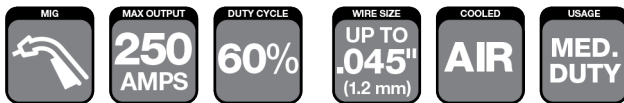


Spray Master Series

Spray Master® 250 AMP MIG Gun Air-Cooled

TWECO
AN ESAB BRAND



WELDING PROCESSES:

**MIG (GMAW), Flux Cored (FCAW),
Aluminum (GMAW)**

Standard Options Include:

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

Industry

- Ship and Offshore Yards
- Repair and Maintenance
- Steel Industry
- Industrial and General Fabrication
- Automotive

FEATURES

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

SPRAY MASTER 250 AMP

SPECIFICATIONS	
Description	Spray Master 250
Welding Output Mixed Gas	250 A at 80%
Wire Diameter, Mild Steel	Up To 0.045" (1.2mm)
Wire Diameter, Stainless	Up To 0.045" (1.2mm)
Wire Diameter, Aluminium	Up To 0.045" (1.2mm)
Wire Diameter, Flux-cored	Up To 0.045" (1.2mm)
Certification Mark (Standards)	CE IEC 60974-7
Operating Temperature	-10 to +40 °C
Cable Length	10 ft. (3 m), 12 ft. (3.6 m), 15 ft. (4.6 m), 20 ft. (6.1 m) and 25 ft. (7.6 m)

Tweco® Style Rear Connector

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

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

Miller® Style Rear Connector

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

Suffix "EL" = Eliminator Front End Consumables

Tweco® Style (8-pin) Rear Connector

8-pin Control Wire Connector - ESAB REBEL

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

Lincoln® Style Rear Connector

Fits Lincoln LNT, 8, 9, SP200

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

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

Euro-Kwik Style Rear Connector

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

Contact Tips – Standard Threaded Style

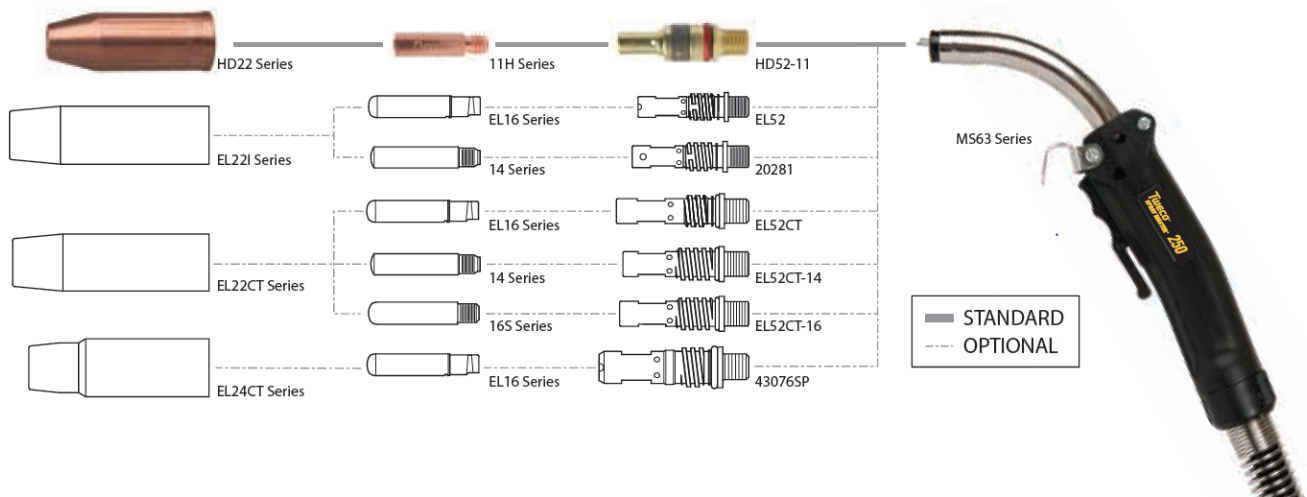
11, 11H & 11T Series

0.25" (6.35 mm) Outside Diameter –
M6 x 1.0 Threads - 1.00" (25.4 mm) Overall Length 25 per pack



Wire Size (in / mm)	Tip I.D.	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.023" (0.6 mm)	.031" (0.79 mm)	11-23	1110-1100	NA		11T-23	1110-1300
.030" (0.8 mm)	.038" (0.97 mm)	11-30	1110-1101	11H-30	1110-1201	11T-30	1110-1301
.035" (0.9 mm)	.044" (1.12 mm)	11-35	1110-1102	11H-35	1110-1202	11T-35	1110-1302
.040" (1.0 mm)	.048" (1.22 mm)	11-40	1110-1103	11H-40	1110-1203	11T-40	1110-1303
.045" (1.2 mm)	.054" (1.37 mm)	11-45	1110-1104	11H-45	1110-1204	11T-45	1110-1304
3/64" AL (1.2 mm)	.059" (1.50 mm)	NA		11AH-364	1110-1213	NA	

