

TWECO[®]

AN ESAB[®] BRAND



MAX OUTPUT
**450
AMPS**

DUTY CYCLE
80%

WIRE SIZE
**UP TO
3/32"
(2.4 mm)**

COOLED
AIR

USAGE
**HEAVY
DUTY**

Tweco[®] Spray Master[®] V-Series Air-Cooled MIG Guns

Patents Pending



You Spoke, We Listened
The Best Just Gets Better
All Without Changing
Our Time-Tested Proven Components

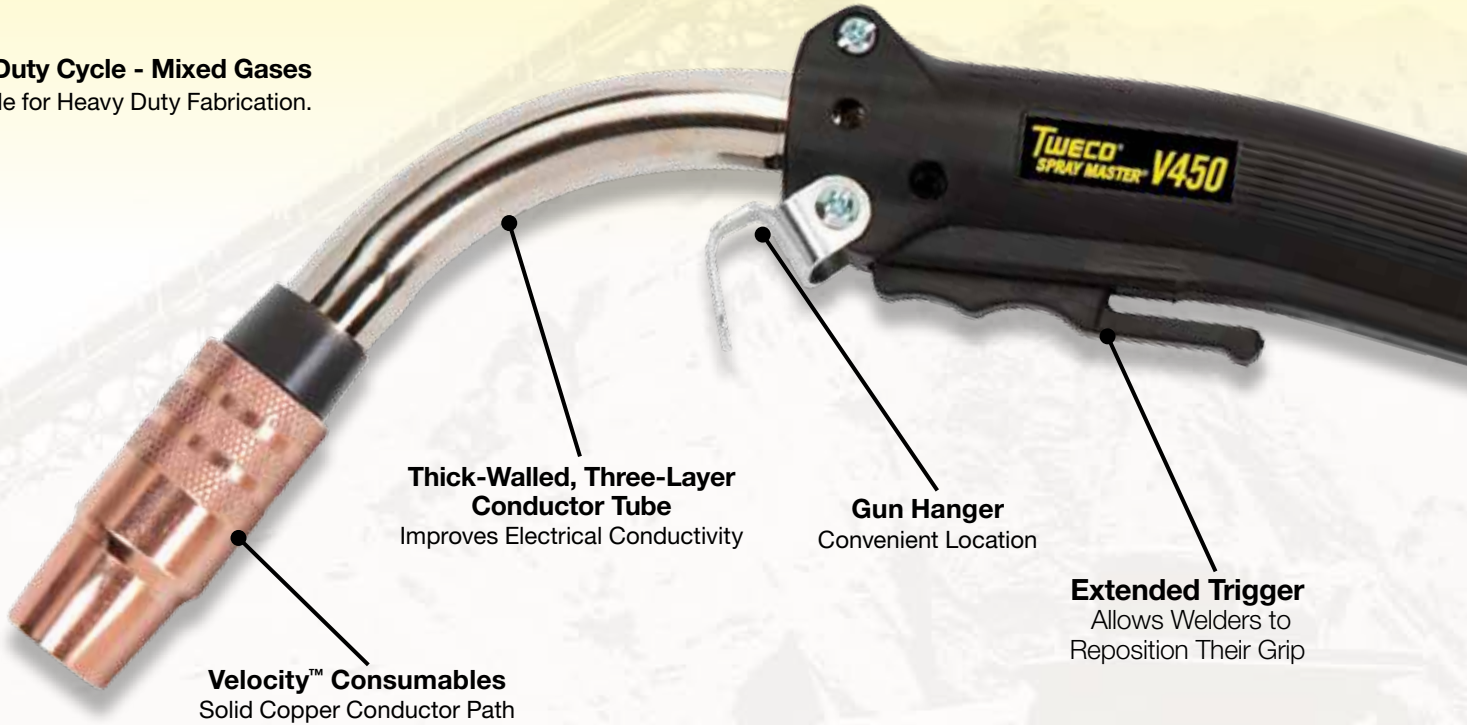
SPEED MADE EASY.



U.S. Customer Care: 800-426-1888
Canada Customer Care: 905-827-4515
International Customer Care: 940-381-1212

Spray Master® V-Series Air-Cooled MIG Gun

80% Duty Cycle - Mixed Gases
Suitable for Heavy Duty Fabrication.



The Best Just Gets Better,

All Without Changing Our Time-Tested Proven Components.

