

Firepower[®]



Welding Brochure



VictorTechnologies.com

MIG/FLUX CORED WELDERS

Tweco Fabricator 141i



Fabricator® 141i Part No. W1003141 3-in-1 Welding System

Machine Specifications

Maximum output	140 Amp
MIG (GMAW/FCAW) Welding	140A / 19V @ 15% Duty Cycle
Output @104°F (40°C)	90A / 18.5V @ 20% Duty Cycle
STICK (SMAW) Welding	90A / 23V @ 15% Duty Cycle
Output @104°F (40°C)	80A / 23.2V @ 35% Duty Cycle
TIG (GMAW) Welding	140A / 15.6V @ 15% Duty Cycle
Output @104°F (40°C)	100A / 14V @ 20% Duty Cycle
Current range	10A - 140 Amp
MIG Welding Voltage Range	14.5V - 19V
Wire Diameter Range	Solid: .023" - .030" (0.6 - 0.8 mm)
	Stainless steel: .023" - .030" (0.6 - 0.8 mm)
	Flux cored: .030" - .035" (0.8 - 0.9 mm)
Wirefeed Speed Range	100 - 600 IPM (2.5 - 15.2 m/min)
Dimensions (H x W x D)	16.14" x 8.27" x 17.72" (410 x 210 x 450mm)
Weight	32.2 lbs. (14.6 kg)

The Tweco® Fabricator 141i is the only product of its kind. It features MIG, Stick and TIG processes – complete in one unit. It's the lightweight system that has changed the game.

This portable powerhouse is designed to take on any MIG, Stick or TIG job it meets. It delivers up to 140 Amps of welding power and weighs less than 33 lbs.

The compact 141i delivers the flexibility you need in the field, including applications like:

- Automotive Repair & Customization
- Farm and Ranch
- Training Institutions
- Maintenance & Repair
- Sheet Metal & Light Fabrication
- On-site & Portable Welding Applications
- Home Hobbyists (DIY)

3-processes. One machine. There's never been a portable power system like this before.



Primary Power

Primary voltage	115VAC
Supply plug	NEMA 5-20P
Lead cord length	10 ft. (3 m)
Max input current	41.5 Amps
Rated kVA	5 kVA

Package Options

Package Options	Part No.
• Fabricator 141i package	W1003141
• Fabricator 141i package w/ Cart	W1003142

MIG/FLUX CORED WELDERS

Thermal Arc Fabricator 181i



Fabricator® 181i Part No. W1003181 3-in-1 Welding System

Machine Specifications

Maximum output	180 Amp
MIG (GMAW/FCAW) Welding	180A / 23V @ 20% Duty Cycle
Output @104°F (40°C)	145A / 22.5V @ 30% Duty Cycle
STICK (SMAW) Welding	175A / 27V @ 20% Duty Cycle
Output @104°F (40°C)	140A / 25.6V @ 30% Duty Cycle
TIG (GMAW) Welding	175A / 17V @ 25% Duty Cycle
Output @104°F (40°C)	160A / 16.4V @ 30% Duty Cycle
Current range	10 - 180 Amp
MIG Welding Voltage Range	10 - 25 Volt
Wire Diameter Range	Mild steel: .023" - .035" (0.6 - 0.9mm)
	Stainless steel: .023" - .035" (0.6 - 0.9mm)
	Aluminum: .030" - .035" (0.8 - 0.9mm)
	Flux cored: .030" - .045" (0.8 - 1.2mm)
Fitted feed roll suits MIG wire	.023" - .030" / .035" (0.6 - 0.8 / 0.9mm)
Dimensions (H x W x D)	16.14" x 8.27" x 17.72" (410 x 210 x 450mm)
Weight	32.2 lbs. (14.6 kg)

The Thermal Arc® Fabricator 181i is the only product of its kind. It features MIG, Stick and TIG processes – complete in one unit. It's the lightweight system that has changed the game.

This portable powerhouse is designed to take on any MIG, Stick or TIG job it meets. It delivers up to 180 Amps of welding power and weighs less than 33 lbs.

The compact 181i delivers the flexibility you need in the field, including applications like:

- Automotive
- Farm and Ranch
- Light Fab Professionals
- Technical Hobbyists
- Welders
- Do-It-Yourselfers
- Construction
- Manufacturing
- Maintenance & Repair
- Educational Institutions

3-processes. One machine. There's never been a portable power system like this before.



Primary Power

Primary voltage	208/230 VAC
Supply plug	NEMA 6-50P
Lead cord length	9 ft. (2.75m)
Maximum input current @ 140 Amp	37 Amp
Rated kVA @ 90 Amps	9 kVA

Package Options

Package Options	Part No.
• Fabricator 181i package	W1003181
• Fabricator 181i package w/ Cart	W1003182

Fabricator® 181i Part No. W1003188 Auto-Pak™ 3-in-1 Welding System

Complete Welding Package for Automotive*

Package Includes:

- Fabricator® 181i 3-in-1™ Welding System

PLUS:

- E70S-6 Welding Wire, .023", 2 lbs.
- E70S-6 Welding Wire, .030", 2 lbs.
- Welding Gloves
- Tweco® 11-23 Tips, .023", (25 qty)
- Tweco 11-30 Tips, .030", (25 qty)
- Welper MIG Pliers
- Auto-Darkening Helmet**

*TIG Torch sold separately.

**Welding helmet ships separately.



Fabricator® 181i Part No. W1003189 Farm-Pak™ 3-in-1 Welding System

Complete Welding Package for Farm & Ranch*

Package Includes:

- Fabricator 181i 3-in-1 Welding System

PLUS:

- E6013 Electrodes, 1/8", 1 lb.
- E6018 Electrodes, 1/8", 1 lb.
- Welding Gloves
- E71T-GS, .035", 2 lbs.
- Tweco 11-35 Tips, .035", (25 qty)
- Chipping Hammer
- Wire Brush
- Auto-Darkening Helmet**

*TIG Torch sold separately.

