

Tweco® Spool Gun 160 Amp

MIG GUNS



20% Duty Cycle - Mixed Gases

Suitable for Light Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), Aluminum (GMAW)

Standard Options Include:

- 8-pin Amphenol Style Connector
- Standard Straight (180°) Conductor Tube
- Holds standard 4" (102 mm) diameter spools
- Optional 30° Rigid Conductor Tube or Knucklehead™ Flexible Conductor Tube

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .035" (0.9 mm)	12 ft (3.6 m)	SG160TA-12-3035	1027-1390
	12 ft (3.6 m)	SG160REB-12-3035	1027-1397

Use on Tweco Fabricator 141i, 181i and 211i power supplies only

Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
180 Amps	20%	Mixed	Up To .035" (0.9 mm)	Air	Light Duty Fabrication

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See Page 77 for Replacement Parts & Optional Accessories

FEATURES

- **Ideal for a Variety of Applications** including aluminum, stainless steel and mild steel welding
- **Long Cables** allow operator to access hard to weld areas
- **Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) with quick disconnect
- **Tweco 160 Amp and 200 Amp Spool Guns** are designed to work with Tweco new inverter technology on the Fabricator® series of welding systems
- **Comfortable Pistol-Grip Handle Design** with outer spool tension control for ease of operation
- **Tweco 200 Amp Spool Guns** include **3-turn Potentiometer** for fine wire feed speed control
- **Tweco 200 Amp Spool Guns** adapt to most welding machines with the use of **ESG-1 Control Box**
- **ESG-1 Control Box** provides the gas solenoid with pre/post purge control and run-in control for arc starting (See page 60 for ordering information)

Tweco® Spool Gun 200 Amp



60% Duty Cycle - Mixed Gases

Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), Aluminum (GMAW)

Standard Options Include:

- 10-pin Amphenol Style Connector
- Standard Straight (180°) Conductor Tube
- Holds standard 4" (102 mm) diameter spools
- Optional 30° Rigid Conductor Tube or Knucklehead™ Flexible Conductor Tube

Tweco® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	SG200REB-12-3545	1027-1398
	25 ft (7.6 m)	SG200REB-25-3545	1027-1399
	25 ft (7.6 m)	SG200-25-3545	1027-1392
	25 ft (7.6 m)	SG200TA-25-3545*	1027-1391

