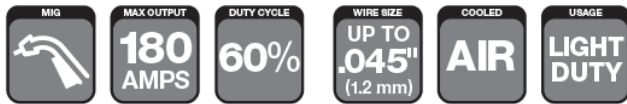


VELOCITY2 Classic No. Series

Classic® No. 1 180 AMP MIG Gun
Air-Cooled



WELDING PROCESSES:

MIG (GMAW), Aluminum (GMAW)

Standard Options Include:

- Rear Connector
- Standard Conductor Tube — Part No. 61-60 (Stock No. 1610-1102) Part No. VA61-60 (Stock No. 1010-1105) Light Duty VELOCITY2 Adapter (Must be ordered separately)
- Conduit Liner— 42 Series

Industry

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

VELOCITY2 CLASSIC NO. MIG GUN SERIES

FEATURES

- **THE INDUSTRY STANDARD** for over 40 years
- **INCORPORATING VELOCITY2 CONSUMABLES** with new ground breaking innovation inspired by welders for welders
- **SOLID COPPER CONDUCTOR PATH** with fewer connections for optimized electrical surface contact.
- **FEWER CONSUMABLES PARTS** means less complexity and lower cost of ownership
- **GAS PORTED VELOCITY2 CONTACT TIPS** stay cooler and last longer
- **EASY TO USE VELOCITY2 TIPS** eliminates threads and requires no tools
- **TIPS CAN BE ROTATED** to prolong life requiring fewer changes
- **EXCELLENT WIRE FEED** ability with centered liner with the conduit liner fitting inside the tip
- **SUPERIOR WELDING PERFORMANCE** from a smoother, more stable arc
- **LARGE COPPER TO COPPER** surface contact for superior thermal and electrical efficiency
- **PROVEN CONTACT TIP LIFE IMPROVEMENTS** with Short Arc Solid Wire 2 to 3 times life, Spray Transfer 4 to 5 times life and Gas Shielded Flux Core 8 to 10 times life

VELOCITY2 CLASSIC NO.1 180 AMP

SPECIFICATIONS	
Description	VELOCITY2 Classic No.1 180 Amp
Welding Output CO ₂ Gas	180 A at 60%
Wire Diameter, Mild Steel	Up To 0.045" (1.2mm)
Wire Diameter, Stainless	Up To 0.045" (1.2mm)
Wire Diameter, Aluminum	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), and 20 ft. (6.1 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 .035" (0.9 mm)	12 ft (3.6 m)	V112-3035	1010-1115
	15 ft (4.6 m)	V115-3035	1010-1116
	20 ft (6.1 m)	V120-3035	1010-1117
Up To .045" (1.2 mm)	12 ft (3.6 m)	V112-4045	1010-1118
	15 ft (4.6 m)	V115-4045	1010-1119
	20 ft (6.1 m)	V120-4045	1010-1120

Miller® Style Rear Connector

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

Lincoln® Style Rear Connector

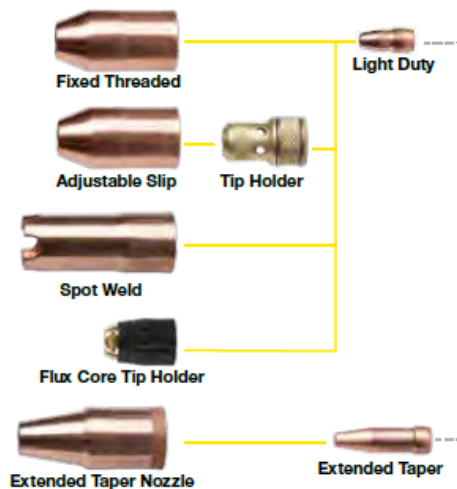
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	15 ft (4.6 m)	VL115-3035	1010-1138

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

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	VX110-4045	1010-1147
	12 ft (3.6 m)	VX112-4045	1010-1148



RATED OUTPUT			WIRE SIZE	COOLED	APPLICATION USAGE
Amps	Duty Cycle	Gas			
180 Amps	60%	CO ₂ Carbon Dioxide	Up To .045" (1.2 mm)	Air	Light Duty Fabrication

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

VELOCITY2 CLASSIC NO.1 180 AMP

Light Duty Contact Tips

Description	Part No.	Stock No.
.023" (0.6 mm) Standard	VTSA23	110-1308
.030" (0.8 mm) Standard	VTSA30	110-1309
.035" (0.9 mm) Standard	VTSA35	110-1310
.040" (1.0 mm) Standard	VTSA40	110-1311
.045" (1.2 mm) Standard	VTSA45	110-1312
3/64" (1.2 mm) Standard*	VTSA364*	110-1313
.052" (1.3 mm) Standard	VTSA52	110-1314
1/16" (1.6 mm) Standard	VTSA116	110-1315
1/16" (1.6 mm) Standard*	VTSA116*	110-1317
5/64" (2.0 mm) Standard	VTSA564*	110-1316
.023" (0.6 mm) Extended Tapper	VTSET23	110-1330
.030" (0.8 mm) Extended Tapper	VTSET30	110-1331
.035" (0.9 mm) Extended Tapper	VTSET35	110-1332
.040" (1.0 mm) Extended Tapper	VTSET40	110-1333
.045" (1.2 mm) Extended Tapper	VTSET45	110-1334
3/64" (1.2 mm) Extended Tapper	VTSETA364*	110-1335
.052" (1.3 mm) Extended Tapper	VTSET52	110-1336
1/16" (1.6 mm) Extended Tapper	VTSETA116	110-1337
1/16" (1.6 mm) Extended Tapper	VTSETA116*	110-1338