**Welding helmet ships separately.



MIG/FLUX CORED WELDERS

Thermal Arc Fabricator 211i



Fabricator® 211i Part No. W1004201 3-in-1 Welding System

Machine Specifications

Maximum output	210 Amp
MIG (GMAW/FCAW) Welding	110A / 19.5V @ 45% Duty Cycle (115V)
Output @104°F (40°C)	210A / 23.5V @ 20% Duty Cycle (230V)
STICK (SMAW) Welding	110A / 24.8V @ 35% Duty Cycle (115V)
Output @104°F (40°C)	200A / 25V @ 25% Duty Cycle (230V)
TIG (GMAW) Welding	150A / 16V @ 35% Duty Cycle (115V)
Output @104°F (40°C)	200A / 18V @ 25% Duty Cycle (230V)
Current range	5 - 150 Amp (115V), 5 - 210 Amp (230V)
MIG Welding Voltage Range	14 - 30 Volt
Wire Diameter Range	Mild steel: .023"- .035" (0.6 - 0.9 mm)
	Stainless steel: .023"- .035" (0.6 - 0.9 mm)
	Aluminum: .030"- 3/64" (0.8 - 1.2 mm)
	Flux cored: .030"- .045" (0.8 - 1.2 mm)
Wirefeed Speed Range	100 - 600 IPM (2.5 - 15.2 m/min) @ 230V
	100 - 400 IPM (2.5 - 10.2 m/min) @ 115V
Dimensions (H x W x D)	H 17.32" x W 10.23" x D 23.62" (440 mm x 260 mm x 600 mm)
Weight	57.3 lbs. (26 kg)

The Thermal Arc® Fabricator 211i features MIG, Stick and TIG processes – complete in one unit. It's the system that has changed the game.

This portable powerhouse is designed to take on any MIG, Stick or TIG job it meets. It delivers up to 210 Amps of welding power and weighs less than 58 lbs.

The 211i delivers the flexibility you need in the field, including applications like:

- Automotive Repair & Customization
- Farm and Ranch
- Training Institutions
- Maintenance & Repair
- Sheet Metal & Light Fabrication
- On-site & Portable Welding Applications
- Home Hobbyists (DIY)

3-processes. One machine. There's never been a portable power system like this before.



Primary Power

Primary voltage	115VAC, 208/230VAC
Supply plug	NEMA 6-50P
Lead cord length	9 ft. (2.75m)
Max input current	36.7 Amp (115V), 30 Amps (230V)
Rated kVA	4.5 kVA (115V), 7 kVA (230V)

Package Options

Package Options	Part No.
• Fabricator 211i package	W1004201
• Fabricator 211i package w/ Cart	W1004202
• Fabricator 211i package w/ single cylinder cart	W1004201

MIG/FLUX CORED WELDERS

Thermal Arc Fabricator 252i



Fabricator® 252i Part No. W1004401 3-in-1 Welding System

Machine Specifications

Maximum output	300 Amp
MIG (GMAW/FCAW) Welding Output @104°F (40°C)	250A / 26.5V @ 40% Duty Cycle 200A / 24V @ 60% Duty cycle 150A / 21.5V @ 100% Duty Cycle
STICK (SMAW) Welding Output @104°F (40°C)	230A / 29.2V @ 40% Duty Cycle 200A / 28V @ 60% Duty cycle 150A / 26V @ 100% Duty Cycle
TIG (GMAW) Welding Output @104°F (40°C)	250A / 20V @ 40% Duty Cycle 200A / 18V @ 60% Duty cycle 150A / 16V @ 100% Duty Cycle
Current range	5-300 A
MIG Welding Voltage Range	14 - 30 Volt
Wire Diameter Range	Mild steel: .023" - .045" (0.6 - 1.2 mm) Stainless steel: .023" - .035" (0.6 - 0.9 mm) Aluminum: .030" - 3/64" (0.8 - 1.2 mm) Flux cored: .030" - .045" (0.8 - 1.2 mm)
Wirefeed Speed Range	67-700 ipm (1.7 – 17.8 m/min)
Dimensions (H x W x D)	H 17.32" x W 10.23" x D 23.62" (440 mm x 260 mm x 600 mm)
Weight	65.3 lbs. (29.6 kg)

The Thermal Arc® Fabricator 252i features MIG, Stick and TIG processes – complete in one unit. It's the system that has changed the game.

This powerhouse is designed to take on any MIG, Stick or TIG job it meets. It delivers up to 300 Amps of welding power and weighs less than 66 lbs.

The 252i delivers the flexibility you need in the field, including applications like:

- Light Industrial Manufacturing
- Mechanical Contractors
- On-Site & Portable Welding Applications
- Automotive Repairs & Customization
- Farms & Ranches
- Training Institutions
- Maintenance & Repairs

3-processes. One machine. There's never been a portable power system like this before.



Primary Power

Primary voltage	Nominal 208/230 VAC
Supply plug	NEMA 6-50P
Lead cord length	9 ft. (2.75m)
Max input current	39.5 Amps
Rated kVA	8.2 kVA

Package Options

Package Options	Part No.
• Fabricator 252i package	W1004401
• Fabricator 252i package w/ single cart	W1004202
• Fabricator 252i package w/ dual cart	W1004403

MIG/FLUX CORED WELDERS

Thermal Arc® FP-95
Thermal Arc® FP-125

FP-95 Part No. 1444-0322 Flux Cored Welding System

Machine Specifications

Maximum output	90 Amp
Duty cycle @ 104°F	15% @ 80 Amp at 17.5V
Current range	20-90 Amp
Number of voltage settings	2
Maximum plate thickness	3/16" (4.8mm)
Wire diameter range	.030" - .035" (0.8 - 0.9mm)
Dimensions (HxWxD)	11" x 7.75" x 14.5" (340x195x370mm)
Weight	45 lbs. (20.6kg)

The portable FP-95 flux-cored wire welder delivers a basic yet effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system is designed to operate from a standard household outlet and delivers a maximum output of 90 amps. Requiring no shielding gas, it's ideal for outside use. The ready to weld system comes complete with Tweco® WeldSkill® gun, return cable & clamp, input power cored & plug, spool of flux cored wire and an operating manual. Optional cart also available.



Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance & repairs

Primary Power

Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	4 ft. (1.2m)
Rated kVA @ 90 Amps	2.5 kVA

FP-125 Part No. 1444-0324 MIG/Flux Cored Welding System

Machine Specifications

Maximum output	110 Amp
Duty cycle @ 104°F	20% @ 88 Amp at 18V
Current range	20-125 Amp
Number of voltage settings	4
Maximum plate thickness	1/4" (6mm)
Wire diameter range	.023" - .035" (0.6 - 0.9mm)
Dimensions (HxWxD)	12.75" x 9.75" x 17.35" (375x250x440mm)
Weight	51 lbs. (23.5kg)

The FP-125 dual-purpose MIG welder offers maximum versatility. The unit features quick-change internal polarity adjustment that makes changing from MIG (GMAW) to flux cored (FCAW) welding quick and easy. With a standard 115 volt household current, it is suitable to use for home projects, but its versatility and 20% duty cycle also makes it ideal for medium duty general repair work and light industrial applications.



