Tweco Arc Welding Accessories

Tweco, a brand of St. Louis-based Thermadyne Industries Inc., is the world’s largest supplier of welding and cutting products. The Tweco line includes an extensive array of products from the basic manual welding tools and accessories to MIG guns, consumables, and a complete selection of products for precision robotic welding applications. Tweco is an ISO 9001 registered company.

Smoke Master® MIG Guns

250 & 450 AMP AIR-COOLED
60% Duty Cycle, CO₂ Gas

- Efficiently Removes up to 90% of Smoke from the Welding Zone
- Features Tweco Eliminator® Style Consumable Parts
- Tough Outer Jacket Made of Full Length Leather for Increased Flexibility and Enhanced Cable Life
- Cleaner, More Efficient Smoke Removal

250 AMP

Smoke Master®

FUME REMOVAL SYSTEM

- Compatible with Tweco Smoke Master MIG Guns
- Efficiently Removes Welding Fumes
- High Efficiency Filter
- Separately Air-cooled Motor
- Automatic Start-Stop Function Standard
- 120V / 60 Hz.

Check out pages 34-35 for a reference chart on our favorite, top of the line MIG guns.

Or see our full line catalog or visit us on the web at www.tweco.com for more information.

Every family has a Knucklehead. Meet ours.

Pete is a welding engineer and works for Thermadyne. He’s also a skilled welder and he’s pretty excited about the new technology from Tweco called KNUCKLEHEAD, that allows welders to work more efficiently from all angles. Pete is among the family of brands from Thermadyne. Pete’s a member of our family too. Both knuckleheads are worth getting to know.

We mean this in the most affectionate sense of the word. Like your mysterious cousin, who looks like a mental but can be workflowing, the makers of the world’s most popular MIG guns, Tweco, has developed a new product using a patent pending mechanical ball and socket joint design that enables users to virtually infinite adjustments and firm positioning.

According to tests performed by the Tweco engineering lab, the KNUCKLEHEAD flexible conductor tube outperforms the leading competitor by a factor of ten. Don’t be a blockhead. Work smarter with the KNUCKLEHEAD by Tweco.

See page 35 & 37, the web or the Tweco & Arcair Catalog for more information on the Knucklehead Flexible Conductor Tube.

Tweco & Arcair Professional

Arc Welding / Gouging Equipment & Consumables Catalog

(Form No. 64-2103)

International Customer Care: 905-827-9777 / FAX 905-827-9797
www.tweco.com
<table>
<thead>
<tr>
<th></th>
<th>Mini</th>
<th>#1</th>
<th>#2</th>
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<td>light duty, maintenance &amp; repair</td>
<td>medium duty, industrial</td>
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<td><strong>Options / Features</strong></td>
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<td>• quick change</td>
<td>• metal jacketed conductor tube</td>
<td>• metal jacketed conductor tube</td>
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<td></td>
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<td>• swivel conductor tube</td>
<td>• Knucklehead™</td>
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<tr>
<td><strong>Nozzle Series</strong></td>
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<td>14 series</td>
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<td>51 series</td>
<td>52 series</td>
<td>54 series</td>
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<td>61 series 45 &amp; 60°</td>
<td>62J series 45 &amp; 60°</td>
<td>63J series 45 &amp; 60°</td>
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<td>WS22-50</td>
<td>WS24A62</td>
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<td>WS14 series</td>
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<td>WS52</td>
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<td><strong>Conductor Tube Series</strong></td>
<td>WM150J Series 45 &amp; 60&quot;</td>
<td>WM250J Series 45 &amp; 60&quot;</td>
<td>64J-60 or 64J-45 (20’ and 25’ models)</td>
<td>TS62J Series 45 &amp; 60&quot;</td>
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<td>WS44 Series</td>
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Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The afore mentioned trademarks are in no way affiliated with Tweco or Thermadyne Industries, Inc.
### Rear Plug Connections

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<tr>
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<td>45 &amp; 60° 63J series</td>
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### Available Lengths


### Duty Cycle Rating

| 60% CO2 gas | 60% CO2 gas | 60% CO2 gas | 80% CO2 gas |

### Nozzle Insulator

| none (self insulated nozzle) | none (self insulated nozzle) | WS34A 63J3 series | none (self insulated nozzle) |