The Spray Master MIG Gun receives Velocity™ Medium and Heavy Duty consumables to create a new line of MIG guns, the Spray Master V-Series. Spray Master V-Series maintains the features that made the original Spray Master legendary:

- **Compact Ergonomic Handle Design** is preferred by many for comfort and maneuverability while reducing operator fatigue.
- **Extended Length Trigger** allows welders to adjust and reposition their grip for access, comfort and to avoid radiated heat. Adjusting your grip helps avoid repetitive motion, thus reducing fatigue.
- **Fully Rotatable Conductor Tube** allows welders further options to reconfigure the MIG Gun form factor to solve access issues, improve maneuverability, as well as reducing fatigue and adjusting for comfort.

- **Thick-Walled, Three-Layer Conductor Tube** is designed for heavy duty cycle applications.
- **Maintains the Original Tweco Cablehoz** in 250, 350, and 450 Amp versions that provide the required electrical and thermal conductivity along with cable flexibility that is best in class.

Spray Master V-Series is outfitted with Velocity a revolutionary new approach in MIG consumables that will change the game in terms of welder productivity. Velocity was designed by welders for welders. For more detailed information on Velocity Medium and Heavy Duty consumables, visit Tweco.com or see our Velocity Medium and Heavy Duty MIG welding consumables range brochure (*Form No. 64-1403*).

SPEED MADE EASY.

Small Ergonomic Handle
Reduces Operator Fatigue

Steel Spring Strain Relief
Supports Cablehoz®

Cablehoz®
Properly Sized for 80% Duty Cycle in
250, 350, and 450 Amp versions

You can upgrade your current Spray Master® MIG guns
by replacing the conductor tube to the next generation Velocity™ platform.

See the back page of this brochure.

Next Generation Tweco® Velocity

MIG Welding Consumables

Patents Pending



Nozzle Assembly
Heavy Duty Copper



Contact Tip
with Gas Ports



Conduit Liner
Perfectly Centered inside Tip

Nozzle Collar
with index marks

Conductor Tube
Fully Insulated

- **You Spoke, We Listened** - Inspired by Welders
- **Cost Savings with Fewer Tips** - Velocity Lasts Longer
- **Easy to Use** - No More Threads, No Tools
- **Smoother Arc** - Improves Stability and Welding Performance
- **No Diffuser** - Less Complexity, Lower Inventory Costs

Velocity™ Consumables Reference

Medium Duty Range Overview

Wire sizes .023" (0.6 mm) → 1/16" (1.6 mm)
Optimized for .035" (0.9 mm) & .045" (1.2 mm)
200 – 350 Amps @ 60% Duty Cycle

Fixed Threaded maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

Adjustable Slip allows welder to adjust the flushness relationship and provides improved access for cleaning.

Spot Weld provides a solution for tack and spot welding with MIG.

Nozzles



Fixed Threaded



Adjustable Slip



Spot Weld

Contact Tips



Medium Duty

Heavy Duty Range Overview

Wire sizes .030" (0.8 mm) → 1/8" (3.2 mm)
Optimized for .045" (1.2 mm) & 5/64" (2.0 mm)
300 – 600 Amps @ 80% Duty Cycle

Fixed Threaded maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

Adjustable Slip allows welder to adjust the flushness relationship and provides improved access for cleaning.

Fixed Threaded (2 piece) maintains flushness relationship and provides for easier cleaning and maintenance.



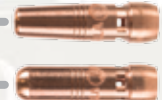
Fixed Threaded



Adjustable Slip



Fixed Threaded (2 piece)



Heavy Duty

Flux Core Overview

Flux Core Tip Holder provides open sight line and the best solution for gasless flux core welding.



Flux Core Tip Holder
Part # VNLFC



Medium & Heavy Duty

Extended Taper Range Overview

For Root Pass and Confined Access

Wire sizes .030" (0.8 mm) → 1/16" (1.6 mm)
Optimized for .045" (1.2 mm)
200 – 350 Amps @ 60% Duty Cycle



