/8"

#### 250 AMP, No.2



Part No.	Description	Bore Dia.
22-37SS	Nozzle, short stop 1/8" recess	3/8"
22-50SS		1/2"
22-62SS		5/8"
22-50	Nozzle, adjustable	1/2"
22-62		5/8"

#### 250/400 AMP, Nos. 2, 3, 4



Part No.	Description	Bore Dia.
23-37	Nozzle, self-insulated 1/8" recess	3/8"
23-50		1/2"
23-62		5/8"
23-75		3/4"



Part No.	Description	Bore Dia.
23T-37	Nozzle, self-insulated 1/8" recess	3/8"
23T-37F	Nozzle, self-insulated flush	3/8"

### Insulators

#### 250 AMP, No.2

Part No. 0032



#### 400 AMP, Nos.3, 4

Part No. 034A

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#### 400 AMP, No.4



Part No.	Description	Bore Dia.
24A-50SS	Nozzle, short stop 1/8" recess	1/2"
24A-62SS	Nozzle, short stop 1/8" recess	5/8"
24A-75SS	Nozzle, short stop 1/8" recess	3/4"
24A-50	Nozzle, adjustable	1/2"
24A-62	Nozzle, adjustable	5/8"
24A-75	Nozzle, adjustable	3/4"



Part No.	Description	Bore Dia.
24FN-50S	Nozzle, fine thread 1/8" recess	1/2"
24FN-62S		5/8"
24FN-75S		3/4"
34FN	Insulator, fine thread	



Part No.	Description	Bore Dia.
24CT-50S	Nozzle, coarse thread 1/8" recess	1/2"
24CT-62S		5/8"
24CT-75S		3/4"
34CT	Insulator, coarse thread	



### Conductor Tubes



Part No.	Description
<b>Gun: No.2</b>	
62A-60	Conductor tube 60° No.2
62A-60J	Conductor tube w/metal jacket 60° No.2
<b>Gun: No.3</b>	
63-60	Conductor tube 60° No.3
63-60J	Conductor tube w/metal jacket 60° No.3
<b>Gun: No.4</b>	
64A-60	Conductor tube 60° No.4
64A-60J	Conductor tube w/metal jacket 60° No.4
<b>Gun: No.5</b>	
65-60	Conductor tube 60° No.5
65-60J	Conductor tube w/metal jacket 60° No.5

## Replacement MIG Parts

### Tweco® Style Consumables Contact Tips

#### 135 AMP, Mini®, No.1



Part No.	Description	Size	
		Inches	mm
11-23	Contact tip, standard	.023	0.6
11-30		.030	0.8
11-35		.035	0.9
11-45		.045	1.2



Part No.	Description	Size	
		Inches	mm
11T-23	Contact tip, tapered	.023	0.6
11T-30		.030	0.8
11T-35		.035	0.9

#### 250/400 AMP, Nos. 2, 3, 4



Part No.	Description	Size	
		Inches	mm
14-23	Contact tip, standard	.023	0.6
14-30		.030	0.8
14-35		.035	0.9
14-45		.045	1.2
14-52		.052	1.3
14-116		1/16	1.6
14-564		5/64	2.0



Part No.	Description	Size	
		Inches	mm
14H-35	Contact tip, heavy duty	.035	0.9
14H-45		.045	1.2
14H-52		.052	1.3
14H-116		1/16	1.6
14H-564		5/64	2.0



Part No.	Description	Size	
		Inches	mm
14T-30	Contact tip, tapered	.030	0.8
14T-35		.035	0.9
14T-45		.045	1.2
14T-52		.052	1.3
14T-116		1/16	1.6

### Diffusers

#### 135 AMP, Mini® Gun

Part No. 35-50- .030-.045 wire



Part No. 35-50

#### No. 1 Gun

Part No. 0051- .030-.045 wire

Part No. 51-23- .023 wire



Part No. 0051

#### 250 AMP, No. 2 Gun

Part No. 0052- .030-.045 wire

Part No. 52-23- .023 wire



Part No. 0052



Part No. 52-23

#### 400 AMP, No. 4 Gun

Part No. 054A brass

Part No. 054P copper

• For .030 - .078



Part No. 054A

### Wire Conduits



Part No.	Description	Size	Length
35-40-15	135 AMP, Mini®	.030"-.035"	15'
45-40-15		.035"-.045"	
42-23-15	250 AMP, Nos.1, 2	.023"	15'
42-3035-15		.030"-.035"	
42-4045-15		.040"-.045"	
42-3035-25		.030"-.035"	
42-4045-25	25'	.040"-.045"	
44-3545-15		.035"-.045"	
44-116-15	400 AMP, Nos.3, 4	1/16"	15'
44-564-15		5/64"	
44-564-25		5/64"	25'
44-3545-25		.035"-.045"	
44-116-25	1/16"		

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## Replacement MIG Parts

### Bernard® Style Consumables Nozzles



Part No.	Description	Bore Dia.
4295	Nozzle, brass tapered	1/2"



Part No.	Description	Bore Dia.
4391	Nozzle, brass	5/8"
4392		1/2"
4393	Nozzle, copper	5/8"
4394		1/2"



Part No.	Description	Bore Dia.
4491	Nozzle, brass	3/4"
4492		9/16"
4591	Nozzle, copper	3/4"
4592		9/16"

### Gas Diffusers

Use with 7400 and 4200 series tips  
**Part No. 4435**



Use with 7400 series tips.  
**Part No. 4435**  
Use with 4200 series tips.  
**Part No. 4635**



### Conductor Tubes



Part No.	Description	Gun AMP
4786	Body Tubes	200-300
4790		400-500

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### Contact Tips



Part No.	Description	Size	
		Inches	mm
1588	Contact tip	.030	0.8
1589		.035	0.9
1590		.045	1.2
1591		1/16	1.6
1592		5/64	2.0
1593		3/32	2.4
1598		.052	1.4



Part No.	Description	Size	
		Inches	mm
4281	Contact tip, tapered	.035	0.9
4282		.045	1.2



Part No.	Description	Size	
		Inches	mm
7488	Contact tip	.030	0.8
7489		.035	0.9
7490		.045	1.2
7491		1/16	1.6
7492		5/64	2.0
7493		3/32	2.4
7498		.052	1.4

### Liners



Part No.	Description	Size	Length
43015	Wire conduit	.023"-.030"	15'
43115		.035"-.045"	
43215		.045"-1/16"	
44115		.035"	
44215		.045"-1/16"	25'
44225		.045"-1/16"	
45415	3/32"	15'	

### Gas Diffusers

Use with 200-300 guns  
**Part No. 4323R**



Use with 350-500 guns  
**Part No. 4423R**



## Replacement MIG Parts

### Miller® Style Consumables

#### Nozzles M10, M15



Part No.	Description	Bore Dia.
169-715	Nozzle, flush	1/2"

#### M25/25/M, M40/40AL



Part No.	Description	Bore Dia.
169-724	Nozzle, 1/8" tip recess	1/2"
200-258	Nozzle, flush	1/2"
169-725	Nozzle, 1/8" tip recess	5/8"
169-726	Nozzle, flush	5/8"
169-727	Nozzle, 1/8" tip stickout	5/8"

#### Spoolmatic® 1, 2, 3, 40A/XR™'s, XRM™'s



Part No.	Description	Bore Dia.
050-115	Nozzle	1/2"
050-622		5/8"

#### Contact Tips

##### M15, M25/25/M, M40/40AL



Part No.	Description	Size	
		Inches	mm
087-299	Contact tip	.023	0.6
000-067		.030	0.8
000-068		.035	0.9
000-069		.045	1.2
172-024		1/16	1.6
172-025		5/64	2.0
172-034		.045	1.2

#### XR™/XRM™-15A/30A, 15W/30W XR-Edge, Spoolmatic® 30A/30W



Part No.	Description	Size	I.D.
135-424	Tip (aluminum wire)	.047"	.059"
135-425		.062"	.078"
135-426	Tip (steel wire)	.062"	.073"
135-427		.030"	.035"
135-428	Tip (aluminum wire)	.030"	.040"
135-429	Tip (steel wire)	.047"	.054"
135-430	Tip (aluminum wire)	.035"	.050"

### Adapters, Diffusers and Retainers

#### M25/25/M, M40/40AL

Tip adapter/diffuser.

Part No. 169-728



Nozzle retainer.

Part No. 169-729



#### M15

Nozzle retainer/diffuser.

Part No. 169-716



### Liners

#### M10, M15, M25/25/M, M40/40AL



Part No.	Description	Size	Length
194010	Wire conduit	.023"-.030"	15'
194011		.030"-.035"	
194012		.035"-.045"	

#### XR™/XRM™-15A/30A, 15W/30W XR-Edge, Spoolmatic® 30A/30W



Part No.	Description	Size	Length
136-682	Wire conduit, Teflon®	.023"-.035"	6-3/4"
136-683		.045"-1/16"	

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## Tregaskiss® Style Consumables Nozzles



Part No.	Description	Bore Dia.
401-4-38	Nozzle, insulated flush	3/8"
401-4-50	Nozzle, insulated 1/8" recess	1/2"
401-4-62		5/8"



Part No.	Description	Bore Dia.
401-5-62	Nozzle, H.D. insulated 1/4" recess	5/8"
401-5-75		3/4"
401-6-62	Nozzle, H.D. insulated 1/8" recess	5/8"
401-6-75		3/4"

## Diffusers

Nozzle retainer.  
Part No. 402-3



Diffuser for standard contact tips.  
Part No. 0404



Diffuser for heavy duty contact tips.  
Part No. 404-1

Retainer ring only.  
Part No. 402-4

Nozzle retainer/diffuser for heavy duty contact tips.  
Part No. 404-3



Nozzle retainer/diffuser, heavy duty for heavy duty contact tips.  
Part No. 404-13

## Conductor Tubes



Part No.	Description	Gun AMP
305-60	Body tube 60°	300
405-45	Body tube 45°	400
405-60	Body tube 60°	400

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## Contact Tips



Part No.	Description	Size	
		Inches	mm
403-35	Contact tip, standard	.035	0.9
403-45		.045	1.2
403-116		1/16	1.6



Part No.	Description	Size	
		Inches	mm
403-1-35	Contact tip, heavy duty	.035	0.9
403-1-45		.045	1.2
403-1-52		.052	1.4
403-1-116		1/16	1.6



Part No.	Description	Size	
		Inches	mm
403-3-35	Contact tip, H.D. tapered	.035	0.9
403-3-45		.045	1.2

## Liners



Part No.	Description	Size	Length
415-35-15	Wire conduit	.035"-.045"	15'
415-116-15		.045"-1/16"	
415-116-2	Wire conduit, nylon core	.045"-1/16"	25'
415-35-25	Wire conduit	3/64"-1/16"	

## Shock Washers

Heavy duty  
Part No. 402-5



Standard  
Part No. 402-7



## Replacement MIG Parts

### 135 AMP Back End Options

#### Tweco® Style Guns

Part No. T135-10-3035- standard wire  
Part No. FC135-10-3545- flux cored



#### Miller® Style Guns

Part No. M135-10-3035- standard wire



### 200 & 400 AMP Back End Options

#### Tweco® Style Guns



Part No.	AMP	Length (inches)	Wire size (inches)
T250-15-3035	250	15	.030 - .035
T250-15-4045	250	15	.040 - .045
T400-15-3545	400	15	.035 - .045
T400-15-116	400	15	.0625

#### Lincoln® Style Guns



Part No.	AMP	Length (inches)	Wire size (inches)
L250-15-3035	250	15	.030 - .035
L250-15-4045	250	15	.040 - .045
L400-15-3545	400	15	.035 - .045
L400-15-116	400	15	.0625

#### Miller® Style Guns



Part No.	AMP	Length (inches)	Wire size (inches)
M250-12-3035	250	12	.030 - .035
M250-15-3035	250	15	.030 - .035
M250-15-4045	250	15	.040 - .045
M400-15-3545	400	15	.035 - .045
M400-15-116	400	15	.0625

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**Modular TIG Torch Kits**  
Page 175



**MIG Torches**  
Pages 182-194



**Arc Gouging Torches**  
Page 237



## Custom Select Ordering System for Bernard Q-Guns

### Bernard Q-Gun™

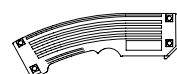
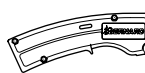
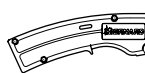
The part number shown here, Q4010AE8EM, is an example of a typical configuration. It consists of a 400 AMP Q-Gun with a 15' cable, curved handle, locking trigger, rotatable short 45° neck, 7400 series 0.035" contact tip and a Miller® style direct plug.

 Inert Gas Equipment  
 2

**Q40**
**10**
**A**

AMP and Cable Type	
Q15	150 AMP max. wire size: .045" (1.2 mm)
Q20	200 AMP max. wire size 1/16" (1.6 mm)
Q30	300 AMP max. wire size: 5/64" (2.0 mm)
Q40	400 AMP max. wire size: 5/64" (2.0 mm)
Q50	500 AMP max. wire size: 3/32" (2.4 mm)
Q60	600 AMP max. wire size: 1/8" (3.2 mm)
S30	300 AMP steel "Monocoil" max. wire size: 5/64" (2.0mm)
S40	400 AMP steel "Monocoil" max. wire size: 5/64" (2.0mm)
S50	500 AMP steel "Monocoil" max. wire size: 3/32" (2.4 mm)
S60	600 AMP steel "Monocoil" max. wire size: 1/8" (3.2 mm)

	Cable Length	
	feet	m
08	8	2.44
10	10	3.05
12	12	3.66
15	15	4.57
20	20	6.16
25	25	7.63



Handle and Trigger		
150 AMP Curved Handle Standard Cable	Standard trigger	<b>A</b>
200, 300 AMP Curved Handle Standard Cable	Standard trigger Locking trigger Dual pull trigger	<b>A</b> <b>B</b> <b>C</b>
400 AMP Curved Handle Standard Cable	Standard trigger Locking trigger Dual pull trigger Dual schedule switch Dual schedule switch w/lock	<b>A</b> <b>B</b> <b>C</b> <b>D</b> <b>E</b>
150-400 AMP* OXO Style Small Curved Handle Standard or Steel Monocoil	Standard trigger Locking trigger	<b>T</b> <b>U</b>
400-600 AMP* OXO Style Large Curved Handle Standard or Steel Monocoil	Standard trigger Locking trigger Dual pull trigger Dual schedule switch Dual schedule switch w/lock	<b>G</b> <b>H</b> <b>I</b> <b>K</b> <b>L</b>

Combine steel Monocoil cable with OXO style handle and QuikTip for gun similar to former OXO APX gun.

\*Only OXO style handle options can be used with Steel Monocoil power cable.

### Select the right MIG gun to fit your precise application requirements.

**A Bernard Q-Gun configured with Custom Select really is the right tool for the job. Why settle for anything less?**

- Build a part number for a new Q-Gun by selecting:  
Amperage, Cable Length, Handle and Trigger, Neck, Contact Tip and Direct Plug.

**Bernard Q-Guns configured with Custom Select are fitted at the factory with these Diffusers and Nozzles.**

- Bernard Q-Guns configured with electrode sizes of 1/16" or smaller will be fitted at the factory with tube head diffusers where available.
- A wide variety of alternative front end parts are available to fit special applications.

## Custom Select Ordering System for Bernard Q-Guns



Neck			
<b>A</b>	Rotatable, short	30°	QT2-30
<b>B</b>	Rotatable, short	45°	QT2-45
<b>C</b>	Rotatable, short	60°	QT2-60
<b>J</b>	Rotatable, short	80°	QT2-80
<b>D</b>	Rotatable, medium	30°	QT3-30
<b>E</b>	Rotatable, medium	45°	QT3-45
<b>F</b>	Rotatable, medium	60°	QT3-60
<b>K</b>	Rotatable, medium	80°	QT3-80
<b>G</b>	Rotatable, long	30°	QT5-30
<b>H</b>	Rotatable, long	45°	QT5-45
<b>I</b>	Rotatable, long	60°	QT5-60
<b>N</b>	Fixed, short	30°	QT2-30
<b>O</b>	Fixed, short	45°	QT2-45
<b>P</b>	Fixed, short	60°	QT2-60
<b>W</b>	Fixed, short	80°	QT2-80
<b>Q</b>	Fixed, medium	30°	QT3-30
<b>R</b>	Fixed, medium	45°	QT3-45
<b>S</b>	Fixed, medium	60°	QT3-60
<b>X</b>	Fixed, medium	80°	QT3-80
<b>T</b>	Fixed, long	30°	QT5-30
<b>U</b>	Fixed, long	45°	QT5-45
<b>V</b>	Fixed, long	60°	QT5-60

Contact Tip	
<b>8</b>	Centerfire™ T Series tip 
<b>7</b>	Elliptical, 7400 series, 1.25" long, std. 
<b>5</b>	Quik Tip™ 
<b>1</b>	Elliptical, 1500 series, 2.00" long, HD 

Wire Size		
	Inches	mm
<b>A</b>	.023	0.6
<b>B</b>	.030	0.8
<b>C</b>	.035	0.9
<b>D</b>	.039	1.0
<b>E</b>	.045	1.2
<b>H</b>	.052	1.4
<b>I</b>	1/16	1.6
<b>K</b>	5/64	2.0
<b>L</b>	3/32	2.4
<b>M</b>	7/64	2.8
<b>N</b>	1/8	3.2

Direct Plug	
<b>B</b>	Bernard®
<b>C</b>	L-Tec®
<b>E</b>	Euro®
<b>H</b>	Hobart®
<b>L</b>	Lincoln®
<b>M</b>	Miller®
<b>N</b>	National®
<b>O</b>	OXO®
<b>S</b>	Tweco® 4 (Lincoln lead)
<b>T</b>	Tweco® 4 (std. lead)
<b>U</b>	Tweco® 4 (two prong twist-lock lead)
<b>W</b>	Tweco® 5 (std. lead)

### Aluminum

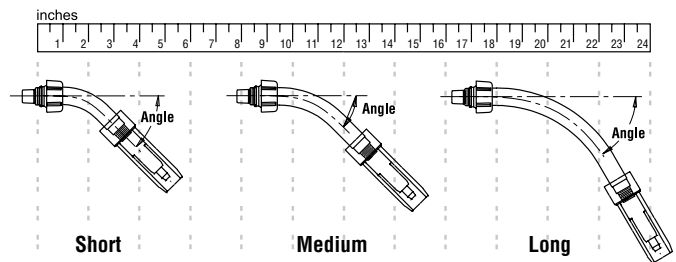
Wire Size		
	Inches	mm
<b>Q</b>	.035	0.9
<b>R</b>	3/64	1.19
<b>S</b>	1/16	1.6

### Typically Selected Necks by Amperage

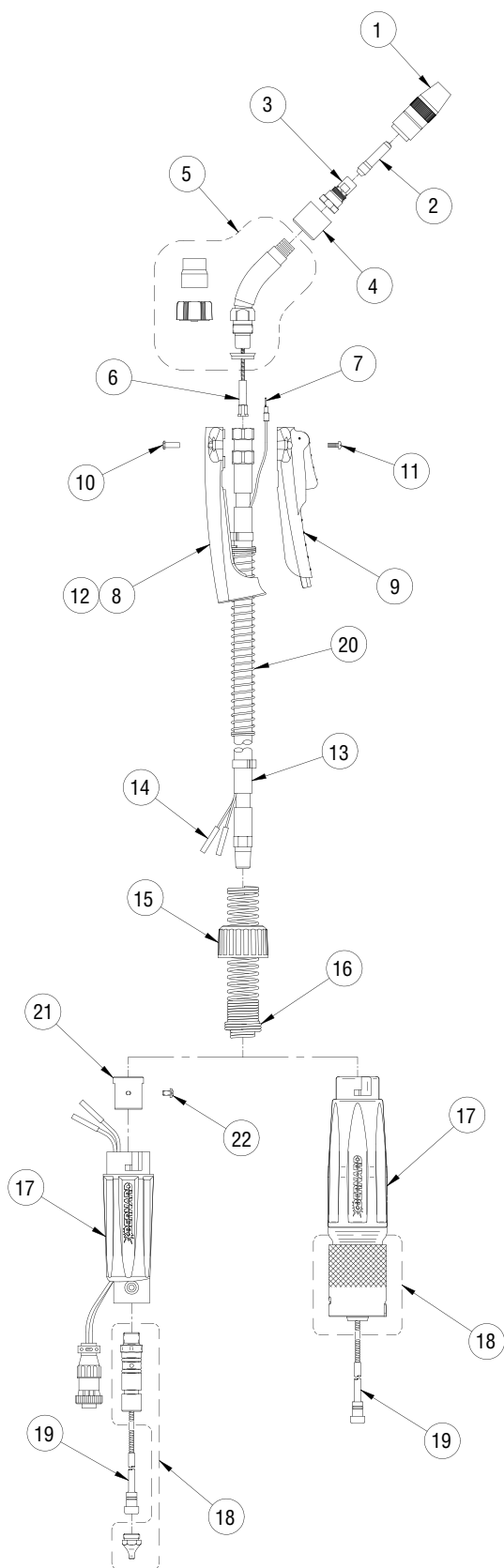
150 - 200 AMP	QT2-45
300 - 400 AMP	QT3-45
500 - 600 AMP	QT5-60

### Illustrated below are the necks defined for Standard Q-Guns.

Short 45° QT2-45, standard for 150, 200 AMP  
 Medium 45° QT3-45, standard for 300, 400 AMP  
 Long 60° QT5-60, standard for 500, 600 AMP

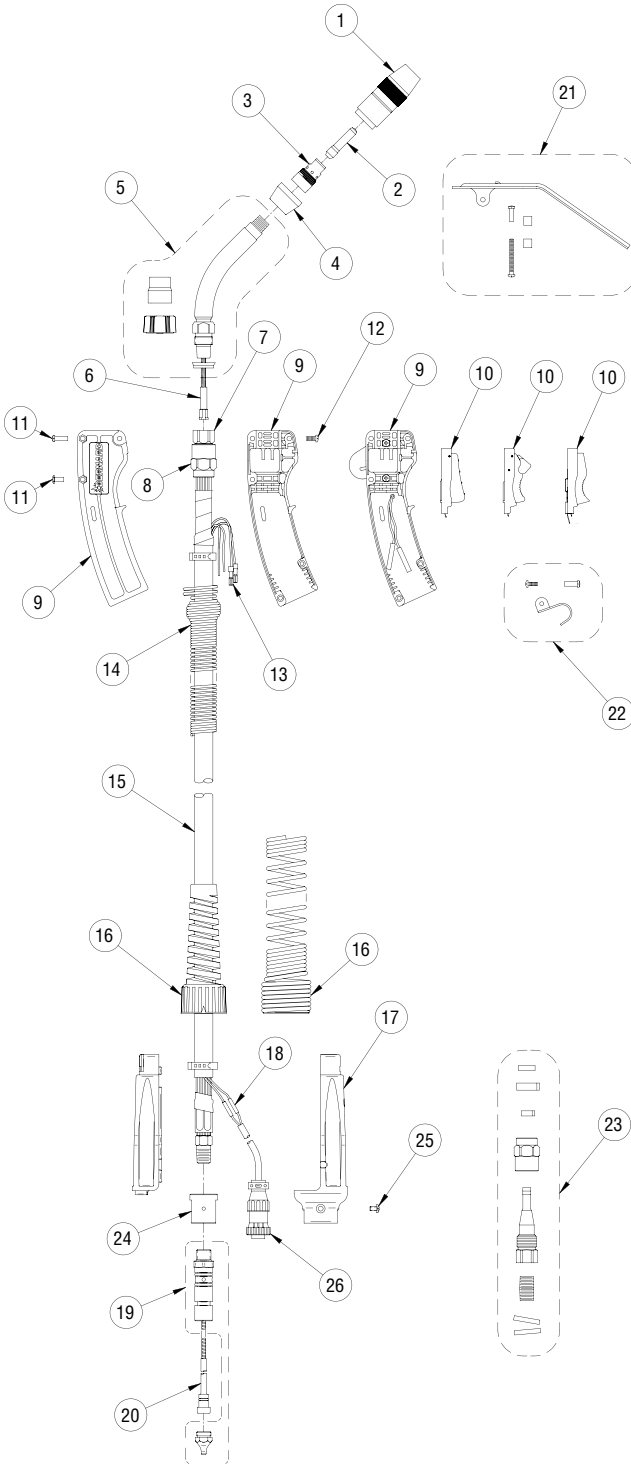


## Q150 Replacement Parts List



Item	Part No.	Description
1	See Centerfire™ spec sheet	Nozzle assembly
2	See Centerfire™ spec sheet	Contact tip
3	See Centerfire™ spec sheet	Gas diffuser
4	See Centerfire™ spec sheet	Cap
5	See neck spec sheet	Neck
6	See jump liner spec sheet	Jump liner
7	2660001	Terminal, quick disconnect (2 req'd)
8	1780062	Handle half, upper
9	2620054	Switch assembly, handle half, lower
10	4207	Post fastener (2 req'd)
11	4209	Handle screw (2 req'd)
12	1880194	Handle kit -(includes: (1) #8, (1) #9, (2) #10, (2) #11)
<b>Replacement Cable with Fittings</b>		
13	1060107	8' (2.44 m)
	1060097	10' (3.05 m)
	1060098	12' (3.66 m)
	1060099	15' (4.57 m)
	1060100	20' (6.10 m)
	1060101	25' (7.62 m)
14	4932	Butt connector (2 req'd)
15	2520007	Cap, rigid strain relief
16	2520048	Spring, strain relief
<b>Rigid Strain Relief</b>		
17	2520073	Strain relief with installed gas pin (Bernard direct plug)
	2520047	Strain relief (Euro direct plug)
	2520047E	Strain relief with trigger cable adapter (OXO, Tweco 4 w/twist lock)
	2520047H	Strain relief with trigger cable adapter (L-Tec, Hobart direct plug)
	2520047L	Strain relief with trigger cable adapter (Lincoln direct plug)
	2520047T	Strain relief with trigger cable adapter (National, Tweco direct plug)
	2520047M	Strain relief with trigger cable adapter (All other direct plugs)
18	See direct plug spec sheet	Direct plug components
19	See Liner spec sheet	Liner
20	2520049	Spring, strain relief
21	1010027	Adapter block (not req'd on Bernard or Euro direct plug)
22	W11127-002	Screw, strain relief (not req'd on Bernard direct plug)