### Diffuser Series

| 35-50 51 series | 52 series | 54 series | 35-50 51 series |

### Liner Series

| WS 21-50 WS22-50 WS24A62 21 series | 40 series | 42 series | 40 series |

### Tip Series

| 11 series | 14 series | 14 series | 11 series |

### Conductor Tube Series

| TS62J Series 45 & 60° | TS62J Series 45 & 60° | WS63 series, 45, 60, 180° | MS64H series, 45, 60, 180° |

### Liner Series

| 44 series | 42 series | 44 series | 44 series |

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**This info is related to std. gun configurations**

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**TWECO Professional**

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**TWECO Website Keyword Search Tip**

In addition to the product name and part number, you can search using keywords such as arc welding accessories, MIG guns, a532, tigwelding, electrode holders and contact tips. (See index on pages 6-7 for more info.)
Consumables
Tips, Diffusers, Nozzles, Conductor Tubes and Wire Conduit to meet all your MIG gun needs. Here is just a sampling of our complete line . . .

**Contact Tips**

**Eliminator® Style Contact Tips**
- EL16T-35
- EL16-35
- EL16-45
- EL16RS-45

**Standard Contact Tips for Traditional and Spray Master® Guns**
- 11-23
- 11T-35
- 16AS-364
- 14AH-364
- 11H-35
- 16S-35

**Chrome Zirconium Copper "RZ" Contact Tips**
- 14RZ-45
- 16RZT-45

**Copper-Silver Tweco Robotics "RS" Contact Tips**
- 16RST-35

**Nozzles**

**Eliminator Style Nozzles**
- EL22CT
- EL21-50

**Standard Nozzles for Traditional and Spray Master® Guns**
- 22T-37-SS
- 22-62
- 23-62-F
- 24CT-62-F

**Optional Nozzles**
- 21-62-FAS
- 25CT-125-FAS

**Diffusers**

**Eliminator Style Diffusers**
- EL52
- EL52CT

**Diffusers for Traditional Style Guns**
- 51
- 52
- 54A

**Heavy Duty Diffuser for Spray Master Guns**
- EL52CT-16

**Competitive Style Diffusers**

**BERNARD® Style Diffusers**
- WS54BH-14
- WS54BH-16

**ESAB® Style Diffusers**
- WS54EH-14
- WS54EH-16

**TREGASKISS® Style Diffusers**
- HD54-14
- HD54-16

**MILLER® Style Diffuser**
- HD52M-11

**OXO® Style Diffusers**
- WS54BH-14

WS54BH-16

Bernard, Miller and OXO are registered trademarks of Illinois Tool Works, Inc. ESAB is a registered trademark of ESAB AB. Tregaskiss is a registered trademark of Tregaskiss, Ltd., Canada. The afore mentioned trademarks are in no way affiliated with Tweco or Thermadyne Industries, Inc.
**Wire Conduit**

Wire Conduits for All Guns
Eliminator®, Traditional & Spray Master®

**Conductor Tubes**

Conductor Tubes for Eliminator, Traditional & Spray Master Guns
45° and 60° Tube Angles

**Flexible Conductor Tubes**

Knucklehead®

- Improved Weld Quality
- Less Welder Fatigue
- Lasts Longer Than Any Design on the Market Today
- Eliminates Downtime Caused by Changing Conductor Tubes
- Increased Productivity
- Improved Gun Ergonomics

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1 - Three connector design - bends up to 60°
2 - Four connector design - bends up to 80°
* - Extended reach design - 2 inches longer

**NEW & Improved Tweco Website**

Visit our new website, same address, newer look, more features. Website now allows the user to look up specific part numbers for detailed specifications, including images and literature available. Stop by and check it out.

www.tweco.com
Manual Arc Welding Equipment

**TwecoTong® Electrode Holders**

200, 250, 300, 350, 400 & 500 AMP
- Copper Alloy Body
- Reversible Top and Bottom Insulators
- Efficient 6-position Jaw Patterns
- Fully Insulated/Protected Springs
- Ball-point Cable Connection

