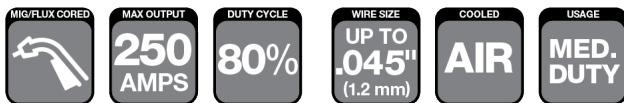


VELOCITY2

Spray Master® V250 AMP MIG Gun Air-Cooled

TWECO
AN ESAB® BRAND



WELDING PROCESSES:

MIG (GMAW), Flux Cored (FCAW),
Aluminum (GMAW)

Standard Options Include:

- Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube—SMVCTLS60 (Stock No. 1240-1377) on all guns up to 15ft (4.6 m)
- SMVCTLS45 (Stock No. 1240-1376) on all guns over 15ft (4.6 m)
- Conduit Liner—42 Series

Industry

- Ship and Offshore Yards
- Repair and Maintenance
- Steel Industry
- Industrial and General Fabrication
- Automotive

FEATURES

The Spray Master MIG Gun receives VELOCITY2 Medium and Heavy Duty consumables to create a new line of MIG guns, the VELOCITY2 Spray Master series. VELOCITY2 Spray Master 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, FOUR-LAYER CONDUCTOR TUBE** is designed for heavy duty cycle applications. The outer layer is made from a high temperature silicone tube decreasing the effect of radiant heat to the MIG gun.
- **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.

VELOCITY2 Spray Master series is outfitted with Velocity a revolutionary new approach in MIG consumables that will change the game in terms of welder productivity.

VELOCITY2 was designed by welders for welders. For more detailed information on VELOCITY2 Medium and Heavy Duty consumables, [visit Tweco.com](http://www.tweco.com)

VELOCITY2 MEDIUM & HEAVY DUTY WELDING CONSUMABLES REFERENCE

Medium Duty Range Overview

Wire sizes .023" (0.6 mm) à 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.

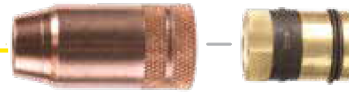
ADJUSTABLE SLIP allows welder to adjust the flushness relationship and provides improved access for cleaning.

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

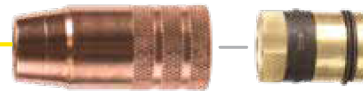
FIXED THREADED maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

ADJUSTABLE SLIP allows welder to adjust the flushness relationship and provides improved access for cleaning.

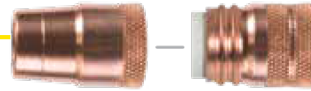
FIXED THREADED (2 piece) maintains flushness relationship and provides for easier cleaning and maintenance.



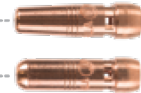
Fixed Threaded



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



Medium & Heavy Duty



Extended Taper Range Overview FOR ROOT PASS AND CONFINED ACCESS

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

Extended Tapper Nozzle



Extended Tapper



Extended Taper Range Overview FOR ROOT PASS AND CONFINED ACCESS

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



Heavy Duty Extended Tapper Nozzle



Heavy Duty Extended Tapper

VELOCITY2 SPRAY MASTER V250

| SPECIFICATIONS | |
|--------------------------------|---|
| Description | Spray Master V250 |
| Welding Output Mixed Gas | 250 A at 80% |
| Wire Diameter, Mild Steel | Up To 0.045" (1.2mm) |
| Wire Diameter, Stainless | Up To 0.045" (1.2mm) |
| Wire Diameter, Aluminium | Up To 0.045" (1.2mm) |
| Wire Diameter, Flux-cored | Up To 0.045" (1.2mm) |
| Certification Mark (Standards) | CE IEC 60974-7 |
| Operating Temperature | -10 to +40 °C |
| Cable Length | 10 ft. (3 m), 12 ft. (3.6 m), 15 ft. (4.6 m), 20 ft. (6.1 m) and 25 ft. (7.6 m) |

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) | 10 ft (3 m) | SMV210-3545 | 1023-1290 |
| | 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 |
| | 25 ft (7.6 m) | SMV225M-3545 | 1023-1289 |

