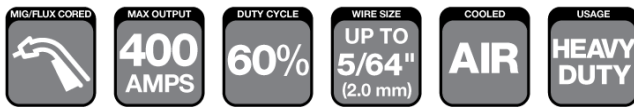


Classic No. Series

Classic® No.4 400 AMP MIG Gun Air-Cooled



WELDING PROCESSES:

MIG (GMAW), Aluminum (GMAW)

Standard Options Include:

- Dual Schedule On/Off Control, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube – Part No. 64J-60 (Stock No. 1640-1106) on all guns up to 15 ft (4.6 m)
- Part No. 64J-45 (Stock No. 1640-1105) on all guns over 15 ft (4.6 m)
- Conduit Liner – 44 Series

Industry

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

FEATURES

- **The Industry Standard** for over 40 years
- **Oval-Shaped Handle** reduces grip required to manipulate MIG gun and eases operator fatigue
- **High-Impact Crush-Resistant Handle** uses special plastic composition for long-lasting durability and dependability
- **Heavy Duty Handle** balanced to pivot at center for ease of use in different welding positions
- **Metal Jacketed Three-Layer Conductor Tube Construction** (copper tube/silicon-resin glass insulator/metal jacket) for improved electrical conductivity
- **Trigger Contains Silver Plated Contacts** with self-cleaning action every time it is engaged or disengaged
- **Heavy Duty Design** for dependable industrial applications
- **Field Repairable Cablehoz®** requires no additional connectors
- **Gun Hanger** located at bottom for convenience of resting the gun when not in use
- **Split Handle Case** provides access for easy repairs
- **Improved Performance** with longer life consumables
- **Wide Selection** of front end consumables available
- **Front and Rear Steel Spring Strain Relief** provides support to the Cablehoz coming out of the rear of the handle and minimizes wire feed issues
- **Heavy Duty Contact Tips** in high heat applications offered
- **Interchangeable Front End Consumables** between Tweco® Classic No. and Tweco Spray Master® series

CLASSIC NO.4 400 AMP

SPECIFICATIONS	
Description	Classic No.4 400 Amp
Welding Output CO2 Gas	400 A at 60%
Wire Diameter, Mild Steel	Up To 1/16" (1.6mm)
Wire Diameter, Stainless	Up To 1/16" (1.6mm)
Wire Diameter, Aluminium	Up To 1/16" (1.6mm)
Wire Diameter, Flux Core	Up To 1/16" (1.6mm)
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)	410-3545	1040-1101
	12 ft (3.6 m)	412-3545	1040-1102
	15 ft (4.6 m)	415-3545	1040-1103
	15 ft (4.6 m)	DS415-3545	1040-1503
	20 ft (6.1 m)	420-3545	1040-1104
	25 ft (7.6 m)	425-3545	1040-1105
Up To 1/16" (1.6 mm)	10 ft (3 m)	410-116	1040-1111
	12 ft (3.6 m)	412-116	1040-1112
	15 ft (4.6 m)	415-116	1040-1113
	20 ft (6.1 m)	420-116	1040-1114
	25 ft (7.6 m)	425-116	1040-1115
5/64" (2.0 mm)	15 ft (4.6 m)	DS420-116	1040-1514
		415-564	1040-1123

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	X412-3545	1040-1602
	15 ft (4.6 m)	X415-3545	1040-1603
	25 ft (7.6 m)	X425-3545	1040-1605
Up To 1/16" (1.6 mm)	15 ft (4.6 m)	X415-116	1040-1613