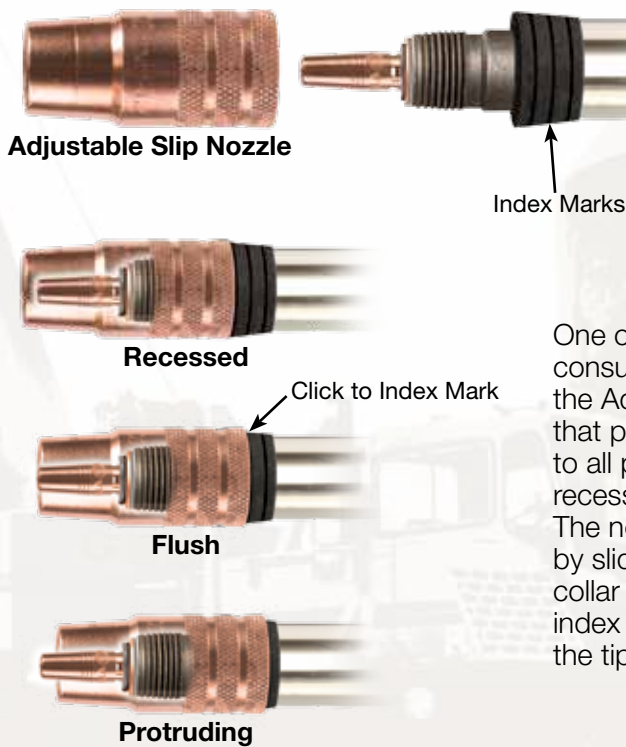
Extended Taper

SPEED MADE EASY.

All of the features of Velocity™ result in more convenience and higher productivity for the welder.

Velocity Conductor Tubes fit Tweco® Spray Master® V250, V350 & V450 MIG Guns.

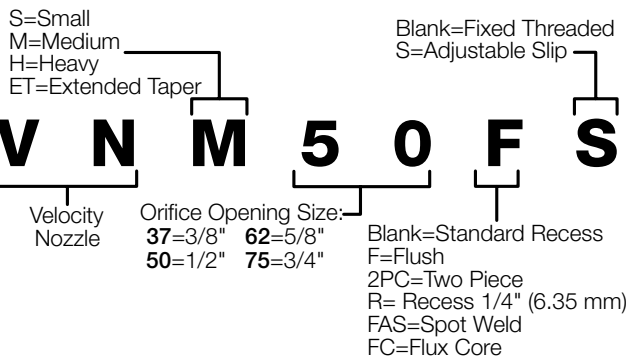
Click it and Go - Easy to Adjust Slip Nozzle



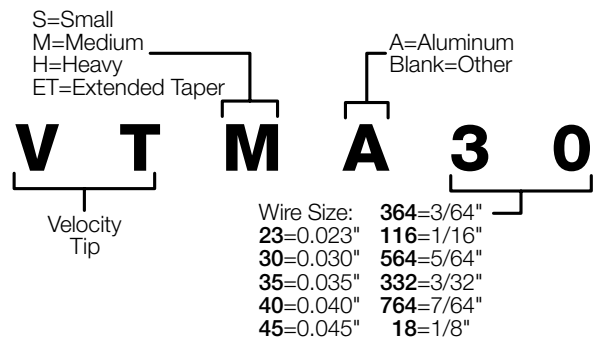
One of the Velocity consumable offerings is the Adjustable Slip Nozzle that provides positive indexing to all positions whether you require recessed, flush or protruding tips. The nozzle clicks into place just by sliding to the index marks on the collar of the conductor tube. Each index mark allows the operator to adjust the tip by 1/8" increments.