## Q200/Q300/Q400 Replacement Parts List



Item	Part No.			Description
	Q200	Q300	Q400	
1	See Centerfire™ spec sheet			Nozzle assembly
2	See Centerfire™ spec sheet			Contact tip
3	See Centerfire™ spec sheet			Gas diffuser
4	See Centerfire™ spec sheet			Cap
5	See neck spec sheet			Neck
6	See jump liner spec sheet			Jump liner
7	4213B	4213B	4313B	Stay-Tite™ end fitting
8	4305	4305	1540003	Stay-Tite™ cone nut
NS	4991	4991	1520017	Conduit clamp (2 req'd)
NS	4823	4823	4939	Jacket clamp (2 req'd)
9	1880155	1880155	1880198	Handle kit, standard trigger*
				Handle kit, locking trigger*
				Handle kit, dual pull trigger*
				Handle kit, D/S, standard trigger*
10	N/A	N/A	DSA-1	Handle kit, D/S, locking trigger*
10	5662	5662	5662	Trigger, standard
	5662L**	5662L**	5662L**	Trigger, locking
	2690001	2690001	2690001	Trigger, dual pull, 3 wire (with insulated terminals)
11	4207	4207	4207	Post fastener (1 req'd - q200 & q300) (5 req'd - q400)
				2030004
12	4209	4209	4209	Handle screw (5 req'd)
13	2660001	2660001	2660001	Terminal, quick disconnect (2 req'd)
14	N/A	N/A	2520042	Handle spring
15	<b>Replacement Cable With Fittings</b>			
	1060120	1060108	1060114	8' (2.44 m)
	1060121	1060109	1060115	10' (3.05 m)
	1060122	1060110	1060116	12' (3.66 m)
	1060123	1060111	1060117	15' (4.57 m)
	1060124	1060112	1060118	20' (6.10 m)
	1060125	1060113	1060119	25' (7.62 m)
16	2520033	2520033	2520041	Strain Relief
17	<b>Rigid Strain Relief Kit (Includes top and bottom halves)</b>			
	2520073	2520073	2520073	Strain relief with installed gas pin (Bernard direct plug)
	2520069	2520069	2520069	Strain relief (euro direct plug)
	2520066	2520066	2520066	Strain relief (all other direct plugs)
18	4932	4932	4932	Butt connector (2 req'd)
19	See Direct Plug Spec Sheet			Direct plug components
20	See Liner Spec			Sheet liner
21	1880012	1880012	1880012	Heat shield kit (includes heat shield, screws, posts, & spacers)
22	1790002	1790002	1790002	Hang up hook kit (Includes hook, screw, & post)
23	1982	1983Q	1984Q	Rear Stay-Tite™ repair kit†
24	1010027	1010027	1010027	Adapter block (Not req'd on Bernard or Euro direct plug)
25	W11127-002	W11127-002	W11127-002	Screw, strain relief (not req'd on Bernard direct plug)
26	GN2021	GN2021	GN2021	Electrical plug - Non D/S (Not req'd on Bernard or Euro direct plug)
	20006A	20006A	20006A	Electrical plug - D/S (Not req'd on Bernard or Euro direct plug)

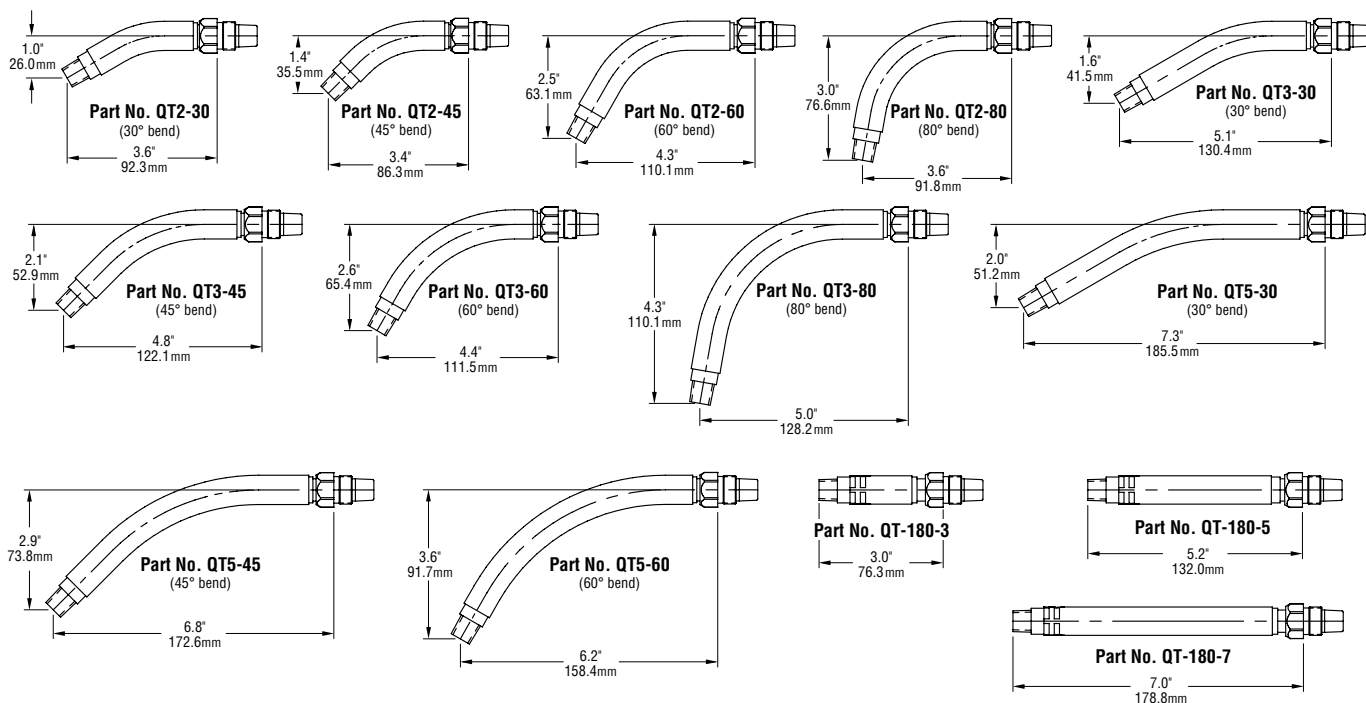
\*1880155 & 1880198 Handle Kits include halves, screws & posts.

DSA-1 Handle Kits include halves, screws, posts, toggle switch and guard.

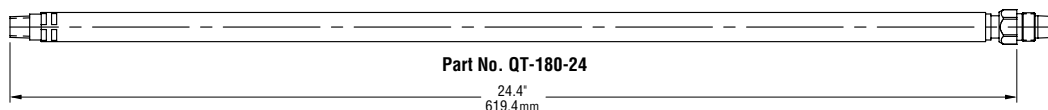
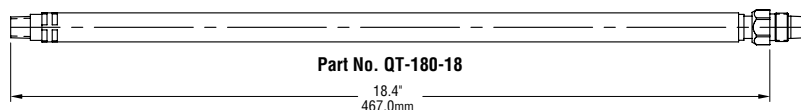
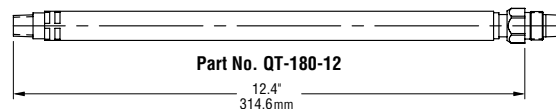
\*\*Patent Pending

†1982, 1983Q & 1984Q Rear Cone Nut Repair Kits include jacket clamp, conduit clamp, cone nut, end fitting, nipple, spacer & butt connectors.

## Available Necks

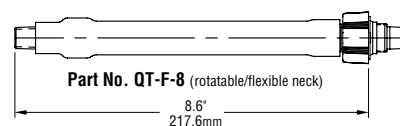
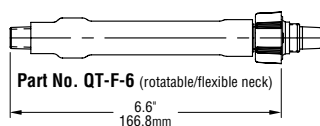
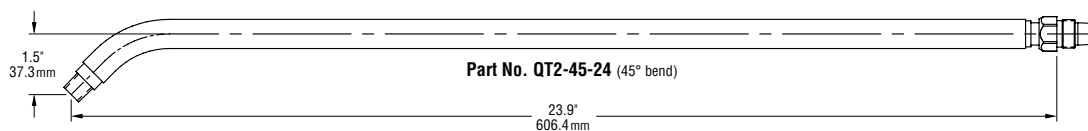
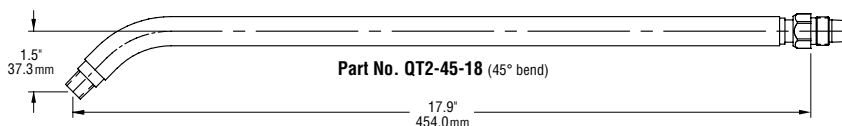
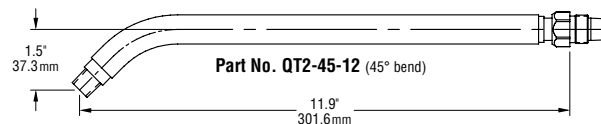


Note: Diffuser thread size: 1/4-18 NPT "Bernard Special."



All body tubes (except the QT-F-6 and QT-F-8) include the components required to make the body tube fixed (wrench-tight) or rotatable (hand-tight).  
Patent Pending

- Part No. 1840057** → [Image of nut]
- Part No. 1840031** → [Image of washer]
- Part No. 4780** → [Image of ferrule]





## Replacement Liners

### Standard Liners

Wire Size	Gun Amperage	Direct Plug	Part No.		
			10' (3.05 m)	15' (4.57 m)	25' (7.62 m)
.023" - .030" (.6 mm - .8 mm)	150A - 600A	All except Tweco 4, L-Tec	N/A*	43015	43025
		Tweco 4, L-Tec		43015T	43025T
.035" - .045" (.9 mm - 1.2 mm)	150A	All except Tweco 4, L-Tec	43110	43115	43125
		Tweco 4, L-Tec	N/A*	43115T	43125T
	200A - 600A	All except Tweco 4, L-Tec	44110	44115	44125
		Tweco 4, L-Tec	N/A*	44115T	44125T
.045" - 1/16" (1.2 mm - 1.6 mm)	200A - 600A	All except Tweco 4, L-Tec	44210	44215	44225
		Tweco 4, L-Tec	N/A*	44215T	44225T
5/64" (2.0 mm)	200A - 400A	All except Tweco 4, L-Tec	N/A*	1920170†	1920172†
		Tweco 4, L-Tec		1920296†	1920298†
	500A - 600A	All except Tweco 4, L-Tec		44315	44325
		Tweco 4, L-Tec		44315T	44325T
3/32" (2.4 mm)	500A - 600A Air-Cooled Only	All except Tweco 4, L-Tec	N/A*	45415	45425
	400A Clean-Air 600A Water-Cooled	All except Tweco 4, L-Tec	N/A*	1920175†	1920177†
7/64" (2.8 mm)	600A Air-Cooled Only	All except Tweco 4, L-Tec	N/A*	45615	45625
1/8" (3.2 mm)				46715	46725

\*10' (3.05 m) liner not available. Order 15' (4.57 m) liner and trim to size.

†Liners without outer jacket.

### Aluminum / Soft Wire Liners

Wire Size	Gun Amperage	Direct Plug	Part No.		
			10' (3.05 m)	15' (4.57 m)	25' (7.62 m)
.035" (.9 mm)	150A - 600A Nylon	All except Tweco 4, L-Tec	N/A*	43015X	N/A
		Tweco 4, L-Tec		43015XT	
	200A - 600A Steel Coil	All except Tweco 4, L-Tec		1920343	
		Tweco 4, L-Tec		1920346	
3/64" (1.2 mm)	200A - 600A Nylon	All except Tweco 4, L-Tec	N/A*	43115X	N/A
		Tweco 4, L-Tec		43115XT	
	200A - 600A Steel Coil	All except Tweco 4, L-Tec		1920344	1920350
		Tweco 4, L-Tec		1920347	N/A
1/16" (1.6 mm)	200A - 600A Nylon	All except Tweco 4, L-Tec	N/A*	44215X	N/A
		Tweco 4, L-Tec		44215XT	
	200A - 600A Steel Coil	All except Tweco 4, L-Tec		1920345	1920351
		Tweco 4, L-Tec		1920348	N/A

\*10' (3.05 m) liner not available. Order 15' (4.57 m) liner and trim to size.

### Replacement Instructions and Service

#### Install Replacement Liner

Insert liner into power pin with cable laying straight. Continue until liner lock is fully seated into power pin. A twisting motion may be necessary to seat O-ring (some direct plugs may require installation of additional components to secure liner).

Making sure cable is straight, trim liner at the nozzle of the neck as follows:

- DS-1 and D-1 Centerfire™ gas diffusers (used with Centerfire™ series tips) = between 5/8" and 3/4".
- 4235 and 4635 gas diffusers (used with 1500 series tips) = 3/8".  
4335 and 4435 gas diffusers (used with 7400 or 4200 series tips) = 1-3/8"
- D118Q gas diffusers (used with Quik Tips™) = 7/8".
- D114Q gas diffusers (used with Quik Tips™) = 3/4".

File the cut end of liner to eliminate burrs and reinstall insulator cap, gas diffuser, tip and nozzle.

**When Using Jump Liner:** Trim and deburr liner with 1/4" (6.4 mm) extending beyond the gun handle and reinstall neck.

#### Remove Existing Liner

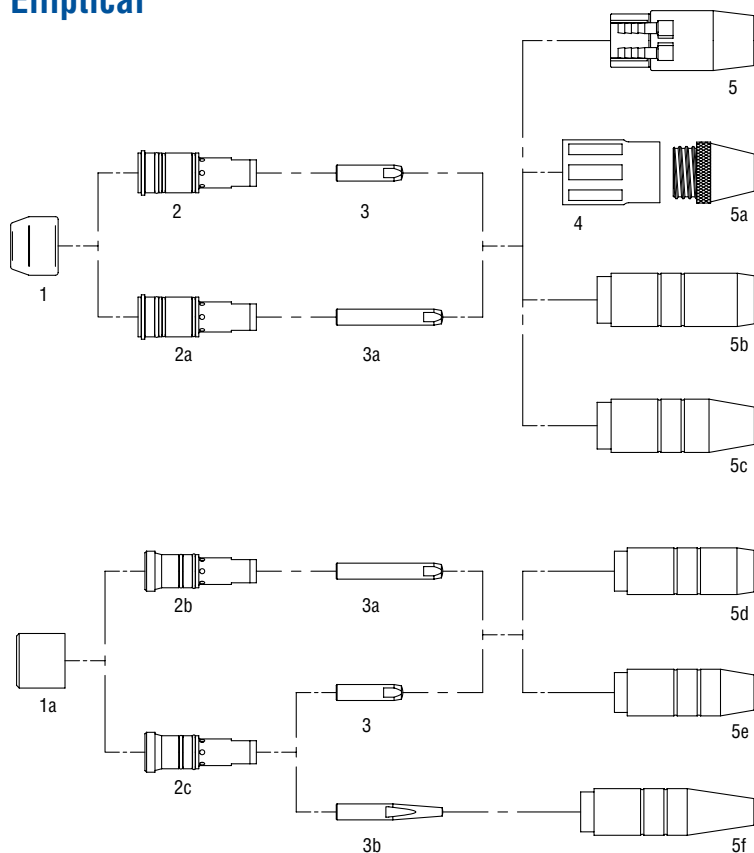
Turn off power. Remove nozzle, tip, gas diffuser and insulator cap (guns with jump liner remove neck). Lay cable straight. Grasp liner lock which protrudes from power pin (some direct plugs may require removal of additional components to access the liner lock) and remove from cable assembly.

#### Service

Inspect for excessive wear and debris on the inside diameter. Do not dip liner in solvents for cleaning. Liner may be periodically blown out with shop air. Replace with new liner when excessive wear or debris produces poor electrode feed.

## Tips / Diffusers / Nozzles

## Elliptical



Item	Part No.	Description	Size			
			Inches	mm		
1	4423R	Cap				
1a	4323R	Cap				
2	4435	Diffuser				
2a	4635	Diffuser				
	4635-116					
2b	4235	Diffuser				
	4235-116					
2c	4335	Diffuser				
	4335-116					
3	7497	Contact tip, 7400 series 	.023	0.6		
	7488		.030	0.8		
	7489		.035	0.9		
	7496		.039	1.0		
	7490		.045	1.2		
	7498		.052	1.4		
	7491		1/16	1.6		
	7492		5/64	2.0		
	7493		3/32	2.4		
	7494		7/64	2.8		
	7495		1/8	3.2		
	3a		1597	Contact tip, 1500 series 	.023	0.6
			1588		.030	0.8
1589		.035	0.9			
1596		.039	1.0			
1590		.045	1.2			
1598		.052	1.4			
1591		1/16	1.6			
1592		5/64	2.0			
1593		3/32	2.4			
1594		7/64	2.8			
3b	4285	Contact tip, 4200 series 	.030	0.8		
	4281		.035	0.9		
	4299		.039	1.0		
	4282		.045	1.2		
	4283		.052	1.4		
4	0036	Nozzle body				
5	1101QD	Nozzle; water cooled, copper	3/4	19.1		
5a	36-50	Nozzle cone	1/2	12.7		
	36-63		5/8	15.9		
	36-75		3/4	19.1		
5b	4491	Nozzle, brass	3/4	19.1		
	4591	Nozzle, copper				
	4591HD	Nozzle, heavy duty				
5c	4491	Nozzle, brass	9/16	14.3		
	4591	Nozzle, copper				
	4591HD	Nozzle, heavy duty				
5d	4391	Nozzle, brass	5/8	15.9		
	4393	Nozzle, copper				
5e	4392	Nozzle, brass	1/2	12.7		
	4394	Nozzle, copper				
5f	4295	Nozzle; tapered, brass	3/8	9.5		

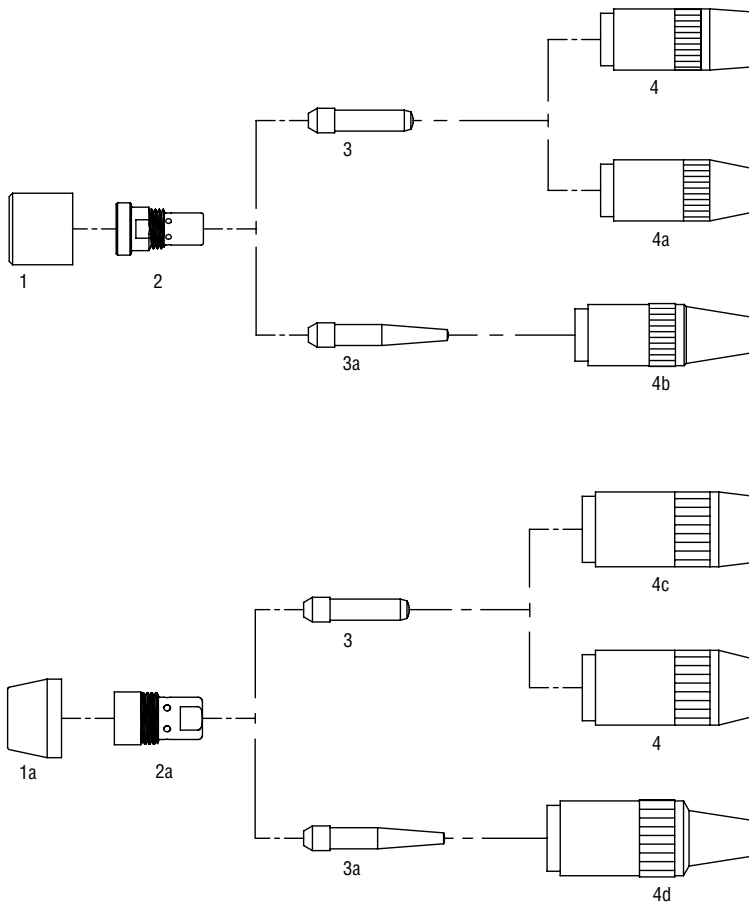
## Centerfire™ Series

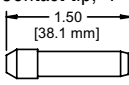
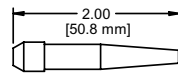
### Centerfire™ Nozzle's Part Number

Use a Centerfire™ nozzle's part number to identify its specifications. The part number below represents a large Centerfire™ nozzle manufactured with 5/8" I.D., 1/8" tip recess and copper.

Nozzle Style	Orifice I.D.	Tip Recess	Material
<b>N</b>	<b>58</b>	<b>18</b>	<b>C</b>
	(i.e. 58 = 5/8")	(i.e. 18 = 1/8")	

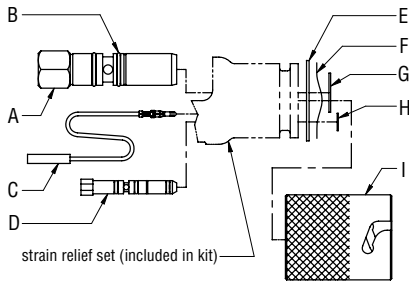
- Available nozzle styles:  
**N** = nozzle large, **NT** = nozzle large tapered, **NS** = nozzle small, **NST** = nozzle small tapered
- Tip recess XT = 1/8" extension beyond end of nozzle
- Available nozzle materials:  
**B** = brass and **C** = copper



Item	Part No.	Description	Size	
			Inches	mm
1	4323R	Cap		
1a	10012	Cap		
2	DS-1	Diffuser		
2a	D-1	Diffuser		
3	T-023	Contact tip, 'T' series 	.023	0.6
	T-030		.030	0.8
	T-035		.035	0.9
	T-039		.039	1.0
	T-045		.045	1.2
	T-052		.052	1.4
	T-062		1/16	1.6
	T-078		5/64	2.0
	T-094		3/32	2.4
	T-109		7/64	2.8
	T-125		1/8	3.2
	3a		TT-023	Contact tip, 'TT' series 
TT-030		.030	0.8	
TT-035		.035	0.9	
TT-039		.039	1.0	
TT-045		.045	1.2	
TT-052		.052	1.4	
TT-062		1/16	1.6	
4	NS-5800C	Nozzle, 5/8" I.D., flush, copper		
	NS-5818C	Nozzle, 5/8" I.D., 1/8" recess, copper		
	NS-5814C	Nozzle, 5/8" I.D., 1/4" recess, copper		
	NS-5800B	Nozzle, 5/8" I.D., flush, brass		
	NS-5818B	Nozzle, 5/8" I.D., 1/8" recess, brass		
	NS-5814B	Nozzle, 5/8" I.D., 1/4" recess, brass		
4a	NS-1218C	Nozzle, 1/2" I.D., 1/8" recess, copper		
	NS-1200B	Nozzle, 1/2" I.D., flush, brass		
	NS-1218B	Nozzle, 1/2" I.D., 1/8" recess, brass		
4b	NST-3800B	Nozzle, 3/8" I.D., flush, brass		
	NST-3818B	Nozzle, 3/8" I.D., 1/8" recess, brass		
	NST-38XTB	Nozzle, 3/8" I.D., 1/8" extension, brass		
4c	N-3400C	Nozzle, 3/4" I.D., flush, copper		
	N-3418C	Nozzle, 3/4" I.D., 1/8" recess, copper		
	N-3414C	Nozzle, 3/4" I.D., 1/4" recess, copper		
	N-3400B	Nozzle, 3/4" I.D., flush, brass		
	N-3418B	Nozzle, 3/4" I.D., 1/8" recess, brass		
	N-3414B	Nozzle, 3/4" I.D., 1/4" recess, brass		
4d	N-5800C	Nozzle, 5/8" I.D., flush, copper		
	N-5818C	Nozzle, 5/8" I.D., 1/8" recess, copper		
	N-5814C	Nozzle, 5/8" I.D., 1/4" recess, copper		
	N-5800B	Nozzle, 5/8" I.D., flush, brass		
	N-5818B	Nozzle, 5/8" I.D., 1/8" recess, brass		
4e	N-5814B	Nozzle, 5/8" I.D., 1/4" recess, brass		
	NT-3800C	Nozzle, 3/8" I.D., flush, copper		

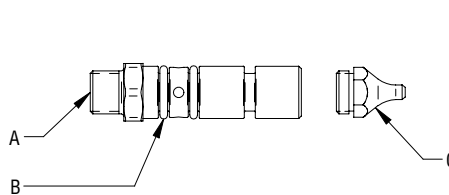
## Available Direct Plug Kits & Replacement Parts

### Bernard® Quick Disconnect Kit


**Part No. 1199**

Item	Part No.	Description
A	2200008	Power pin assembly
B	4929	O-Ring (2 required)
C	4924	Lead wire (2 required)
D	2060033	Gas pin assembly
E	4911	Snap ring, large
F	4916	Wave ring
G	4912	Snap ring, medium
H	2250016	Snap ring, small
I	4925	Locking sleeve