*For Aluminum Wire

Conductor Tubes - Air Cooled

VELOCITY2 Classic No. 1

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads
60 Degree with 2-1/4" (57 mm) Radius	VA61-60	1010-1105	Neoprene Rubber	O.D. M12 x 1.5-6 g

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

Light Duty Nozzles

Self Insulated Nozzles. 2 per pack

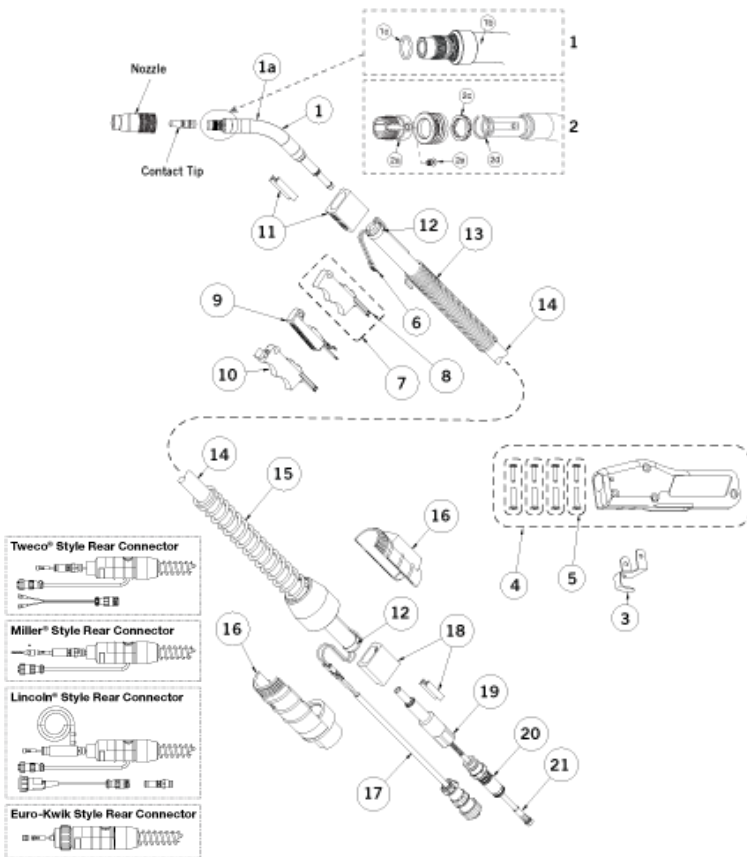
Description	Part No.	Stock No.
1/2" Fixed Threaded-Flush	VNS50F	1220-1200
1/2" Fixed Threaded-Recess	VNS50	1220-1201
5/8" Fixed Threaded-Flush	VNS62F	1220-1202
5/8" Fixed Threaded-Recess	VNS62	1220-1203
3/8" Fixed Threaded-Flush	VNS37F	1220-1204
3/8" Fixed Threaded-Recess	VNS37	1220-1206
1/2" Adj. Slip-Heavy Cone	VNSH50S	1220-1229
Adj. Slip-Tip Holder	VNSSINS	1220-1132
3/8" Extended Tapper Nozzle	VNSET37F	1220-1235
3/4" Spot Nozzle Assembly	VNS75FAS	1220-1205
FC Tip Holder-Insulator	VNSFCI	1220-1208
FC Tip Holder & Insulator Assembly	VNSFC	1220-1207

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



#	DESCRIPTION	VELOCITY2 CLASSIC NO. 1	
		PART NO	STOCK No.
	Contact Tip	Refer To Page 3	
	Nozzle	Refer To Page 3	
1	60° VELOCITY2 Conductor Tube Assy.	61-60 VA61-60	1610-1102 1010-1105
1a	Silicone Tubing (Sold/Foot)	VCTLJBLK	1640-1409
1b	Insulator, VELOCITY2 Conductor Tube Assy.	VCTLSI	1640-1408
2	Gun Hanger	152	2020-2152
3	Handle (Standard)	81	2010-2081
4	Binder Posts & Screws	122FM	2020-2122
5	Trigger Control Wire Terminal (Standard—2 ea.)	244DS	2040-2245
6	Trigger Assembly (Standard)	91	2010-2091
7	Trigger Blades	91C	2010-2093
8	Front Cable Connector	101R	2010-2103
9	Cable Clamp	136	2060-2690
10	Front Strain Relief Spring	141-6-SPR	2010-2143
11	Cablehoz® (Sold by the Foot)	200	1720-2100
12	Rear Strain Relief Spring	235RSSR	2060-2035
13	Rear Strain Relief Spring	R6RC	2060-2040
	Rear Case (Euro)	X6RC	2060-2006
14	Control Wire (Standard)	MS354-DSM	2060-2140
	Control Wire (Dual Schedule)	194DS	2040-2195
15	Rear Cable Connector (Direct Plug)	104	2040-2104
	Rear Cable Connector (Euro)	172X-M	2020-2181
16	Adapter (Direct Plug)	M170-2H	2020-2165
17	Connector Plug	Refer To Full Line Catalog	
18	Conduit Assembly	Refer to Page 3	
19	Protective Cable Wrap, 50 ft (15.2 m) per box	TCR50	9900-1150

XA00210421 / NA / English / 12/2019 / Note: Specifications subject to change without notice. Products may vary from those pictured.



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