Conduit Liner Set Screw
Conductor Tube Clamp Screw

VELOCITY NOZZLE IDENTIFICATION

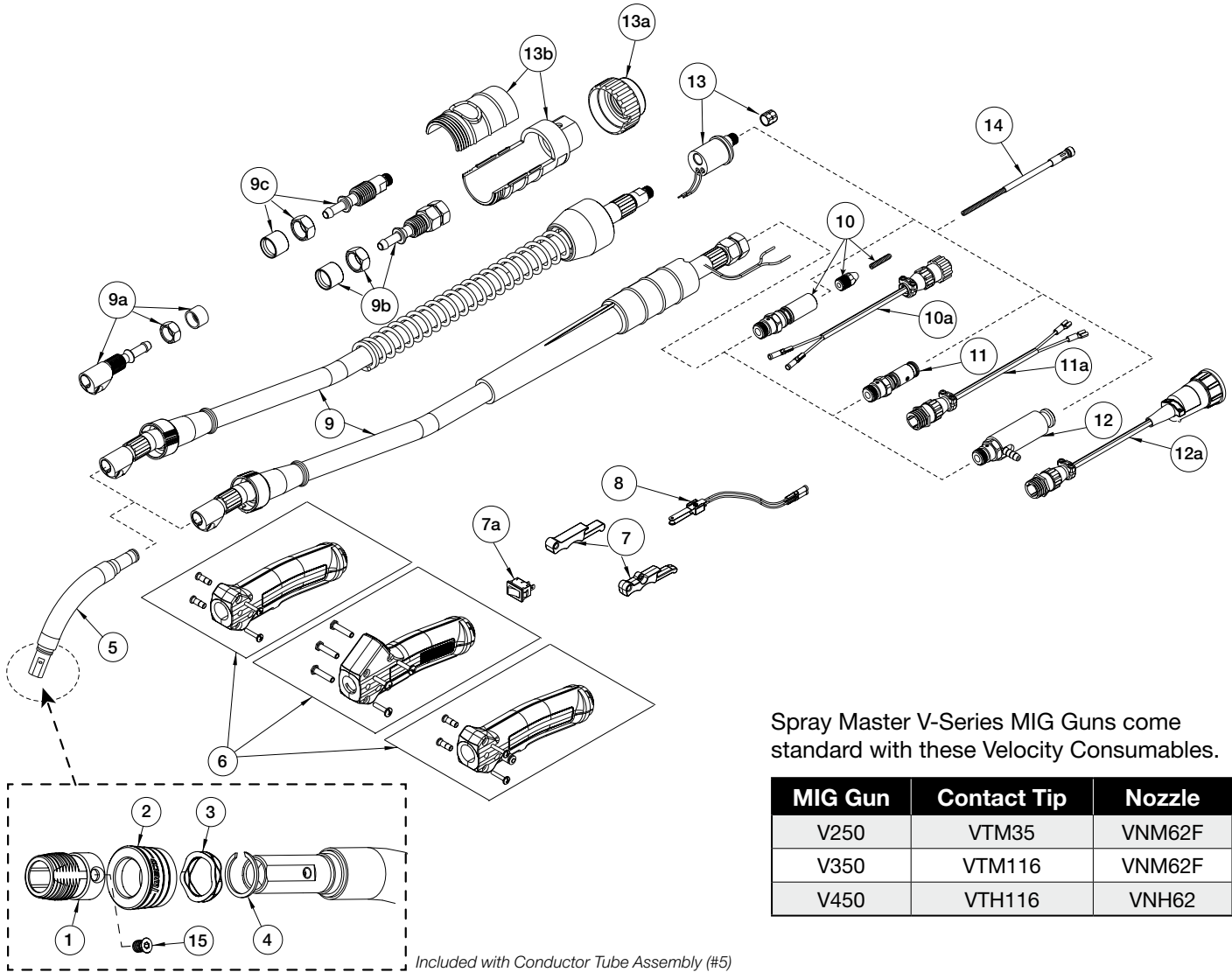


VELOCITY CONTACT TIP IDENTIFICATION



*Reference your MIG gun Operator's Manual for details.

Spray Master® V-Series MIG Gun Replacement Parts



Spray Master V-Series MIG Guns come standard with these Velocity Consumables.

MIG Gun	Contact Tip	Nozzle
V250	VTM35	VNM62F
V350	VTM116	VNM62F
V450	VTH116	VNH62

Upgrade your Spray Master® MIG gun to Velocity™ by replacing the conductor tube. See the back page of this brochure.



- 1) Order a Velocity conductor tube assembly.
- 2) Order a new replacement liner.
- 3) Order Velocity consumables - contact tips and nozzles.
See our Velocity consumables range brochure (Form No. 64-1403).
- 4) See our website or owners manual for specific step by step instructions to complete the modification.

