



### MIG Consumables

#### Tweco® MIG 11-Series Contact Tips

Part No.	Description
1444-0025	MIG 11-Series .023" Contact Tip 10 PK
1444-0026	MIG 11-Series .030" Contact Tip 10 PK
1444-0027	MIG 11-Series .035" Contact Tip 10 PK
1444-0029	MIG 11-Series .040" Contact Tip 10 PK

#### Tweco® MIG 11-Series Nozzles

1444-0050	MIG 11-Series 3/8" Nozzle Flush
1444-0051	MIG 11-Series 1/2" Nozzle Flush
1444-0052	MIG 11-Series 5/8" Nozzle Flush

#### Gasless Flux Cored Wire

Part No.	Description
1440-0230	.030" - 2 lbs
1440-0231	.030" - 10 lbs
1440-0235	.035" - 2 lbs
1440-0236	.035" - 10 lbs

#### Argon/CO<sub>2</sub> Gas MIG Wire

see catalog	MILD STEEL .023" - 2, 11 lbs
see catalog	MILD STEEL .030" - 2, 11 lbs
1440-0245	STAINLESS STEEL .030" - 2 lbs
1440-0489	STAINLESS STEEL .030" - 10 lbs

- Delivers a Versatile and Effective Welding Performance
- All accessories included
- Offers quick-change internal polarity adjustment – an easy switch from MIG to Flux-Cored
- Operates from standard 230V outlet and delivers 165 Amps
- Weighs 60 lbs (27.2 kg)
- Gas and Gasless Operation

### MIG (GMAW) WIRE AMPERAGE RANGE

AWS Wire Class	Diameter (in)	Amperage Range			
		MIN. 50A	100A	150A	200A
SOLID WIRE MILD STEEL	.023		.025" - .050" †		
	.030		.031" - 1/8" †		
	.035		.050" - 1/2" †		
	.045		.078" - 1/2" †		
SOLID WIRE STAINLESS STEEL	.030		.031" - 1/8" †		
FLUX CORED MILD STEEL	.030		.031" - .078" †		
	.035			.037" - 3/16" †	

(Recommend multi-pass over 3/16" plate thickness) \* E71T-GS, Single Pass wire only. † Plate Thickness

### WELDING TIPS

- Keep the torch handle at a 45° angle with respect to the metal. Maintain the nozzle about 1.4" (0.6 mm) from the surface.
- Move the torch handle with prudence and steadiness
- Avoid MIG welding in areas with too much draft. Too much draft blows away the shielding gas from the weld pool and may cause in the weld
- Keep the wire and its cover clean. DO NOT use rusted wire
- Avoid sharp bends and kinks on the MIG gun cable
- If possible, clean the wire liner with compressed air when replacing the wire spool
- Periodically, remove the dust using low pressure air or nitrogen (2-3 Bar/30-45 psi) from the inside of the power source, to assure adequate heat dissipation from power source during operation



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