**Use on Tweco Fabricator 220i and 252i power supplies only*

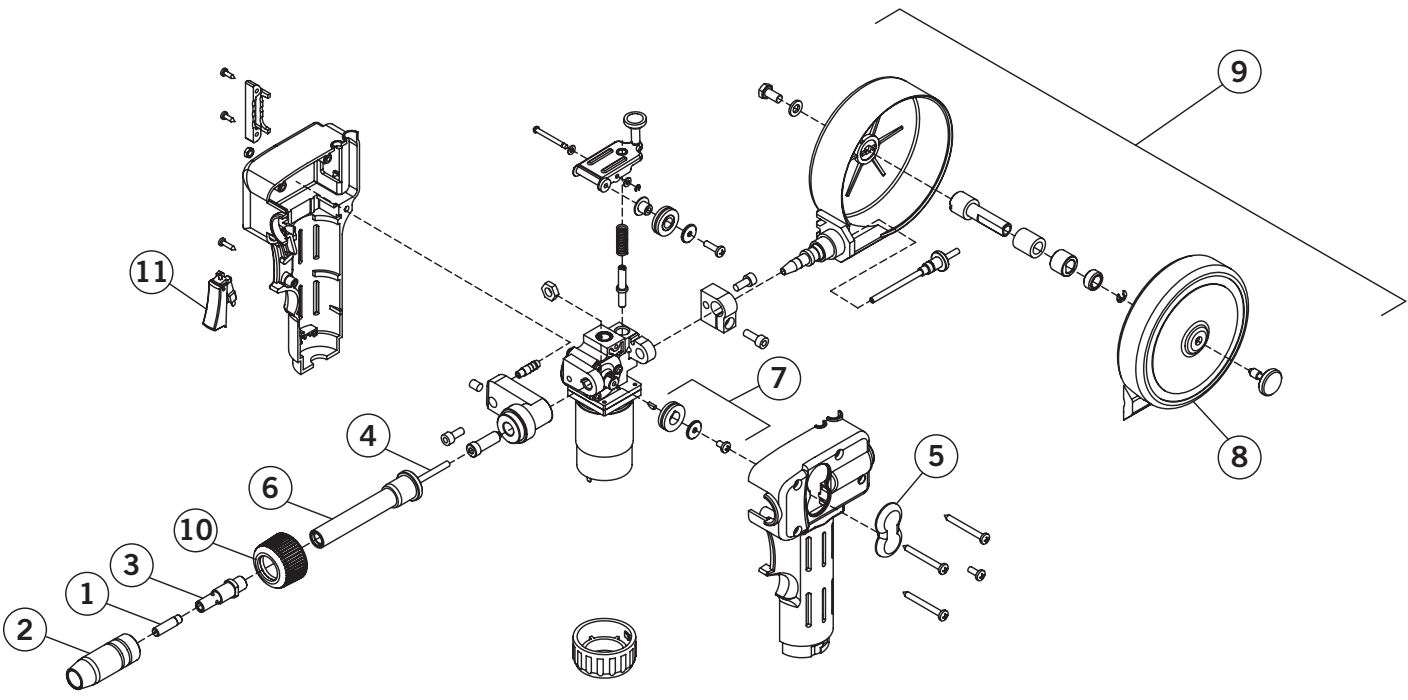
Rated Output			Wire Size	Cooled	Application Usage
Amps	Duty Cycle	Gas			
200 Amps	60%	Mixed	Up To .045" (1.2 mm)	Air	Medium Duty Fabrication

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See Page 77 for Replacement Parts & Optional Accessories

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Tweco® Spool Gun 160 & 250 Amp Replacement Parts

MIG GUNS



#	Description	Part No.	Stock No.
1	Contact Tip .023 (0.6 mm)	11-23	1110-1100
	Contact Tip .030 (10.8 mm)	11-30	1110-1101
	Contact Tip .035 (10.9 mm)	11-35	1110-1102
2	Nozzle 3/8" (9.5 mm)	21T-37	1210-1300
	Nozzle 3/8" (9.5 mm)	21-37	1210-1100
	Nozzle 1/2" (12.7 mm)	21-50	1210-1110
	Nozzle 5/8" (15.9 mm)	21-62	1210-1120
3	Gas Diffuser	51	1510-1101
4	Conduit	SPG66065	2031-2107
5	Drive Roll Cover	WSPDRC	2031-2227
6	Conductor Tube	WSP62180	2031-2225

#	Description	Part No.	Stock No.
7	.023 Drive Roll - V-Shaped	WSPDRV023	2031-2228
	.023 Guide Roll - V-Shaped	WSPGRV023	2031-2234
	.030 & .035 Drive Roll - V-Shaped	WSPDRV030035	2031-2257
	.030 & .035 Guide Roll - V-Shaped	WSPGRV030035	2031-2258
	.045 Drive Roll - V-Shaped	WSPDRV047	2031-2230
	.045 Guide Roll - V-Shaped	WSPGRV047	2031-2236
	.023 Drive Roll - U-Shaped	WSPDRU023	2031-2250
	.030 & .035 Guide Roll - U-Shaped	WSPDRU030035	2031-2252
	.045 Drive Roll - U-Shaped	WSPDRU047	2031-2254
	Smooth Guide Roll (for use with U-Shaped Drive Rolls, not grooved)	WSPGR	2031-2256
8	Spool Case Cover	WSPSCC	2031-2233
9	Complete Spool Case	WSPSC	2031-2232
10	Conductor Tube Nut	WSP62N	2031-2226
11	Trigger Assembly	WSP92	2031-2231
NS	Replacement Motor	WSPMOTOR	2031-2237
NS	Key Stock for Drive Roll	WSPKEY	2031-2239