Applications include:

- Maintenance & repairs
- Farm/Ranch
- Home DIY Hobbyist

Primary Power

Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6 ft. (1.8m)
Rated kVA @ 90 Amps	2.8 kVA

MIG/FLUX CORED WELDERS

Thermal Arc® FP-135

FP-135 Part No. 1444-0326 MIG/Flux Cored Welding System

Machine Specifications

Maximum output	135 Amp
Duty cycle @ 104°F	40% @ 90 Amp at 18V
Current range	20-135 Amp
Number of voltage settings	4
Maximum plate thickness	1/4" (6mm)
Wire diameter range	.023" - .035" (0.6 - 0.9mm)
Dimensions (HxWxD)	12.75" x 9.75" x 17.35" (375x250x440mm)
Weight	56 lbs. (25.5kg)

The portable FP-135 dual purpose wire welder delivers a very versatile and effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard household outlet and delivers a high maximum output of 135 amps. The ready to weld system comes complete with Tweco® WeldSkill® gun, return cable & clamp, input power cord & plug, spool of flux cored wire, regulator and an operating manual. FP-135's high output and duty cycle makes this a great all round package. Optional cart also available.

Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- General light duty fabrication & repair



Primary Power

Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6 ft. (1.8m)
Rated kVA @ 90 Amps	2.8 kVA

FP-135 Welding Kit Part No. 1444-0346

Package Includes:

- FP135 MIG Welder
- MIG Welder Cart
- Wire Brush
- Auto-Darkening Helmet
- Chipping Hammer
- Regulator



FP-165 Part No. 1444-0328 MIG/Flux Cored Welding System

Machine Specifications

Maximum output	165 Amp
Duty cycle @ 104°F	20% @ 130 Amp at 30V
Current range	20-165 Amp
Number of voltage settings	4
Maximum plate thickness	3/8" (9mm)
Wire diameter range	.023" - .035" (0.6 - 0.9mm)
Dimensions (HxWxD)	12.75" x 9.75" x 17.35" (375x250x440mm)
Weight	60 lbs. (27.3kg)

The portable FP-165 dual purpose wire welder delivers a very versatile and effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard 230V outlet and delivers a high maximum output of 165 amps. The ready to weld system comes complete with Tweco® WeldSkill® gun, return cable & clamp, input power cord & plug, spool of flux cored wire, regulator and an operating manual. Optional cart available.

Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- General light duty fabrication & repair



Primary Power

Primary voltage	230 Volt
Supply plug	NEMA 6-50P
Lead cord length	6 ft. (1.8m)
Rated kVA @ 90 Amps	2.8 kVA



FP-165 Welding Kit Part No. 1444-0348

Package Includes:

- FP165 MIG Welder
- MIG Welder Cart
- Wire Brush
- Auto Darkening Helmet
- Chipping Hammer
- Regulator

MIG/FLUX CORED WELDERS

Firepower® FP-260

FP-260 Part No. 1444-0312 Welding System

Machine Specifications

Maximum output	270 Amp
Duty cycle @ 104°F	60% @ 200 Amp at 30V
Current range	20-270 Amp
Number of voltage settings	7
Maximum plate thickness	5/8" (16mm)
Wire diameter range	.023" - .045" (0.6 - 1.2mm)
Dimensions (HxWxD)	31" x 19.5" x 33" (375x250x440mm)
Weight	60 lbs. (27.3kg)

The FP-260 dual purpose wire welder delivers a very versatile and effective welding performance. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard 230V outlet and delivers a high maximum output of 270 amps. The ready to weld system comes complete with Tweco® WeldSkill® gun, return cable & clamp, input power cord & plug and an operating manual. This system offers industrial grade performance at an affordable price. A spool gun option for welding aluminum is also available.

Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- General light duty fabrication & repair
- Light industrial

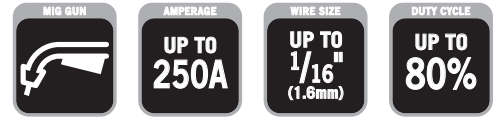


Primary Power

Primary voltage	230 Volt
Supply plug	NEMA 6-50P
Lead cord length	10 ft. (3m)
Rated kVA @ 190 Amps	11.2 kVA

Tweco® Fusion MIG Guns

(For part numbers see chart on next page.)



Tweco Fusion™ 140, 180 & 220

140 Amps @ 20% Duty Cycle • 180 Amps @ 40% Duty Cycle • 220 Amps @ 40% Duty Cycle

- Typical applications: light fabrication, welding of HVAC, architectural metal work, DIY, hobby, farm and autobody
- Operator appeal with ergonomic handle with diamond pattern for better grip
- Uses new high performance Velocity™ consumables
- Long-life microswitch trigger design
- Rugged with steel spring strain relief



Tweco Fusion 250

250 Amps @ 80% Duty Cycle

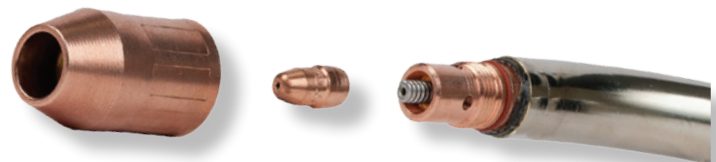
- Typical applications: general light fabrication, production welding, auto-body, RV/campers, farm equipment
- Operator appeal with ergonomic handle with extended trigger length
- Uses new high performance Velocity™ consumables
- High output / high duty cycle
- Rugged with steel spring strain relief



Tweco Velocity™ MIG Welding Consumables

Tweco Fusion™ MIG Guns come standard with Velocity™ Consumables

- Solid copper conductor path with fewer connections
- Optimized electrical surface contact
- Optimized wire feedability with centered liner
- Fewer consumable parts to replace – lower cost of ownership
- Easy to change Velocity tips – No threads, no tools required
- Tips can be rotated to optimize life requiring fewer changes
- Superior welding performance from a smooth, stable arc



VELOCITY™ CONSUMABLES	
Velocity™ Nozzles	Velocity™ Contact Tips
VNS-50F	VTS-23
VNS-50	VTS-30
VNS-37F	VTS-35
VNS-37	VTS-40
VNS-62F	VTS-45
VNS-62	VTS-364
VNS-75FAS	V TSA-364
VNS-FC	VTS-52
VNS-FCI*	VTS-116
	V TSA-116
	VTS-564