****Suffix "K4"** = Knucklehead Conductor Tube –
Part No. 64SFLX4-80 (1640-1113)
Prefix "DS" = Dual Schedule

Lincoln® Style Rear Connector

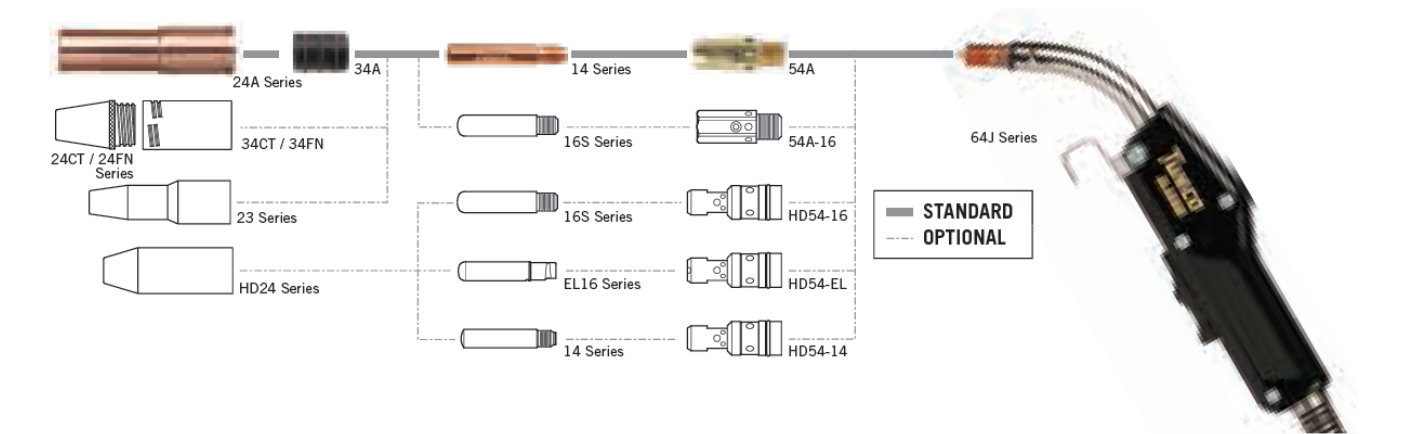
Fits Lincoln LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	12 ft (3.6 m)	L412-3545	1040-1143
	15 ft (4.6 m)	L415-3545	1040-1146
	15 ft (4.6 m)	L415-3545K4	1040-1689
Up To 1/16" (1.6 mm)	10 ft (3 m)	L410-116	1040-1141
	12 ft (3.6 m)	L412-116	1040-1144
	15 ft (4.6 m)	L415-116	1040-1147

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	M410-3545	1040-1130
	12 ft (3.6 m)	M412-3545	1040-1133
	15 ft (4.6 m)	M415-3545	1040-1136
	15 ft (4.6 m)	M415-3545K4	1040-1688
	20 ft (6.1 m)	M420-3545	1040-1126
	25 ft (7.6 m)	M425-3545	1040-1129
Up To 1/16" (1.6 mm)	10 ft (3 m)	M410-116	1040-1131
	12 ft (3.6 m)	M412-116	1040-1134
	15 ft (4.6 m)	M415-116	1040-1137
	20 ft (6.1 m)	M420-116	1040-1127
	25 ft (7.6 m)	M425-116	1040-1128
5/64" (2.0 mm)	15 ft (4.6 m)	M415-564	1040-1138

CLASSIC NO.4 400 AMP



Contact Tips – Standard Threaded Style

14, 14H & 14T Series

0.25" (6.35 mm) Outside Diameter –
.250-28 UNF Threads - 1.50" (38.1 mm) Overall Length



Wire Size (in / mm)	Tip I.D. (in / mm)	Standard		Heavy Duty		Tapered	
		Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.
.023" (0.6 mm)	.031" (0.79 mm)	14-23	1140-1100	NA		14T-23	1140-1300
.030" (0.8 mm)	.038" (0.97 mm)	14-30	1140-1101	NA		14T-30	1140-1301
.035" (0.9 mm)	.044" (1.12 mm)	14-35	1140-1102	14H-35	1140-1202	14T-35	1140-1302
.040" (1.0 mm)	.048" (1.22 mm)	14-40	1140-1103	14H-40	1140-1203	14T-40	1140-1303
.045" (1.2 mm)	.054" (1.37 mm)	14-45	1140-1104	14H-45	1140-1204	11T-45	1140-1304
.052" (1.3 mm)	.064" (1.65 mm)	14-52	1140-1105	14H-52	1140-1205	14T-52	1140-1305
1/16" (1.6 mm)	.073" (1.85 mm)	14-116	1140-1106	14H-116	1140-1206	14T-116	1140-1306
5/64" (2.0 mm)	.090" (2.29 mm)	14-564	1140-1109	14H-564	1140-1209	NA	
3/64" AL (1.2 mm)	.059" (1.50 mm)	14A-364	1140-1113	14AH-364	1140-1213	NA	
1/16" AL (1.6 mm)	.082" (2.08 mm)	NA		14AH-116	1140-1214	NA	

CLASSIC NO.4 400 AMP SERIES

Nozzles & Nozzle Insulators – Air-Cooled

24A Series

Formed Nozzle - 0.750" (19.05 mm) Outside Diameter Use with Nozzle Insulator
Part No. 34A (Stock No. 1340-1100).