Control Wire Jumper Cords

Use with Tweco Spool Gun 200 Amp - Part No. SG200-25-3545 (Stock No. 1027-1392)

Manufacturer	Machine	Part No.	Stock No.
Miller®	Millermatic® 210	WSPMILL4PJC2	2031-2246
Miller	Millermatic 212	WSPMILL4PJC	2031-2245
Lincoln®	Power MIG® 255C	WSPLIN7PJC	2031-2247
Hobart®	Ironman™ 210, 250	WSPMILL4PJC	2031-2245
ESAB®	MigMaster® 203	WSPESAB7PJC	2031-2248
ESAB	MigMaster 253	WSPESAB7PJC	2031-2248
ESAB	MigMaster 250	WSPESAB7PJC	2031-2248

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Tweco® Spool Gun 300 Amp

MIG GUNS



60% Duty Cycle - Mixed Gases
Suitable for Medium Duty Fabrication.

WELDING PROCESSES:
MIG (GMAW), Aluminum (GMAW)

Standard Options Include:

- Standard Conductor Tube – Part No. PMP64EL-180 (Stock No. 1642-1140)
- Requires the use of the ESG-1 (Stock No. 1028-1295) Control Box for most welding machines

FEATURES

- Tweco 300 Amp Spool Guns are designed to work with Tweco new inverter technology on the ArcMaster® MST series of welding systems
- Ideal for a Variety of Applications including aluminum, stainless steel and mild steel welding

- Tweco 300 Amp Spool Guns adapt to most welding machines with the use of **ESG-1 Control Box** that provides the gas solenoid with pre/post purge control and run-in control for arc starting
- Comfortable Pistol-Grip Handle Design with outer spool tension control for ease of operation

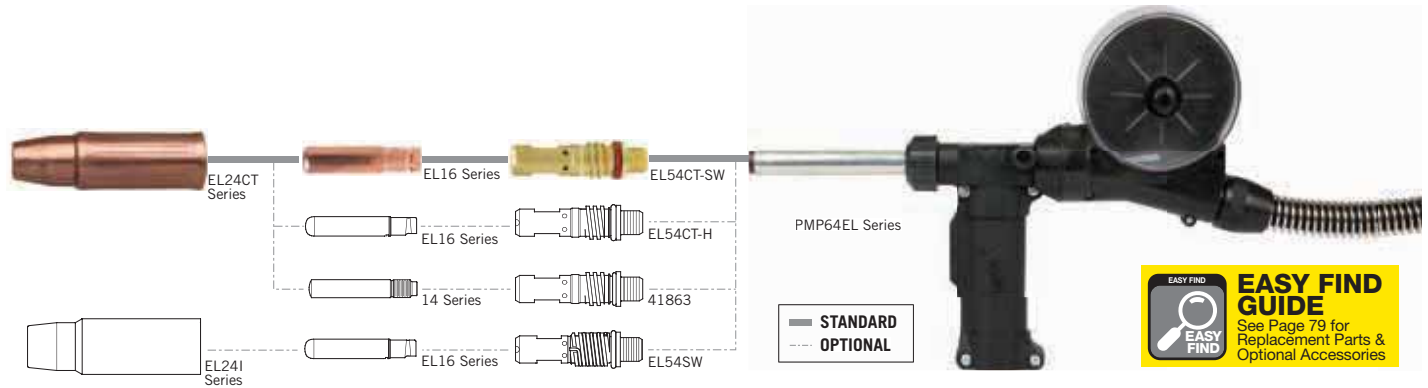
- Three-Layer Conductor Tube Construction** (Copper Tube / Silicon-Resin Glass Insulator / Metal Jacket) with quick disconnect
- Tweco® 300 Amp Spool Guns include **3-turn Potentiometer** for fine wire feed speed control

Tweco® Style Rear Connector

RATED OUTPUT			WIRE SIZE	COOLED	APPLICATION USAGE
AMPS	DUTY CYCLE	GAS			
300 Amps	60%	Mixed	Up To 1/16" (1.6 mm)	Air	Medium Duty Fabrication