*Insulator for the flux-cored tip holder

Tweco® Fusion MIG Guns

TWECO FUSION™ MIG GUNS SELECTION CHART						
Amps	MIG Gun	DIY/Hobby	Farm	MRO	Autobody	Light Fab
≤ 150 Amps	Best Fit: Tweco Fusion 140 Alternate Fit: Tweco Fusion 180	Best	Good	Good	Best	
150 – 200 Amps	Best Fit: Tweco Fusion 180 Alternate Fit: Tweco Fusion 220	Best	Best	Best	Best	
200 – 250 Amps	Best Fit: Tweco Fusion 220 Alternate Fit: Tweco Fusion 250	Good	Best	Best	Best	Best
≥ 250 Amps	Best Fit: Tweco Fusion 250		Best	Best	Best	Best

TWECO FUSION™ MIG GUNS				
Rear Connection	Tweco Fusion™ 140 Part Number	Tweco Fusion™ 180 Part Number	Tweco Fusion™ 220 Part Number	Tweco Fusion™ 250 Part Number
Thermal Arc® (8 Pin)	1017-1321	1017-1332	1023-1261	1023-1097
Tweco® (4 Pin)	1017-1320	1017-1331	1023-1260	1023-1061
Miller®	1017-1319	1017-1330	1023-1259	1023-1069
Lincoln®	1017-1318	1017-1329	1023-1258	1023-1085
Euro-Kwik	1017-1323	1017-1334	1023-1263	1023-1091

POWER SUPPLY COMPATIBILITY				
Thermal Arc® Connector (8 Pin)	Tweco® Connector (4 Pin)	Miller® Connector	Lincoln® Connector	Euro-Kwik Connector
Thermal Arc® Fabricator 141i, 181i, 211i & 252i	Thermal Arc® Fabricator 190, 210, 251 & 281 Lincoln® SP100, SP100T, SP125 Plus, SP130, SP170T & SP170 Plus Hobart® Beta Mig 170	Millermatic® 130, 130 XP, 135, 140, 150, 155, 175, 180, 185, 200, 210, 211, 212 Hobart® Handler 130XL, 210, Trek 180, Ironman™ 210	Lincoln® SP140T, SP180T, PowerMIG® 140C & 180C, Easy-Core™ 125, Pro-Core™ 125, Easy-MIG® 140, Weld-Pak 125HD, 140HD & 180HD, MIG-Pak™ 140 & 180, Easy-MIG® 180, Pro-MIG™ 140 & 180	ESAB® MigMaster® 160 & 173

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Tweco® MINI-MIG Gun

The 160 amp, air-cooled Tweco Mini MIG gun is ideal for light-duty, hobby-style do-it-yourself welding applications.

Duty cycle rating

- 60% duty cycle with CO₂ gas at 160 amps

Benefits & features

Reduces operator fatigue

- Light-duty hobby gun

Easy to use

- Designed for do-it-yourself application

Out-of-the-box welding

- Fully assembled, ready to use MIG gun

Included features

- Air-cooled MIG gun
- Wire size capacity .030" - .035" (0,8mm - 0,9mm)
- Gun lengths in 10 ft. (3M) and 12 ft. (4M)

Optional kits

- Kits for Miller® rear connection and Lincoln® rear connection

Part No. 1000-1131; 10 ft. (3M)

Part No. 1000-1132; 12 ft. (4M)

Part No. 1000-1101; MIG Hobby Kit for Miller rear connection

Part No. 1000-1100; MIG Hobby Kit for Lincoln rear connection



Tweco Spray Master® 250 MIG Gun

The 250 amp, air-cooled Tweco Spray Master is the coolest MIG gun for spray transfer welding applications.

Duty cycle rating

- 80% duty cycle with Argon mixed gas at 250 amps

Benefits & features

Reduces operator fatigue

- With its ergonomic handle design

Ease of installation and ease of use

- With its simplified direct rear plug

Easy to repair and maintain

Improves welding productivity

- By using spray and pulse transfer welding with Argon mixed gases
- Reduces spatter build-up and thereby reduces spatter clean-up time

Out-of-the-box welding

- Fully assembled, ready to use MIG gun

Included features

- Air-cooled MIG gun
- Wire size capacity .030" - .045" (0,9mm - 1,2mm)
- Gun lengths in 12 ft. (4M) and 15 ft. (5M)

Part No. 1023-1101; 12 ft. (4M)

Part No. 1023-1102; 15 ft. (5M)



Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The afore mention registered trademarks are in no way affiliated with Tweco or Victor Technologies Industries, Inc.

Tweco® Classic #2 MIG Gun

The 200 amp, air-cooled Tweco #2 MIG gun is professional's choice for air-cooled 200 amp MIG welding application.

Duty cycle rating

- 60% duty cycle with CO₂ gas at 200 amps

Benefits & features

Most preferred gun style

- Industry's most popular handle design

Enhanced toughness

- Higher impact resistant materials
- Improved structural design

Improved durability

- Higher strength interlocking handle design

Higher performance

- Refined ergonomics with angled trigger

Included features

- Air-cooled MIG gun
- Wire size capacity .030" - .035" (0,8mm - 0,9mm)
- Gun lengths in 10 ft. (3M), 12 ft. (4M), and 15 ft. (5M)

Part No. 1020-1111; 10 ft. (3M)

Part No. 1020-1112; 12 ft. (4M)



Tweco® WeldSkill® Spool Guns

Benefits & features

- Excellent service and ease of operation
- Comfortable handle design
- Quick disconnect conductor tube
- Adapts to most welding machines
- Easy to use
- Designed for do-it-yourself application

160 Amp 20% Duty Cycle

Part No. 1027-1390

(for use on Thermal Arc 141i, 181i, 211i)

- Gun length 15 ft. (5M)

200 Amp 60% Duty Cycle

Part No. 1027-1391

(10 Pin Amphenol style connector)

- Gun length 25 ft. (8M)

200 Amp 60% Duty Cycle

Part No. 1027-1392

(use only on Thermal Arc 252i power supplies)

- Gun length 25 ft. (8M)