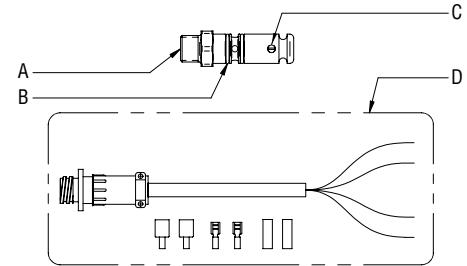
### Miller® Direct Plug Kit


**Part No. 1199M**

Item	Part No.	Description
A	2200101	Power pin assembly
B	4478	O-Ring (2 required)
C	4477	Power pin tip (.023" - .045")
	4474	Power pin tip (3/32" - 1/8")
	4477-564	Power pin tip (.052" - 5/64")*
Power Pin Tips for Aluminum Wire		
C	2200105	Power pin tip (.030" - .035")*
	2200106	Power pin tip (.040" - 3/64")*
	2200107	Power pin tip (.052" - 1/16")*

\*Optional

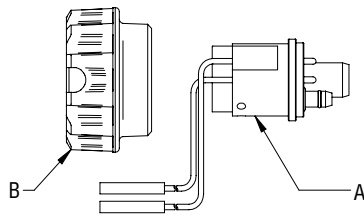
### Tweco® 4/5 Direct Plug Kits


**Part No. 1199T4-** Tweco® 4 Direct Plug Kit  
**Part No. 1199T5-** Tweco® 5 Direct Plug Kit

Item	Part No.	Description
A	2200103	Power pin assembly (Tweco® 4)
	2200104	Power pin assembly (Tweco® 5)
B	4713	O-Ring (2 required - Tweco® 4)
	4929	O-Ring (2 required - Tweco® 5)
C	4714	Set screw
D	SCT1N	Trigger cable adapter
	SCL1N	Trigger cable adapter, Lincoln*
	SCX1N	Trigger cable adapter, ESAB*

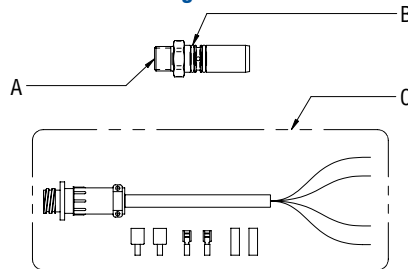
\*Optional

### Euro Direct Plug Kit


**Part No. 1199E**

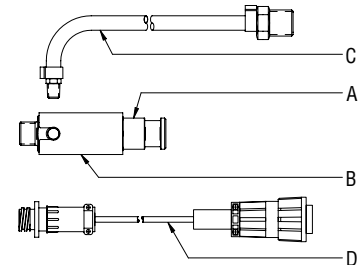
Item	Part No.	Description
A	5060	Euro block assembly
B	4816	Adaptor nut

### Hobart® Direct Plug Kit


**Part No. 1199H**

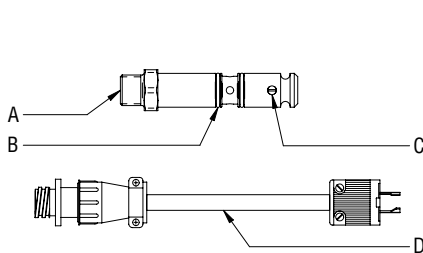
Item	Part No.	Description
A	2200098	Power pin assembly
B	4713	O-ring (2 required)
C	SCT1N	Trigger cable adapter

### Lincoln® Direct Plug Kit


**Part No. 1199L**

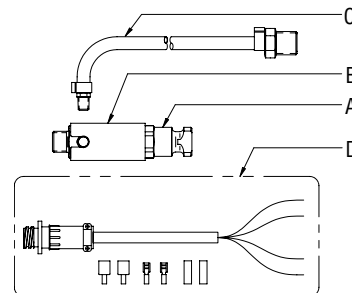
Item	Part No.	Description
A	2200099	Power pin
B	1840059	Insulator
C	GLM1	Gas line assembly
D	SCL1N	Trigger cable adapter

### L-Tec Direct Plug Kit


**Part No. 1199LT**

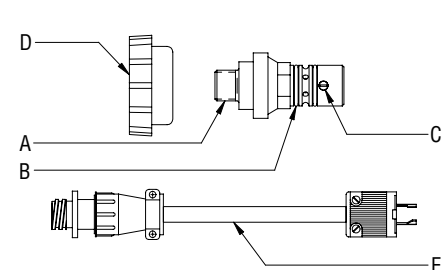
Item	Part No.	Description
A	2200100	Power pin assembly
B	4713	O-Ring (2 required)
C	4714	Set screw
D	SCX1N	Trigger cable adapter

### National Direct Plug Kit


**Part No. 1199N**

Item	Part No.	Description
A	2200102	Power pin
B	1840059	Insulator
C	GLM1	Gas line assembly
D	SCT1N	Trigger cable adapter

### OXO® Direct Plug Kit


**Part No. 1199X**

Item	Part No.	Description
A	2200108	Power pin assembly
B	4929	O-Ring (2 required)
C	4714	Set screw
D	6234	Adaptor nut
E	SCX1N	Trigger cable adapter

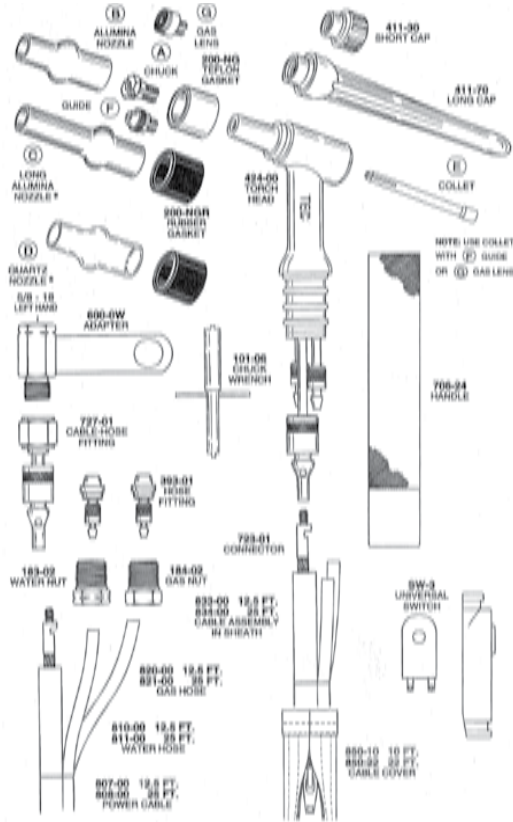
## Water Cooled TIG Torches

### Model 424: 500 Amp Torch

- Silicone rubber insulation.
- Rainbow, color-coded, sheath protected hoses, connect and disconnect without tools.
- Tapered design—no gaskets, insulators or seals.
- 100% continuous duty cycle, DC straight polarity.
- “Lectro-Lock” instant backcap for releasing of electrodes.
- Accommodates 3" - 7" (75-180 mm) electrode length.
- Uses alumina ceramic or clear glass nozzles.
- Electrode size: .020" - 3/16".
- Has replaceable Teflon® nozzle gasket.
- Gas lens is available.

Part No. 424-12- 12' Torch Assembly

Part No. 424-25- 25' Torch Assembly



#### A. Chucks

Part No.	I.D. (inches)	I.D. mm
220-05	.020"	0.5
220-00	.040"	1.0
221-00	1/16"	1.6
222-00	3/32"	2.4
223-00	1/8"	3.2
224-00	5/32"	4.0
225-00	3/16"	4.8

#### B. Alumina Nozzles

Part No.	Size	I.D. (inches)
130-00	#4	1/4"
131-00	#5	5/16"
132-00	#6	3/8"
133-00	#7	7/16"
134-00	#8	1/2"
135-00	#9	9/16"
136-00	#10	5/8"

#### C. Long Alumina Nozzles\*

Part No.	Size	I.D. (inches)
130-07	#4L	1/4"
131-07	#5L	5/16"
132-07	#6L	3/8"
133-07	#7L	7/16"

#### D. Quartz Nozzles (Glass-Vycor)\*

Part No.	Size	I.D. (inches)
150-00	#4	1/4"
151-00	#5	5/16"
152-00	#6	3/8"
153-00	#7	7/16"
154-00	#8	1/2"

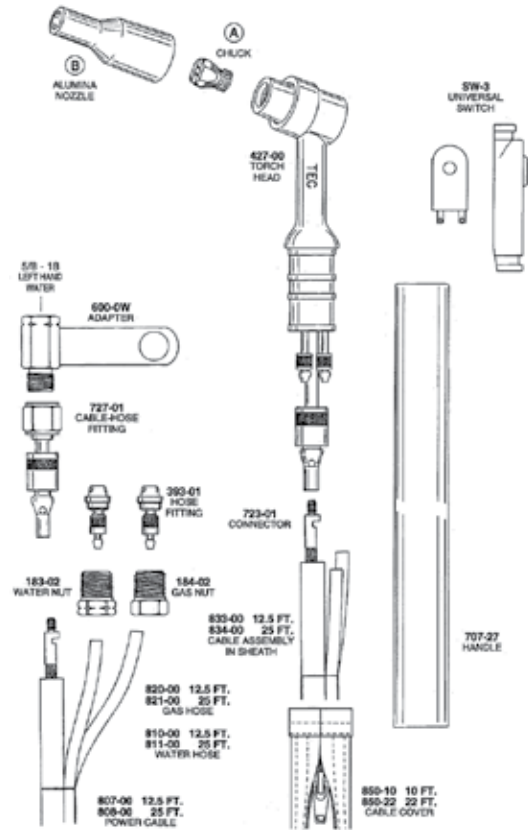
\* Requires 200-NGR Gasket

### Model 427: 650 Amp Torch

- Silicone rubber insulation.
- Extended handle to protect hand from reflected heat.
- Rainbow, color-coded, sheath protected hoses, connect and disconnect without tools.
- Tapered design—no gaskets, insulators or seals.
- 100% continuous duty cycle, DC straight polarity.
- Positive front locking of electrode.
- Accommodates 2-1/2" electrode.
- Uses alumina ceramic nozzles.
- Electrode size: 1/8" - 5/16"

Part No. 427-12- 12' Torch Assembly

Part No. 427-25- 25' Torch Assembly



#### A. Chucks

Part No.	I.D. (inches)	I.D. mm
223-07	1/8"	3.2
224-07	5/32"	4.0
225-07	3/16"	4.8
226-07	1/4"	6.4
227-07	5/16"	8.0

#### B. Alumina Nozzles

Part No.	Size	I.D. (inches)
141-00	#5	5/16"
142-00	#6	3/8"
143-00	#7	7/16"
144-00	#8	1/2"
145-00	#10	5/8"

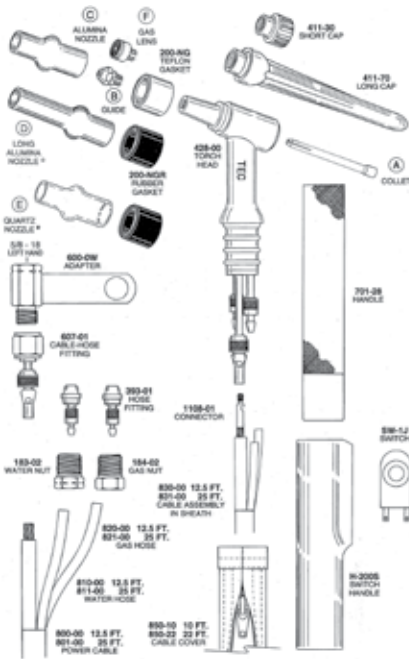
## Water Cooled TIG Torches

### Model 428: 350 Amp Torch

- Color-coded, sheath protected hoses connects and disconnects without tools.
- "Lectro-Lock" instant backcap lock for releasing of electrodes.
- Silicone rubber insulation.
- Accommodates 3" to 7" electrode length.
- 100% continuous duty cycle, DC straight polarity.
- Uses alumina ceramic or clear glass nozzles.
- Has replaceable Teflon® nozzle gasket.
- Gas lens available.
- Electrode size: .020" - 5/32".

Part No. 428-12- 12' Torch Assembly

Part No. 428-25- 25' Torch Assembly



#### A. Collets

Part No.	I.D. (inches)	I.D. mm
962-01	.020"	0.5
964-01	.040"	1.0
965-01	1/16"	1.6
966-01	3/32"	2.4
967-01	1/8"	3.2
968-01	5/32"	4.0

#### B. Guides

Part No.	I.D. (inches)	I.D. mm
961-21	.020"	0.5
961-41	.040"	1.0
961-51	1/16"	1.6
961-61	3/32"	2.4
961-71	1/8"	3.2
961-81	5/32"	4.0

#### C. Alumina Nozzles

Part No.	Size	I.D. (inches)
130-00	#4	1/4"
131-00	#5	5/16"
132-00	#6	3/8"
133-00	#7	7/16"
134-00	#8	1/2"
135-00	#9	9/16"
136-00	#10	5/8"

#### D. Long Alumina Nozzles\*

Part No.	Size	I.D. (inches)
130-07	#4L	1/4"
131-07	#5L	5/16"
132-07	#6L	3/8"
133-07	#7L	7/16"

#### E. Quartz Nozzles (Glass - Vycor)\*

Part No.	Size	I.D. (inches)
150-00	#4	1/4"
151-00	#5	5/16"
152-00	#6	3/8"
153-00	#7	7/16"
154-00	#8	1/2"

#### F. Gas Lens Guide

Part No.	I.D. (inches)	I.D. mm
950-21	.020"	0.5
950-41	.040"	1.0
950-51	1/16"	1.6
950-61	3/32"	2.4
950-71	1/8"	3.2

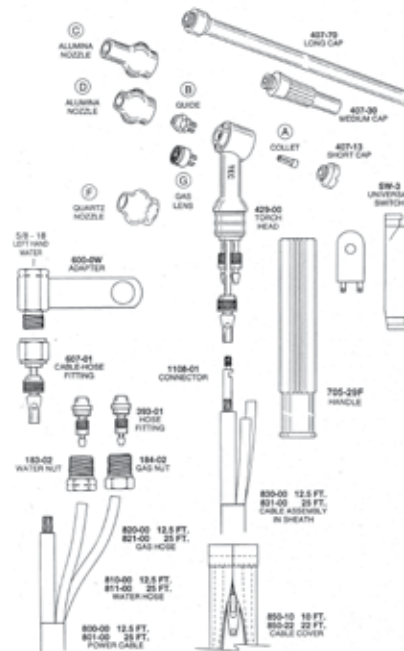
\* Requires 200-NGR Gasket

### Model 429: 300 Amp Torch

- Silicone rubber insulation.
- Rainbow, color-coded, sheath protected hoses, connect and disconnect without tools.
- Tapered design—no gaskets, insulators or seals.
- 100% continuous duty cycle, DC straight polarity.
- Lectro-lock instant backcap for releasing of electrodes.
- Accommodates 3" - 7" electrode length.
- Uses alumina ceramic or clear glass nozzles.
- Gas lens available.
- Electrode size: .020" - 1/8".

Part No. 429-12- 12' Torch Assembly

Part No. 429-25- 25' Torch Assembly



#### A. Collets

Part No.	I.D. (inches)	I.D. mm
104-421	.020"	0.5
104-441	.040"	1.0
104-451	1/16"	1.6
104-461	3/32"	2.4
104-471	1/8"	3.2

#### B. Guides

Part No.	I.D. (inches)	I.D. mm
961-21	.020"	0.5
961-41	.040"	1.0
961-51	1/16"	1.6
961-61	3/32"	2.4
961-71	1/8"	3.2

#### C. Alumina Nozzles

Part No.	Size	I.D. (inches)
130-11	#4	1/4"
131-11	#5	5/16"
132-11	#6	3/8"
133-11	#7	7/16"

#### D. Alumina Nozzles-Short

Part No.	Size	I.D. (inches)
130-01	#4	1/4"
131-01	#5	5/16"
132-01	#6	3/8"
133-01	#7	7/16"

#### F. Quartz Nozzles-Short (Glass - Vycor)

Part No.	Size	I.D. (inches)
150-01	#4	1/4"
151-01	#5	5/16"
152-01	#6	3/8"
153-01	#7	7/16"

#### G. Gas Lens Guides

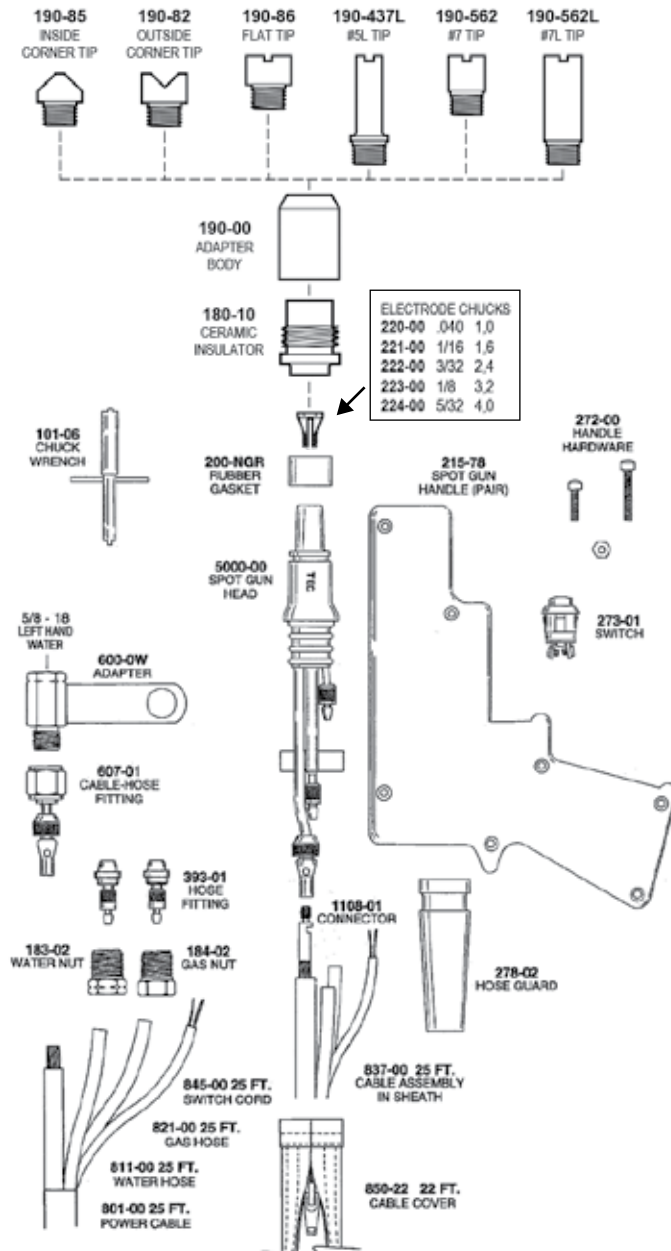
Part No.	I.D. (inches)	I.D. mm
950-21	.020"	0.5
950-41	.040"	1.0
950-51	1/16"	1.6
950-61	3/32"	2.4
950-71	1/8"	3.2

## TIG Spot Guns

### Model 5000: 430 Amp Water Cooled TIG Spot Gun

- Production spot gun.
- Operates up to 430 Amps on DC straight polarity.
- Will spot weld such materials as mild steel, stainless steel, Monel and Inconel in the thickness of 1/8" or less from one side.
- Constructed of durable, long lasting materials.
- Locators or tips are available for tacking inside or outside corners, flanges, butt, lap, "T" joints.
- Accommodates .040" - 5/32" electrodes.
- Electrode lengths 3" and 6"

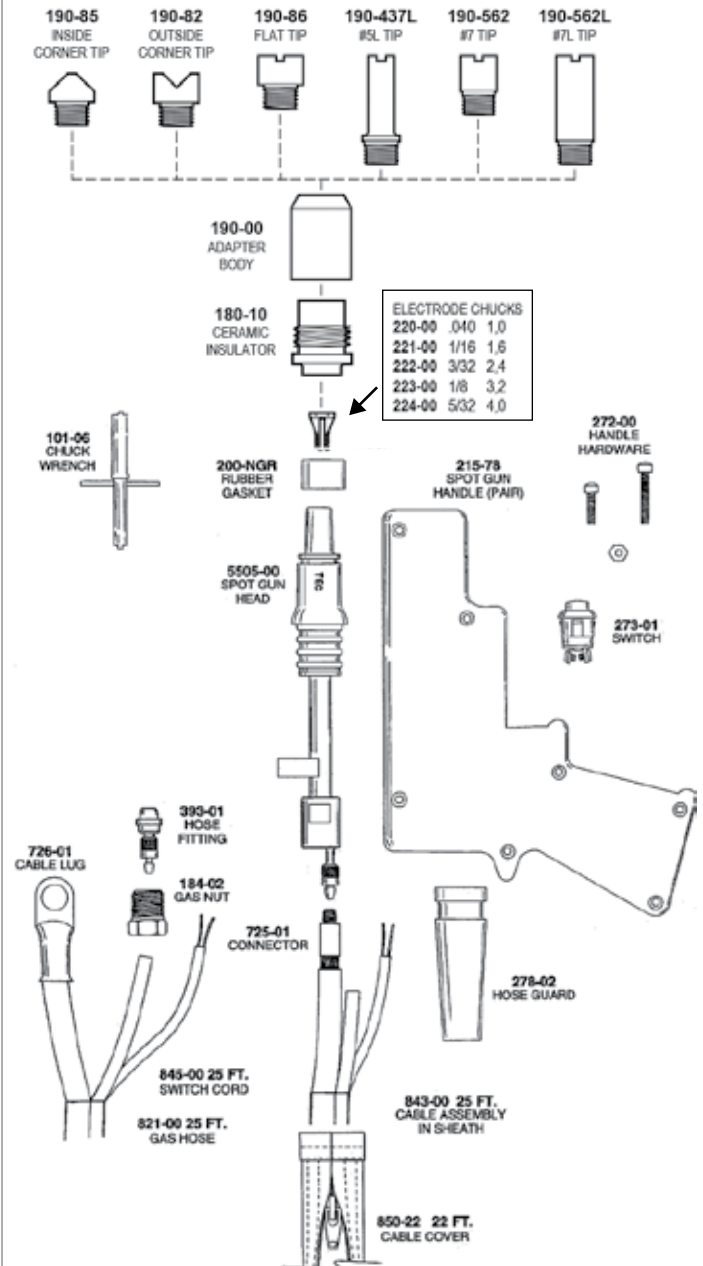
Part No. 5000- 25' Torch Assembly



### Model 5505: 200 Amp Air Cooled TIG Spot Gun

- Light duty spot gun.
- Operates up to 200 Amps on DC straight polarity.
- Will spot weld such materials as mild steel, stainless steel, Monel and Inconel in the thickness of 1/8" or less from one side.
- Constructed of durable, long lasting materials.
- Locators or tips are available for tacking inside or outside corners, flanges, butt, lap "T" joints.
- Accommodates .040" - 5/32" electrodes.
- Electrode lengths 3" and 6"

Part No. 5505- 25' Torch Assembly



## General MIG Gun Information / FABGUN™ Air-Cooled MIG Gun

Tweco® offers a full line of MIG guns for a variety of welding applications; ranging in amperages from 160 to 600 for semi-automatic and fully automatic applications. Tweco® guns handle wire sizes from .023 to 5/64" in the lower-to-mid range and .035 to 1/8" in the mid-to-higher range. All guns are rated for welding applications with CO<sub>2</sub>; amperages may be reduced with mixed gases. There are many variables that will determine actual mixed gas rating.

Available in 10 ft. (3.05m), 12 ft. (3.66m) and 15 ft. (4.60m), Tweco® MIG guns are equipped with 60° conductor tubes as standard.

Tweco® "quality" MIG guns set the standards for which you have come to expect:

- All Tweco® MIG Guns are equipped with genuine Tweco® consumables with threaded connections and are fully assembled, factory tested and ready to hook-up and run.
- Wire Conduits offer a maximum welding columnar strength, thus reducing to a minimum the wave in the wire, producing smooth feeding and eliminating stubbing action at the arc.
- Tweco® Cablehoz® Assemblies are highly flexible with copper conductor strands, control wires and gas hose combined into one coaxial unit which is strong, lightweight and easy to handle.
- The fully insulated Tweco® MIG-Kwik Connection allows quick connect/disconnect at the wire feeder. Only seconds are required to plug in or unplug into the unit. This eliminates down time as easy replacements can be made in seconds.
- Rear plug connections are designed for compatibility with Lincoln®, Miller® and European wire feed connections and to many other wire feeders used worldwide.
- Tweco® is ISO 9001 certified and manufactures its products to the strict quality standards set for ISO registered companies.



Tweco® Spraymaster™ Air Cooled MIG Gun in use.

## FABGUN™ 250 AMP Air-Cooled MIG Gun

- 60% duty cycle, CO<sub>2</sub> gas.
- Simple, reliable gun construction with fewer parts to simplify maintenance.
- Easy gun selection with only three MIG gun models for use on many major manufacturers' welding systems.
- A convenient color-coded selection guide that makes it easy to match the right FABGUN™ model to the power supply system they're using.
- Lightweight, ergonomic handle for more comfort and reduced fatigue.
- Standard Tweco® consumables readily available.
- Genuine Tweco® quality and reliability at an attractive, highly competitive price.