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	25 ft (7.6 m)	SSG225-3545	1027-1370
	50 ft (15.2 m)	SSG250-3545	1027-1371
	100 ft (30.5 m)	SSG2100-3545	1027-1372

When using the 300 Amp Spool Gun with Tweco® ArcMaster® MST Series machines, use Tweco SGI100 Spool Gun Interface Box, Part No. W4009115



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Tweco® ESG-1 Control Box



Part No. ESG-1
(Stock No. 1028-1295)

115 Volt, Single Phase, 60 Hz
used with Eliminator Spool Guns

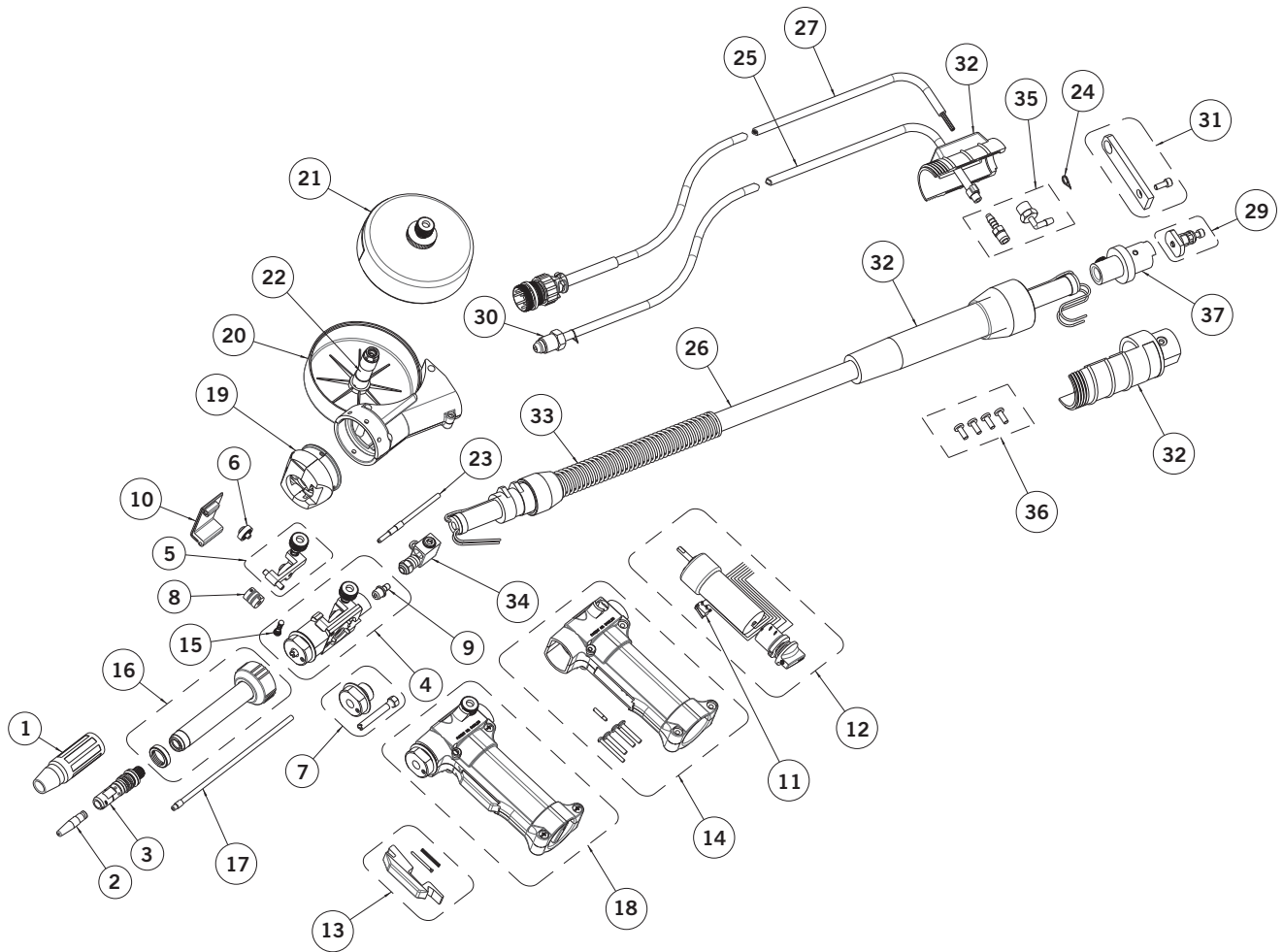
WELDING PROCESSES:
MIG (GMAW), Aluminum (GMAW)

