

Tweco®

Spray Master™

AIR-COOLED MIG GUNS

The **Cooler** Gun
for your **Hottest**
Spray and Pulse
Welding Applications.

The
Professional's
Choice.



Welding the World Since 1936!

A THERMADYNE® Company

A Cool Gun for Your Hottest Applications!



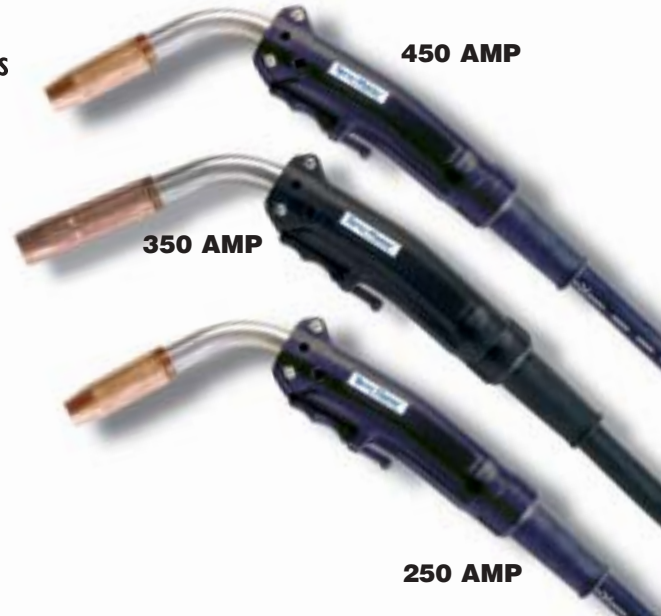
A THERMADYNE Company

Spray Master™

AIR-COOLED MIG GUNS

250, 350 & 450 AMP AIR-COOLED 80% duty cycle, mixed gases

- Heavy-duty contact tip and diffuser for improved performance in high heat applications
- Rated at 80% duty cycle using Argon/CO₂ gases
- Ergonomic handle design reduces welder's fatigue
- Simplified direct rear plug for ease of installation
- Easy to repair and maintain – only 10 parts
- Optional locking trigger or dual schedule trigger (350 & 450 Amp only)
- Ideal for use with Argon mixed gas for Spray and Pulse welding applications



250 AMP MIG GUN

Wire Size	Cable Length	Rear Connection Style (PART NO. / STOCK NO.)				Dual Schedule Trigger	Locking Trigger	Long Conductor Tubes
		Tweco*	Miller	Lincoln†	Euro-Kwik			
.035"- .045" 0,9-1,2mm Wire	10 ft. 3M	MS210-3545 1023-1100	MS210M-3545 1023-1110	N/A	MS210X-3545 1023-1125			
.035"- .045" 0,9-1,2mm Wire	12 ft. 4M	MS212-3545 1023-1101	MS212M-3545 1023-1111	MS212L-3545 1023-1136	MS212X-3545 1023-1126			
.035"- .045" 0,9-1,2mm Wire	15 ft. 5M	MS215-3545 1023-1102	MS215M-3545 1023-1112	N/A	MS215X-3545 1023-1127			
.035"- .045" 0,9-1,2mm Wire	20 ft. 6M	MS220-3545 1023-1103	MS220M-3545 1023-1113	N/A	N/A			
.035"- .045" 0,9-1,2mm Wire	25 ft. 8M	MS225-3545 1023-1108	MS225M-3545 1023-1118	N/A	MS225X-3545 1023-1133			