### 250 AMP Rear Connection Style

Wire Size	Cable Length	Tweco®	Miller®	Lincoln®	Euro-Kwik®
.045	12'	FAB250T-12	FAB250M-12	FAB250L-12	
1.2 mm	4 m	1020-1550	1020-1551	1020-1552	

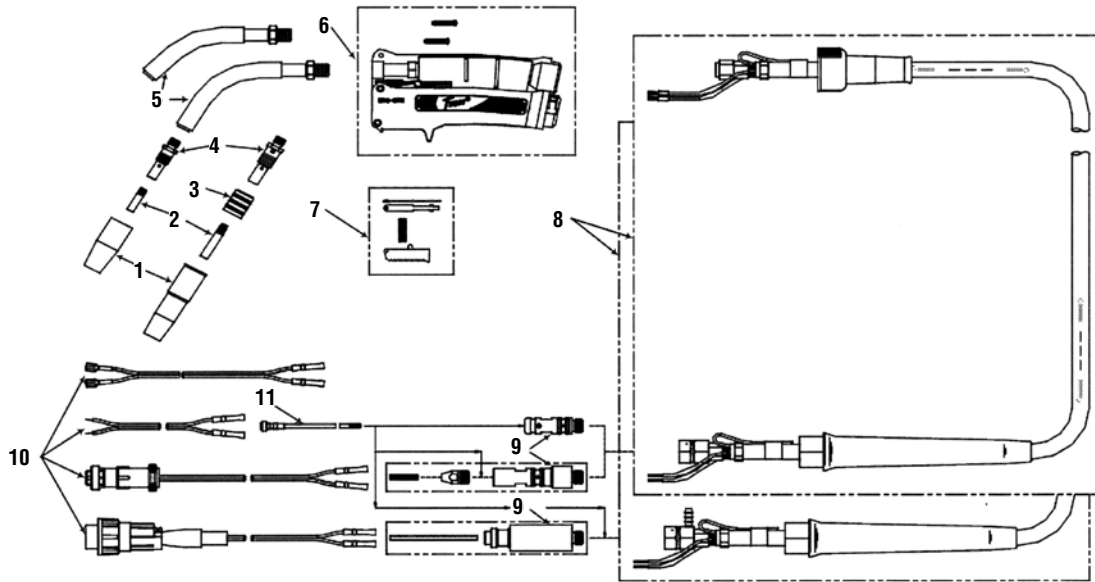
\* May require adaptor plug for some feeders

## Specific Welding System Compatibility

Miller® Electric		Thermal Arc / ESAB® / Lincoln®	
FAB250M-12	1020-1551	FAB250T-12	1020-1550
Millermatic 135		THERMAL ARC	
Millermatic 175		Fabricator 210	
Millermatic 210		Fabricator 250	
Millermatic Pulser		ESAB®	
Millermatic Vintage		Multimaster260	
Millermatic 251		LINCOLN®	
Millermatic 300		SP150	
Cricket		SP100	
Millermatic 90		SP130	
Millermatic 120		Weldpac 150	
Millermatic 130		SP135T	
Millermatic 150		SP135 Plus	
Millermatic 200		SP175	
Millermatic 35 (1980 & newer)		SP175 Plus	
Millermatic 250		Power Mig 200	
Millermatic 185		Power Mig 255	
Porta-Mig		Wirematic 250	
		Wirematic 255 (except digital)	

Lincoln®	
FAB250L-12	1020-1552
SP200	





### Consumables

(1) Nozzles					(3) Insulator	(5) Conductor Tubes	
Bore Size	3/8" / 9.5 mm	3/8" / 9.5 mm	1/2" / 12.7 mm	5/8" / 15.9 mm		60°	45°
21 Series Flush	21T-37 1210-1300	21-37 1210-1110	21-50 1210-1110	21-62 1210-1120	32 1320-1100	FAB62-60 1620-1320	FAB62-45 1620-1321
	21T-37F 1210-1302	21-37F 1210-1102	21-50F 1210-1112	21-62F 1210-1122			
22 Series Short Stop			22-50 1220-1110	22-62 1220-1120			
	22T-37-SS 1220-1301	22-37-SS 1220-1101	22-50-SS 1220-1111	22-62-SS 1220-1121			

(2) Contact Tips							(4) Diffuser
Wire Size	.023" / 0.6 mm	.030" / 0.8 mm	.035" / 0.9 mm	.040" / 1.0 mm	.045" / 1.2 mm	3/64" AL / 1.2 mm	
Tip I.D.	.031" / 0.79 mm	.038" / 0.97 mm	.044" / 1.12 mm	.048" / 1.22 mm	.054" / 1.37 mm	.059" / 1.50 mm	
11 Series Heavy Duty Tapered	11-23 1110-1100	11-30 1110-1101	11-35 1110-1102	11-40 1110-1103	11-45 1110-1104		35-50 1500-1100
		11H-30 1110-1201	11H-35 1110-1202	11H-40 110-1203	11H-45 110-1204	11AH-364 1110-1213	For Aluminum 35-50A 1500-1101
	11T-23 1110-1300	11T-30 1110-1301	11T-35 1110-1302	11T-40 1110-1303	11T-45 1110-1304		
14 Series Heavy Duty Tapered	14-23 1140-1100	14-30 1140-1101	14-35 1140-1102	14-40 1140-1103	14-45 1140-1104	14A-364 1140-1113	FAB52 1520-1120
			14H-35 1140-1202	14H-40 1140-1203	14H-45 1140-1204	14AH-364 1140-1213	
	14T-23 1140-1300	14T-30 1140-1301	14T-35 1140-1302	14T-40 1140-1303	14T-45 1140-1304		

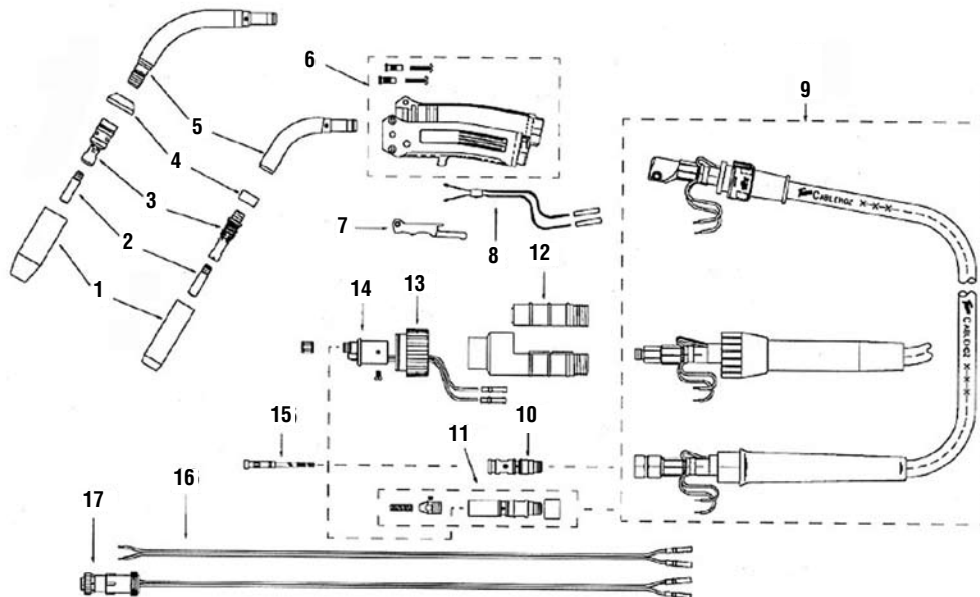
### Other Parts

No.	Description	Part No.	Model No.
6	Handle assembly & screws	FAB82	2020-2200
7	Switch assembly	FAB92	2020-2205
8	Replacement cable	FAB250C12	1720-2150
8	Replacement cable (Lincoln® plug)	FAB250C12L	1720-2151
9	Tweco® wire guide plug	35K-174C	2000-2169
9	Miller® wire guide plug	170M	2000-2810
9	Lincoln® wire guide	TLAK352	2641-2030

No.	Description	Part No.	Model No.
10	Thermal Arc control wire	MS354-IT	2060-2136
10	Generic control wire	35K-350-1	2000-2352
10	Miller® control wire	WM354-M	2030-2075
10	Lincoln® control wire	35SP-354	2000-2354
11	Conduit for .023" (0.6 mm) wire	23-40-15	1400-1123
11	Conduit for .035" (0.9 mm) wire	35-40-15	1400-1133
11	Conduit for .045" (1.2 mm) wire	45-40-15	1400-1143

## Spraymaster™ Air Cooled MIG Gun

### Spray Master™ Air-Cooled MIG Gun



No.	250 AMP	350 AMP	450 AMP	Description
1	Nozzles (not shown)			
2	Contact Tips (not shown)			
3	HD52-11 1520-1130	EL52CT-16 1560-1107	HD54-16 1540-1136	Diffuser (standard)
3A	HD52-23-11 1520-1131			Diffuser (optional) .023 / 0.6 mm wire
4	63J-3 1630-1121	63J-3 1630-1121	66J-3 1660-1836	Insulator assembly ELC250 & ELC350
5	MS63-60S 1630-1196	MS63-60S 1630-1196	MS64H-60 1640-1319	Conductor tube
5	MS63-45S 1630-1195	MS63-45S 1630-1195	MS64H-45 1640-1318	Conductor tube (Standard on 25 guns only)
6	MS84 2060-2130	MS84 2060-2130	MS84 2060-2130	Handle w/screws
6A	152 2020-2152	152 2020-2152	152 2020-2152	Gun hanger (not shown)
7	ELC94 2060-2647	ELC94 2060-2647	ELC94 2060-2647	Trigger
7A	ELC96L 2060-2654	ELC96L 2060-2654	ELC96L 2060-2654	Locking trigger (not shown)
7B	DS96TB 2060-2654	DS96TB 2060-2654	DS96TB 2060-2654	Dual schedule trigger assembly (not shown)
8	ELC96B 2060-2606	ELC96B 2060-2606	ELC96B 2060-2606	Trigger blade assembly
9	MS210 1720-2115	MS310 1730-2035	MS410 1740-2115	Cablehoz assembly 10 / 3 m
9	MS212 1720-2116	MS312 1730-2036	MS412 1740-2116	Cablehoz assembly 12 / 3 m
9	MS215 1720-2117	MS315 1730-2037	MS415 1740-2117	Cablehoz assembly 15 / 3 m

No.	250 AMP	350 AMP	450 AMP	Description
9	MS225 1720-2118	MS325 1730-2038	MS425 1740-2118	Cablehoz assembly 25 / 3 m
9A	MS210X 1720-2106	MS310X 1730-2010	MS410X 1740-2121	Cablehoz assembly Euro-Kwik® 10 / 3 m
9A	MS212X 1720-2107	MS312X 1730-2011	MS412X 1740-2122	Cablehoz assembly, Euro-Kwik® 12 / 3 m
9A	MS215X 1720-2108	MS315X 1730-2012	MS415X 1740-2123	Cablehoz assembly, Euro-Kwik® 15 / 3 m
9A	MS225X 1720-2109	MS325X 1730-2013	MS425X 1740-2124	Cablehoz assembly, Euro-Kwik® 25 / 3 m
10	350-174H 2035-2110	350-174H 2035-2110	350-174H 2035-2110	Tweco® connector plug
11	350-174MH 2035-2111	350-174MH 2035-2111	350-174MH 2035-2111	Miller® connector plug
12	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006	Euro-Kwik® connector case
13	174X-2 2040-2177	174X-2 2040-2177	174X-2 2040-2177	Euro-Kwik® nut
14	174EX-1 2040-2276	174EX-1 2040-2276	174EX-1 2040-2276	Euro-Kwik® connection assembly
15	Not Shown			Conduit
16	35K-350-1 2000-2352	35K-350-1 2000-2352	35K-350-1 2000-2352	Tweco® control wire
17	WM-354M 2030-2075	WM-354M 2030-2075	WM-354M 2030-2075	Tweco® control wire & plug
Not Shown	194DS 2040-2195	194DS 2040-2195	194DS 2040-2195	Dual schedule control wire & plug

## Spraymaster™ Air Cooled MIG Gun

### 250 AMP Gun Assemblies



Part No.	Model No.	Description
<b>With Tweco® Rear Connections</b>		
MS210-3545	1023-1100	.035 - .045" 0.9-1.2 mm 10' / 3 m cable
MS212-3545	1023-1101	.035 - .045" 0.9-1.2 mm 12' / 4 m cable
MS215-3545	1023-1102	.035 - .045" 0.9-1.2 mm 15' / 5 m cable
MS225-3545	1023-1108	.035 - .045" 0.9-1.2 mm 25' / 8 m cable
<b>With Miller® Rear Connections</b>		
MS210M-3545	1023-1110	.035" - .045" 0.9-1.2 mm 10' / 3 m cable
MS212M-3545	1023-1111	.035" - .045" 0.9-1.2 mm 12' / 4 m cable
MS215M-3545	1023-1112	.035" - .045" 0.9-1.2 mm 15' / 5 m cable
MS225M-3545	1023-1118	.035" - .045" 0.9-1.2 mm 25' / 8 m cable
<b>With Euro-Kwik® Rear Connections</b>		
MS210X-3545	1023-1125	.035" - .045" 0.9-1.2 mm 10' / 3 m cable
MS212X-3545	1023-1126	.035" - .045" 0.9-1.2 mm 12' / 4 m cable
MS215X-3545	1023-1127	.035" - .045" 0.9-1.2 mm 15' / 5 m cable
MS225X-3545	1023-1133	.035" - .045" 0.9-1.2 mm 25' / 8 m cable

### 350 AMP Gun Assemblies

Description	Part No.	Model No.	Part No.	Model No.
<b>With Tweco® Rear Connections</b>				
.045" - 1/16" 1.2-1.6 mm 10' / 3 m cable	MS310-116	1036-1610	MS410-116	1040-1050
.045" - 1/16" 1.2-1.6 mm 12' / 4 m cable	MS312-116	1036-1613	MS412-116	1040-1051
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable	MS315-116	1036-1615	MS415-116	1040-1052
.045" - 1/16" 1.2-1.6 mm 25' / 8 m cable	MS325-116	1036-1616	MS425-116	1040-1058
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable*	MS315-116LC	1036-1627	MS415-116LC	1040-1090
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable**	MS315-116DS	1036-1631	MS415-116DS	1040-1095
<b>With Miller® Rear Connections</b>				
.045" - 1/16" 1.2-1.6 mm 10' / 3 m cable	MS310M-116	1036-1635	MS410M-116	1040-1060
.045" - 1/16" 1.2-1.6 mm 12' / 4 m cable	MS312M-116	1036-1638	MS412M-116	1040-1061
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable	MS315M-116	1036-1640	MS415M-116	1040-1062
.045" - 1/16" 1.2-1.6 mm 25' / 8 m cable	MS325M-116	1036-1642	MS425M-116	1040-1068
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable*	MS315-116LC	1036-1629	MS415-116LC	1040-1092
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable**	MS315-116DS	1036-1633		
<b>With Euro-Kwik® Rear Connections</b>				
.045" - 1/16" 1.2-1.6 mm 10' / 3 m cable	MS310X-116	1036-1618	MS410X-116	1040-1075
.045" - 1/16" 1.2-1.6 mm 12' / 4 m cable	MS312X-116	1036-1621	MS412X-116	1040-1076
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable	MS315X-116	1036-1623	MS415X-116	1040-1077
.045" - 1/16" 1.2-1.6 mm 25' / 8 m cable	MS325X-116	1036-1620	MS425X-116	1040-1083
.045" - 1/16" 1.2-1.6 mm 15' / 5 m cable*	MS315X-116LC	1036-1628	MS415X-116LC	1040-1091

\* w/locking trigger  
\*\* w/ dual schedule trigger

## Spraymaster™ Consumables

### Nozzles



### 350 AMP Guns

Fits Diffuser EL52CT-16 (1560-1107)

Nozzle Style	3/8" 9.5 mm bore	1/2" 12.7 mm bore	5/8" 15.9 mm bore	3/4" 19.1 mm bore
Standard CT type (1/8" tip recess)	EL-22CT-37 1260-1625	EL22CT-50 1260-1626	EL22CT-62 1260-1627	EL22CT-75 1260-1628
Optional CT type (tip flush)		EL22CT-50F 1260-1636	EL22CT-62F 1260-1637	
Optional CT type (tip protruded)		EL22CT-50P 1260-1691	EL22CT-62P 1260-1692	EL22CT-75P 1260-1693
Optional CT type (heavy duty)			EL22CT-62H 1260-1629	
Optional ARC spot nozzles (flat arc spot)			EL221-62FAS 1260-1605	

\* 350 AMP guns ship w/ standard 5/8" / 15.9 mm bore nozzle EL22CT-62

### 250 AMP Guns

Fits Diffuser HD52-11 (1520-1130)

Nozzle Style	3/8" 9.5 mm bore	1/2" 12.7 mm bore	5/8" 15.9 mm bore
Standard slip-on type (1/8" tip recess)	HD22-37 1220-1305	HD22-50 1220-1306	HD22-62 1220-1307
Optional slip-on type (tip flush)	HD22-37F 1220-1310	HD22-50F 1220-1311	HD22-62F 1220-1312

\* 250 AMP guns ship w/ standard 1/2 / 12.7 mm bore nozzle HD22-50

### 450 AMP Guns

Fits Diffuser HD54-16 (1540-1136)

Nozzle Style	1/2" 12.7 mm bore	5/8" 15.9 mm bore	3/4" 19.1 mm bore
Standard slip-on type (1/8" tip recess)	HD24L-50 1240-1200	HD24L-62 1240-1201	HD24L-75 1240-1202
Optional slip-on type (tip flush)	HD24L-50F 1240-1204	HD24L-62F 1240-1205	HD24L-75F 1240-1206
Optional slip-on type (1/8" tip recess) heavy duty	HD24-50 1240-1240	HD24-62 1240-1241	HD24-75 1240-1242
Optional slip-on type (tip flush) heavy duty	HD24-50F 1240-1235	HD24-62F 1240-1236	HD24-75F 1240-1237

### Contact Tips

Wire Size In. / Metric	Tip I.D. In. / Metric	250 AMP	350 & 450 AMP
.023" 0.6 mm	.031" 0.79 mm	11-23 1110-1100	
.030" 0.8 mm	.038" 0.97 mm	11H-30 1110-1201	
.035" 0.9 mm	.044" 1.12 mm	11H-35 1110-1202	16S-35 1160-1102
.040" 1.0 mm	.048" 1.22 mm	11H-40 1110-1203	16S-40 1160-1103
.045" 1.2 mm	.054" 1.37 mm	11H-45 1110-1204	16S-45 1160-1104
.052" 1.3 mm	.064" 1.65 mm		16S-52 1160-1105
1/16" 1.6 mm	.073" 1.85 mm		16S-116 1160-1106
5/64" 2.0 mm	.090" 2.29 mm		16S-564 1160-1109
3/64" AL 1.2 mm	.059" 1.50 mm	11AH-364 1110-1213	16AS-364 1160-1113
1/16" AL 1.6 mm	.082" 2.08 mm		16AS-116 1160-1114

### Conduit

Wire Size In. / Metric	250 AMP	Wire Size In. / Metric	350 & 450 AMP
<b>For Use With Steel Wire</b>			
.023" 0.6 mm	42-23-15 1420-1103	.035" / .045" 0.9 / 1.2 mm	44-3545-15 1440-1103
.030" / .035" 0.8 / 0.9 mm	42-3035-15 1420-1113	.052" / 1/16" 1.3 / 1.6 mm	44-116-15 1440-1113
.040" / .045" 1.0 / 1.2 mm	42-4045-15 1420-1123	5/64" 2.0 mm	44-564-15 1440-1123
<b>For Use With Aluminum Wire</b>			
.035" / 3/64" 0.9 / 1.2 mm	42N-3545-15 1420-1003	.030" / 3/64" 0.8" / 1.2 mm	44N-3545-15 1440-1003

## Mini MIG & No. 1 Gun Assemblies

### Mini MIG Gun Assemblies with 'Standard' Consumables

160 AMP Air Cooled



Mini Mig Gun

Description	Part No.	Model No.	Part No.	Model No.
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
.023" / 0.6 10' / 3 m cable	23-10	1000-1121		
.035" / 0.9 10' / 3 m cable	35-10	1000-1131	X35-10	1000-1631
.035" / 0.9 12' / 4 m cable	35-12	1000-1132	X35-12	1000-1632
.035" / 0.9 15' / 5 m cable	35-15	1000-1133	X35-15	1000-1633
.045" / 1.2 10' / 3 m cable	45-10	1000-1141		
.045" / 1.2 12' / 4 m cable	45-12	1000-1142		
.045" / 1.2 15' / 5 m cable	45-15	1000-1143		
	w/ Miller® Connection		w/ Lincoln® Rear Connection	
.023" / 0.6 10' / 3 m cable	M23-10	1000-1210		
.035" / 0.9 10' / 3 m cable	M35-10	1000-1211	L35-10	1000-1231
.035" / 0.9 12' / 4 m cable	M35-12	1000-1213		
.035" / 0.9 15' / 5 m cable	M35-15	1000-1215	L35-15	1000-1233
.045" / 1.2 10' / 3 m cable	M45-10	1000-1212		
.045" / 1.2 12' / 4 m cable	M45-12	1000-1214		
.045" / 1.2 15' / 5 m cable	M45-15	1000-1216		

### No.1 MIG Gun Assemblies with 'Standard' Consumables

160 AMP Air Cooled



No. 1

Description	Part No.	Model No.	Part No.	Model No.
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
.023" / 0.6 10' / 3 m cable	110-23	1010-1101		
.035" / 0.9 10' / 3 m cable	110-3035	1010- 1111		
.035" / 0.9 12' / 4 m cable	112-3035	1010- 1112		
.035" / 0.9 15' / 5 m cable	115-3035	1010- 1113		
.045" / 1.2 10' / 3 m cable	110-4045	1010- 1121	X110-4045	1010-1621
.045" / 1.2 12' / 4 m cable	112-4045	1010- 1122	X112-4045	1010-1622
.045" / 1.2 15' / 5 m cable	115-4045	1010- 1123	X115-4045	1010-1623
	w/ Miller® Connection		w/ Lincoln® Rear Connection	
.023" / 0.6 10' / 3 m cable	M110-23	1010-1130		
.035" / 0.9 10' / 3 m cable	M110-3035	1010-1131		
.035" / 0.9 12' / 4 m cable	M112-3035	1010-1133		
.035" / 0.9 15' / 5 m cable	M115-3035	1010-1135	L115-3035	1010-1145
.045" / 1.2 10' / 3 m cable	M110-4045	1010-1132		
.045" / 1.2 12' / 4 m cable	M112-4045	1010-1134		
.045" / 1.2 15' / 5 m cable	M115-4045	1010-1136		

## No. 2 & No. 3 MIG Gun Assemblies

### No.2 MIG Gun Assemblies with 'Standard' Consumables

200 AMP Air Cooled

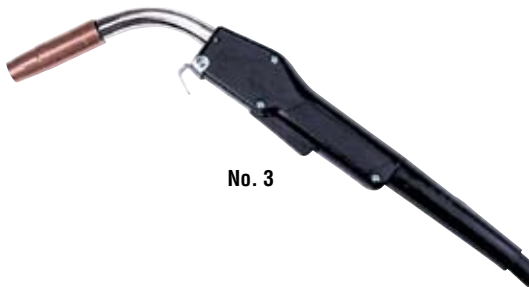


No. 2

Description	Part No.	Model No.	Part No.	Model No.
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
.035" / 0.9 10' / 3 m cable	210-3035	1020-1111	X210-3035	1020-1611
.035" / 0.9 12' / 4 m cable	212-3035	1020-1112	X212-3035	1020-1612
.035" / 0.9 15' / 5 m cable	215-3035	1020-1113	X215-3035	1020-1613
.045" / 1.2 10' / 3 m cable	210-4045	1020-1121	X210-4045	1020-1621
.045" / 1.2 12' / 4 m cable	212-4045	1020-1122	X212-4045	1020-1622
.045" / 1.2 15' / 5 m cable	215-4045	1020-1123	X215-4045	1020-1623
	w/ Miller® Connection		w/ Lincoln® Rear Connection	
.035" / 0.9 10' / 3 m cable	M210-3035	1020-1130	L210-3035	1020-1140
.035" / 0.9 12' / 4 m cable	M212-3035	1020-1132	L212-3035	1020-1142
.035" / 0.9 15' / 5 m cable	M215-3035	1020-1134	L215-3035	1020-1144
.045" / 1.2 10' / 3 m cable	M210-4045	1020-1131	L210-4045	1020-1141
.045" / 1.2 12' / 4 m cable	M212-4045	1020-1133	L212-4045	1020-1143
.045" / 1.2 15' / 5 m cable	M215-4045	1020-1135	L215-4045	1020-1145

### No.3 MIG Gun Assemblies with 'Standard' Consumables

300 AMP Air Cooled



No. 3

Description	Part No.	Model No.	Part No.	Model No.
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
.045" / 1.2 10' / 3 m cable	310-3545	1030-1101	X310-3545	1030-1601
.045" / 1.2 12' / 4 m cable	312-3545	1030-1102	X312-3545	1030-1602
.045" / 1.2 15' / 5 m cable	315-3545	1030-1103	X315-3545	1030-1603
1/16" / 1.6 10' / 3 m cable	310-116	1030-1111		
1/16" / 1.6 12' / 4 m cable	312-116	1030-1112		
1/16" / 1.6 15' / 5 m cable	315-116	1030-1113	X315-116	1030-1613
	w/ Miller® Connection		w/ Lincoln® Rear Connection	
.045" / 1.2 10' / 3 m cable	M310-3645	1030-1130	L310-3545	1030-1140
.045" / 1.2 12' / 4 m cable	M312-3545	1030-1133	L312-3545	1030-1143
.045" / 1.2 15' / 5 m cable	M315-3545	1030-1136	L315-3545	1030-1146

## No.4 & 5 MIG Gun Assemblies

### No.4 MIG Gun Assemblies with 'Standard' Consumables

400 AMP Air Cooled



No. 4

Description	Part No.		Model No.	
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
.045" / 1.2 10' / 3 m cable	410-3545	1040-1101	X410-3545	1040-1601
.045" / 1.2 12' / 4 m cable	412-3545	1040-1102	X412-3545	1040-1602
.045" / 1.2 15' / 5 m cable	412-3545	1040-1103	X415-3545	1040-1603
1/16" / 1.6 10' / 3 m cable	410-116	1040-1111		
1/16" / 1.6 12' / 4 m cable	412-116	1040-1112		
1/16" / 1.6 15' / 5 m cable	415-116	1040-1113	X415-116	1040-1613
5/64" / 2.0 10' / 3 m cable	410-564	1040-1121		
5/64" / 2.0 12' / 4 m cable	412-564	1040-1122		
5/64" / 2.0 15' / 5 m cable	415-564	1040-1123		
	w/ Miller® Connection		w/ Lincoln® Rear Connection	
.045" / 1.2 10' / 3 m cable	M410-3545	1040-1130	L410-3545	1040-1140
.045" / 1.2 12' / 4 m cable	M412-3545	1040-1133	L412-3545	1040-1143
.045" / 1.2 15' / 5 m cable	M415-3545	1040-1136	L415-3545	1040-1146
1/16" / 1.6 10' / 3 m cable	M410-116	1040-1131	L410-116	1040-1141
1/16" / 1.6 12' / 4 m cable	M412-116	1040-1134	L412-116	1040-1144
1/16" / 1.6 15' / 5 m cable	M415-116	1040-1137	L415-116	1040-1147
5/64" / 2.0 10' / 3 m cable	M410-564	1040-1132		
5/64" / 2.0 12' / 4 m cable	M412-564	1040-1135		
5/64" / 2.0 15' / 5 m cable	M415-564	1040-1138		

### No.5 MIG Gun Assemblies with 'Standard' Consumables

500 AMP Air Cooled



No.5

Description	Part No.		Model No.	
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
.045" / 1.2 10' / 3 m cable	510-3545	1050-1101		
.045" / 1.2 12' / 4 m cable	512-3545	1050-1102		
.045" / 1.2 15' / 5 m cable	515-3545	1050-1103		
1/16" / 1.6 10' / 3 m cable	510-116	1050-1111		
1/16" / 1.6 12' / 4 m cable	512-116	1050-1112		
1/16" / 1.6 15' / 5 m cable	515-116	1050-1113	X515-116	1050-1613
3/32" / 2.4 10' / 3 m cable	510-332	1050-1131		
3/32" / 2.4 12' / 4 m cable	512-332	1050-1132		
3/32" / 2.4 15' / 5 m cable	515-332	1050-1133		
	w/ Miller® Connection		w/ Lincoln® Rear Connection	
.045" / 1.2 15' / 5 m cable	M515-3545	1050-1172		
1/16" / 1.6 10' / 3 m cable	M510-116	1050-1161		
1/16" / 1.6 12' / 4 m cable	M512-116	1050-1167		
1/16" / 1.6 15' / 5 m cable	M515-116	1050-1173		
3/32" / 2.4 15' / 5 m cable	M515-332	1050-1175		

Note: All No.5 MIG Guns are furnished with 5" Radius conductor tubes.