Standard Options Include:

- Standard Power Cord 6 ft (2 m)
- Requires Jumper Cord, Part No. SSG300-106JC (Stock No. 2031-2150)

Tweco® Spool Gun 300 Amp Replacement Parts

MIG GUNS



#	Description	Part No.	Stock No.
1	Nozzle	EL24CT Series	
2	Contact Tip	EL16 Series	
3	Diffuser	EL54CT-SW	
4	Head Block Assembly	SPG103	2031-2100
5	Pressure Arm Assembly	SPG103-1	2060-1727
6	Idler Bearing Assembly	--	--
7	Adapter Nut & Wire Guide	EPG66-N	2031-2096
8	Drive Roll 0.030" (0.8 mm)	EPG103-2-08	2031-2091
	Drive Roll 0.035" (0.9 mm)	EPG103-2-09	2031-2077
	Drive Roll 0.040" (1.0 mm)	EPG103-2-10	2031-2023
	Drive Roll 3/64" (1.2 mm) Standard	EPG103-2-12	2031-2003
	Drive Roll 1/16" (1.6 mm)	EPG103-2-16	2031-2022
9	Gas Nipple & Wire Tie	--	--
10	Handle Cover Assembly	EPG86-2	2031-2013
11	Trigger Switch	ESG90	2025-2399
12	Motor Assembly (24VAC)	SSGM24	2031-2101
13	Trigger Lever	SPG-96TL	2060-2733
14	Handle Sub-Assembly	SSG86	2060-2739
15	Poppet Valve Assembly	PMP-PV	2060-2737
16	Conductor Tube 30 Degree	PMP64EL30	1642-1141
	Conductor Tube 180 Degree	PMP64EL180	1642-1140
	Flexible Conductor Tube	PMP64SFLX360	1642-1142

#	Description	Part No.	Stock No.
	Jump Liner	PMP44PTF116	1644-1096
17	Jump Liner Teflon	PMP-44FLX-116	1644-1095
	Jump Liner Copper	PMP-44-116	1644-1097
18	Spool Gun Assembly w/o Cable & Support	SSG300G	2031-2117
19	Pivot Assembly	ESG186	2025-2397
20	Spool Canister Assembly	ESG186S	2025-1392
21	Spool Cover Assembly	ESG186C	2025-2393
22	Friction Tube Replacement (5 PC)	ESG186S-3	2025-2385
23	Conduit Assembly	--	--
24	Wire Tie	BG-53N04	8040-1998
25	Gas Hose Assembly F/SSG Spool Gun	SSG3003GH	2060-2741
26	Extruded Spool Gun Cablehoz, 25 ft (8 m) Long	SSG30025	2060-2742
27	10 Pin Control Cable Assembly F/SSG Spool Gun	SSG300CW	2060-2744
28	Hex Wrench Set	--	--
29	25 mm Dinse Connector	SSG-DINS25	2035-2186
30	Rear Gas Nipple	EPG-RGN	2031-2083
31	Straight Lug	ESG-172SL	2031-2110
32	Rear Case Sub-Assembly	SSGT6RC	2031-2111
33	Front Strain Relief Assembly	SPG146R	2031-2112
34	Cable Connector Assembly	SPG102	2031-2113
35	Hose Barb Connector	ESG6RCUGN	2031-2114
36	10-24 X 1/2" BH Plastic Screw	SSG172PS	2031-2115
37	Rear Power Connector	ESG172	2031-2116
NS	Protective Cable Wrap, 50 ft (15 m) per box	TCR50	9900-1150