Conduit Liners – For Use With Steel Welding Wires

180-250 Amp – Steel Wound

| Wire Size | Length | Part No. | Stock No. |
|---------------------------------|---------------|------------|-----------|
| .030" - .035" (0.8 - 0.9 mm) | 15 ft (4.6 m) | 42-3035-15 | 1420-1113 |
| .030" - .035" (0.8 - 0.9 mm) | 25 ft (7.6 m) | 42-3035-25 | 1420-1115 |
| .040" - .045" (1.0 - 1.2 mm) | 15 ft (4.6 m) | 42-4045-15 | 1420-1123 |
| .040" - .045" (1.0 - 1.2 mm) | 25 ft (7.6 m) | 42-4045-25 | 1420-1125 |
| .052" - 1/16" (1.3 - 1.6 mm) | 15 ft (4.6 m) | 42-116-15 | 1420-1124 |

Lincoln® Style Rear Connector

Fits Lincoln LNT7, 8, 9, SP200

| Wire Size | Length | Part No. | Stock No. |
|-------------------------|---------------|--------------|-----------|
| Up To .045" (1.2 mm) | 10 ft (3 m) | SMV210L-3545 | 1023-1292 |
| | 15 ft (4.6 m) | SMV215L-3545 | 1023-1293 |
| | 20 ft (6.1 m) | SMV220L-3545 | 1023-1294 |
| | 25 ft (7.6 m) | SMV225L-3545 | 1023-1295 |

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. MS354-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) | 12 ft (3.6 m) | SMV212X-3545 | 1023-1287 |
| | 20 ft (6.1 m) | SMV220X-3545 | 1023-1291 |
| | 25 ft (7.6 m) | SMV225X-3545 | 1023-1284 |

Knucklehead Conductor Tube Part No. VCTL64SFLX480 (Stock No. 1640-1337) Part No. VCTL64SFLX360 (Stock No. 1640-1336)

Long Reach Conductor Tube Part No. SMVCTLS60LM (Stock No. 1640-1403) Part No. SMVCTLS45LM (Stock No. 1640-1402)

Conduit Liners – For Use With Aluminium Welding Wires

180-250 Amp – Teflon

| Wire Size | Length | Part No. | Stock No. |
|---------------------------------|---------------|-------------|-----------|
| .030" - 3/64" (0.8 - 1.2 mm) | 15 ft (4.6 m) | 42N-3545-15 | 1420-1003 |

VELOCITY2 SPRAY MASTER V250

VELOCITY2 MEDIUM & HEAVY DUTY MIG WELDING CONSUMABLES

Medium Duty Contact Tips

| Description | Part No. | Stock No. |
|-----------------|----------|-----------|
| .023" (0.6 mm) | VTM23 | 1160-1750 |
| .030" (0.8 mm) | VTM30 | 1160-1751 |
| .035" (0.9 mm) | VTM35 | 1160-1752 |
| .040" (1.0 mm) | VTM40 | 1160-1753 |
| .045" (1.2 mm) | VTM45 | 1160-1754 |
| 3/64" (1.2 mm)* | VTMA364* | 1160-1755 |
| .052" (1.3 mm) | VTM52 | 1160-1756 |
| 1/16" (1.6 mm) | VTM116 | 1160-1757 |
| 1/16" (1.6 mm)* | VTMA116* | 1160-1758 |
| 5/64" (2.0 mm) | VTM564 | 1160-1759 |

Note: All Contact Tips are packaged in quantities of ten (10) per bag and all Nozzles are packaged in quantities of two (2) per bag.

Heavy Duty Contact Tips

| Description | Part No. | Stock No. |
|-----------------|----------|-----------|
| .030" (0.8 mm) | VTH30 | 1160-1760 |
| .035" (0.9 mm) | VTH35 | 1160-1761 |
| .040" (1.0 mm) | VTH40 | 1160-1762 |
| .045" (1.2 mm) | VTH45 | 1160-1763 |
| 3/64" (1.2 mm)* | VTHA364* | 1160-1764 |
| .052" (1.3 mm) | VTH52 | 1160-1765 |
| 1/16" (1.6 mm) | VTH116 | 1160-1766 |
| 1/16" (1.6 mm)* | VTHA116* | 1160-1767 |
| 5/64" (2.0 mm) | VTH564 | 1160-1768 |
| 3/32" (2.4 mm) | VTH332 | 1160-1769 |
| 7/64" (2.8 mm) | VTH764 | 1160-1770 |
| 1/8" (3.2 mm) | VTH18 | 1160-1771 |