WELDING SYSTEM REPLACEMENT MIG GUNS



1444-0406

REPLACEMENT MIG GUNS

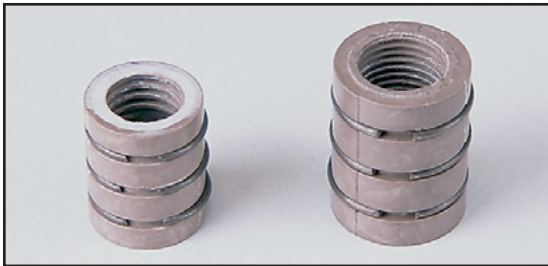
Part No.	Description
1444-0406	FP-300 MIG Gun Fits FP 200, FP 260 Welders Euro Connect Maximum Output Amps 230/270
1444-0413	FP-200 MIG Gun Fits FP 120, FP 130, FP 160 Welders Maximum Output Amps 120/155 Requires adaptor
1444-0740	Max output amps 180
1444-0741	Max output amps 180
1444-0417	Adaptor for use with Model 1444-0413. Adaptor is required only when replacing a Tweco® style MIG gun with a Helvi gun

180 AMP SPOOL GUN



Spool gun assembly with 19 ft. cable, 180 Amp @ 30%. No interface kit required, just plug and play. **Part No. W4011100**

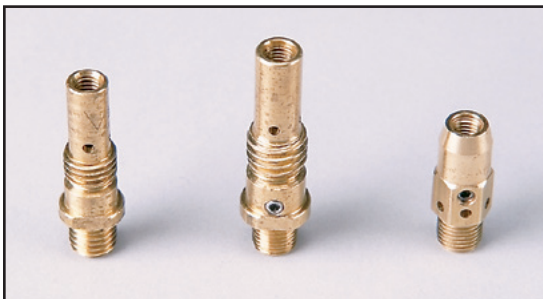
MIG NOZZLE INSULATORS



MIG NOZZLE INSULATORS

Part No.	Description
1444-0075	FP-32 Insulator for 250 amp gun (2 pk)
1444-0261	FP-34A Insulator for 400 amp gun (2 pk)

GAS DIFFUSERS



GAS DIFFUSERS

Part No.	Description
1444-0080	FP-51 Diffuser for 180 amp gun (2 pk)
1444-0165	FP-52 Diffuser for 250 amp gun (2 pk)
1444-0265	FP-54A Diffuser for 400 amp gun (2 pk)
1444-0082	FP-35-50 Male Thread diffuser for Tweco style gun
1444-0489	FP-35 Female Thread diffuser for Tweco style gun

Fabricator® MIG Consumables

CONTACT TIPS

Part No.	Description
Fabricator 140, 180, 190	
1110-1100	11-23; .023" (0.6mm)
1110-1101	11-30; .030" (0.8mm)
1110-1102	11-35; .035" (0.9mm)
1110-1103	11-40; .040" (1.0mm)
1110-1104	11-45; .045" (1.2mm)
Fabricator 210	
1140-1100	14-23; .023" (0.6mm)
1140-1101	14-30; .030" (0.8mm)
1140-1102	14-35; .035" (0.9mm)
1140-1103	14-40; .040" (1.0mm)
1140-1104	14-45; .045" (1.2mm)
Fabricator 251 and 281	
1140-1100	14-23; .023" (0.6mm)
1140-1101	14-30; .030" (0.8mm)
1140-1102	14-35; .035" (0.9mm)
1140-1103	14-40; .040" (1.0mm)
1140-1104	14-45; .045" (1.2mm)



11-23

NOZZLES

Part No.	Description
Fabricator 140, 180, 190	
1210-1100	21-37; 3/8" (9.5mm)
1210-1110	21-50; 1/2" (12.7mm)
1210-1120	21-62; 5/8" (16mm)
Fabricator 210	
1220-1101	22-37; 3/8" (9.5mm)
1220-1110	22-50; 1/2" (12.7mm)
1220-1120	22-62; 5/8" (16mm)
Fabricator 251 and 281	
1240-1101	24A-37-SS; 3/8" (9.5mm)
1240-1110	24A-50; 1/2" (12.7mm)
1240-1120	24A-62; 5/8" (16mm)
1240-1130	24A-75; 3/4" (19mm)



24A-50

CONDUITS

Part No.	Description
Fabricator 140, 180, 190 and 210	
1420-1103	42-23-15; .023", 15ft (7.6m)
1420-1113	42-3035-15; .030"-.035", 15ft (4.5m)
1420-1123	42-4045-15; .040"-.045", 15ft (4.5m)
Fabricator 251 and 281	
1420-1103	42-23-15; .023", 15ft (7.6m)
1420-1113	42-3035-15; .030"-.035", 15ft (4.5m)
1440-1103	44-3545-15; .035"-.045", 15ft (4.5m)
1440-1003	44N-3545-15; .035"-3/64", 15ft (4.5m)

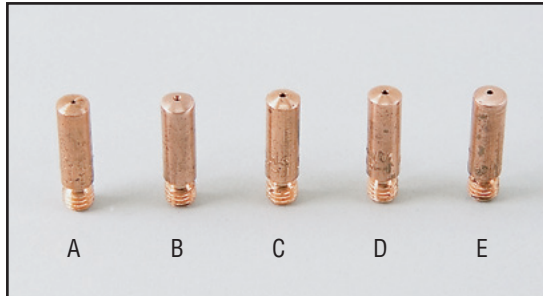


42-3035-15

FABRICATOR MIG GUN OPTIONS:

MIG gun options	Fabricator 190	Fabricator 210	Fabricator 251 / 281
Tweco® MINI-MIG gun	YES	YES	–
Tweco Spray Master® 250	YES	YES	YES
Tweco Professional #2	YES	YES	–
Tweco Professional #4	–	–	YES
Tweco WeldSkill® Spool Gun	–	YES	YES
Single Cylinder Rack	–	YES	YES

180 AMP MIG GUN CONTACT TIPS

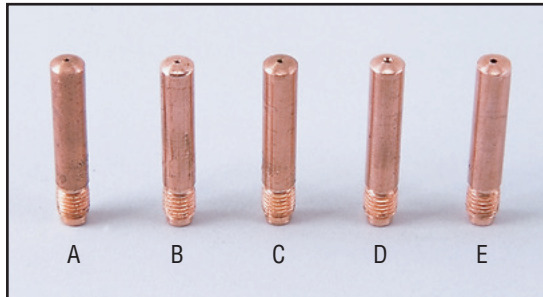


180 Amp MIG Gun Contact Tips

Part No.	Description
A 1444-0025	FP11-23, .023 wire, Tip ID .031 (10 pk)
B 1444-0026	FP11-30, .030 wire, Tip ID .038 (10 pk)
C 1444-0027	FP11-35, .035 wire, Tip ID .044 (10 pk)
D 1444-0028	FP11-40, .040 wire, Tip ID .048 (10 pk)
E 1444-0029	FP11-45, .045 wire, Tip ID .054 (10 pk)