Spray Master® V-Series MIG Gun Replacement Parts

#	Description	Spray Master V250 Amp		Spray Master V350 Amp		Spray Master V450 Amp	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
1	Threaded Stainless Sleeve	VCTLSL	1640-1397	VCTLSL	1640-1397	VCTLSL	1640-1397
2	Nozzle Collar	VCTLSLK	1640-1398	VCTLSLK	1640-1398	VCTLSLK	1640-1398
3	Wave Spring	VCTLSPR	1640-1399	VCTLSPR	1640-1399	VCTLSPR	1640-1399
4	Wave Spring Retainer	PMA64RS	1640-1396	PMA64RS	1640-1396	PMA64RS	1640-1396
5	Conductor Tube Assembly	SMVCT45	1240-1373	SMVCT60	1240-1374	SMVCT60	1240-1374
6	Handle – Standard Spray Master	SMV82	2060-2082	SMV83	2060-2083	SMV84	2060-2084
	Handle – Dual Schedule (Rocker Switch)	N/A	N/A	SMV83DS	2060-2077	SMV84DS	2060-2078
	Handle – Locking Trigger	SMV82LC	2060-2079	SMV83LC	2060-2080	SMV84LC	2060-2081
7	Trigger – Standard & Dual Schedule	ELC94	2060-2647	ELC94	2060-2647	ELC94	2060-2647
	Trigger – Locking	MS94-LC	2060-2693	MS94-LC	2060-2693	MS94-LC	2060-2693
7b	Dual Schedule Rocker Switch	N/A	N/A	MS94-RSW	2060-2694	MS94-RSW	2060-2694
8	Trigger Blade Assembly	ELC94-BL	2060-2671	ELC94-BL	2060-2671	ELC94-BL	2060-2671
9	Cablehoz® Assembly – 10 ft (3 m)	N/A	N/A	MS310	1730-2035	N/A	N/A
	Cablehoz Assembly – 12 ft (4 m)	MS212	1720-2116	MS312	1730-2036	MS512	1750-2116
	Cablehoz Assembly – 15 ft (5 m)	MS215	1720-2117	MS315	1730-2037	MS515	1750-2117
	Cablehoz Assembly – 25 ft (8 m)	MS225	1720-2118	MS325	1730-2038	MS525	1750-2118
	Cablehoz Assembly, Euro-Kwik – 12 ft (4 m)	MS212X	1720-2107	N/A	N/A	MS512X	1750-2119
	Cablehoz Assembly, Euro-Kwik – 15 ft (5 m)	MS215X	1720-2108	N/A	N/A	MS515X	1750-2120
	Cablehoz Assembly, Euro-Kwik – 25 ft (8 m)	MS225X	1720-2109	N/A	N/A	N/A	N/A
9a	Cablehoz Front Mechanical Connector Replacement Kit	MS102-RK	2060-2132	MS104-RK	2060-2133	EL106-RK	2060-2620
9b	Cablehoz Rear Mechanical Connector Replacement Kit	MS172-RK	2060-2134	MS174-RK	2060-2135	--	--
9c	Cablehoz Rear Mechanical Connector Replacement Kit For Euro-Style	172X-M	2020-2181	174X-M	2040-2181	--	--
10a	Miller® Rear Connector	350174MHFS	2035-2118	350174MHFS	2035-2118	350174MHFS	2035-2118
10b	Miller Control Wire & Plug	WM-354M	2030-2075	WM-354M	2030-2075	WM-354M	2030-2075
NS	Miller Dual Schedule Control Wire & Plug	N/A	N/A	194DS	2040-2195	194DS	2040-2195
11a	Tweco® Rear Connector	350174HFS	2035-2119	350174HFS	2035-2119	350174HFS	2035-2119
11b	Tweco Control Wire	MS354-TAJ	2060-2139	MS354-TAJ	2060-2139	MS354-TAJ	2060-2139
NS	Tweco Dual Schedule Control Wire & Plug	MS-354DS-TJ	2060-2138	MS-354DS-TJ	2060-2138	MS-354DS-TJ	2060-2138
12a	Lincoln® Rear Connector	350-174LH	2035-2112	350-174LH	2035-2112	350-174LH	2035-2112
12b	Lincoln Control Wire & Plug	MS-354DS-LJ	2060-2137	MS-354DS-LJ	2060-2137	MS-354DS-LJ	2060-2137
13	Euro-Kwik Connection Assembly	174EX-1	2040-2276	174EX-1	2040-2276	174EX-1	2040-2276
13a	Euro-Kwik Nut	174X-2	2040-2177	174X-2	2040-2177	174X-2	2040-2177
13b	Euro-Kwik Connector Case	X6RC	2060-2006	X6RC	2060-2006	X6RC	2060-2006
14	Conduit – Refer to our catalog or visit Tweco.com	--	--	--	--	--	--
15	Sleeve Screw	VCT41CS	2040-2048	VCT41CS	2040-2048	VCT41CS	2040-2048

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Spray Master® V250 Amp Air-Cooled MIG Gun