Nozzle Style	Bore Diameter	Part No.	Stock No.	Nozzle Design	Nozzle/Contact Tip Relationship
Slip-On	3/8" (9.5 mm)	24A-37SS	1240-1101	Standard Short Stop	1/8" (3.2 mm) Tip Recess
	3/8" (9.5 mm)	24AT-37SS	1240-1301	Standard Short Stop	1/8" (3.2 mm) Tip Recess
	1/2" (12.7 mm)	24A-50	1220-1110	Standard	Adjustable Tip Recess - Tip Protruding
	1/2" (12.7 mm)	24A-50SS	1240-1111	Standard Short Stop	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	24A-62	1240-1120	Standard	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	24A-62SS	1240-1121	Standard Short Stop	1/8" (3.2 mm) Tip Recess
	5/8" (15.9 mm)	24AH-62	1240-1220	Standard Heavy Stop	Adjustable Tip Recess - Tip Protruding
	5/8" (15.9 mm)	24AH-62SS	1240-1221	Standard Short Stop	1/8" (3.2 mm) Tip Recess
	3/4" (19.5 mm)	24A-75	1240-1130	Standard	Adjustable Tip Recess - Tip Protruding
	3/4" (19.5 mm)	24AH-75	1240-1230	Standard Heavy Stop	Adjustable Tip Recess - Tip Protruding
	3/4" (19.5 mm)	24AH-75SS	1240-1231	Standard Short Stop	1/8" (3.2 mm) Tip Recess

Conductor Tubes – Air-Cooled

Classic No. 4

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	64J-60	1640-1106	Metal	I.D. 3/8"-24UNF-2B	I.D. 3/8"-24UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	64J-45	1640-1105	Metal	I.D. 3/8"-24UNF-2B	I.D. 3/8"-24UNF-2B O.D. 9/16"-18 UNF-2A
60 Degree with 3" (76.2 mm) Radius	64A-60	1640-1102	Metal	I.D. 3/8"-24UNF-2B	I.D. 3/8"-24UNF-2B O.D. 9/16"-18 UNF-2A
45 Degree with 3" (76.2 mm) Radius	64A-45	1640-1101	Metal	I.D. 3/8"-24UNF-2B	I.D. 3/8"-24UNF-2B O.D. 9/16"-18 UNF-2A
180 Degree, Straight	64A180	1640-1104	Metal	I.D. 3/8"-24UNF-2B	I.D. 3/8"-24UNF-2B O.D. 9/16"-18 UNF-2A
Eliminator 60 Degree with 3" (76.2 mm) Radius	64ELJ-60	1640-1117	Metal	I.D. 3/8"-24UNF-2B	I.D. M12 x 1.5-6H
Eliminator 45 Degree with 3" (76.2 mm) Radius	64ELJ-45	1640-1116	Metal	I.D. 3/8"-24UNF-2B	I.D. M12 x 1.5-6H
Eliminator 180 Degree, Straight	64ELJ-180	1640-1119	Metal	I.D. 3/8"-24UNF-2B	I.D. M12 x 1.5-6H