Extended Taper Contact Tips

| Description | Part No. | Stock No. |
|-----------------|-----------|-----------|
| .030" (0.8 mm) | VTET30 | 1160-1772 |
| .035" (0.9 mm) | VTET35 | 1160-1773 |
| .040" (1.0 mm) | VTET40 | 1160-1774 |
| .045" (1.2 mm) | VTET45 | 1160-1775 |
| 3/64" (1.2 mm)* | VTETA364* | 1160-1776 |
| .052" (1.3 mm) | VTET52 | 1160-1777 |
| 1/16" (1.6 mm) | VTET116 | 1160-1778 |

Note: 44 Series Conduit Shoot For VTET tips Part No. VTET44S (Stock No. 1440-1325) individually sold 5 per bag.

Extended HD Taper Contact Tips

| Description | Part No. | Stock No. |
|----------------|----------|-----------|
| .035" (0.9 mm) | VTHET35 | 1160-1780 |
| .045" (1.2 mm) | VTHET45 | 1160-1782 |
| .052" (1.3 mm) | VTHET52 | 1160-1784 |
| 1/16" (1.6 mm) | VTHET116 | 1160-1785 |

Medium Duty Nozzles

Self Insulated Nozzles. 2 per pack

| Description | Part No. | Stock No. |
|---------------------------------------|----------|-----------|
| 1/2" (12.7 mm) Threaded Nozzle Recess | VNM50 | 1240-1857 |
| 1/2" (12.7 mm) Threaded Nozzle Flush | VNM50F | 1240-1856 |
| 5/8" (15.9 mm) Threaded Nozzle Recess | VNM62 | 1240-1854 |
| 5/8" (15.9 mm) Threaded Nozzle Flush | VNM62F | 1240-1855 |
| 3/4" (19.1 mm) Threaded Nozzle Recess | VNM75 | 1240-1852 |
| 3/4" (19.1 mm) Threaded Nozzle Flush | VNM75F | 1240-1853 |
| 1/2" (12.7 mm) Slip Nozzle | VNM50S | 1240-1859 |
| 5/8" (15.9 mm) Slip Nozzle | VNM62S | 1240-1860 |
| 3/4" (19.1 mm) Slip Nozzle | VNM75S | 1240-1863 |
| Slip Nozzle Base | VNS | 1240-1864 |
| 1/2" (12.7 mm) Slip Nozzle Cone Only | VNM50SC | 1240-1861 |
| 5/8" (15.9 mm) Slip Nozzle Cone Only | VNM62SC | 1240-1862 |
| 3/4" (19.1 mm) Slip Nozzle Cone Only | VNM75SC | 1240-1865 |
| 5/8" (15.9 mm) Spot Nozzle | VNM62FAS | 1240-1866 |
| 3/4" (19.1 mm) Spot Nozzle | VNM75FAS | 1240-1868 |

Extended Taper Nozzle

| | | |
|---|---------|-----------|
| 3/8" (9.5 mm) Ext. Taper Nozzle Recess | VNET37 | 1240-1874 |
| 3/8" (9.5 mm) Ext. Taper Nozzle Flush | VNET37F | 1240-1897 |
| 1/2" (12.7 mm) Ext. Taper Nozzle Recess | VNET50 | 1240-1873 |
| 1/2" (12.7 mm) Ext. Taper Nozzle Flush | VNET50F | 1240-1872 |
| 5/8" (15.9 mm) Ext. Taper Nozzle Recess | VNET62 | 1240-1869 |

Flux Core Tip Holder

| | | |
|----------------------|-------|-----------|
| Flux Core Tip Holder | VNLFC | 1240-1892 |
|----------------------|-------|-----------|