## No.6 MIG Gun Assembly / Contact Tips

### No.6 MIG Gun Assemblies with 'Standard' Consumables

600 AMP Air Cooled



Description	Part No.	Model No.	Part No.	Model No.
	w/ Tweco® Rear Connection (Requires Adapter Plug)		w/ Euro-Kwik® Rear Connection	
1/16" / 1.6 15' / 5 m cable	615-116	1060-1207		
3/32" / 2.4 15' / 5 m cable	615-332	1060-1217		
Description	w/ Miller® Connection		w/ Lincoln® Rear Connection	
	Part No.	Model No.	Part No.	Model No.
.045" / 1.2 15' / 5 m cable	M615-3545	1060-1227		
1/16" / 1.6 15' / 5 m cable	M615-116	1060-1232		
3/32" / 2.4 15' / 5 m cable	M615-332	1060-1242		

Note: All No.6 Mig-Guns are furnished with 5" radius conductor tubes.

### Contact Tips - All Guns Standard, Tapered & Heavy Duty Styles



Part No. 11H-35



Part No. 14AH-364



Part No. 16S-35

Wire Size Inches/ Metric	Tip I.D. Inches/ Metric	Mini & No. 1			No. 2, 3, & 4			No. 5		No. 6 Standard 3/8" Tip H D Tip
		Standard	Optional Heavy Duty	Optional Tapered	Standard	Optional Heavy Duty	Optional Tapered	Standard Recess	Optional 1/8" Recess	
.023" / 0.6 mm	.031" / 0.79 mm	11-23 1110-1100		11T-23 1110-1300	14-23 1140-1100		14T-23 1140-1300			
.030" / 0.8 mm	.038" / 0.97 mm	11-30 1110-1101	11H-30 1110-1201	11T-30 1110-1301	14-30 1140-1101		14T-30 1140-1301			
.035" / 0.9 mm	.044" / 1.12 mm	11-35 1110-1102	11H-35 1110-1202	11T-35 1110-1302	14-35 1140-1102	14H-35 1140-1202	14T-35 1140-1302	15H-35 1150-1202		16S-35* 1160-1102
.040" / 1.0 mm	.048" / 1.22 mm	11-40 1110-1103	11H-40 1110-1203	11T-40 1110-1303	14-40 1140-1103	14H-40 1140-1203	14T-40 1140-1303			16S-40* 1160-1103
.045" / 1.2 mm	.054" / 1.37 mm	11-45 1110-1104	11H-45 1110-1204	11T-45 1110-1304	14-45 1140-1104	14H-45 1140-1204	14T-45 1140-1304	15H-45 1150-1204	15HFC-45 1150-1254	16S-45* 1160-1104
.052" / 1.3 mm	.064" / 1.65 mm				14-52 1140-1105	14H-52 1140-1205	14T-52 1140-1305	15H-52 1150-1205	15HFC-52 1150-1255	16S-52* 1160-1105
1/16" / 1.6 mm	.073" / 1.85 mm				14-116 1140-1106	14H-116 1140-1206	14T-116 1140-1306	15H-116 1150-1206	15HFC-116 1150-1256	16S-116* 1160-1106
5/64" / 2.0 mm	.090" / 2.29 mm				14-564 1140-1109	14H-564 1140-1209		15H-564 1150-1209	15HFC-5644 1150-1259	16S-564* 1160-1109
3/32" / 2.4 mm	.106" / 2.67 mm							15H-332 1150-1210	15HFC-332 1150-1260	16S-332* 1160-1110
7/64" / 2.8 mm	.120" / 3.05 mm							15H-764 1150-1211	15HFC-764 1150-1261	16S-764* 1160-1111
1/8" / 3.2 mm	.144" / 3.66 mm							15H-18 1150-1212	15HFC-18 1150-1262	16S-18* 1160-1112
3/64" AL / 1.2 mm	.059" / 1.50 mm		11AH-364 1110-1213		14A-364 1140-1113	14AH-364 1140-1213		15AH-364 1150-1213		16AS-364* 1160-1113
1/16" AL 1.2 mm	.082" / 1.85 mm					14AH-116 1140-1214		15AH-116 1150-1214		16AS-116* 1160-1114

\* 16S Tips- when used in No. 5 Mig-Guns require a 55S style diffuser. Use 55S-SWL or 55S-HL for 5/32 tip recess. Use 55S-SW or 55S-H for 3/8 tip recess.



## Standard Nozzles & Nozzle Insulators - All Guns

### Standard Nozzles & Nozzle Insulators- All Guns



Part No. 21T-37



Part No. 22T-37-SS



Part No. 23-62



Part No. 21-50



Part No. 22-62



Part No. 23-62-F

Gun Model	Nozzle Style	Insulator	3/8" / 9.5 mm Bore	1/2" / 12.7 mm Bore	5/8" / 15.9 mm Bore	3/4" / 19.1 mm Bore
<b>21 Series</b>						
Mini-Mig-Gun (Standard)	Self-insulated, tip flush		21-37-F 1210-1102	21-50-F 1210-1112	21-62-F 1210-1122	
No. 1 (Standard)	Self-insulated, 1/8" tip recess		21-37 1210-1100	21-50 1210-1110	21-62 1210-1120	
	Optional, tapered, self-insulated, (*1/8" tip recess), (**tip flush)		21T-37* 1210-1300 21T-37-F** 1210-1302			
<b>22 Series: * 034A Insulator must be used with this series nozzle.</b>						
No.2 (Standard)	Adjustable, recess to projection	0032 1320-1100		22-50 1220-1110	22-62 1220-1120	
	Optional, short-stop, 1/8" tip recess	0032 1320-1100	22-37-SS 1220-1301	22-50-SS 1220-1111	22-62-SS 1220-1121	
	Optional, tapered, tip flush	0032 1320-1100	22T-37-SS 1220-1522			
<b>23 Series: * Use SZFN diffuser with this series on a #2 MIG gun.</b>						
No. 3 (Standard)	Self-insulated, 1/8" tip recess		23-37 1230-1100	23-50 1230-1110	23-62 1230-1120	23-75 1230-1130
	Self Insulated, 3/8" tapered		23T-37 1230-1300			
	Optional, self-insulated, tip flush		23-37-F 1230-1102	23-50-F 1230-1112	23-62-F 1230-1122	23-75-F 1230-1132
	Optional, heavy duty self-insulated, 1/8" tip recess			23H-50 1230-1210	23H-62 1230-1220	23H-75 1230-1230
	Optional, heavy duty self-insulated, tip flush				23H-62-F 1230-1222	

**Note:** 21-50 nozzle installed in all 150 AMP WeldSkill® MIG guns.  
22-50 nozzle installed in all 250 AMP WeldSkill® MIG guns.

## Standard Nozzles & Nozzle Insulators - All Guns / Optional Arc Spot

### Standard Nozzles & Nozzle Insulators - All Guns



Part No. 34A



Part No. 24AT-37-SS



Part No. 24A-50



Part No. 24CT-62-F



Part No. 25T-75

Gun Model	Nozzle Style	Insulator	3/8" / 9.5 mm Bore	1/2" / 12.7 mm Bore	5/8" / 15.9 mm Bore	3/4" / 19.1 mm Bore
<b>24 Series</b>						
No. 4 (Standard)	Adjustable, recess to projection	034A 1340-1100		24A-50 1240-1110	24A-62 1240-1120	24A-75 1240-1130
	Optional, short-stop, 1/8" Tip recess	034A 1340-1100	24A-37-SS 1240-1101	24A-50-SS 1240-1111	24A-62-SS 1240-1121	24A-75-SS 1240-1131
	Optional, ss tapered, 1/8" Tip recess	034A 1340-1100	24AT-37-SS 1240-1301			
	Optional, heavy duty, adjustable	034A 1340-1100		24AH-50 1240-1210	24AH-62 1240-1220	24AH-75 1240-1230
	Optional, heavy duty, short stop	034A 1340-1100		24AH-50-SS 1240-1211	24AH-62-SS 1240-1221	24AH-75-SS 1240-1231
	Optional, coarse thread, 1/8" Tip recess	34CT 1340-1400	24CT-37-S 1240-1404	24CT-50-S 1240-1414	24CT-62-S 1240-1424	24CT-75-S 1240-1434
	Optional, coarse thread, Tip flush	34CT 1340-1400		24CT-50-F 1240-1412	24CT-62-F 1240-1422	
	Optional, coarse thread, 1/2" Tip recess	34CT 1340-1400			24CT-62-R 1240-1423	24CT-75-R 1240-1433
<b>25 Series</b>						
No. 5 (Standard)	Coarse thread, 1/8" Tip recess	35CT 1350-1400		25CT-50 1250-1410	25CT-62 1250-1420	25CT-75 1250-1430
	Optional, self-insulated, 1/8" Tip recess				25I-62 1250-1120	25I-75 1250-1130
<b>26 Series</b>				<b>5/8" / 15.9 mm Bore</b>	<b>3/4" / 19.1 mm Bore</b>	<b>7/8" / 22 mm Bore</b>
No. 6 (Standard)	Self-insulated, 1/8" Tip recess			26I-62 1260-1120	26I-75 1260-1130	
	Optional, coarse thread, 1/8" Tip recess	36CT		26CT-62 1260-1420	26CT-75 1260-1430	

### Optional Arc Spot



Part No. 21-62-FAS



Part No. 25CT-125-FAS

Type	Mini & No. 1	No. 2	No. 3	No. 4	No. 5
Flat Arc Spot	21-62-FAS 1210-1520 (5/8" bore)	22-62-FAS 1220-1520 (5/8" bore)	23-75-FAS 1230-1530 (3/4" bore)	24A-62-FAS 1240-1520 (5/8" bore)	25CT-125-FAS 1250-1560 (1-1/4" bore)
				24A-75-FAS 1240-1530 (3/4" bore)	25CT-162-FAS 1250-1570 (1-5/8" bore)
				24A-100-FAS 1240-1550 (1" bore)	

## Nozzles & Standard Diffusers / Standard Conductor Tubes

### Standard Diffusers



Part No. 0052



Part No. 55SW

Mini MIG Gun	No. 1	No. 2	No. 3 & 4	No. 5		
35-50 1500-1100 (standard)	0051 1510-1101 (standard)	0052 1520-1101 (standard)	054A 1540-1103 (standard)	55SW 1550-1101 (note: 1)	(use with 16S tips) 55S-SW 1550-1110 (note: 1)	(use with 16S tips) 55S-SWL 1550-1120 (note: 1)
35-50A 1500-1101 (use with AL wire)	51-23 1510-1100 (use with .023 wire)	52-23 1520-1100 (use with .023 wire)	054K with slip in tips	0055 1550-1100 (note: 2)	(use with 16S tips) 55S-H 1550-1111 (note: 4)	(use with 16S tips) 55S-HL 1550-1121
		52FN 1520-1102 (use with No. 3 & 4 nozzles)		055H 1550-1102 (note: 3)		

Diffusers for No. 5 & 6 MIG Guns must be used with conduits as follows:

Note: 1 = 45-3545, 45-116, 45N-3545 (small wire)

Note: 2 = 45-564, 45N-116

Note: 3 = 45H-332, 45H-764, 45H-18

Note: 4 = All Note 2 & 3 conduits

### Standard Conductor Tubes



Part No. 61-60



Part No. 62J-60



Part No. 65J-60

Degree/ Bend	Mini	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6
						5" Radius	5" Radius
45°	35-60-45 1600-1101	61-45 1610-1101	62J-45 1620-1300	63J-45 1630-1110	64J-45 1640-1105	65J-45 1650-1110	66J-45 1660-1825
60° (standard)	35-60-60 1600-1102	61-60 1610-1102	62J-60 1620-1301	63J-60 1630-1111	64J-60 1640-1106	65J-60 1650-1111	66J-60 1660-1826

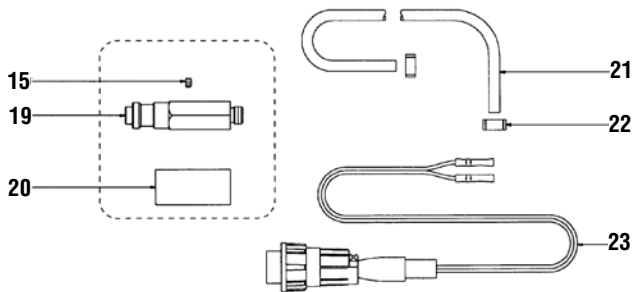
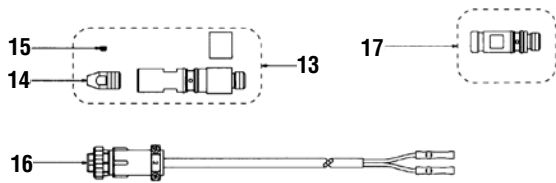
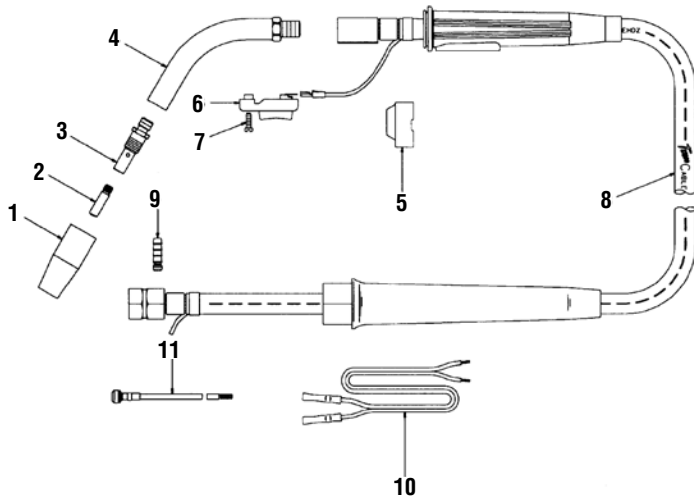
### Optional Standard Conductor Tubes

Mini MIG Gun			Conductor Tube Extensions			No. 3 & 4	No. 5
			No. 3 & 4	No. 5			
60° For use with aluminum wire	35-60A-60 1600-1002	Extension 4" 180°	64A-4EX 1640-1301	65-4EX 1650-1301	Extension 45°	64EX-45 1640-1311	65EX-45 1650-1311
Flexible conductor tube	35-60-F 1600-1140	Extension 6" 180°	64A-6EX 1640-1302	65-6EX 1650-1302	Extension 60°	64EX-60 1640-1312	65EX-60 1650-1312
		Extension 8" 180°	64A-8EX 1640-1303	65-8EX 1650-1303	Extension 80°	64EX-80 1640-1313	

**Note:** Extensions are designed to fit standard conductor tubes. Conduits must be replaced when installing conductor tube extensions.

## Mini MIG Gun Replacement Parts

### Mini MIG Gun Parts Breakdown

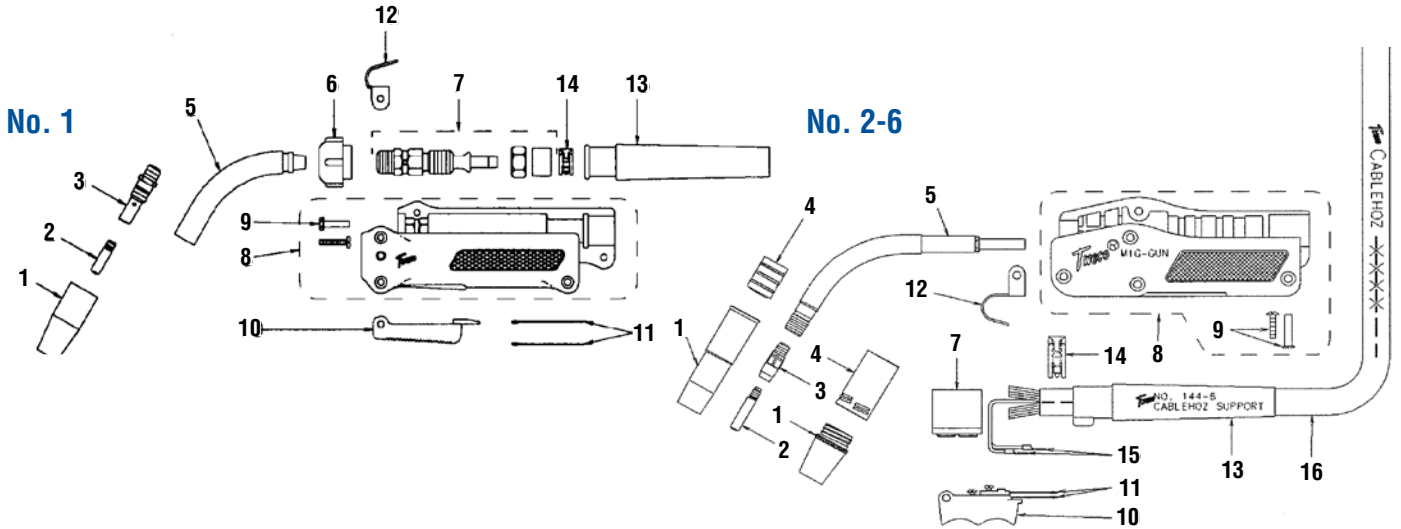


Item No.	Descriptions	Part No.	Model No.
1	Nozzles	S/C	S/C
2	Contact tips	S/C	S/C
3	Diffusers	S/C	S/C
4	Conductor tubes	S/C	S/C
5	Handle cap	35-80A-1	2000-2081
6 & 7	Trigger and screw	35-90	2000-2090
8	Cable assembly 10' cable with handle & support	35-010A	1700-2126
8	Cable assembly 12' cable with handle & support	35-012A	1700-2127
8	Cable assembly 15' cable with handle & support	35-015A	1700-2128
9	Gas nipple	35-170-5	2000-2175
10	Control wire	35K-350-1	2000-2352
11	Conduits	S/C	S/C
13	Miller® connector plug	170M	2000-2810
14	Miller® connector plug end cap	174M-N	2040-2184
15	Set screw	044C	2040-2044
16	Miller® control wire plug assembly	MK-354-M	2602-2402
17	Tweco® standard connector plug	35K-174C	2000-2169
19	Lincoln® SP200 connector plug	044C	2040-2044
20	Lincoln® connector plug insulator	LAK-352-1	2641-2030
21	Gas hose, 18"	MK-353-24	2642-2210
22	Hose clamp	AK-353-2A	2642-2302
23	Lincoln® control wire assembly	35SP-354	2000-2354

S/C = See Consumable Parts Listing

**No. 1- 6 MIG Gun Replacement Parts**

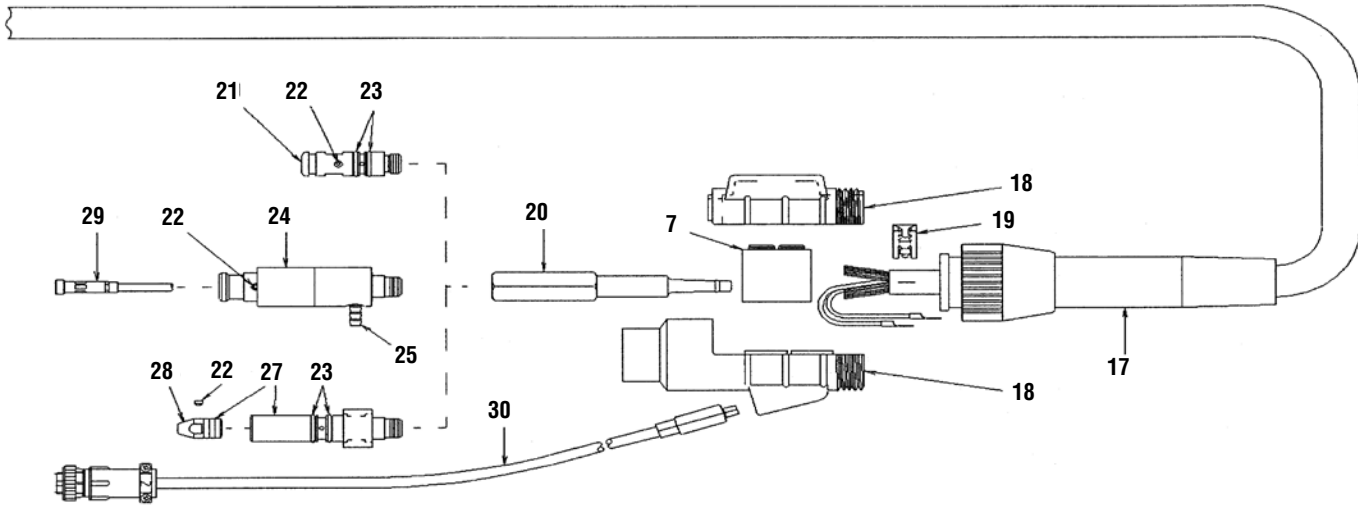
**No. 1 - 6 MIG Gun Parts Breakdown**



Item No.	Description	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6
1	Nozzles	Standard consumable parts					
2	Contact tips	Standard consumable parts					
3	Diffusers	Standard consumable parts					
4	Nozzle insulators	Standard consumable parts					
5	Conductor tubes	Standard consumable parts					
6	Conductor tube retaining nut	061R 2010-2061					
7	Front power connector	101R 2010-2103	0102 2020-2102	0102 2020-2102	0104 2040-2104	0104 2040-2104	0104 2040-2104
7	Rear power connector	0104 2040-2104	0104 2040-2104	0104 2040-2104	0104 2040-2104	0104 2040-2104	0104 2040-2104
8	Handle	0081 2010-2081	0083 2030-2083	0083 2030-2083	084A 2040-2084	0085 2050-2085	0085 2050-2085
9	Handle binder post & screw	122FM 2020-2122	122FM 2020-2122	122FM 2020-2122	124FM 2040-2124	124FM 2040-2124	124FM 2040-2124
10	Trigger assembly	0091 2010-2091	0092 2020-2092	0092 2020-2092	094R 2040-2096	094R 2040-2096	094R 2040-2096
11	Trigger blades (2 ea.)	091C 2010-2093	092C 2020-2094	092C 2020-2094	094C 2040-2093	094C 2040-2093	094C 2040-2093
12	Gun hanger	0152 2020-2152	0152 2020-2152	0152 2020-2152	0154 2040-2154	0154 2040-2154	0154 2040-2154
13	Front cable support	141-6 2010-2141	142-6 2020-2142	142-6 2020-2142	144-6- 2040-2144	145-6 2050-2145	145-6 2050-2145
14	Front cable clamp	132-12 2020-2132	132-12 2020-2132	132-12 2020-2132	134-14 2040-2134	134-14 2040-2134	134-14 2040-2134
15	Front control terminals	244DS 2040-2245	0244 2040-2244	0244 2040-2244	0244 2040-2244	0244 2040-2244	0244 2040-2244
16	Cablehoz, per ft.	0200 1720-2100	0200 1720-2100	0300 1730-2100	0400 1740-2100	0500 1750-2100	600S 1760-2100