FP = Firepower®

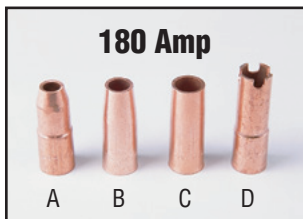
250 & 400 AMP MIG GUN CONTACT TIPS



250 & 400 Amp MIG Gun Contact Tips

Part No.	Description
A 1444-0220	FP14-23, .023 wire, Tip ID .031 (10 pk)
B 1444-0221	FP14-30, .030 wire, Tip ID .038 (10 pk)
C 1444-0222	FP14-35, .035 wire, Tip ID .044 (10 pk)
D 1444-0223	FP14-40, .040 wire, Tip ID .048 (10 pk)
E 1444-0224	FP14-45, .045 wire, Tip ID .054 (10 pk)

MIG GUN NOZZLES



Nozzles - 180 Amp Guns

Part No.	Description
A 1444-0050	FP21-37, 3/8" Bore (1pk)
B 1444-0051	FP21-50, 1/2" Bore (1pk)
C 1444-0052	FP21-62, 5/8" Bore (1pk)
D 1444-0053	FP21-62-FAS, 5/8" Bore, Arc Spot (1pk)

Nozzles - 250 Amp Guns

Part No.	Description
A 1444-0140	FP22-50, 1/2" Bore (1pk)
B 1444-0141	FP22-62, 5/8" Bore (1pk)
C 1444-0142	FP22-62-FAS, 5/8" Bore, Arc Spot (1pk)

Nozzles - 400 Amp Guns

Part No.	Description
A 1444-0240	FP24A-50, 1/2" Bore (1pk)
B 1444-0241	FP24A-62, 5/8" Bore (1pk)
C 1444-0242	FP24A-62-FAS, 5/8" Bore, Arc Spot (1pk)

Thermal Arc® 95 S Inverter Part No. W1003202 Stick/Lift TIG Welding System

Machine Specifications

Input voltage	115 VAC 1 Phase 50/60Hz
Rated output	Stick 90 Amp / 23.6V @ 20% TIG 95 Amp / 13.8V @ 20%
Nominal OCV	60 Volt
SMAW Electrode Range	1/16" - 3/32"
GTAW DC Tungsten Range	.040" - 3/32"
Dimensions (HxWxD)	13" x 5.1" x 9.0" (330x130x230mm)
Weight	9.7 lbs. (4.4kg)

The Thermal Arc 95 S Inverter is a versatile multi-process machine with stick and lift TIG capability. With up to 95 amps of welding power it delivers excellent performance on a wide variety of materials. In DC Lift TIG mode the 95 S provides 95 amps of welding power suitable for a wide range of materials from Chrome-Moly and steel tubing to general fabrication of mild and stainless steels. Delivering a superior smooth and stable arc performance down to 5 amps for the thinnest of materials. Extremely lightweight and portable yet designed to handle the toughest jobs.

Applications include:

- Maintenance and repairs
- Sheet metal fabrication
- Farm/Ranch
- Auto body repair
- Home DIY Hobbyist



Above: 95S Stick (SMAW) package option - part no. W1003203

Primary Power

Primary voltage	115 Volt
Supply plug	NEMA 5-15P
Lead cord length	6 ft. (1.8m)
Maximum input current @ 140 Amp	24 Amp
Rated kVA @ 190 Amps	2.8 kVA

Package Options

Package Options	Part No.
• 95S Stick (SMAW) package	W1003202
• 95S TIG (GTAW) package	W1003203

Thermal Arc® 161 S Stick/Lift TIG Welding System Part No. W1003602

Machine Specifications

Input Voltage	115/208-230 VAC, 1 PH, 50/60 Hz
Rated Output 115V	Stick 100A/ 24V @35%, TIG 110A/ 14.4V @30%
Rated Output 230V	Stick 160A/ 26.4V @30%, TIG 160A/ 16.4V @30%
Nominal OCV	71V
Max OCV	65
Dimensions (HxWxD)	9.0" (229mm) x 5.3" (135mm) x 15.5" (394mm)
Weight	17.4 lbs. (7.9kg)

The Thermal Arc 161 S Portable DC Welder is designed for Stick & Lift TIG welding operations and provides a greater range of output for the advanced hobbyist or light industrial applications. It is capable of delivering 110 Amps on 115 Volt circuits for Stick & TIG welding. When used on 208-230 Volt circuits, maximum output is 160 Amps for either welding process. This welder features optimized hot start and arc-force circuits delivering superior arc starting and control when stick welding.

Applications include:

- Home Hobbyists
- Farm and ranch
- Educational institutions
- Maintenance and Repair



Primary Power

Primary voltage	115/208-230V
Hertz	50/60 Hz
Phase	1 PH
Designed to	IP23S
Approvals EN	60974-1

Package Options

- 161 S TIG (GTAW) package

Part No.

W1003603

Above: 161 S Stick (SMAW) package option - part no. W1003602

Thermal Arc® 201 TS Stick/Lift TIG Welding System Part No. W1003801

Machine Specifications

Rated Output:

Stick 115V, 15A	22.8V @ 70%
TIG 115V, 15A	14V @ 60%
Stick 115V, 20A	24.4V @ 30%
TIG 115V, 20A	16.4V @ 30%
Stick 230V 200A	28.0V @ 20% TIG 230V 200A / 18.0V @ 20%

Nominal OCV	71V
Dimensions (HxWxD)	9.0" (229mm) x 5.3" (135mm) x 17.7" (450mm)
Weight	21.6 lbs. (9.7kg)

The Thermal Arc 201 TS Portable DC Welder packs a serious punch and is ideal for tradesmen or welders with more demanding requirements. Powerful yet compact and portable, the 201TS can deliver 125 Amps on 115 Volt circuits for Stick welding and 160 Amps for TIG. When used on 208-230 Volt circuits, maximum output is 200 Amps for either welding process. The 201 TS features optimized hot start and user adjustable arc-force circuits delivering superior arc starting and control when Stick welding. The power source has High Frequency or Lift TIG circuitry for TIG welding and includes a trigger hold function (2T/4T), down slope timer, gas solenoid for flow through gas and the ability to use torch switch or foot control accessories. The TIG torch included in the package has an integrated amperage control dial and on/off switch, which allows for the ultimate in welding control and simplicity.