Conduit Liners – For Use With Steel Welding Wires

300-450 Amp – Steel Wound

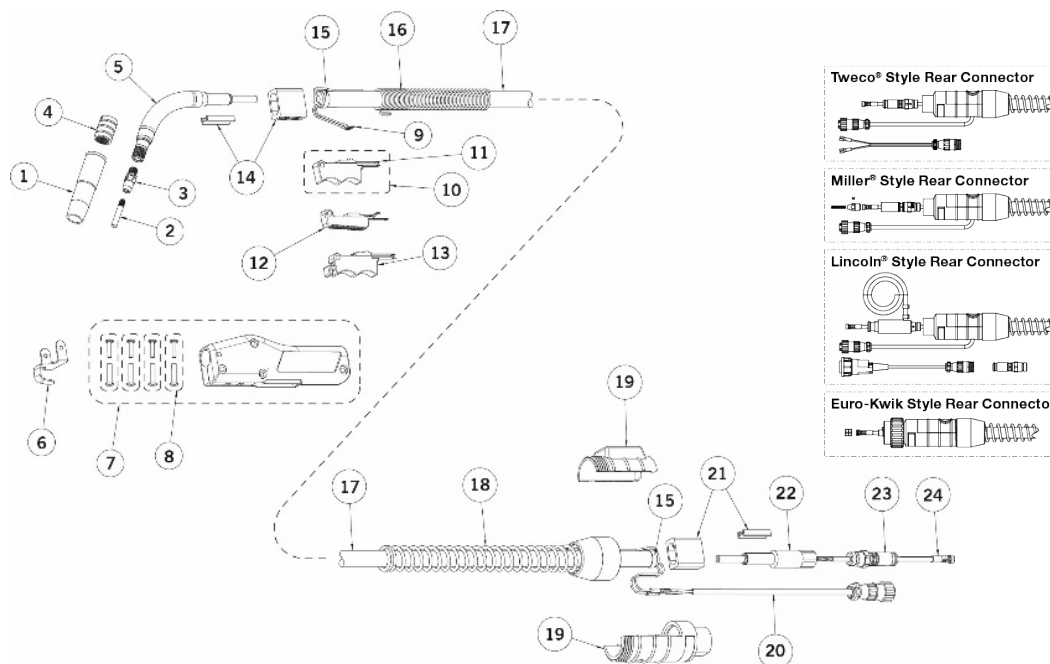
Wire Size	Length	Part No.	Stock No.
.035" - .049" (0.9 – 1.2 mm)	15 ft (4.6 m)	44-3545-15	1440-1103
.035" - .045" (0.9 - 1.2 mm)	25 ft (7.6 m)	44-3545-25	1440-1105
.052" - 1/16" 1(.3 - 1.6 mm)	15 ft (4.6 m)	44-116-15	1440-1113
.052" - 1/16" 1(.3 - 1.6 mm)	25 ft (7.6 m)	44-116-25	1440-1115
5/64" (2.0 mm)	15 ft (4.6 m)	44-564-15	1440-1123
5/64" (2.0 mm)	25 ft (7.6 m)	44-564-25	1440-1125
3/32" (2.4 mm)	15 ft (4.6 m)	44-332-15	1440-1127

Conduit Liners – For Use With Aluminium Welding Wires

300-450 Amp – Nylon

Wire Size	Length	Part No.	Stock No.
.030" – 3/64" (0.8 – 1.2 mm)	15 ft (4.6 m)	44N-3545-15	1440-1003
1/16" (1.2 mm)	15 ft (4.6 m)	44N-116-15	1440-1012

Replacement Parts



#	Description	Classic No. 4
		Part No./ Stock No.
1	Nozzle	Refer To Page 3
2	Contact Tip	Refer To Page 2
3	Diffuser	54A 1540-1100
4	Nozzle Insulator	34A 1340-1100
5	Conductor Tube	Refer To Page 3
6	Gun Hanger	154B 2040-2156
7	Handle (Standard)	84RC 2040-2087
	Handle (Dual Schedule)	84RC-DS 2040-2088
8	Binder Posts & Screws	124FM 2040-2124
9	Trigger Control Wire Terminal (Standard - 2 ea.)	244 2040-2224
	Trigger Control Wire Terminal (Dual Schedule - 4 ea.)	244LK 2040-2246
10	Trigger Assembly (Standard)	94RR 2040-2098
11	Trigger Blades	94RC 2040-2100
12	Trigger Assembly (Dual Schedule)	94RDS 2040-2101
13	Trigger Assembly (Locking)	94R-L 2040-2102
14	Front Cable Connector	104 2040-2104

#	Description	Classic No. 4
		Part No./ Stock No.
15	Cable Clamp	136 2060-2690
16	Front Strain Relief Spring	144-6-SPR 2040-2146
17	Cablehoz - 2-Lead Wire	400 1740-2100
	Cablehoz - 4-Lead Wire	400-TW4 1740-2106
18	Rear Strain Relief Spring	235RSSR 2060-2035
19	Rear Case (Direct Plug)	R6RC 2060-2040
	Rear Case (Euro)	X6RC 2060-2006
20	Control Wire (Standard)	MS354-DSM 2060-2140
	Control Wire (Dual Schedule)	194DS 2040-2195
21	Rear Cable Connector (Direct Plug)	104 2040-2104
	Rear Cable Connector (Euro)	174X-M 2040-2181
22	Adapter (Direct Plug)	M170-4H 2020-2166
NS	Repair/Conversion Kits	84R-CK 2040-2089
23	Connector Plug	--
24	Conduit Assembly	Refer To Page 3
NS	Protective Cable Wrap, 50 ft (15.2 m) per box	TCR50 9900-1150



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