SPRAY MASTER 250 AMP SERIES



Nozzles & Nozzle Insulators – Air-Cooled

HD22 Series

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



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

Conductor Tubes – Air-Cooled

Spray Master® 250

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

Conduit Liners – For Use With Steel Welding Wires

180-250 Amp – Steel Wound

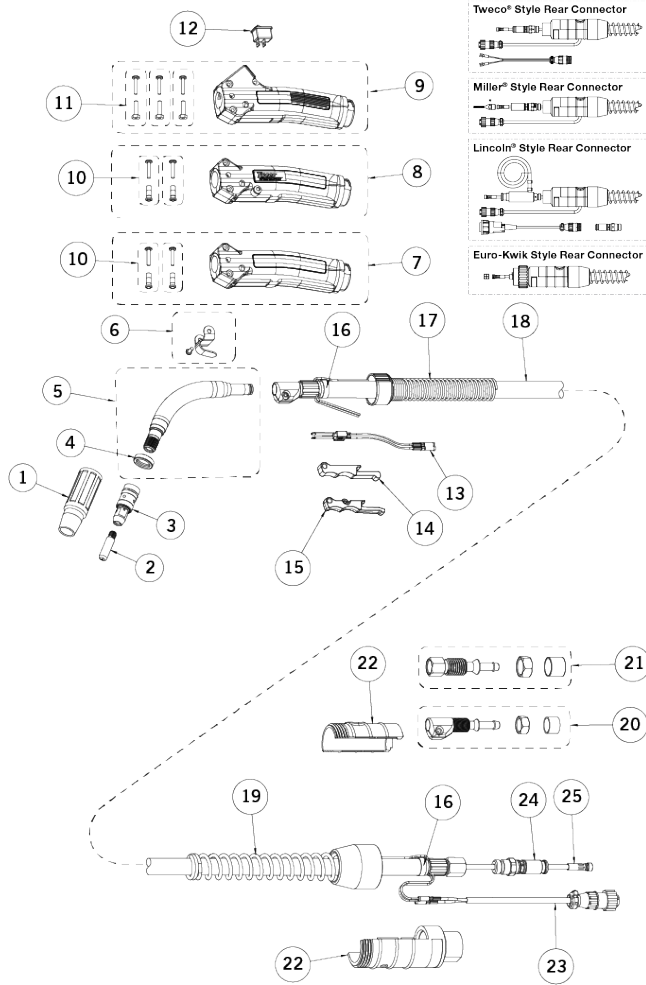
Wire Size	Length	Part No.	Stock No.
.030" - .035" (0.8 - 0.9 mm)	15 ft (4.6 m)	42-3035-15	1420-1113
.030" - .035" (0.8 - 0.9 mm)	25 ft (7.6 m)	42-3035-25	1420-1115
.040" - .045" (1.0 - 1.2 mm)	15 ft (4.6 m)	42-4045-15	1420-1123
.040" - .045" (1.0 - 1.2 mm)	25 ft (7.6 m)	42-4045-25	1420-1125
.052" - 1/16" (1.3 - 1.6 mm)	15 ft (4.6 m)	42-116-15	1420-1124

Conduit Liners – For Use With Aluminium Welding Wires

180-250 Amp – Teflon

Wire Size	Length	Part No.	Stock No.
.030" – 3/64" (0.8 – 1.2 mm)	15 ft (4.6 m)	42N-3545-15	1420-1003

Replacement Parts



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#	Description	Spray Master 250	
		Part No.	Stock No.
1	Nozzle	Refer To Page 3	
2	Contact Tip	Refer To Page 2	
3	Diffuser	HD52-11	1520-1130
4	Nozzle Insulator	63J-3	1630-1121
5	Conductor Tube	Refer To Page 3	
6	Gun Hanger	152	2020-2152
7	Handle (Standard)	MS84	2060-2130
8	Handle (Locking Trigger)	MS84LC	2060-2127
9	Handle (Dual Schedule)	MS84DSRS	2060-2128
10	Binder Posts & Screws (Standard & Locking)	ELC124FM	2060-2646
11	Binder Posts & Screws (Dual Schedule)	122FMS	2020-2123
12	Rocker Switch (Dual Schedule)	MS94RSW	2060-2694
13	Trigger Blade Assembly	ELC94-BL	2060-2671
14	Trigger (Standard)	ELC94	2060-2647
15	Trigger (Locking)	MS94LC	2060-2693
16	Cable Clamp	136	2060-2690
17	Front Strain Relief Spring & Cap	MS144	2060-2131
18	10 ft (3 m) Cablehoz® Assembly (Direct Plug)	MS210	1720-2115
	12 ft (3.6 m) Cablehoz Assembly (Direct Plug)	MS212	1720-2116
19	Rear Strain Relief Spring & Cap	235RSSR	2060-2035
20	Front Cable Connector Repair Kit (Direct Plug & Euro)	MS102-RK	2060-2132
21	Rear Cable Connector Repair Kit (Direct Plug)	MS172-RK	2060-2134
	Rear Cable Connector Repair Kit (Euro)	172X-M	2020-2181
22	Rear Case (Direct Plug)	C6RC	2060-2041
	Rear Case (Euro)	X6RC	2060-2006
23	Miller® Control Wire	MS354-DSM	2060-2140
24	Connector Plug	—	
25	Conduit Assembly	Refer To Page 3	
NS	Protective Cable Wrap, 50 ft (15.2 m) per box	TCR50	9900-1150



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