Applications include:

- Home Hobbyists
- Farm and ranch
- Educational institutions
- Maintenance and Repair



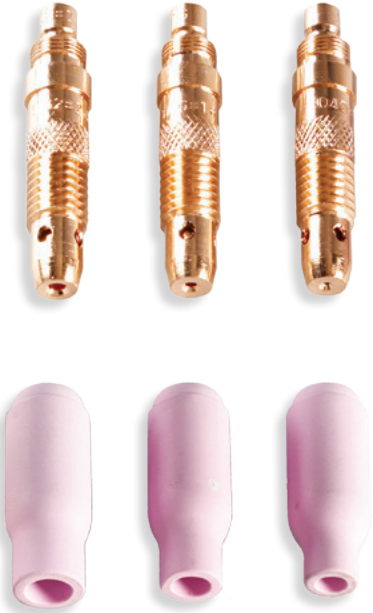
Primary Power

Primary voltage	115/208-230V
Hertz	50/60 Hz
Phase	1 PH
Designed to	IP23S
Approvals EN	60974-1

Package Options

- | Package Options | Part No. |
|---------------------------------|----------|
| • 201 TS Stick/Lift TIG package | W1003801 |

Thermal Arc® 95 S, 161 S and 201 TS Consumables



Consumable/Replacement Parts	
Part No.	Description
1442-0002	Backcap
1442-0003	Collet .040
1442-0004	Collet 1/16"
1442-0005	Collet 3/32"
1442-0006	Collet Body .040
1442-0007	Collet Body 1/16"
1442-0008	Collet Body 3/32"
1442-0009	Cup Alumina 4
1442-0010	Cup Alumina 5
1442-0011	Cup Alumina 6
1442-0012	TIG Accessory Kit
1442-0013	Tungsten .042 2% Thoriated
1442-0014	Tungsten 1/16" 2% Thoriated
1442-0015	Tungsten 3/32" 2% Thoriated
W4012500	17V TIG Torch, Complete, 25mm Connection

Thermal Arc TIG Torches & Accessories

Part No. W4013802 (for 181i)
 17V, 13 ft, 8 pin and accessory kit with: 1/16", 3/32", 1/8" thoriated tungstens;
 1/16", 3/32", 1/8" collets; 1/16", 3/32", 1/8" collet bodies; No. 5, 6, 7 Alumina
 nozzle; short back cap; long back cap.

Part No. W4012500 (for 95 S)
 17V, 25mm Dinse connection

Part No. W4012600 (for 161 S)
 17V, 50mm Dinse connection

Part No. W4014603 (for 211i)
 26V, 50mm Dinse connection

Part No. W4013600 (for 252i, 201 TS, 186 AC/DC)
 26V, 50mm Dinse connection



FP-100 Part No. 1443-0412 Welding System

Machine Specifications

Output range	5-85 amps (120V)
Rated Output @ Duty Cycle	65A @ 15% Duty Cycle (120V)
Max OCV	65
Consumable Size	1/16" to 3/32" STICK electrode
Dimensions (HxWxD)	11.5" x 9" x 13.3" (290x225x338mm)
Weight	27 lbs. (12kg)

Enjoy the convenience of arc welding repairs at an affordable price. The FP-100 operates on standard 120 volt household current and is designed to be simple to operate. The FP-100 portable arc welding system features AC welding output as well as infinite amperage control making it easy for even novice welders to obtain professional results. The rugged easy grip handle and its light weight make this unit both practical and portable. The FP-100 is ideal for home, farm and light maintenance repairs.

Applications include:

- Home DIY hobbyist
- Farm/ranch
- Maintenance & repairs
- General fabrication



Primary Power

Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6 ft. (1.8m)
Rated kVA @ 85 Amps	2.5 kVA

FP-235 AC/DC Part No. 1443-0416 Welding System

Machine Specifications

Output range	20-235 amps (230V)
Rated Output @ Duty Cycle	200A @ 20% AC Duty Cycle 135A @ 20% DC Duty Cycle
Max OCV	65
Consumable Size	1/16" - 5/32" STICK electrode
Dimensions (HxWxD)	23" x 17.5" x 14" (597x441x360mm)
Weight	113 lbs. (51kg)

The FP-235 AC/DC provides powerful 235 Amp AC/185 Amp DC Arc (SMAW) welding performance at an affordable price. DC output produces better visual welds, with more control and less splatter. Its the preferred method for overhead out of position welding. The FP-235 features infinite amperage adjustment, which provides precise welding control. This versatile unit is ideal for both light and heavy-duty repairs. The FP-235's rugged, portable design delivers the reliability and performance to make it an ideal unit for general fabrication as well as farm, ranch, automotive and light maintenance repairs.

Applications include:

- Home DIY hobbyist
- Farm/ranch
- Maintenance & repairs
- General fabrication



Primary Power

Primary voltage	230V
Supply plug	NEMA 6-50P
Lead cord length	6 ft. (1.8m)

Thermal Arc® 186 AC/DC Part No. W1006301 Portable AC/DC HF TIG System

Machine Specifications

Maximum output	200 Amp
STICK (SMAW) Welding Output @104°F (40°C)	170A / 26.6V @ 16% Duty Cycle 150A / 26V @ 25% Duty cycle 150A / 26V @ 100% Duty Cycle
TIG (GMAW) Welding Output @104°F (40°C)	200A / 18V @ 20% Duty Cycle 180A / 17.2V @ 25% Duty cycle 150A / 16V @ 35% Duty Cycle
Current range	10-200 Amps
Dimensions (H x W x D)	H 15.75" x W 9.45" x D 18.7" (400 mm x 240 mm x 475 mm)
Weight	48.4 lbs. (22 kg)

The Thermal Arc 186 AC/DC is a multi-process, complete Stick & TIG system solution ready for any application. Fully featured professional performance capability made easy to use. High output duty cycle, and ready to perform.