* May require adapter plug for some feeders

† Fits Lincoln LN 7, 8, 9, SP200

350 AMP MIG GUN

Wire Size	Cable Length	Rear Connection Style (PART NO. / STOCK NO.)				Dual Schedule Trigger	Locking Trigger	Long Conductor Tubes
		Tweco*	Miller	Lincoln†	Euro-Kwik			
.045"-1/16" 1,2-1,6mm Wire	10 ft. 3M	MS310-116 1036-1610	MS310M-116 1036-1635	N/A	MS310X-116 1036-1618			
.045"-1/16" 1,2-1,6mm Wire	12 ft. 4M	MS312-116 1036-1613	MS312M-116 1036-1638	MS312L-116 1036-1646	MS312X-116 1038-1621			
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS315-116 1036-1615	MS315M-116 1036-1640	MS315L-116 1036-1647	MS315X-116 1036-1623			
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS315-116DS 1036-1631	MS315M-116DS 1036-1633	N/A	N/A	X		
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS315-116LC 1036-1627	MS315M-116LC 1036-1629	N/A	MS315X-116LC 1036-1628		X	
.045"-1/16" 1,2-1,6mm Wire	20 ft. 6M	MS320-116 1036-1612	MS320M-116 1036-1637	N/A	N/A			
.045"-1/16" 1,2-1,6mm Wire	25 ft. 8M	MS325-116 1036-1617	MS325M-116 1036-1642	N/A	MS325X-116 1036-1620			

* May require adapter plug for some feeders

† Fits Lincoln LN 7, 8, 9, SP200

A Cool Gun for Your Hottest Applications!



A THERMADYNE Company

450 AMP MIG GUN

Wire Size	Cable Length	Rear Connection Style (PART NO. / STOCK NO.)				Dual Schedule Trigger	Locking Trigger	Long Conductor Tubes
		Tweco*	Miller	Lincoln†	Euro-Kwik			
.045"-1/16" 1,2-1,6mm Wire	10 ft. 3M	MS410-116 1040-1050	MS410M-116 1040-1060	MS410L-116 1040-1070	MS410X-116 1040-1075			
.045"-1/16" 1,2-1,6mm Wire	12 ft. 4M	MS412-116 1040-1051	MS412M-116 1040-1061	N/A	MS412X-116 1040-1076			
.045"-1/16" 1,2-1,6mm Wire	12 ft. 4M	N/A	MS412M-116DS 1040-1096	N/A	N/A	X		
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS415-116 1040-1052	MS415M-116 1040-1062	MS415L-116 1040-1072	MS415X-116 1040-1077			
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS415-116DS 1040-1095	MS415M-116DS 1040-1097	N/A	N/A	X		
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS415-116LC 1040-1090	MS415M-116LC 1040-1092	MS415L-116LC 1040-1074	MS415X-116LC 1040-1091		X	
.045"-1/16" 1,2-1,6mm Wire	15 ft. 5M	MS415-116LM 1040-1053	MS415M-116LM 1040-1063	MS415L-116LM 1040-1073	MS415X-116LM 1040-1078			X
.045"-1/16" 1,2-1,6mm Wire	20 ft. 6M	MS420-116 1040-1059	MS420M-116 1040-1064	N/A	N/A			
.045"-1/16" 1,2-1,6mm Wire	20 ft. 6M	N/A	MS420M-116DS 1040-1098	N/A	N/A	X		
.045"-1/16" 1,2-1,6mm Wire	25 ft. 8M	MS425-116 1040-1058	MS425M-116 1040-1068	MS425L-116 1040-1071	MS425X-116 1040-1083			
.045"-1/16" 1,2-1,6mm Wire	25 ft. 8M	N/A	MS425M-116DS 1040-1099	N/A	N/A	X		
.045"-1/16" 1,2-1,6mm Wire	25 ft. 8M	N/A	MS425M-116LM 1040-1069	N/A	N/A			X

* May require adapter plug for some feeders

† Fits Lincoln LN 7, 8, 9, SP200



350 Amp
Spray Master™ Parts

Minimize inventory costs with Spray Master's interchangeable front end consumables

NOZZLE STYLE	Fit Diffuser HD52-11 (1520-1130)		
	3/8" / 9,5MM BORE	1/2" / 12,7MM BORE	5/8" / 15,9MM 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 with standard 1/2" / 12,7mm bore nozzle: HD22-50