- **A-532** (200A)
- **A-316** (250A)
- **A-732** (300A)
- **A-14** (350A)
- **A-14-HD** (400A)
- **A-38-HD** (500A)

**Ground Clamps**

Steel, Copper & Flat Ground Clamps
- Steel Ground Clamp (300A & 500A)
- Copper Ground Clamp (200A, 300A & 500A)
- Flat Ground Clamp (200A & 300A)

- **SGC-500** (500A)
- **GC-300** (300A)
- **FGC-500** (500A)

**Heavy Duty Rotary Ground Devices**

400, 600, 800, 1500 & 2000 AMP
- Available with 1, 2 or 3 Heads
- Simple Tension Adjusting Bolt for Maximum Efficiency
- No Brushes, Springs or Mercury
- 2" Shaft

- **RG-440** (1500A)
- **GCRG-140** (400A)

**Roto-Work Grounding Clamps**

500, 600, 1200 & 2000 AMP
- Work in Conjunction with Rotary Ground Devices
- Large Tightening Screws and Ample Contact
  - Surface Area for Efficient Operation

- **WCGR-1200** (1200A)
- **GC-600-75** (Clamp Only)
Switchable Magnetic Ground Clamps

Do you want to save time and money? Add convenience in welding with the Switchable Magnetic Ground Clamp from Tweco. Designed for use in flat and pipe applications, Switchable Magnetic Ground Clamps are easy to operate, easy to mount and can withstand heat up to 176°F (80°C). Turn the knob clockwise and you instantly have a secure grip.

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<td>SMGC600</td>
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Cable Connectors

MPC & Whip Cable Connectors
- Positive Cam Action Optimizing Interfacing
- Heat and Oil Resistance Covers
- Zinc Plated Cover and Ball-point Cable Screws
- Various Cable Capacities & Packages Available

4-MPC

2-1-MPC

TwecoLugs®

Crimp & Solder Type
- 150A, 225A, 250A & 325A Rating
- 50A, 70A & 90A Rating (Power Cable Lugs)
- Various Cable Sizes Available

T-40HD (325A) T-120 (225A) T-46 (90A)

Terminals and TwecoLugs

Screw-on Terminals
- Fit ⅛" (12.7mm) Terminal Size
- 3 Sizes Available

Female Terminals
- ⅛" (13.5mm) Stud Hole Size
- Various Configurations Available

Ball-Point Connection Type Lugs
- ⅛" (13.5mm) Stud Hole Size
- Various Configurations Available

Heavy Duty Type Lugs
- Mechanical Ball-Point
- Various Configurations Available

International Customer Care: 905-827-9777 / FAX 905-827-9797
www.tweco.com
Tweco Robotics Quick Robotics
Welcome to world class Tweco Robotics MIG guns and accessories. The engineers at Tweco have worked overtime to continue the tradition of delivering best in class robotics MIG guns and accessories that will provide the reliability and value you expect from Tweco.

Robotic MIG Guns and Accessories

**QRL Series Robotic MIG Gun**

**400 Amp Lightweight Air-Cooled MIG Gun**
The new Tweco Robotics Quick Robotic Light Weight MIG Gun (QRL) offers the ideal MIG gun for “Table Top” robots. It is designed for ever day applications that require a lighter weight and smaller profile for robotic welding MIG gun functions.

- Quick Conductor Tube Lock for Easy Conductor Tube Replacement
- 40% Lighter Than the QRA Series MIG Gun
- E-stop Cable with Connections
- Smaller Physical Profile
- Compatible with Existing Mount Arms, and Uses Current conductor tubes and Consumables
- External Protective Sleeve
- Precision Front Case Assembly (gives high repeatability to mount and conductor tube)
- Furnished with Tweco Robotics R45-3545 Conduit

**QRA Series Robotic MIG Gun**

**600 Amp Air-cooled MIG Gun**
Tweco Robotics QRA series air-cooled MIG gun body and cable assemblies provide many features that will enhance your robotic welding application. MIG gun body and cable assemblies are furnished with these standard features:

- Improved Quick Tube Locking
- Standard 1⅛” (41.28mm) Ø Mounting Cartridge Sleeve
- Precision Front Case Assembly (gives high repeatability to mount and conductor tube)
- E-stop Cable with Connections
- Both Front and Rear Heavy Cable Support Springs
- Kevlar®/Nylon Outer Protective Cable Cover
- Internal Protective Sleeve
- Internal Purge Hose for Spraying Protex® Antispatter Compound Through the Conductor Tube and Nozzle
- Furnished with Tweco Robotics R45-116 Conduit
- Furnished with a Tweco®, Miller® and Lincoln® Rear Connector Plug

**QRW / QRWA Series Robotic MIG Gun**

**600 Amp Water-cooled & Water/Air-Cooled MIG Gun**
Tweco Robotics water-cooled MIG gun body and cable assemblies are offered in two (2) configurations. The QRW series features a water-cooled cable assembly while the QRWA series features an air-cooled cable assembly. Both accept the QTRW series water-cooled conductor tube. The QRWA series provides maximum cooling at the conductor tube end with a rugged, trouble free cable assembly.

- Water Shut-off Valves Located in the MIG Gun Body Assembly
- Color Coded “Water-in” and “Water-out” Hoses for Easier Hook-up
- Water Hose Quick Connections
- High Flow Rate – QRWA Series – for Improved Conductor Tube Cooling
- Larger Water Lines – QRW – for Improved Conductor Tube Cooling
RDM Series Deflection Mount

RDM 2000 Series
Tweco Robotics® RDM-2000 series — is a safety device designed to act as a switch between the conductor tube and the robot.

- Available in Three (3) models:
  - Part No. RDM-2000-S (Stock No. 3500-1155) – Light Duty
  - Part No. RDM-2000-M (Stock No. 3500-1156) – Medium Duty
  - Part No. RDM-2000-H (Stock No. 3500-1157) – Heavy Duty
- Units come standard with an air assist feature allowing the robot technician to increase the break-away pressure when required.
- E-Stop Cable Assembly- 18” long - Part No. RDM2000-JC (Stock No. 3044-1842) comes standard with the unit.

QRC™-2000 Nozzle Cleaning Station

The QRC Nozzle Cleaning Station has an advanced Rotary Impact Drive (RID) system which removes the spatter, allowing the cleaned MIG gun nozzle to continue the welding process. It also has a unique self-exhaust PDE cleaning system that keeps debris from the reamer blade area. The revolutionary clamp mechanism on the QRC-2000 system provides precise clamping on the nozzle.

- Rotary Impact Drive (RID) System
- Dual Stage Pneumatic Clamping Device Ensures Positive, Secure Clamping on the Nozzle
- Easy to Program
- Two-Stage Cam Plate (2.5” cylinder) is a Solid Block with Universal Arm
- Pneumatic Drive Exhaust (PDE) System Blows Air Through Vent Holes on the Incline Housing Which Helps Prevent Slag Buildup in Shaft Area
- Uses Only Half the Air Consumption of Other Cleaning Stations
- Total Stroke Inside Nozzle 2” (50.8mm)
- Reamer Blade (QRC-100), Five Clamp Blocks and Programming Tools Included with the Unit

Cleaning Station Accessories

QWT-3 Wire Trim Unit
For use with QRC-2000

QRM-3 Anti-Spatter Mist Applicator
For use with QRC-2000

QRM-100 Anti-Spatter Mist Applicator
Reduce spatter build up in your MIG nozzle. Removal of spatter made easier. Provide better gas flow and improved weld quality.

Tweco Water Coolers

TC900 & TCV-900 Series
Enhance your water-cooled MIG welding process by incorporating a water-cooler from Tweco Products.

- Vertical or Horizontal Models Available
- Designed for MIG Guns up to 800 Amps and TIG Torches up to 500 Amps
- Stainless Steel Construction Eliminates Coolant Contamination Due to Electrolyte and Chemical Reactions
- High Efficiency Radiator Design Pulls Outside Air Through Radiator
- Available with Either Gear or Vane Pumps.
- Pump Bypass to Tank on Rotary Gear Pump – Keeps Pump from Overheating
- Vance Pumps are Equipped with a Bypass to Eliminate Excessive Pump Wear

See our full line catalog or visit us on the web at www.tweco.com for more information.
Tweco Robotics Fixed Automation

Tweco Robotics offers a complete line of automation MIG guns with or without cable assemblies. The product line consists of both air-cooled and water-cooled MIG guns and cable assemblies.