## No. 1, 2, 3, 4, 5 & 6 MIG Gun Replacement Parts

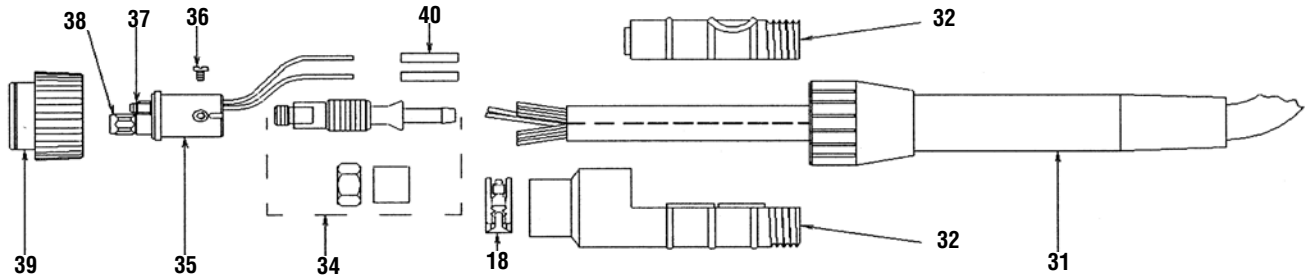
### All Tweco®, Miller® and Lincoln® Direct Plug MIG Guns



Item No.	Description	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6
7	Front power connector	101R 2010-2103	0102 2020-2102	0102 2020-2102	0104 2040-2104	0104 2040-2104	0104 2040-2104
7	Rear power connector	0104 2040-2104	0104 2040-2104	0104 2040-2104	0104 2040-2104	0104 2040-2104	0104 2040-2104
17	Rear support (Except Euro-Kwik®)	350-R-230-10 2035-2235	350-R-230-10 2035-2235	350-R-230-10 2035-2235	350-R-230-10 2035-2235	350-R-230-10 2035-2235	350-R-230-10 2035-2235
18	Rear case (except Euro-Kwik®)	M6RC 2060-2018	M6RC 2060-2018	M6RC 2060-2018	M6RC 2060-2018	M6RC 2060-2018	M6RC 2060-2018
19	Rear cable clamp	132-12 2020-2132	132-12 2020-2132	134-14 2040-2134	134-14 2040-2134	134-14 2040-2134	134-14 2040-2134
20	Power cable adapter (Except Euro-Kwik®)	M170-2 2020-2171	M170-2 2020-2171	M170-2 2020-2171	M170-2 2020-2171	M170-2 2020-2171	M170-2 2020-2171
21	Tweco® connector plug	350-174H 2035-2174	350-174H 2035-2174	350-174H 2035-2174	350-174H 2035-2174	176SH 2060-2177	176SH 2060-2177
22	Set screw	44C 2040-2044	44C 2040-2044	44C 2040-2044	44C 2040-2044	44C 2040-2044	44C 2040-2044
23	O-rings	224 2040-2224	224 2040-2224	224 2040-2224	224 2040-2224	225 2050-2225	225 2050-2225
24	Lincon® connector plug Direct plug gun	350-174L-H 2035-2112	350-174L-H 2035-2112	350-174L-H 2035-2112	350-174L-H 2035-2112	EL176-LH 2060-2680	EL176-LH 2060-2680
25	Gas nipple	35-170-5 2000-2175	35-170-5 2000-2175	35-170-5 2000-2175	35-170-5 2000-2175	35-170-5 2000-2175	35-170-5 2000-2175
27	Miller® connector plug direct plug gun	350-174MH 2035-2111	350-174MH 2035-2111	350-174MH 2035-2111	350-174MH 2035-2111	EL176-MH 2060-2178	EL176-MH 2060-2178
28	Miller® connector plug end cap	174M-N 2040-2184	174M-N 2040-2184	174M-N 2040-2184	174M-N 2040-2184	175M-N 2050-2	175M-N 2050-2
29	Conduit	See following pages					
30	Tweco® control wire plug, not furnished with gun	AK-354 2642-2400	AK-354 2642-2400	AK-354 2642-2400	AK-354 2642-2400	AK-354 2642-2400	AK-354 2642-2400
30	Lincoln® control wire plug, furnished with direct plug gun	LAK-354 2642-2450	LAK-354 2642-2450	LAK-354 2642-2450	LAK-354 2642-2450	LAK-354 2642-2450	LAK-354 2642-2450
30	Miller® control wire plug, furnished with direct plug gun	MSAK-354 2642-2470	MSAK-354 2642-2470	MSAK-354 2642-2470	MSAK-354 2642-2470	MSAK-354 2642-2470	MSAK-354 2642-2470

## No. 1, 2, 3, 4, & 5 MIG Gun Replacement Parts / Wire Conduits - All Guns

### All Euro-Kwik® MIG Guns



Item No.	Description	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6
31	Rear support (Euro-Kwik® guns)	350R-230-10 2035-2235	350R-230-10 2035-2235	350R-230-10 2035-2235	350R-230-10 2035-2235	350R-230-10 2035-2235	350R-230-10 2035-2235
32	Rear Case (Euro-Kwik® guns)	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006	X6RC 2060-2006
34	Power connection (Euro-Kwik® guns)	172X-M 2020-2181	172X-M 2020-2181	172X-M 2020-2181	172X-M 2020-2181	176X-M 2060-2181	176X-M 2060-2181
35	Rear connector (Euro-Kwik® guns)	174EX-1 2040-2276	174EX-1 2040-2276	174EX-1 2040-2276	174EX-1 2040-2276	174EX-1 2040-2276	174EX-1 2040-2276
36	Screw	4M-S 2011-2004	4M-S 2011-2004	4M-S 2011-2004	4M-S 2011-2004	4M-S 2011-2004	4M-S 2011-2004
37	O-ring Euro-Kwik® guns	174EX-1G 2040-2282	174EX-1G 2040-2282	174EX-1G 2040-2282	174EX-1G 2040-2282	174EX-1G 2040-2282	174EX-1G 2040-2282
38	Conduit cap Euro-Kwik® guns	174EX-1C 2040-2279	174EX-1C 2040-2279	174EX-1C 2040-2279	174EX-1C 2040-2279	174EX-1C 2040-2279	174EX-1C 2040-2279
39	Connector nut Euro-Kwik® guns	174X-2 2040-2177	174X-2 2040-2177	174X-2 2040-2177	174X-2 2040-2177	174X-2 2040-2177	174X-2 2040-2177
40	Butt connectors	35-350-1 2000-2351	35-350-1 2000-2351	35-350-1 2000-2351	35-350-1 2000-2351	35-350-1 2000-2351	35-350-1 2000-2351

### Wire Conduits - All Guns

Wire Size	Mini MIG Gun (All Models)		No. 1 & 2 (All Models)		No. 3 & 4 (All Models & No. 5 X-Guns)		No. 5 & 6 (All Except X-Guns)	
	15 / 5 m	20 / 6 m	15 / 5 m	25 / 7.6 m	15 / 5 m	25 / 7.6 m	15 / 5 m	25 / 7.6 m
.023" 0.6 m	23-40-15 1400-1123		42-23-15 1420-1103					
.030" - .035" 0.8-0.9 mm	35-40-15 1400-1133	35-40-20 1400-1134	42-3035-15 1420-1113	42-3035-25 1420-1115				
.040" - .045" 1.0-1.2 mm	45-40-15 1400-1143	45-40-20 1400-1144	42-4045-15 1420-1123	42-4045-25 1420-1125				
.035" - .045" 0.9-1.0 mm					44-3545-15 1440-1103	44-3545-25 1440-1105	45-3545-15 1450-1103	45-3545-25 1450-1105
.052" - 1/16" 1.3-1.6 mm					44-116-15 1440-1113	44-116-25 1440-1115	45-116-15 1450-1113	45-116-25 1450-1115
5/64" 2.0 mm					44-564-15 1440-1123	44-564-25 1440-1125	45-564-15 1450-1123	45-564-25 1450-1125
3/32" 2.4 mm							45H-332-15 1450-1133	
7/64" 2.8 mm							45H-764-15 1450-1143	
1/8" 3.2 mm							45H-18-15 1450-1153	
.030" - .035" AL 0.8 - 0.9 mm	35TF-40-10* 1400-1031		42N-3545-15 1420-1003		44N-3545-15 1440-1003		45N-3545-15 1450-1003	
.040" - 3/64" AL 1.0 - 1.2 mm	45TF-40-10* 1400-1041		42N-3545-15 1420-1003		44N-3545-15 1440-1003		45N-3545-15 1450-1003	
1/16" 1.6 mm					44N-116-15 1440-1012		45N-116-15 1450-1013	



Part No. 42-3035-15



Part No. 44-3545-15

\*TF liners not recommended for lengths over 10' / 3 m

## Air Cooled TIG Torches

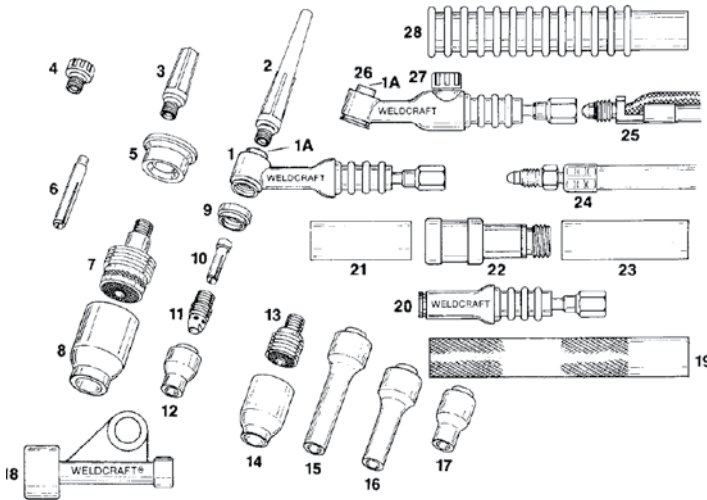
### WP-9 Series

- Versatile & lightweight for thin gauge material.
- Torch bodies only include cup gasket.
- Torch packages include: torch body, handle, medium back cap (WP-9P torch does not use back caps), and power cable.
- If other than standard power cable is desired for air cooled torch, change last character to receive desired power cable.
  - 2: Two piece power cable.
  - R: One piece rubber jacketed power cable.



Part No. WP-9V

Part No.	Description	Max AMPS	Head Angle	Gas Valve	Handle Style	Access Kit
WP-9	Torch body	125	70°	No	Ribbed 3/4 dia.	AK-1
WP-9-12-2	Torch package					
WP-9-12-R						
WP-9-25-2						
WP-9-25-R						
WP-9V	Torch body, valve	125	70°	Knob & stem	Ribbed 3/4 dia.	AK-1
WP-9V-12-2	Torch package					
WP-9V-12-R						
WP-9V-25-2						
WP-9V-25-R						
WP-9FV	Torch body, flex valve	125	90°	Knob & stem	Ribbed 3/4 dia.	AK-1
WP-9FV-12-2	Torch package					
WP-9FV-12-R						
WP-9FV-25-2						
WP-9FV-25-R						



#### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Diameter	.020	.040	1/16	3/32
Collet	13N20	13N21	13N22	13N23
Collet body	13N25	13N26	13N27	13N28
Gas lens	45V41	45V42	45V43	45V44
Lg. diameter gas lens collet	13N20L	13N21L	13N22L	13N23L
Lg. diameter gas lens	45V0204S	45V0204S	45V116S	45V64S

#### Chart B: Gas Nozzles

Size	3	4	5	6	7	8	10	12	Short
Alumina		13N08	13N09	13N10	13N11	13N12	13N13		
Alumina gas lens		53N58	53N59	53N60	53N61	53N61S			
Large dia. gas lens				57N75		57N74	53N88	53N87	53N89*
Lava		13N14	13N15	13N16	13N17	13N18	13N19		
Long lava	796F70	796F71	796F72	796F73					
Ex long lava	796F74	796F75	796F76	796F77					

\*Not recommended for use with high frequency current.

**Cable Covers:** WC-3-10, WC-3-22  
**Extension Kit:** EK-2-25-R  
**Weight:** 3 oz. (less power cable)  
**Torch Length:** WP-9: 7" - WP-9P: 6-1/2"

#	Part No.	Description
1	WP-9	Torch body, includes cup gasket (70°)
1A	09-4	Insert
2	41V24	Long back cap, includes 98W77 O-ring
3	41V35	Medium back cap, includes 98W77 O-ring
4	41V33	Short back cap, includes 98W77 O-ring
5	54N63-20	Lg. diameter gas lens insulator
6	see chart A	Lg. diameter gas lens collet
7	see chart A	Lg. diameter gas lens
8	see chart B	Lg. diameter gas lens nozzle
9	598882	Cup gasket
10	see chart A	Collet
11	see chart A	Collet body
12	see chart B	Alumina nozzle
13	see chart A	Gas lens (see chart A)
14	see chart B	Alumina gas lens nozzle
15	see chart B	Extra long lava nozzle
16	see chart B	Long lava nozzle
17	see chart B	Lava nozzle
18	105Z57	Power cable adapter
19	H-100	Handle (smooth, standard on WP-9P)
20	WP-9P	Pencil torch body, includes cup gasket (180°)
21-3	V-92	Valve assembly includes items 21, 22, 23
21	V-92-1	Front handle (not sold separately)
22	V-92-2	Valve body (not sold separately)
23	V-92-3	Rear handle (not sold separately)
24	<b>Power cable – 1-piece</b>	
	57Y01	12-1/2 ft. (3.8 m) vinyl
	57Y03	25 ft. (7.6 m) vinyl
	57Y01R	12-1/2 ft. (3.8 m) rubber
	57Y03R	25 ft. (7.6 m) rubber
25	<b>Power cable – 2-piece</b>	
	57Y01-2	12-1/2 ft. (3.8 m)
	45V09R	(gas hose only - 12-1/2 ft.)
	57Y03-2	25 ft. (7.6 m)
25	45V10R	(gas hose only - 25 ft.)
	WP-9V	Valve torch body, includes cup gasket and valve stem (70°)
27	VS-2	Valve stem, includes 98W77 O-ring
28	H-100R	Handle (ribbed, standard on WP-9V, 9)
<b>Cable Repair Kits</b>		
ZCRK17		1-piece power cable repair kit
ZCRK17-2		2-piece power cable repair kit



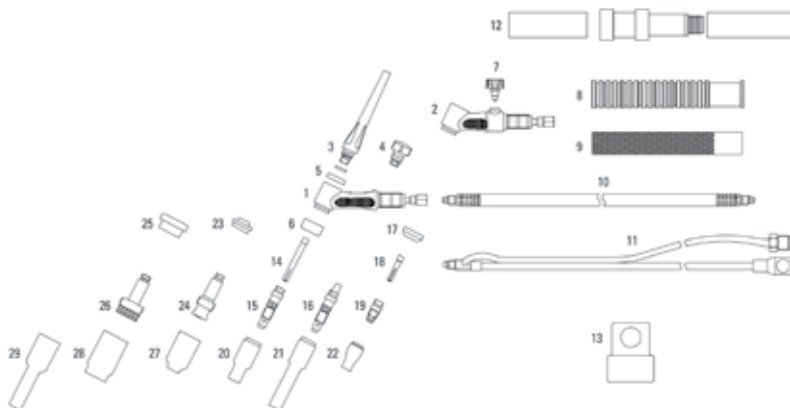
**WP-17 Series**

- High capacity for thin to medium gauge materials.
- Compact and durable for field welding applications. Ribbed handle for comfort and cool operation. Fingertip gas control valve on WP-17V model and heavy duty 2 pc. power cable is supplied as standard equipment. Parts interchange with WP-18, WP-26, and WP-26V models.
- Torch packages available with R for 1 piece rubber power cables. Torch body includes cup gasket.
- Torch packages include: Torch body, handle, long back cap, power cable. Power cable adapter is not needed with two piece power cable.
- If other than standard power cable is desired for air cooled torch, change last character to receive desired power cable.
  - 2: Two piece power cable.
  - R: One piece rubber jacketed power cable.



Part No. WP-17

Part No.	Description	Max AMPS	Head Angle	Gas Valve	Handle Style	Accessory Kit
WP-17	Torch body	150	70°	No	Ribbed 7/8 dia.	AK-2
WP-17-12-2 WP-17-25-2	Torch package					
WP-17V	Torch body, valve	150	70°	Knob & stem	Ribbed 7/8 dia.	AK-2
WP-17V-12-2 WP-17V-12-R WP-17V-25-2 WP-17V-25-R	Torch package					
WP-17FV	Torch body, flex valve					
WP-17FV-12-2 WP-17FV-12-R WP-17FV-25-2 WP-17FV-25-R	Torch package					



**Chart A: Collets, Collet Bodies, Gas Lens**

Electrode dia.	.020	.040	1/16	3/32	1/8
Collet	10N21	10N22	10N23	10N24	10N25
Collet body	10N29	10N30	10N31	10N32	10N28
Single pc. collet/collet body				10N332SP	10N18SP
Stubby nozzle insulator	18CG20	18CG20	18CG20	18CG20	18CG20
Gas lens	45V29	45V24	45V25	45V26	45V27
Lg. diameter gas lens	45V0204	45V0204	45V116	45V64	995795
Lg. diameter gas lens insulator	54N63	54N63	54N63	54N63	54N63
Stubby collet		10N22S	10N23S	10N24S	10N25S
Stubby collet body		17CB20	17CB20	17CB20	17CB20
Gas lens insulator	54N01	54N01	54N01	54N01	54N01

**Chart B: Gas Nozzles**

Size	4	5	6	7	8	10	12	Short
Alumina	10N50	10N49	10N48	10N47	10N46	10N45	10N44	
Alumina gas lens	54N18	54N17	54N16	54N15	54N14			54N19*
Large diameter gas lens			57N75		57N74	53N88	53N87	53N89*
Long alumina		10N49L	10N48L	10N47L				
Long gas lens		54N17L	54N16L	54N15L				
Lava	105Z43	105Z42	105Z44	105Z45	08N78	08N79	08N80	
Long lava	12N03	105Z60	12N02	105Z61				
Stubby alumina	13N08	13N09	13N10	13N11	13N12	13N13		
Long alumina large diameter gas lens			57N75 L		57N74 L	53N88 L	53N87 L	
X-long alumina large diameter gas lens			57N75L XL		57N74L XL	53N88 XL	53N87 XL	
XX-long alumina large diameter gas lens			57N75L XXL		57N74L XXL	53N88 XXL	53N87 XXL	

\*Not recommended for use with high frequency current.

#.	Part No.	Description
1	WP-17	Torch body (70°), includes insulators
2	WP-17V	Torch body with valve (70°), includes insulators
3	57Y02	Long back cap, includes 98W18 O-ring
4	57Y04	Short back cap, includes 98W18 O-ring
5	18-7	Back cap insulator
6	18CG	Nozzle insulator
7	VS-2	Valve stem, includes 98W77 O-ring
8	H-100R	Ribbed handle
9	H-100	Knurled handle
10	57Y01R	Power cable - 12-1/2' rubber
	57Y03R	Power cable - 25' rubber
	57Y01-2	Power cable - 2 pc. 12-1/2' rubber
	45V09R	(gas hose only - 12-1/2' braided)
11	57Y03-2	Power cable - 2 pc. 25' rubber
	45V10R	(gas hose only - 25' braided)
	V-92	Slide valve
12	V-92	Slide valve
13	105Z57	Power cable adapter
<b>Cable Repair Kits</b>		
ZCRK17		1-piece power cable repair kit
ZCRK17-2		2-piece power cable repair kit

**Cable Covers:** WC-3-10, WC-3-22  
**Extension Kit:** EK-2-25-R  
**Weight:** 6 oz. (less power cable)  
**Torch Length:** 7-3/4"  
**Qwik Connector:**  
 400A - Q5  
 150A w/ hose - Q5G-150  
 150A flow thru - Q5GT-150

**Accessory Kits AK-2 (WP-17, 17V, 17FV)**  
 1-Short back cap  
 3-Collets .040, 1/16", 3/32"  
 3-Collet bodies .040, 1/16", 3/32"  
 3-Al. nozzles 4, 5, 6  
 3-Tungsten electrodes 2%, .040, 1/16", 3/32", x 7"

## Air Cooled TIG Torches

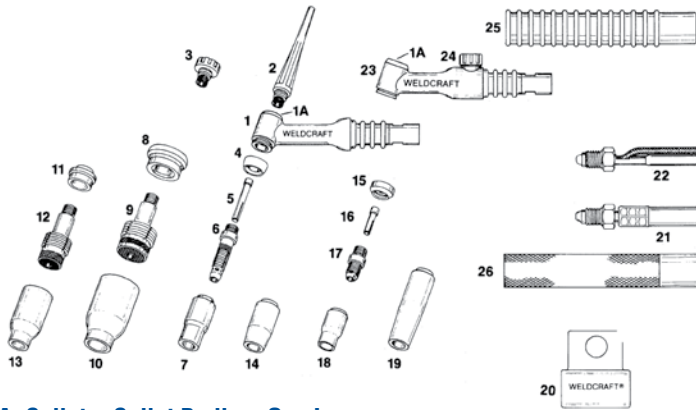
### WP-26 Series

- Maximum capacity air cooled torch for continuous heavy-duty use.
- Heavy copper construction for rugged field work. Heavy duty 2-piece power cable and ribbed handle are standard equipment. Parts interchange with WP-18, WP-17 and WP-17V models.
- Torch packages available with R for 1 piece rubber power cables. Torch bodies only include cup gasket.
- Torch packages include: torch body, handle, long back cap, and power cable assembly.
- Power cable adapter is not needed on 2-piece power cable.
- If other than standard power cable is desired for air cooled torch, change last character to receive desired power cable.
  - 2: 2-piece power cable.
  - R: 1-piece rubber jacketed power cable (1-piece vinyl power cable is not available).



Part No. WP-26

Part No.	Description	Max AMPS	Head Angle	Gas Valve	Handle Style	Access Kit
WP-26	Torch body	200	70°	-	Ribbed 1-1/4" dia.	AK-3
WP-26-12-2	Torch package					
WP-26-12-R						
WP-26-25-2						
WP-26-25-R						
WP-26V	Torch body, valve	200	70°	Knob & stem	Ribbed 1-1/4" dia.	AK-3
WP-26V-12-2	Torch package					
WP-26V-12-R						
WP-26V-25-2						
WP-26V-25-R						
WP-26FV	Torch body, flex valve	200	90°	Knob & stem	Ribbed 1-1/4" dia.	AK-3
WP-26FV-12-2	Torch package					
WP-26FV-12-R						
WP-26FV-25-2						
WP-26FV-25-R						



#### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Dia.	.020	.040	1/16	3/32	1/8	5/32
Collet	10N21	10N22	10N23	10N24	10N25	54N20
Collet Body	10N29	10N30	10N31	10N32	10N28	406488
Gas Lens	45V29	45V24	45V25	45V26	45V27	45V28
Lg. Dia Gas Lens Collet	45V0204	45V0204	45V116	45V64	995795	45V63
Stubby Collet		10N22S	10N23S	10N24S	10N25S	
Stubby Collet Body		17CB20	17CB20	17CB20	17CB20	17CB20

#### Chart B: Gas Nozzles

Size	4	5	6	7	8	10	12	Short
Alumina	10N50	10N49	10N48	10N47	10N46	10N45	10N44	
Alumina gas lens	54N18	54N17	54N16	54N15	54N14			54N19*
Lg. dia. gas lens			57N75		57N74	53N88	53N87	53N89*
Long Alumina		10N49L	10N48L	10N47L				
Long gas lens		54N17L	54N16L	54N15L				
Lava	105Z43	105Z42	105Z44	105Z45	08N78	08N79	08N80	
Long lava	12N03	105Z60	12N02	105Z61				
Stubby alumina	13N08	13N09	13N10	13N11	13N12	13N13		

\*Not recommended for use with high frequency current.