NOZZLE STYLE	Fit Diffuser EL52CT-16 (1560-1107)			
	3/8" / 9,5MM BORE	1/2" / 12,7MM BORE	5/8" / 15,9MM BORE	3/4" / 19,1MM 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)	N/A	EL22CT-50F 1260-1636	EL22CT-62F 1260-1637	N/A
Optional CT Type (Tip Protruded)	N/A	EL22CT-50P 1260-1691	EL22CT-62P 1260-1692	EL22CT-75P 1260-1693
Optional CT Type (Heavy Duty)	N/A	N/A	EL22CT-62H 1260-1629	N/A
Optional Arc Spot Nozzles (Flat Arc Spot)	N/A	N/A	EL221-62FAS 1260-1605	N/A

*350 amp guns ship with standard 5/8" / 15,9mm bore nozzle: EL22CT-62

NOZZLE STYLE	Fits Diffuser HD54-16 (1540-1136)		
	1/2" / 12,7MM BORE	5/8" / 15,9MM BORE	3/4" / 19,1MM 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

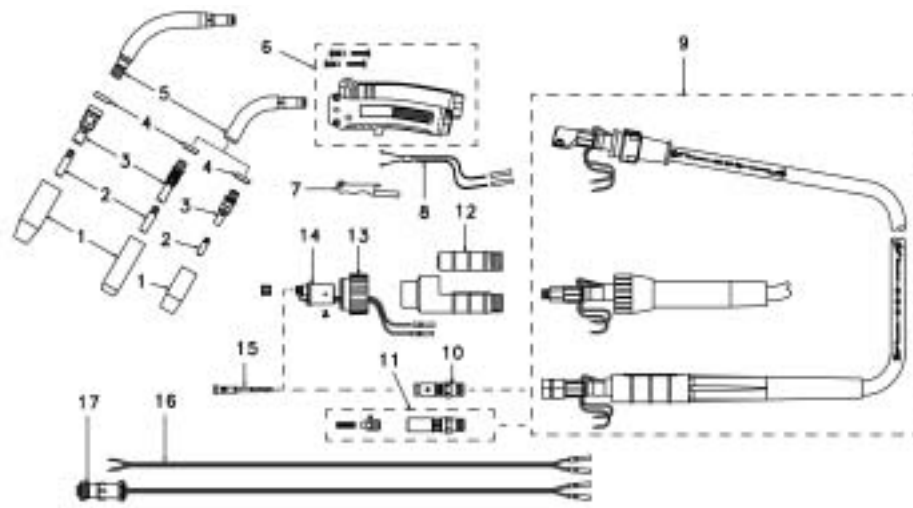
*450 amp guns ship with standard 5/8" / 15,9mm bore nozzle: HD24L-62

WIRE SIZE IN. / METRIC	TIP I.D. IN. / METRIC	(PART NO. / STOCK NO.)	
		250 AMP	350 & 450 AMP
.023" 0,6mm	.031" 0,79mm	11-23 1110-1100	N/A
.030" 0,8mm	.038" 0,97mm	11H-30 1110-1201	N/A
.035" 0,9mm	.044" 1,12mm	11H-35 1110-1202	16S-35 1160-1102
.040" 1,0mm	.048" 1,22mm	11H-40 1110-1203	16S-40 1160-1103
.045" 1,2mm	.054" 1,37mm	11H-45 1110-1204	16S-45 1160-1104
.052" 1,3mm	.064" 1,65mm	N/A	16S-52 1160-1105
1/16" 1,6mm	.073" 1,85mm	N/A	16S-116 1160-1106
5/64" 2,0mm	.090" 2,29mm	N/A	16S-564 1160-1109
3/64" AL 1,2mm	.059" 1,50mm	11AH-364 1110-1213	16AS-364 1160-1113
1/16" AL 1,6mm	.082" 2,08mm	N/A	16AS-116 1160-1114