QF — TAM — RA — WRS

Each series offers something different that will meet your specific MIG fixed automation welding application specifications.

Thermadyne is excited to offer you incredible choices and innovation in fixed automation MIG welding equipment. Only the quality you come to expect from Tweco.

Fixed Automation MIG Guns and Accessories

QF Series Fixed Automation MIG Gun

QFA Air-cooled / QFW Water-Cooled

This series of Automation MIG guns is offered with and without cable assemblies. The series incorporates some of the same features found on the Tweco Robotics QR series MIG gun assemblies. Offered for use in MIG air-cooled and water-cooled welding applications.

Welding applications using the air-cooled QF series MIG guns can take advantage of the eight different bend configurations of air-cooled QTR66 conductor tubes. Welding applications requiring the water-cooled QF series MIG guns utilizes the water-cooled QTRW series conductor tubes, which are available in three different amperage ranges (300, 400, and 600), and eight different degrees of bend configurations.

TAM Series Fixed Automation MIG Gun

400 Amp & 500 Amp Air-Cooled

This series of Automation MIG guns is offered with and without a cable assembly. The series is only offered for air-cooled welding applications. There are two amperage ranges available, 400 and 500 ampere @ 60% duty cycle, both are offered with and without a cable assembly.

Mounting of this particular series is directly to the 1¼” (28.58mm) outside diameter of the MIG gun barrel. The outer surface of the MIG gun body is insulated from the inner tube by a polyester molding compound providing excellent di-electric properties.

TAM series with cable assemblies are offered in lengths of 2 ft. (.61m) to 15 ft. (5m).

RA Series Fixed Automation MIG Gun

400 Amp & 600 Amp Air-Cooled

This series of Automation MIG guns are offered only with a cable assembly and strictly for air-cooled welding applications. There are two amperage ranges to choose from, 400 and 600 ampere @ 60% duty cycle. Mounting surface is the outer diameter of the 1¼” (41.28mm) plastic case.

Five different bend configuration conductor tubes are available to choose from in each amperage range. The conductor tubes are keyed into the brass body of the assembly allowing a conductor tube to be replaced and the adjustments to be minimal when going from one tube configuration to another.

See our full line catalog or visit us on the web at www.tweco.com for more information.
**WRS Series Fixed Automation MIG Gun**

400 Amp & 600 Amp Water-Cooled

This series of Automation MIG guns are offered only with a cable assembly and strictly for air-cooled welding applications. There are two amperage ranges to choose from, 400 and 600 ampere @ 60% duty cycle. Mounting surface is the outer diameter of the 1¼” (41.28mm) plastic case.

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**TJ-2 Tri-Just**

An ideal holding fixture that provides a means to locate and hold your MIG gun in place.

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**TJ2-KB Keyed Bracket**

MIG gun bracket for use with TJ-2 TRI-JUST.

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**Tweco Water Coolers**

**TC900 & TCV-900 Series**

Enhance your water-cooled MIG welding process by incorporating a water-cooler from Tweco Products.

- Vertical or Horizontal Models Available
- Designed for MIG Guns up to 800 Amps and TIG Torches up to 500 Amps
- Stainless Steel Construction Eliminates Coolant Contamination Due to Electrolyte and Chemical Reactions
- High Efficiency Radiator Design Pulls Outside Air Through Radiator
- Available with Either Gear or Vane Pumps.
- Pump Bypass to Tank on Rotary Gear Pump – Keeps Pump from Overheating
- Vance Pumps are Equipped with a Bypass to Eliminate Excessive Pump Wear

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**QRM-100 Anti-Spatter Mist Applicator**

Reduce spatter build up in your MIG nozzle. Removal of spatter made easier. Provide better gas flow and improved weld quality.

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**TJ2-KB**

MIG gun bracket for use with TJ-2 TRI-JUST.

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**TCV-900**

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International Customer Care: 905-827-9777 / FAX 905-827-9797
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