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)	SMV212-3545	1023-1276
	15 ft (4.6 m)	SMV215-3545	1023-1277
	20 ft (6.1 m)	SMV220-3545	1023-1278
	25 ft (7.6 m)	SMV225-3545	1023-1279

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	SMV210M-3545	1023-1280
	12 ft (3.6 m)	SMV212M-3545	1023-1281
	15 ft (4.6 m)	SMV215M-3545	1023-1282
	20 ft (6.1 m)	SMV220M-3545	1023-1283
	25 ft (7.6 m)	SMV225M-3545	1023-1289

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	SMV212L-3545	1023-1285

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. SMV354-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)	SMV210X-3545	1023-1286
	12 ft (3.6 m)	SMV212X-3545	1023-1287
	15 ft (4.6 m)	SMV215X-3545	1023-1288
	25 ft (7.6 m)	SMV225X-3545	1023-1284

Spray Master V350 Amp Air-Cooled MIG Gun

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 1/16" (1.6 mm)	10 ft (3 m)	SMV310-116	1036-1750
	12 ft (3.6 m)	SMV312-116	1036-1752
	15 ft (4.6 m)	SMV315-116	1036-1756
	15 ft (4.6 m)	SMV315-116DSRS	1036-1783

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	SMV310M-116	1036-1751
	12 ft (3.6 m)	SMV312M-116	1036-1754
	15 ft (4.6 m)	SMV315M-116	1036-1765
	25 ft (7.6 m)	SMV325M-116	1036-1775

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	SMV312L-116	1036-1753
	15 ft (4.6 m)	SMV315L-116	1036-1762
	15 ft (4.6 m)	SMV315L-116DSRS	1036-1788

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. SMV354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	SMV315X-116	1036-1770

"DSRS" = Dual Schedule Rocker Switch

Spray Master V450 Amp Air-Cooled MIG Gun

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 1/16" (1.6 mm)	10 ft (3 m)	SMV410-116	1040-1825
	12 ft (3.6 m)	SMV412-116	1040-1829
	15 ft (4.6 m)	SMV415-116	1040-1833
	15 ft (4.6 m)	SMV415-116LM	1040-1838
	20 ft (6.1 m)	SMV420-116	1040-1854
	25 ft (7.6 m)	SMV425-116	1040-1859

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	SMV410M-116	1040-1827
	12 ft (3.6 m)	SMV412M-116	1040-1830
	15 ft (4.6 m)	SMV415M-116	1040-1844
	15 ft (4.6 m)	SMV415M-116DSRS	1040-1846
	15 ft (4.6 m)	SMV415M-116LC	1040-1848
	15 ft (4.6 m)	SMV415M-116LM	1040-1849
	20 ft (6.1 m)	SMV420M-116	1040-1855
	25 ft (7.6 m)	SMV425M-116	1040-1861

Lincoln® Style Rear Connector

Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	SMV410L-116	1040-1826
	15 ft (4.6 m)	SMV415L-116	1040-1839
	15 ft (4.6 m)	SMV415L-116DSRS	1040-1840
	15 ft (4.6 m)	SMV415L-116LC	1040-1842
	15 ft (4.6 m)	SMV415L-116LM	1040-1843
	25 ft (7.6 m)	SMV425L-116	1040-1860

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. SMV354-DSLJ (Stock No. 2060-2137) Must be ordered separately.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	10 ft (3 m)	SMV410X-116	1040-1828
	12 ft (3.6 m)	SMV412X-116	1040-1832
	15 ft (4.6 m)	SMV415X-116	1040-1850

"DSRS" = Dual Schedule Rocker Switch; "LC" = Locking Trigger; "LM" = Long Reach; 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 Victor Technologies International, Inc. Tweco and Spray Master are registered trademarks of Victor Technologies International, Inc.

Spray Master Conductor Tube Upgrade

Description	Part No.	Stock No.
45° Conductor Tube Assembly	SMVCT45	1240-1373
60° Conductor Tube Assembly	SMVCT60	1240-1374
60° Conductor Tube Long Reach Assembly	SMVCT60LM	1640-1374

Upgrade Spray Master to Velocity™

- 1) Order a Velocity conductor tube assembly from the table at left.
- 2) Order a new replacement liner.
- 3) Order Velocity consumables - contact tips and nozzles. See our Velocity consumables range brochure (Form No. 64-1403).
- 4) See our website or owners manual for specific step by step instructions to complete the modification.