WIRE SIZE IN. / METRIC	(PART NO. / STOCK NO.)		WIRE SIZE IN. / METRIC	(PART NO. / STOCK NO.)
	250 AMP	350 & 450 AMP		
FOR USE WITH STEEL WIRE				
.023" 0,6mm	42-23-15 1420-1103		N/A	N/A
.030 / .035" 0,8 / 0,9mm	42-3035-15 1420-1113	.035 / .045" 0,9 / 1,2mm	44-3545-15 1440-1103	
.040 / .045" 1,0 / 1,2mm	42-4045-15 1420-1123	.052 / 1/16" 1,3 / 1,6mm	44-116-15 1440-1113	
N/A	N/A	5/64" 2,0mm	44-564-15 1440-1123	
FOR USE WITH ALUMINUM WIRE				
.035 / 3/64" 0,9 / 1,2mm	42N-3545-15 1420-1003	.030 / 3/64" 0,8 / 1,2mm	44N-3545-15 1440-1003	

- NOTES: 1) Front ends on 250 and 350 amp models are interchangeable by changing diffusers.
2) Front ends on 350 and 450 amp models are interchangeable by changing conductor tubes.
3) Consumable parts for Tweco's standard #4 gun may be used on Spray Master™ guns.

- 4) Consumable parts for Tweco's Eliminator® guns may be used with Spray Master™ guns by changing to an MS64-60 conductor tube



Tweco Products Inc., located in Wichita KS, is an ISO 9001 registered manufacturer.

(PART NO. / STOCK NO.)				
ITEM NO.	250 AMP	350 AMP	450 AMP	DESCRIPTION
1		Not Shown		Nozzles – See Page 3
2		Not Shown		Contact Tips – See Page 3
3	HD52-11 1520-1130	EL52CT-16 1560-1107	MS54-16SW 1540-1127	Diffuser (Standard)
3a	HD52-23-11 1520-1131		N/A	Diffuser (Optional) .023" / 0,6mm Wire
4		63J-3 1630-1121	66J-3 1660-1836	Insulator Assembly – ELC250 & ELC350
5	MS63-60S 1630-1196	MS63-60 1630-1189	MS64H-60 1640-1319	Conductor Tube
5	MS63-45S 1630-1195	MS63-45 1630-1188	MS64H-45 1640-1318	Conductor Tube (Standard On 25 ft. Guns Only)
6		MS84 2060-2130		Handle w/Screws
6a		152 2020-2152		Gun Hanger (not shown)
7		ELC94 2060-2647		Trigger
7a		ELC94L 2060-2654		Locking Trigger (not shown)
7b		DS96TB 2060-2632		Dual Schedule Trigger Assembly (not shown)
8		EL96B 2060-2606		Trigger Blade Assembly
9	MS210 1720-2115	MS310 1730-2035	MS410 1740-2115	Cablehoz Assembly 10 ft. / 3M
9	MS212 1720-2116	MS312 1730-2036	MS412 1740-2116	Cablehoz Assembly 12 ft. / 4M
9	MS215 1720-2117	MS315 1730-2037	MS415 1740-2117	Cablehoz Assembly 15 ft. / 5M
9	MS225 1720-2118	MS325 1730-2038	MS425 1740-2118	Cablehoz Assembly 25 ft. / 8M
9a	MS210X 1720-2106	MS310X 1730-2010	MS410X 1740-2121	Cablehoz Assembly, Euro-Kwik® 10 ft. / 3M
9a	MS212X 1720-2107	MS312X 1730-2011	MS412X 1740-2122	Cablehoz Assembly, Euro-Kwik® 12 ft. / 4M
9a	MS215X 1720-2108	MS315X 1730-2012	MS415X 1740-2123	Cablehoz Assembly, Euro-Kwik® 15 ft. / 5M
9a	MS225X 1720-2109	MS325X 1730-2013	MS425X 1740-2124	Cablehoz Assembly, Euro-Kwik® 25 ft. / 8M
10		350-174H 2035-2110		Tweco® Connector Plug
11		350-174MH 2035-2111		Miller® Connector Plug
12		X6RC 2060-2006		Euro-Kwik® Connector Case
13		174X-2 2040-2177		Euro-Kwik® Nut
14		174EX-1 2040-2276		Euro-Kwik® Connection Assembly
15		Not Shown		Conduit – See Page 3
16		35K-350-1 2000-2352		Tweco® Control Wire
17		WM-354M 2030-2075		Miller® Control Wire & Plug
Not Shown		194DS 2040-2195		Dual Schedule Control Wire & Plug

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