Features:

- HF TIG (GTAW)
- Lift TIG (GTAW)
- STICK (SMAW)

Applications include:

- Aluminum Fabricators
- Training Institutions
- Maintenance & Repair
- On-Site & Portable Welding Applications
- Automotive, Boats & Trailers



Primary Power

Primary voltage	Nominal 208/230 VAC
Supply plug	NEMA 6-50P
Lead cord length	9 ft. (2.75m)
Max input current	35.6 Amps
Rated kVA	9.5 kVA

Package Options

Package Options	Part No.
• Thermal Arc 186 AC/DC System	W1006301
• Thermal Arc 186 AC/DC System with Foot Pedal	W1006303
• Thermal Arc 186 AC/DC System with Foot Pedal & Cart	W1006304

Welding Carts

Benefits & features

Rugged and durable MIG Welding cart holds welding machine on top tray and a single cylinder rack in the bottom tray and the gas bottle can be securely tied down with chains

Part No. 1444-0407 MIG Welding Cart for FP125, FP135, FP165

Welding Cart



Small Cart with Running Gear/Cylinder Rack

Sturdy construction. For gas cylinders no larger than 7" (178mm) diameter, maximum weight 75 lbs. (34 kg).

Part No. W4011500

FP-2000 Firepower® Air-Carbon Arc Gouging Torch

The Firepower Arc Gouging Torch is the perfect tool for metal removal applications on the farm, in metal shops and much more. The arc gouging process melts the metal with an electric arc and then blows it away with ordinary compressed air in a single pass!

Benefits & features

Reduces operator fatigue

- Natural 15° torch angle and 360° swivel cable provide comfort and operator ease
- Torch weight is only 3.6 lbs. (1.6 kg)

Applications

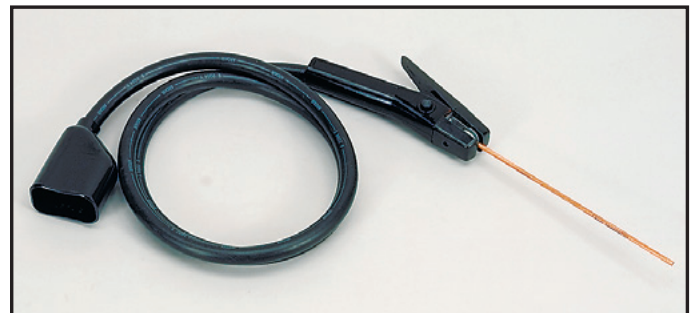
- Bead removal on welded joints
- Back gouging, edge preparation
- Defect repair

Included features

- Length: 7 ft.
- Rugged construction for the harsh environment

Operating parameters

- Carbon specs: 1/8" (3,2 mm) to 1/4" (6.5mm) round carbon electrodes and is rated up to 450 amps
- Operates with compressed air from 40 PSI (2.8 kg/cm²) to 60 PSI (4.2 kg/cm²)
- Requires a minimum of a 300 amp 3 Phase, arc welding machine. AC or DC; DC preferred



Part No. 1443-0042

Firepower® Electrode Holder

The industry standard for your stick electrode welding applications with 200 amp capacity.

Benefits & features

Long lasting

- Heavy duty, shock-proof nylon handle
- Ball point cable connection

Ease of use and ease of installation

- Reversible top and bottom insulators

Included features

- 6-position jaw pattern to hold welding electrode in place
- Fully insulated
- Supplied with an Allen wrench and cable connection ferrule assuring efficient connection and minimizing cable strand breakage at the connection

Part No. 1443-0015



Tweco® “HOLD-TITE” Electrode Holder

Provides a unique style, with Tweco-style head provides the gripping force to hold the stick electrode in place. It has 400 amp capacity for heavy duty welding applications.

Benefits & features

Long lasting

- Rugged and reliable design
- Ball point cable connection

Ease of use and ease of installation

Included features

- Fully insulated
- Supplied with an Allen wrench and cable connection ferrule assuring efficient connection and minimizing cable strand breakage at the connection

Part No. 9120-1010



Cable Connectors

Part No.	Description	Cable Capacity	Standard Package
9425-1125	1-WPC Complete Set of Connectors	4, 2, 1	1
9425-1225	2-WPC Complete Set of Connectors	1/0, 2/0, 3/0	1



Tweco® Welding Ground Clamps – Steel levers

Comes in 300 amp and 500 amp capacities. These can be used in stick welding, submerged arc welding, gas metal arc welding, gas tungsten arc welding applications for light and medium duty metal fabrication.

Benefits & features

Long lasting

- Heavy duty spring
- Ball point screw to secure the welding cable to the ground clamp

Included features

- Steel upper and lower levers
- Heavy duty spring providing clamping force to the work surface
- Connector body with ball point screw
- Overall length 9"
- Cable connection capacity of 1/2" stud connection

Ease of use and ease of installation with large jaw opening of 2" with jaw opening depth of 1.75"

Part No. 9205-1230 – 300 amp capacity

Part No. 9205-1250 – 500 amp capacity



Tweco Welding Ground Clamps - Copper

Comes in 200 amp and 300 amp capacities. These can be used in stick welding, submerged arc welding, gas metal arc welding, gas tungsten arc welding applications for light and medium duty metal fabrication.

Benefits & features

Long lasting

- Rugged and reliable in design
- Ball point screw to secure the welding cable to the ground clamp

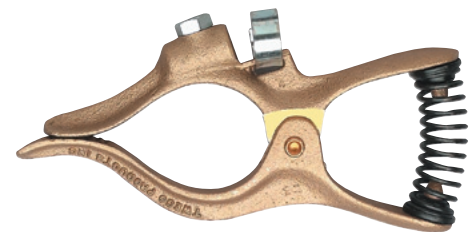
Included features

- Copper cast upper and lower jaws
- Heavy duty spring providing clamping force to the work surface
- Overall length 6" (200 amp) and 8.5" (300 amp)

Ease of use and ease of installation with large jaw opening of depth of 3" (200 amp) and 4" (300 amp)

Part No. 9205-1120 – 200 amp capacity

Part No. 9205-1130 – 300 amp capacity



Tweco Switchable Magnetic Ground Clamps

Can be used as a ground clamp device around pipe and flat applications, or with any large magnetic base metal. It is used to lay the ground clamp magnetically attached to the metal being welded, thus providing the electrical ground.

Benefits & features

Long lasting - rugged and reliable in design

Included features

- 200 amp and 300 amp capacities

Very easy to use and easy to install

- Get a very secure grip by turning the knob and release the grip by turning it back
- These are switchable, meaning that the ground clamp can easily be removed by turning "off" the magnetic function thereby releasing the ground clamp from the base metal structure

Part No. 9255-1060 – 200 amp capacity

Part No. 9255-1061 – 300 amp capacity



NOW AVAILABLE

Premium Firepower® Auto-Darkening Welding Helmet



Firepower®

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Part No. 1441-0086



Piston & Plug



Pinstripes



Skull & Fire

Part No. 1441-0085

Part No. 1441-0088



Stars & Stripes

Part No. 1441-0087

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