#### AK-3 (WP-26, 26V, 26FV)

- 1-Short back cap
- 3-Collets 1/16", 3/32", 1/8"
- 3-Collet bodies 1/16", 3/32", 1/8"
- 3-Al. nozzles 5, 6, 8
- 3-Tungsten electrodes 2% 1/16, 3/32" 1/8" x 7"

<b>Cable Covers:</b>	WC-3-10, WC-3-22
<b>Extension Kit:</b>	Not available
<b>Weight:</b>	10 oz. (less power cable)
<b>Torch Length:</b>	8-1/2"

#	Part No.	Description
1	WP-26	Torch body, includes cup gasket (70°)
1A	18-7	Insert
2	57Y02	Long back cap, includes 98W18 O-ring
3	57Y04	Short back cap, includes 98W18 O-ring
4	18CG	Cup gasket
5	see chart A	Collet
6	see chart A	Collet body
7	see chart B	Alumina nozzle
8	54N63	Lg. diameter gas lens insulator
9	see chart A	Lg. diameter gas lens
10	see chart B	Lg. diameter gas lens nozzle (see chart B)
11	54N01	Gas lens insulator
12	see chart A	Gas lens
13	see chart B	Alumina gas lens nozzle
14	see chart B	Lava nozzle
15	18CG20	Stubby gasket
16	see chart A	Stubby collet
17	see chart A	Stubby collet body
18	see chart B	Stubby alumina nozzle
19	see chart B	Long lava nozzle
20	45V62	Power cable adapter
<b>Power cable - 1 piece rubber</b>		
21	46V28R	12-1/2 ft. (3.8 m)
	46V30R	25 ft. (7.6 m)
<b>Power cable - 2-piece</b>		
22	46V28-2	12-1/2 ft. (3.8 m)
	40V75R	(gas hose only – 12-1/2 ft.)
	46V30-2	25 ft. (7.6 m)
	41V30R	(gas hose only – 25 ft.)
23	WP-26V	Valve torch body, includes cup gasket & stem (70°)
24	VS-1	Valve stem, includes 98W77 O-ring
25	H-200R	Handle (ribbed, standard)
26	H-200	Handle (smooth, optional)
<b>Cable Repair Kits</b>		
ZCRK26		1-piece power cable repair kit
ZCRK26-2		2-piece power cable repair kit

## Water Cooled TIG Torches

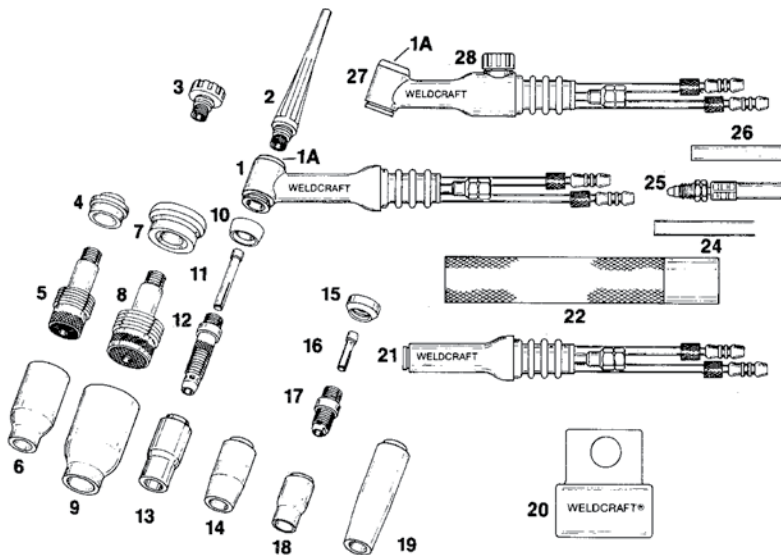
### WP-18 Series

- Work horse torches for continuous duty. Heavy duty rugged production torch for continuous duty to 350 amps. WP-18SP: pencil style.
- Parts interchange with WP-17, WP-17V, WP-26, WP-26V torch models. Available with built-in fingertip gas control valve.
- Torch packages include: Torch body, handle, long back cap, power cable and hoses. Power cable adapter must be ordered separately.
- Water cooling requirements: 1 – 1-1/2 quarts per minute at maximum of 50 PSI pressure.
- All are three piece power cables. Torch bodies only include cup gasket.
- R: Rubber jacketed power cable; all others are vinyl jacketed.



Part No. WP-18

Part No.	Description	Max AMPS	Head Angle	Gas Valve	Handle Style	Access Kit	Hook-Up Kit
WP-18	Torch body	350	70°	-	Textured 1-1/16" dia.	AK-3	HK-1
WP-18-12	Torch package						
WP-18-12-R							
WP-18-25							
WP-18-25-R							
WP-18V	Torch body, valve	350	70°	Knob	Textured	AK-3	HK-1
WP-18V-25	Torch package						
WP-18V-25							
WP-18V-25-R							



#	Part No.	Description
1	WP-18	Torch body, includes cup gasket (70°)
1A	18-7	Insert
2	57Y02	Long back cap, includes 98W18 O-ring
3	57Y04	Short back cap, includes 98W18 O-ring
4	54N01	Gas lens insulator
5	see chart A	Gas lens
6	see chart B	Alumina gas lens nozzle (See chart B)
7	54N63	Lg. diameter gas lens insulator
8	see chart A	Lg. diameter gas lens (see chart A)
9	see chart B	Lg. diameter gas lens nozzle (see chart B)
10	18CG	Cup gasket
11	see chart A	Collet (see chart A)
12	see chart A	Collet body (see chart A)
13	see chart B	Alumina nozzle (see chart B)
14	see chart B	Lava nozzle (see chart B)
15	18CG20	Stubby gasket
16	see chart A	Stubby collet
17	see chart A	Stubby collet body
18	see chart B	Stubby alumina nozzle
19	see chart B	Long lava nozzle
20	45V11	Power cable adapter
21	WP-18SP	Pencil torch body, includes cup gasket
22	H-200	Handle (smooth, standard on WP-18, 18SP)
24	<b>Water Hose</b>	
	40V74	12-1/2 ft. (3.8 m)
	40V74R	40V74 12-1/2 ft. (3.8 m), rubber
	41V32	25 ft. (7.6 m)
25	<b>Power Cable</b>	
	40V64	12-1/2 ft. (3.8 m)
	40V64R	12-1/2 ft. (3.8 m), rubber
	41V29	25 ft. (7.6 m)
26	<b>Gas Hose</b>	
	40V75	12-1/2 ft. (3.8 m)
	40V75R18	12-1/2 ft. (3.8 m), rubber
	41V30	25 ft. (7.6 m)
27	<b>Gas Hose</b>	
	41V30R18	25 ft. (7.6 m), rubber
27	WP-18V	Body, includes cup gasket and valve stem (70°)
28	VS-2	Valve stem, includes 98W77 O-ring
<b>Cable Repair Kits</b>		
ZCRK18	Power cable repair kit	
ZHRKW18	Water hose repair kit	

### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Dia.	.020	.040	1/16	3/32	1/8	5/32
Collet	10N21	10N22	10N23	10N24	10N25	54N20
Collet body	10N29	10N30	10N31	10N32	10N28	406488
Gas lens	45V29	45V24	45V25	45V26	45V27	45V28
Lg. dia. gas lens	45V0204	45V0204	45V116	45V64	995795	45V63
Stubby collet		10N22S	10N23S	10N24S	10N25S	
Stubby collet body		17CB20	17CB20	17CB20	17CB20	

### Chart B: Gas Nozzles

Size	4	5	6	7	8	10	12	Short
Alumina	10N50	10N49	10N48	10N47	10N46	10N45	10N44	
Alumina gas lens	54N18	54N17	54N16	54N15	54N14			54N19*
Large dia. gas lens			57N75		57N74	53N88	53N87	53N89*
Long alumina		10N49L	10N48L	10N47L				
Long gas lens		54N17L	54N16L	54N15L				
Lava	105Z43	105Z42	105Z44	105Z45	08N78	08N79	08N80	
Long lava	12N03	105Z60	12N02	105Z61				
Stubby alumina	13N08	13N09	13N10	13N11	13N12	13N13		

\*Not recommended for use with high frequency current.

#### AK-3 (WP-18, 18V)

- 1-Short back cap
- 3-Collets 1/16", 3/32", 1/8"
- 3-Collets bodies 1/16", 3/32", 1/8"
- 3-Alumina nozzle 5, 6, 8
- 3-Tungsten electrodes 2%, 1/16", 3/32", 1/8" x 7" - thoriated

- Cable Covers:** WC-3-10, WC-3-22
- Extension Kit:** EK-1-25
- Weight:** 7 oz. (less hoses)
- Torch Length:** 9-1/4"

## Water Cooled TIG Torches

### Super Cool 18® TIG Torch

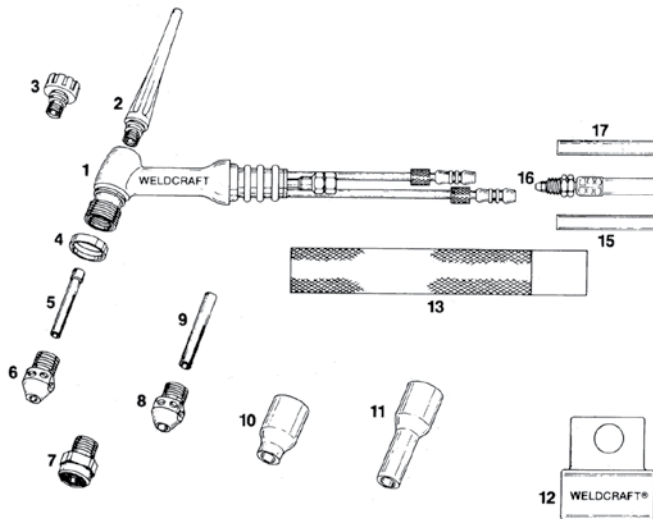
Weldcraft's Super Cool 18® solves the age-old problem of overheating associated with 18 style 350 amp water-cooled torches. Its unique patented water cooling chamber eliminates overheating, softening, twisting and buckling of the collet, which generally occurs when welding with AC current on aluminum alloys. The water cooling chamber design ensures water flow over the entire length of the head, keeping the collet and nose collet body cool. The gas nozzle is now screwed onto the water chamber sleeve so it will remain cooler for longer service.

- Torch packages available with R for rubber power cables.
- Torch bodies only include nozzle gasket.
- Torch packages include: Torch body, handle, long back cap, and power cable assembly. Power cable adapter must be ordered separately.
- Water cooling requirements: 1 – 1-1/2 quarts per minute at maximum of 50 PSI pressure.
- 3-piece vinyl power cable.



Part No. WP-18SC

Part No.	Description	Max AMPS	Head Angle	Handle Style	Access Kit	Hook-Up Kit
WP-18SC	Torch body	400	70°	Textured 1-1/16 dia.	AK-18	HK-1
WP-18SC-12	Torch package					
WP-18SC-25						



#### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Dia.	.040	1/16	3/32	1/8	5/32	3/16
Standard collet	10N22	10N23	10N24	10N25	54N20	
Heavy-duty collet				10N25HD	54N20HD	18C36
Gas lens	18GL04	18GL16	18GL32	18GL18	18GL53	18GL36
Std. nose collet body	NCB-53	NCB-53	NCB-53	NCB-53		
H.D. nose collet body				NCB-36*	NCB-36*	NCB-36*

\*Use only with heavy duty collets. Water cooled torches require cooling water flow of 1 quart (.94 liter) to 1-1/2 quarts (1.4 liters) per minute at a maximum of 50 PSI pressure.

#### Chart B: Gas Nozzles

Size	4	5	6	7	8	Short
Alumina	54N18	54N17	54N16	54N15	54N14	54N19*
Long alumina		54N17L	54N16L	54N15L	54N14L	

\*Not recommended for use with high frequency current.

**Cable Covers:** WC-3-10, WC-3-22  
**Extension Kit:** EK-1-25  
**Torch Length:** 9-1/4"

#	Part No.	Description
1	WP-18SC	Torch body, includes nozzle gasket (70°)
2	57Y02	Long back cap, includes 98W18 O-ring
3	57Y04	Short back cap, includes 98W18 O-ring
4	18NG	Nozzle gasket
5	see chart A	Standard collet
6	see chart A	Standard nose collet body
7	see chart A	Gas lens
8	see chart A	Heavy-duty nose collet body
9	see chart A	Heavy-duty collet
10	see chart B	Alumina nozzle
11	see chart B	Long alumina nozzle
12	45V11	Power cable adapter
13	H-200	Handle
17	<b>Water Hose</b>	
	40V74	12-1/2 ft. (3.8 m)
	40V74R	12-1/2 ft. (3.8 m), rubber
	41V32	25 ft. (7.6 m)
16	<b>Power Cable</b>	
	40V64	12-1/2 ft. (3.8 m)
	40V64R	12-1/2 ft. (3.8 m), rubber
	41V29	25 ft. (7.6 m)
15	<b>Gas Hose</b>	
	40V75	12-1/2 ft. (3.8 m)
	40V75R18	12-1/2 ft. (3.8 m), rubber
	41V30	25 ft. (7.6 m)
15	41V30R18	25 ft. (7.6 m), rubber
	<b>Cable Repair Kits</b>	
ZCRK18	Power cable repair kit	
ZHRKW18	Water hose repair kit	

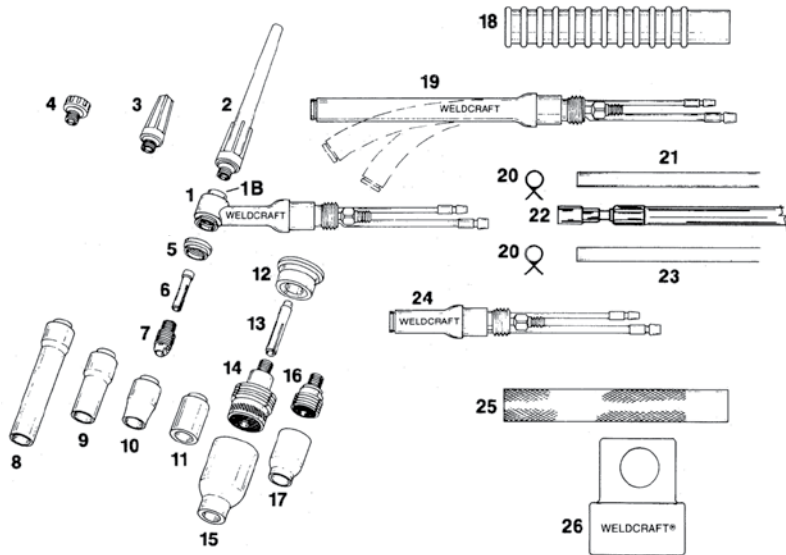
## Water Cooled TIG Torches

### WP-20 Series

- Lightweight, small durable torches
- Compact and well-balanced for general duty use. Efficient around the head cooling for trouble free performance and long life. Parts interchange with WP-9, WP-9P and WP-25 Models.



Part No.	Description	Max AMPS	Head Angle	Gas Valve	Handle Style	Access Kit	Hook-Up Kit
WP-20	Torch body	250	70°	-	Textured 3/4" dia.	AK-4	HK-1
WP-20-12	Torch package						
WP-20-12-R							
WP-20-25 WP-20-25-R							
WP-20V	Torch body	250	70°	Knob & stem	Textured 3/4" dia.	AK-4	HK-1
WP-20V-12 WP-20V-25	Torch package						
WP-20P	Torch body	225	180°	-	Textured 3/4" dia.	AK-4A	HK-1
WP-20P-12	Torch package						
WP-20P-25							
WP-25	Torch body	200	180° FLEX	-	Textured 3/4" dia.	AK-4A	HK-1
WP-20P-12	Torch package						
WP-20P-25							



Part No. WP-20

#	Part No.	Description
1	WP-20	Torch body, includes cup gasket (70°)
1B	09-4	Insert
2	41V24	Long back cap, includes 98W77 O-ring
3	41V35	Medium back cap, includes 98W77 O-ring
4	41V33	Short back cap, includes 98W77 O-ring
5	598882	Cup gasket
6	see chart A	Collet
7	see chart A	Collet body
8	see chart B	Extra long lava nozzle
9	see chart B	Long lava nozzle
10	see chart B	Alumina nozzle
11	see chart B	Lava nozzle
12	54N63-20	Lg. diameter gas lens insulator
13	see chart A	Lg. diameter gas lens collet
14	see chart A	Lg. diameter gas lens
15	see chart B	Lg. diameter gas lens nozzle
16	see chart A	Gas lens
17	see chart B	Alumina gas lens nozzle
18	53N06R	Handle (ribbed, optional)
19	WP-25	Flexible torch body, includes cup gasket
20	53N04	Hose clamp
<b>Gas Hose</b>		
21	45V09	12-1/2 ft. (3.8 m)
	45V09R	12-1/2 ft. (3.8 m), rubber
	45V10	25 ft. (7.6 m)
	45V10R	25 ft. (7.6 m), rubber
<b>Power Cable</b>		
22	45V03	12-1/2 ft. (3.8 m)
	45V03R	12-1/2 ft. (3.8 m), rubber
	45V03HD	12-1/2 ft. (3.8 m), heavy duty
	45V04	25 ft. (7.6 m)
	45V04R	25 ft. (7.6 m), rubber
23	45V04HD	25 ft. (7.6 m), heavy duty
	<b>Water Hose</b>	
	45V07	12-1/2 ft. (3.8 m)
	45V07R	12-1/2 ft. (3.8 m), rubber
	45V07HD	12-1/2 ft. (3.8 m), heavy duty
24	45V08	25 ft. (7.6 m)
	45V08R	25 ft. (7.6 m), rubber
	45V08HD	25 ft. (7.6 m), heavy duty
	WP-20P	Pencil torch body, includes cup gasket
	<b>Handle</b>	
25	H-100	Torch handle for WP-20V
	53N06	Handle (smooth, standard) for WP-20, WP-20P, WP-25
26	45V11	Power cable adapter
<b>Cable Repair Kits</b>		
	ZCRK20	Power cable repair kit
	ZHRKG20	Gas hose repair kit
	ZHRKW20	Water hose repair kit
VS-2		Valve stem, includes 98W77 O-ring (not shown)

#### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Dia.	.020	.040	1/16	3/32	1/8
Collet	13N20	13N21	13N22	13N23	13N24
Collet body	13N25	13N26	13N27	13N28	13N29
Gas lens	45V41	45V42	45V43	45V44	45V45
Lg. diameter gas lens collet	13N20L	13N21L	13N22L	13N23L	13N24L
Lg. diameter gas lens	45V0204S	45V0204S	45V116S	45V64S	995795S

#### Chart B: Gas Nozzles

SIZE	3	4	5	6	7	8	10	12	SHORT
Alumina		13N08	13N09	13N10	13N11	13N12	13N13		
Alumina gas lens		53N58	53N59	53N60	53N61	53N61S			
Large dia. gas lens				57N75		57N74	53N88	53N87	53N89*
Lava		13N14	13N15	13N16	13N17	13N18	13N19		
Long Lava	796F70	796F71	796F72	796F73					
Ex. Long Lava	796F74	796F75	796F76	796F77					

\*Not recommended for use with high frequency current.

**Cable Covers:** WC-3-10, WC-3-22  
**Extension Kit:** EK-1-25  
**Weight WP-20:** 3 oz. (less hoses)  
**Weight WP-25:** 4 oz. (less hoses)  
**Torch Length:** WP-20: 7" WP-20P: 6-1/2" WP-25: 11"

**AK-4 (WP-20)**  
 1-Short Back Cap  
 3-Collets 1/16", 3/32", 1/8"  
 3-Collet Bodies 1/16", 3/32", 1/8"  
 3-Al. Nozzle 5, 6, 7  
 3-Tungsten Electrodes 2%, 1/16", 3/32", 1/8" x 7"

## Water Cooled Machine Torches

### WP-22 Series

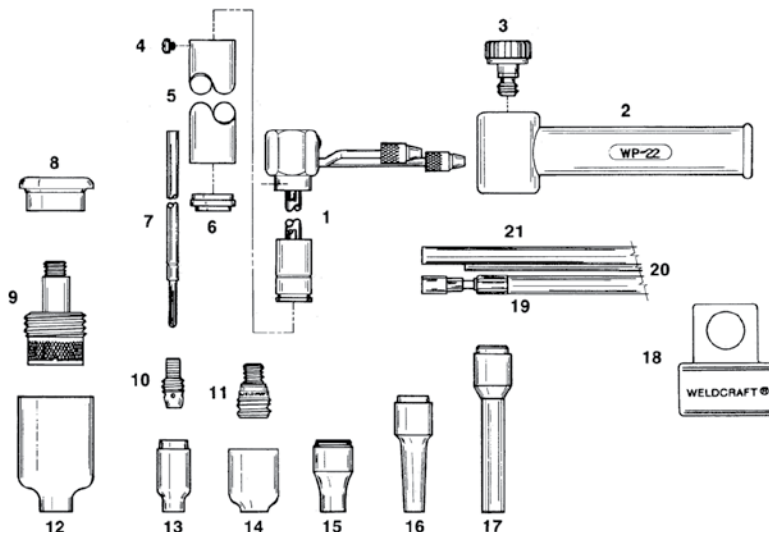
Front or back loading of the tungsten electrode. Torch does not need to be moved to load or remove the electrode. Front or back tightening of the electrode. The adjustment to tighten the electrode can be made with the ribbed sleeve at the nozzle end or by the knob at the back end of torch. Standard collet bodies, gas lens collet bodies and gas cups interchange with the popular WP-20 manual torch.

- Model A uses 7" long tungsten electrodes.
- Model B uses 3" long tungsten electrodes.
- Air cooled available: WP-23A.

Part No.	Description	Max AMPS	Overall Length	Access Kit	Hook-Up Kit
WP-22A	Torch head	250	6-1/2"	N/A	HK-1
WP-22A-3	Torch package				
WP-22A-12 WP-22A-25					
WP-22B	Torch head	250	3-1/2"	N/A	HK-1
WP-22B-3	Torch package				
WP-22B-12 WP-22B-25					



Part No. WP-22A



#	Part No.	Description
1	WP-22A	7" long torch body
	WP-22B	3" long torch body
2	22-9	Insulating boot
3	22-7	Collet knob, includes 98W77 O-ring
4	18R-1	6-32 x 3/16" fillister head screw
5	22-8A	7" barrel
	22-8B	3" barrel
6	22-10	Cup gasket
7	see chart A	Collet
8	54N63-22	Lg. diameter gas lens insulator
9	see chart A	Lg. diameter gas lens
10	see chart A	Collet body
11	see chart A	Gas lens
12	see chart B	Lg. diameter gas lens nozzle
13	see chart B	Alumina nozzle
14	see chart B	Alumina gas lens nozzle
15	see chart B	Lava nozzle
16	see chart B	Long lava nozzle
17	see chart B	Extra long lava nozzle
18	45V11	Power cable adapter
<b>Power Cable</b>		
19	45V03HD-L3	3 ft. (.9 m)
	45V03HD	12-1/2 ft. (3.8 m)
	45V04HD	25 ft. (7.6 m)
<b>Gas Hose</b>		
20	45V09-L3	3 ft. (.9 m)
	45V09	12-1/2 ft. (3.8 m)
	45V10	25 ft. (7.6 m)
<b>Water Hose</b>		
21	45V07HD-L3	3 ft. (.9 m)
	45V07HD	12-1/2 ft. (3.8 m)
	45V08HD	25 ft. (7.6 m)
<b>Cable Repair Kits</b>		
ZCRK20	Power cable repair kit	
ZHRKG20	Gas hose repair kit	
ZHRKW20	Water hose repair kit	

### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Diameter	.040	1/16	3/32	1/8
Collet	22N21A 22N21B	22N22A 22N22B	22N23A 22N23B	22N24A 22N24B
Collet body	13N26	13N27	13N28	13N29
Gas lens	45V42	45V43	45V44	45V45
Lg. diameter gas lens collet	22N21AL	22N22AL	22N23AL	22N24AL
Lg. diameter gas lens	45V0204S	45V116S	45V64S	995795S

Water cooled torches require cooling water flow of 1 quart (.94 liter) to 1-1/2 quarts (1.4 liters) per minute at a maximum of 50 PSI pressure.

### Chart B: Gas Nozzles

Size	3	4	5	6	7	8	10	12	Short
Alumina		13N08	13N09	13N10	13N11	13N12	13N13		
Alumina gas lens		53N58	53N59	53N60	53N61	53N61S			
Lg. diameter gas lens				57N75		57N74	53N88	53N87	53N89*
Lava		13N14	13N15	13N16	13N17	13N18	13N19		
Long lava	796F70	796F71	796F72	796F73					
Ex. long lava	796F74	796F75	796F76	796F77					

\*Not recommended for use with high frequency current.

**Cable Covers:** WC-3-10, WC-3-22  
**Extension Kit:** EK-1-25

## Water Cooled / Air Cooled TIG Torches

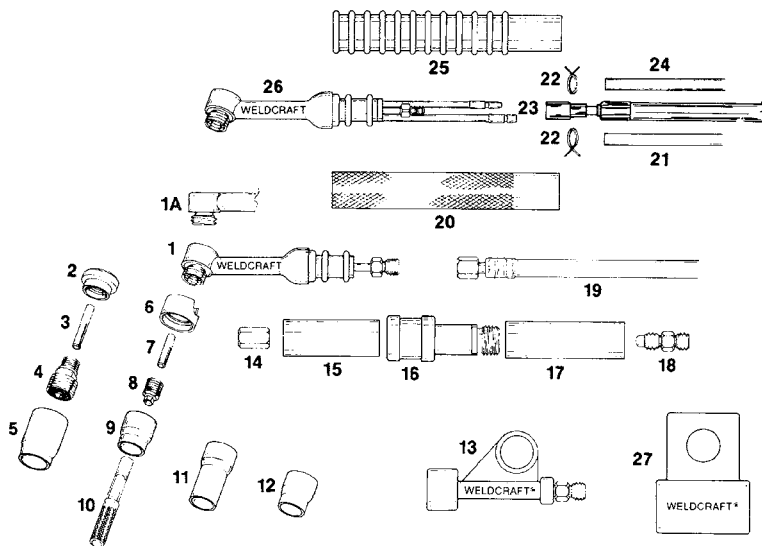
### WP-24 Series

- Small, lightweight torch ideal for intricate work and reaches into tight places.
- Handle mounted gas control valve available. Feather weight but well-balanced and durable.
- Torch packages include: Torch body, handle, power cable assembly, and insulating gasket. power cable adapter must be ordered separately.
- If other than standard power cable is desired for air cooled torch, change last character to receive desired power cable.
- Parts interchange with WP-24W model.