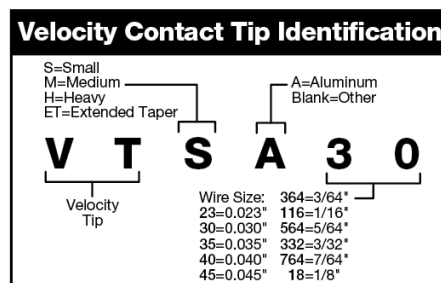
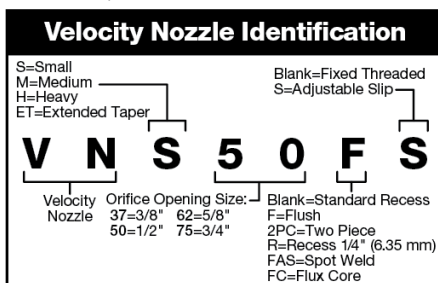
Note: VELOCITY2 medium and heavy duty contact tips and nozzles are for use with Tweco Classic® No. series, Spray Master® series and Supra® XT series MIG Guns.

Heavy Duty Nozzles

Self Insulated Nozzles. 2 per pack

| Description | Part No. | Stock No. |
|---------------------------------------|-----------|-----------|
| 1/2" (12.7 mm) Threaded Nozzle Recess | VNH62 | 1240-1877 |
| 1/2" (12.7 mm) Threaded Nozzle Flush | VNH62F | 1240-1878 |
| 5/8" (15.9 mm) Threaded Nozzle Recess | VNH62R | 1240-1898 |
| 5/8" (15.9 mm) Threaded Nozzle Flush | VNH75 | 1240-1875 |
| 3/4" (19.1 mm) Threaded Nozzle Recess | VNH75F | 1240-1876 |
| 3/4" (19.1 mm) Threaded Nozzle Flush | VNH75R | 1240-1899 |
| 1/2" (12.7 mm) Slip Nozzle | VNH62S | 1240-1893 |
| 5/8" (15.9 mm) Slip Nozzle | VNH75S | 1240-1894 |
| 3/4" (19.1 mm) Slip Nozzle | VNS | 1240-1864 |
| Slip Nozzle Base | VNH62SC | 1240-1895 |
| 1/2" (12.7 mm) Slip Nozzle Cone Only | VNH75SC | 1240-1896 |
| 5/8" (15.9 mm) Slip Nozzle Cone Only | VNH50RC | 1240-1867 |
| 3/4" (19.1 mm) Slip Nozzle Cone Only | VNH622PC | 1240-1880 |
| 5/8" (15.9 mm) Spot Nozzle | VNH62C | 1240-1884 |
| 3/4" (19.1 mm) Spot Nozzle | VNH62RC | 1240-1870 |
| 1/2" (12.7 mm) Threaded Nozzle Recess | VNH62F2PC | 1240-1881 |
| 1/2" (12.7 mm) Threaded Nozzle Flush | VNH62FC | 1240-1885 |
| 5/8" (15.9 mm) Threaded Nozzle Recess | VNH752PC | 1240-1882 |
| 5/8" (15.9 mm) Threaded Nozzle Flush | VNH75C | 1240-1886 |
| 3/4" (19.1 mm) Threaded Nozzle Recess | VNH75RC | 1240-1871 |
| 3/4" (19.1 mm) Threaded Nozzle Flush | VNH75F2PC | 1240-1883 |
| 1/2" (12.7 mm) Slip Nozzle | VNH75FC | 1240-1887 |
| 5/8" (15.9 mm) Slip Nozzle | VNH2PC | 1240-1879 |