Part No. WP-24

Part No.	Description	Max AMPS	Head Angle	Handle Style	Access Kit	Hook-Up Kit	Cable
WP-24	Torch body	80	60°	Textured 3/4 Dia.	AK-5	Call for details	2-piece rubber power cable
WP-24-12-2	Torch package						
WP-24-25-2	Torch package						
WP-24W	Torch body	180	70°	Textured 3/4 Dia.	AK-5W	HK-1	3-piece vinyl power cable
WP-24W-12	Torch package						
WP-24W-25	Torch package						



#### Chart A: Collets, Collet Bodies, Gas Lens

Electrode Diameter	.020	.040	1/16	3/32
Collet	53N15	53N16	53N14	24C332
Collet body	53N17	53N18	53N19	24CB332
Gas lens collet	53N62	53N63	53N64	24GLC332
Gas lens	45V41	45V42	45V43	45V44

Water cooled torches require cooling water flow of 1 quart (.94 liter) to 1-1/2 quarts (1.4 liters) per minute at a maximum of 50 PSI pressure.

#### Chart B: Gas Nozzles

Size	.165	4	5	6	7	8
Alumina		A53N24	A53N25	A53N27		
Lava	53N23	53N24	53N25	53N27		
Long lava		53N28		53N26		
Alumina gas lens		53N58	53N59	53N60	53N61	53N61S

\*Not recommended for use with high frequency current

<b>Cable Covers:</b>	WC-3-10, WC-3-22
<b>Extension Kit:</b>	Not available
<b>Weight WP-24:</b>	1 oz. (less power cable)
<b>Weight WP-24W:</b>	3 oz. (less hoses)
<b>Torch Length:</b>	7-1/2"

#	Part No.	Description
1	WP-24	Torch body includes cup gasket (60°)
1A	WP-24N	Torch body same as WP-24, with 90° head
2	53N66	Gas lens insulator
3	see chart A	Gas lens collet
4	see chart A	Gas lens
5	see chart B	Alumina gas lens nozzle
6	53N22	Cup gasket
7	see chart A	Collet
8	see chart A	Collet body
9	see chart B	Lava nozzle
10	53N20	Collet body wrench
11	see chart B	Long lava nozzle
12	see chart B	Alumina nozzle
13	53N43	Power cable adapter (WP-24)
14	24 -4	Coupler
15-7	V-92	Valve assembly. includes items 15, 16, 17
15	V-92-1	Front handle (not sold separately)
16	V-92-2	Valve body (not sold separately)
17	V-92-3	Rear handle (not sold separately)
18	24 -5	Adapter
	<b>Power Cable (WP-24)</b>	
	56Y38	12-1/2 ft. (3.8 m) vinyl
19	56Y97	25 ft. (7.6 m) vinyl
	56Y38R	12-1/2 ft. (3.8 m) rubber
	56Y97R	25 ft. (7.6 m) rubber
20	H-100	Handle (smooth, standard)
	<b>Water Hose (WP-24W)</b>	
21	45V07	12-1/2 ft. (3.8 m)
	45V08	25 ft. (7.6 m)
22	53N04	Hose clamp
	<b>Power Cable (WP-24W)</b>	
23	45V03	12-1/2 ft. (3.8 m)
	45V04	25 ft. (7.6 m)
	<b>Gas Hose (WP-24W)</b>	
24	45V09	12-1/2 ft. (3.8 m)
	45V10	25 ft. (7.6 m)
25	H-100R	Handle (ribbed, optional)
26	WP-24W	Torch body, includes cup gasket (70°)
27	45V11	Power cable adapter (WP-24W)

## Water Cooled TIG Torches

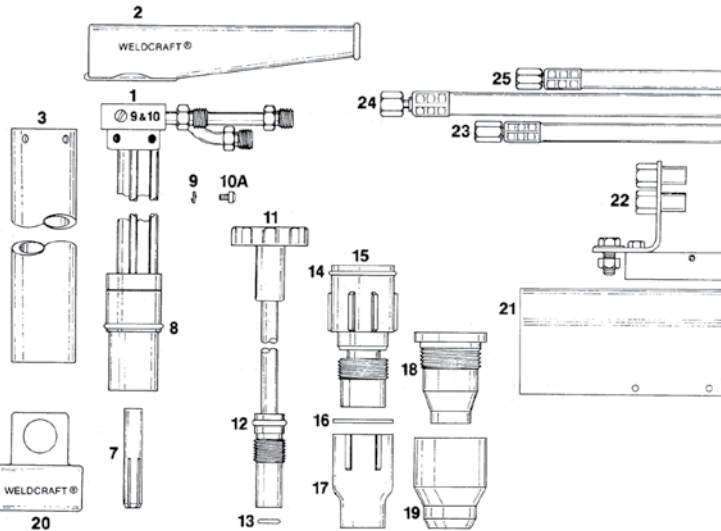
### WP-27 Series

- Features front or back loading or tightening of the tungsten electrode. Torch does not need to be moved to load or remove the electrode. The adjustment to tighten the electrode can be made with the ribbed sleeve at the nozzle end or by the knob at the back end of torch. Internal tungsten adjustment. The electrode can be raised or lowered within the torch for extremely fine positioning. Axial movement of approximately 1/4" is possible.
- Collet body has integral replaceable gas lens screens.
- Cooling requirements: 2 qt./min. (1.9 L/min.) - air cooled available in 9"-WP-27AAC.
- Maximum pressure 50 PSI (345 kPa).
- Electrode capacity .040" - 1/4" dia. (1,0 - 6,4 mm).
- Torch packages include: body assembly, barrel, shaft assembly, insulating boot, cable and hoses.



Part No. WP-27

Part No.	Description	Max AMPS	Barrel Dia.	Overall Length	Access Kit	Hook-Up Kit
WP-27A	Torch head	500	1-3/8	9"	AK-27	HK-1
WP-27A-12 WP-27A-25	Torch package					
WP-27B	Torch head	500	1-3/8	20"	AK-27	HK-1
WP-27B-3	Torch package w/ bracket assembly					
WP-27B-12 WP-27B-25	Torch package					



#### Chart A: Collets, Gas Lens

Electrode Diameter	1/16	3/32	1/8	5/32	3/16	1/4
Collet	57N46	57N47	57N48	57N49	57N50	57N51
Gas Lens	49V23	49V24	49V25	49V26	49V27	49V28

#### Chart B: Gas Nozzles

Size	6	8	10	12	SHORT*
Alumina	57N75	57N74	53N88	53N87	53N89
Metal**			57N78	57N77	

\*Not recommended for use with high frequency current.

\*\*Requires 57N76 adapter.

**Cable Covers:** WC-4-10, WC-4-22  
**Extension Kit:** Not available

#	Part No.	Description
1	WP-27A	Torch body, (9" long) includes shaft assembly, barrel & boot
	WP-27B	Torch body, (20" long) includes shaft assembly, barrel & boot
2	27-12	Insulating boot
3	27-10A	Barrel assembly. "A" model, includes 3 ea. 27-10 screw, 3 ea. 27-11 washer
	27-10B	Barrel assembly. "B" model, includes 3 ea. 27-10 screw, 3 ea. 27-11 washer
6	18R-1	6-32 x 3/16" fillister head screw
7	-	Collet (See chart A)
8	27-2-4	O-ring
9	27-11	#6 bronze lock washer
10	27-10	6-32 x 5/16" binding head screw
10A	27-19	6-32 x 5/16" binding head nylon screw
11	27-13A	Shaft assembly. "A" model includes shaft, knob, 1 ea. 27-13-2 & 27-13-3 O-ring
	27-13B	Shaft assembly. "B" model includes shaft, knob, 1 ea. 27-13-2 & 27-13-3 O-ring
12	27-13-2	O-ring
13	27-13-3	O-ring
14	181W89	O-ring 57WCNA Water cooled nozzle (not shown)
15	see chart A	Gas lens, includes 1 ea. 181W89 O-ring, 1 ea. 57N56 gasket
16	57N56	Gasket
17	see chart B	Alumina nozzle
18	57N76	Metal nozzle adapter
19	see chart B	Metal nozzle
20	45V11	Power cable adapter
21	27-18-3	Bracket insulating cover
22	27-18	Bracket assembly.* includes bracket, insulator block, insulator cover, mounting hardware: 1 ea. 1/2"-13 x 1" hex head brass cap screw 1 ea. 1/2"-13 hex brass nut 1 ea. 1/2" medium steel lock washer 1 ea. 1/2" plain brass washer
23	<b>Gas Hose</b>	
	40V82R-3	3 ft. (9 m)
	40V82R	12-1/2 ft (3.8 m)
24	<b>Power Cable</b>	
	40V84R-3	3 ft. (9 m)
	40V84R	12-1/2 ft (3.8 m)
	40V84RL	25 ft. (7.6 m)
25	<b>Water-in Hose</b>	
	40V83R-3	3 ft. (9 m)
	40V83R	12-1/2 ft (3.8 m)
	40V83RL	25 ft. (7.6 m)

\*Bracket assembly used on 3 ft. torch package only.



## Flex Torches

### Flex Torches

- Water-cooled flexible torch body & WP-25 long reach flex-Pencil type water-cooled torch body.
- Each WP-225 torch package includes: Torch body, 9-70 and 1726 heads, power cable assembly and handle.
- WP-25 torch packages include: Torch body, handle and power cable assembly.



Part No. SF-225



Part No. WP-25

Part No.	Description	Max AMPS	Cooling	Power Cable	Water Hose	Gas Hose	Handle
WP-225	Torch body	225	Water				
WP-225-12	Torch package			45V03	45V07	45V09	53N06
WP-225-25	Torch package			45V04	45V08	45V10	
WP-225-12-HD	Torch package			45V03HD	45V07HD	45V09	
WP-225-25-HD	Torch package			45V04HD	45V08HD	45V10	
WP-225-12-R	Torch package			45V03R	45V07R	45V09R	
WP-225-25-R	Torch package	45V04R	45V08R	45V10R			
WP-25	Torch body	200	Water				
WP-25-12	Torch package			45V03	45V07	45V09	53N06
WP-25-25	Torch package			45V04	45V08	45V10	
WP-25-12-HD	Torch package			45V03HD	45V07HD	45V09	
WP-25-25-HD	Torch package			45V04HD	45V08HD	45V10	
WP-25-12-R	Torch package			45V03R	45V07R	45V09R	
WP-25-25-R	Torch package	45V04R	45V08R	45V10R			

### WP-150/200 Air Cooled Flexible Torch Body Assembly



Part No. WP-150



Part No. WP-200

Flex Torch Bodies (Less Head)					
Part No.	Max AMPS	Cooling	Gas Valve	Torch Body	Element
WP-150	80-150	Air	No	150TB	150CE
WP-150V	80-150	Air	Yes	150VTB	150CE
WP-200	150-200	Air	No	200TB	200CE
WP-200V	150-200	Air	Yes	200VTB	200CE

### Torch Package Assembly

Each WP-150/150V and WP-200/200V torch package includes: 1726 and 1726P heads, heavy duty 2-piece power cable, coil element, solid element, handle and wrench. Available with R for 1-piece rubber power cables.

Part No.	Max AMPS	Cooling	Gas Valve	Torch Body	Coil Element	Handle
WP-150-12-2	150	Air	No	150TB	150CE	105Z55R
WP-150V-12-2			Yes	150VTB		
WP-150-25-2			No	150TB		
WP-150V-25-2			Yes	150VTB		
WP-200-12-2	200	Air	No	200TB	200CE	10N15R
WP-200V-12-2			Yes	200VTB		
WP-200-25-2			No	200TB		
WP-200V-25-2			Yes	200VTB		

### Interchangeable Heads



Part No. 9-70



Part No. 9-90



Part No. 09-P



Part No. 0024



Part No. 24-90



Part No. 1726



Part No. 1726P

Parts Used	Part No.	Max. AMPS		Head Angle
		A/C	W/C	
WP-9, 9P, 9V WP-20, 20P, 25	9-70	125	200	70°
	9-90	125	200	90°
	09-P	125	200	180°
WP-24, 24W	0024	80	160	70°
	24-90	80	160	90°
WP-17, 17V WP-18, 18V WP-26, 26V	1726	150/200	225	70°
	1726P	150/200	225	180°

## Flex Torches / 300 AMP Air Cooled TIG Torches

### Flex-Neck Parts



Part No.	Description	Torch Body
150TB	Torch body	9F, 17F, 24F WP150
150VTB	Torch body (valve)	9F, 17F, 24F WP150V
300LN	Lock nut	9F, 17F, 24F WP150
150W	Wrench	9F, 17F, 24F, WP150
105Z55R	Handle	9F, 17F, 24F, WP150
10N15R	Handle	16F, 26F, WP200, 200V
200W	Wrench	16F, 26F, WP200, 200V
200LN	Lock nut	16F, 26F, WP200, 200V
200TB	Torch body	16F, 26F, WP200
200VTB	Torch body (valve)	16F, 26F, WP200V
150CE	Coil element	WP150, 150V
200CE	Coil element	WP200, 200V
150SE	Solid element (converts torch to rigid neck)	WP150, 150V
200SE	Solid element (converts torch to rigid neck)	WP200, 200V
150TB-AA	Rubber torch body	9F, 17F, 24F, WP150
200TB-AA	Rubber torch body	16F, 26F, WP200

### Air-Cooled Flex

Part No.	Max Amps	Accessory Parts Used
009F	125	WP-9, 9P, 9V, 20, 20P, 25
017F	150	WP-17, 17V
026F	200	WP-18, 18V, 26, 26V
024F	80	WP-24
016F	160	AHP-16, 35

### Torch Body Assembly

Torch Assembly	Max. Amp	Cooling	Gas Valve	Torch Body
WP-9F	125	Air	No	150TB
WP-9FV	125	Air	Yes	150VTB
WP-17F	150	Air	No	150TB
WP-17FV	150	Air	Yes	150VTB
WP-26F	200	Air	No	200TB
WP-26FV	200	Air	Yes	200VTB
WP-24F	80	Air	No	150TB
WP-24FV	80	Air	Yes	150VTB
WP-16F	160	Air	No	200TB
WP-16FV	160	Air	Yes	200VTB

### Torch Package Assembly

- Torch package includes: torch body assembly, ribbed handle, 2-piece power cable, and wrench.
- Available with R for 1-piece rubber power cables.
- All other torch packages must be ordered by components: only T/B, handle, cable.

Torch Assembly	Head Style	Max Amps	Cooling	Ribbed Handle
WP-9F-12-2 WP-9F-25-2 WP-9FV-12-2 (valve) WP-9FV-25-2 (valve)	9F	125	Air	105Z55R
WP-17F-12-2 WP-17F-25-2 WP-17FV-12-2 (valve) WP-17FV-25-2 (valve)	17F	150	Air	105Z55R
WP-26F-12-2 WP-26F-25-2 WP-26FV-12-2 (valve) WP-26FV-25-2 (valve)	26F	200	Air	10N15R
WP-24F-12-2 WP-24F-25-2 WP-24FV-12-2 (valve) WP-24FV-25-2 (valve)	24F	80	Air	105Z55R
WP-16FV-25-2 (valve) WP-16FV-25-R	16F	160	Air	10N15R

### Crafter™ Series 300 AMP Air Cooled Torch

- New high performance cable assembly.
- Uses 26 style replacement parts.
- 300 AMP DC and 250 AMP AC rating at 60% duty cycle.
- Also available in 125 AMP and 200 AMP models.



Part No.	Description	Size
CS300	Torch body	-
CS300-12-2	Torch package	12.5'
CS300-25-2	Torch package	25'
CS300-12PC	Power cable	12.5'
CS300-25PC	Power cable	25'

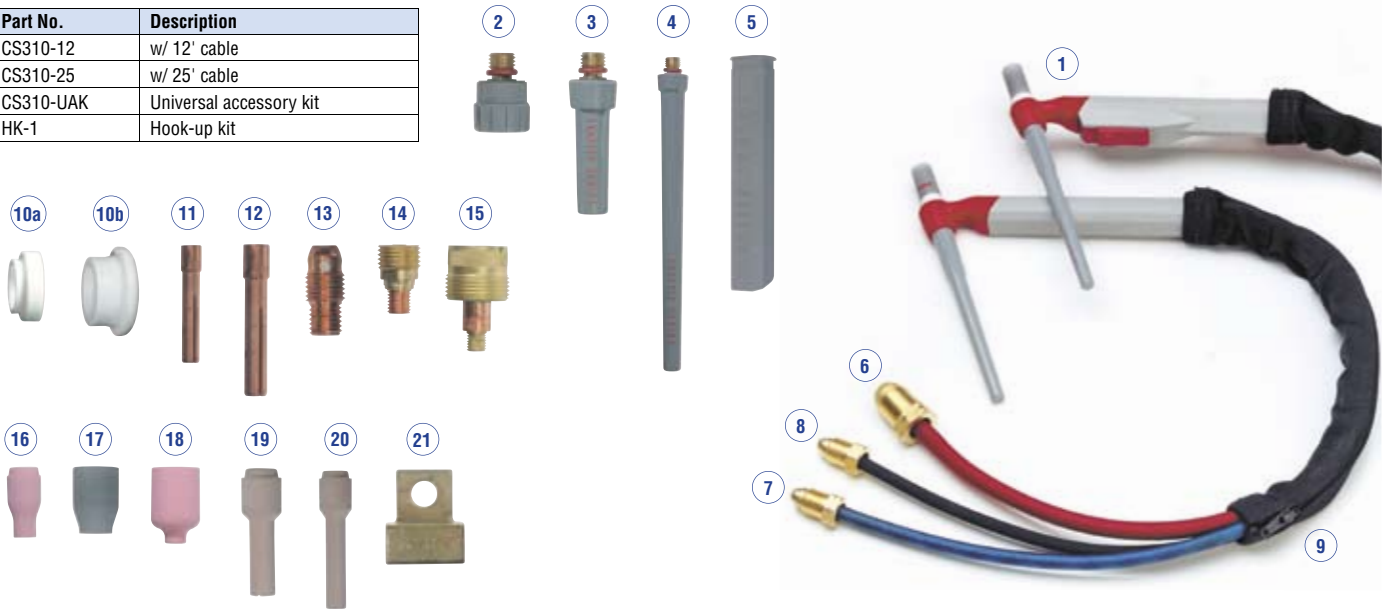
## Crafter™ Series 310 AMP / All In One Collet-Collet Body

### Crafter™ Series 310 AMP

- CS310 torch packages come assembled with: Torch body, handle, gas & water hoses, power cable, cable cover, #6 HPN nozzle, 3/32" collet, 3/32" collet body, 3/32" x 7" tungsten electrode and long back cap.
- CS310-UAK - Universal accessory kit, contains: (1) 3/32" and 1/8" collets, (1) 3/32" and 1/8" collet bodies, (1) 3/32" gas lens collet bodies, (1) 3/32" x 7" and 1/8" x 7" tungsten electrodes, (1) Short, medium and long back caps, (1) #5 and #6 alumina nozzles, and (1) #5 and #6 gas lens alumina nozzles.



Part No.	Description
CS310-12	w/ 12' cable
CS310-25	w/ 25' cable
CS310-UAK	Universal accessory kit
HK-1	Hook-up kit



**Chart A: Collets, Collet Bodies, Gas Lens**

#	Electrode Diameter	.020	.040	1/16	3/32	1/8
11	Collet	13N20	13N21	13N22	13N23	13N24
12	Lg. gas lens collet	13N20L	13N21L	13N22L	13N23L	13N24L
13	Collet body	13N25	13N26	13N27	13N28	13N29
14	Gas lens	41V41	45V42	45V43	45V44	45V45
15	Lg. gas lens collet body	45V0204S	45V0204S	45V116S	45V64S	995795S

**Chart B: Gas Nozzles**

#	Size	4	5	6	7	8	10	12
16	Alumina	13N08	13N09	13N10	13N11	13N12	13N13	
17	Gas lens alumina	53N58	53N59	53N60	53N61	53N61S		
18	Lg. gas lens alumina			57N75		57N74	53N88	53N89
19	Long lava nozzle**	796F71	796F72	796F73				
20	X-tra lg. lava nozzle	796F75	796F76	796F77				

**Note:** For higher applications, reference CS410, WP-18SC, or call your weldcraft supplier.

#	Part No.	Description
1	CS310A	Torch body, includes 598882 insulator
2	CS110-BCS	Back cap, short, includes 98W77 O-ring
3	CS110-BCM	Back cap, medium, includes 98W77 O-ring
4	CS110-BCL	Back cap, long, includes 98W77 O-ring
5	CS110-H	D-Handle
6	CS310-12PC	Power cable, red, 12.5' (3.8 m)
	CS310-25PC	Power cable, red, 25' (7.6 m)
7	CS310-25W	Water hose, blue, for CS310 and CS410, 25' (7.6 m)
8	CS310-12G	Gas hose, black, 12.5' (3.8 m)
	CS310-25G	Gas hose, black, 25' (7.6 m)
9	WC-3-10	Cable cover, 10' (3.0 m)
	WC-3-22	Cable cover, 22' (6.7 m)
10a	598882	Teflon insulator
10b	54N63-20	Teflon insulator, for large diameter gas lenses
21	45V11	Power cable adapter

### All In One Collet / Stubby Pencil Collet Body

- Fits into your existing torch quickly and easily with no special adjusting or additional care to achieve proper tungsten alignment.
- Quicker, easier changeover of tungsten size.
- Eliminates mismatch of collets and collet bodies.
- Avoids lost collets.
- Fewer parts to stock and easier to manage.
- Same great torch performance.
- Improved centering of the tungsten.



Part No.	Size
10N116SP	1/16"
10N332SP	3/32"
10N18SP	1/8"
13N116SP	1/16"
13N332SP	3/32"
13N18SP	1/8"


## Air and Water Cooled Quick Connect System

### Quick Connect System

Power Supply	Connection Type	QCS Hook-up Kit		
		Air Cooled		Water Cooled
		1 Pc.	2 Pc.	
<b>ESAB®</b>				
Heliarc 160I	DIN	Q5G-150	00Q5	
Handy TIG 180	DIN	Q5G-150	00Q5	
Heliarc 252/352	Threaded stud*	Q5G-150 Q5G-200	00Q5	0Q5W
<b>LINCOLN®</b>				
Invertec®				
160 series	DIN	Q5G-150	00Q5	Q5WGT
V-205-T	DIN (gas through)	Q5GT-150*		
V-205-S	DIN	Q5G-150	00Q5	
Square Wave Series				
TIG 175	DIN (gas through)	Q5GT-150		Q5WGT 0Q5W
TIG 275	DIN (gas through)	Q5GT-200		
TIG 355	Threaded stud*			
Precision series				
TIG 275	Direct thread connections	Not required	Not required	Not required
TIG 375				
<b>MILLER®</b>				
Econotig®	DIN (gas through)	Q5GT-150		Q5WGT
Dynasty®				
300 series	DIN DIN	Q5G-150 Q5G-200	00Q5	0Q5W
Maxstar®				
91	DIN	Q5G-150	00Q5	
152	DIN	Q5G-150	00Q5	
200 Series	DIN	Q5G-150	00Q5	
300 Series	DIN	Q5G-200	00Q5	
Synchrowave®	DIN (gas through)	Q5GT-150		
250 (all models)	Threaded stud*	Q5G-150	00Q5	0Q5W
350 (all models)	Threaded stud*	Q5G-200	00Q5	0Q5W
500	Threaded stud*	Q5G-200	00Q5	0Q5W
Aerowave®	Threaded stud*	Q5G-200	00Q5	0Q5W


\*Power supplies with a threaded stud require a QCS-M adapter.

<b>THERMAL ARC®</b>		
Pro-Lites®		
LS300	DIN	Q5G-150
LT300	DIN	Q5G-200
LM300	DIN	Q5G-200
Pro-Plus®		
400S	DIN	Q5G-150, Q5G-200
400GTS	DIN	Q5G-150, Q5G-200
400GMS	DIN	Q5G-150, Q5G-200
AC/DC Inverter		
400GTSW	DIN	Q5G-150, Q5G-200
CC/CV Inverter		
600GMS	DIN	Q5G-150, Q5G-200




**00Q5**

- 2 Pc. cable up to 200a.




**Q5G-150**

- Solid din w/gas side hose.
- For 150a 1 pc. cable.




**Q5G-200**

- Solid din w/ gas side hose.
- For 200a 1 pc. cable.




**Q5GT-150**

- Gas through din.
- For 150a 1 pc. cable.




**Q5GT-200**

- Gas through din.
- For 200a 1 pc. cable.



**0Q5W**

- Solid din w/ water side hose.



**Q5WGT**

- Gas through din.
- For water-cooled torch.