Use VNH2PC & VNHXXRC series nozzles with the extended HD Taper Contact Tips

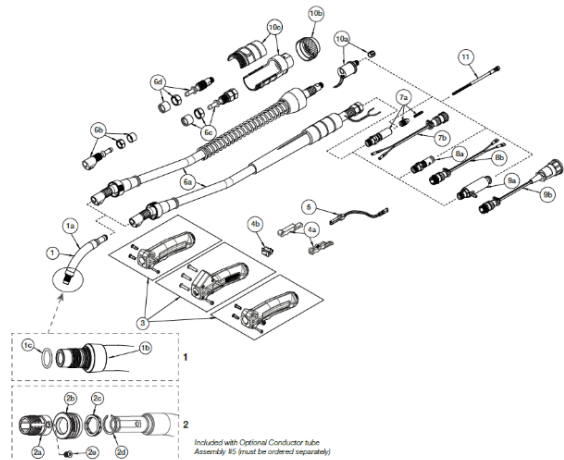


Replacement Parts

| # | Description | Part No. | Stock No. |
|----|--|--------------------|-----------|
| 1 | Conductor Tube-60° | SMVCTLS60 | 1240-1377 |
| | Conductor Tube-45° | SMVCTLS45 | 1240-1376 |
| | Conductor Tube-60° LM | SMVCTLS60LM | 1640-1403 |
| | Conductor Tube-45° LM | SMVCTLS45LM | 1640-1402 |
| 1a | Silicone Tubing (Sold/Foot) | VCTLJBLK | 1640-1409 |
| 1b | Insulator, VELOCITY2 Conductor Tube Assy | VCTLSI | 1640-1408 |
| 1c | O-Ring (Pkg Of 10 each) | VCTLS015 | 1640-1410 |
| 2 | Conductor Tube-60° (Stainless Steel Sleeve) | SMVCT60SS | 1240-1378 |
| | Conductor Tube-45° (Stainless Steel Sleeve) | SMVCT45SS | 1240-1379 |
| | Conductor Tube-60° LM (Stainless Steel Sleeve) | SMVCT60LMSS | 1640-1404 |
| | Conductor Tube-45° LM (Stainless Steel Sleeve) | SMVCT45LMSS | 1640-1405 |
| | Conductor Tube-180° (Stainless Steel Sleeve) | SMVCT180 | 1240-1375 |
| 2a | Threaded Stainless Steel Sleeve | VCTLSL | 1640-1397 |
| 2b | Nozzle Collar | VCTLSLK | 1640-1398 |
| 2c | Wave Spring | VCTLSPR | 1640-1399 |
| 2d | Wave Spring Retainer | PMA64RS | 1640-1396 |
| 2e | Sleeve Screw | VCT41CS | 2040-2048 |
| 3 | Handle – Standard Spray Master | SMV82 | 2060-2082 |
| | Handle – Dual Schedule (Rocker Switch) | - | - |
| | Handle – Locking Trigger | SMV82LC | 2060-2079 |
| 4a | Trigger – Std & Dual Schedule | ELC94 | 2060-2647 |
| | Trigger - Locking | MS94LC | 2060-2693 |
| 4b | Dual Schedule Rocker Switch | - | - |
| 5 | Trigger Blade Assy | ELC94-BL | 2060-2671 |
| 6 | Gun Hanger | 152 | 2020-2152 |
| 10 | Binder Posts & Screws (Standard & Locking) | ELC124FM | 2060-2646 |
| 11 | Binder Posts & Screws (Dual Schedule) | 122FMS | 2060-2135 |
| 16 | Cable Lamp | 136 | 2060-2690 |

| # | Description | Part No. | Stock No. |
|----|---|------------------------|-----------|
| 17 | Front Strain Relief Spring & Cap | MS144 | 2060-2131 |
| 18 | 10 ft (3m) Cablehoz® Assembly (Direct Plug) | MS210 | 1720-2115 |
| | 12 ft (3.6m) Cablehoz® Assembly (Direct Plug) | MS212 | 1720-2116 |
| | 15 ft (4.6m) Cablehoz® Assembly (Direct Plug) | MS215 | 1720-2117 |
| 19 | Rear Strain Relief Spring & Cap | 235RSSR | 2060-2035 |
| 20 | Front Cable Connector Repair Kit (Direct Plug & Euro) | MS102-RK | 2060-2132 |
| 21 | Rear Cable Connector Repair Kit (Direct Plug) | MS172-RK | 2060-2134 |
| | Rear Cable Connector Repair Kit (Euro) | 172X-M | 2020-2181 |
| 22 | Rear Case(Direct Plug) | C6RC | 2060-2041 |
| | Rear Case(Euro) | X6RC | 2060-2006 |
| 23 | Miller® Control Wire | MS354-DSM | 2060-2140 |
| 24 | Connector Plug | -- | |
| 25 | Conduit Assembly | Refer To Page 3 | |
| NS | Protective Cable Wrap, 50ft (15.2 m) per box | TCR50 | 9900-1150 |

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 Tweco. Tweco, Spray Master and Cablehoz are registered trademarks of ESAB.



ESAB / esab.com

