

## MIG Consumable Selection Guide

### 160 Amp - Mini MIG Guns

Nozzle Style	Bore Diameter (in/mm)	Part No.	Stock No.	Nozzle/Contact Tip Relationship	Gas Diffuser		Conductor Tube	
					Part No.	Stock No.	Part No.	Stock No.
Thread-On	3/16" (9.5mm)	21-37	1200-1202	1/8" (3.2mm) Tip Bevel	36-50 (F)	1500-1100	35-40-60	1600-1101
	1/4" (12.7mm)	21-37	1200-1200	1/8" (3.2mm) Tip Bevel		35-40-60	1600-1102	35-40-60
	3/8" (9.5mm)	21-37	1200-1200	1/8" (3.2mm) Tip Bevel		35-40-60	1600-1103	35-40-60
	1/2" (12.7mm)	21-37	1200-1202	1/8" (3.2mm) Tip Bevel		35-40-60	1600-1104	35-40-60
	5/8" (15.9mm)	21-37	1200-1202	1/8" (3.2mm) Tip Bevel		35-40-60	1600-1105	35-40-60

NOTE: Slip-On (S) nozzles require a nozzle insulator - Part No. 32 (Stock No. 1200-1100)  
 The (F) after the Gas Diffuser Part No. indicates the series of Contact Tip that can be used with the particular diffuser. Refer to Contact Tip Chart - column "Gas Diffuser".

### 180 Amp - No. 1 MIG Guns

Nozzle Style	Bore Diameter (in/mm)	Part No.	Stock No.	Nozzle/Contact Tip Relationship	Gas Diffuser		Conductor Tube	
					Part No.	Stock No.	Part No.	Stock No.
Thread-On	3/16" (9.5mm)	21-37	1200-1202	1/8" (3.2mm) Tip Bevel	81 (F)	1500-1101	61-40	1600-1101
	1/4" (12.7mm)	21-37	1200-1200	1/8" (3.2mm) Tip Bevel		61-40	1600-1102	61-40
	3/8" (9.5mm)	21-37	1200-1200	1/8" (3.2mm) Tip Bevel		61-40	1600-1103	61-40
	1/2" (12.7mm)	21-37	1200-1202	1/8" (3.2mm) Tip Bevel		61-40	1600-1104	61-40
	5/8" (15.9mm)	21-37	1200-1202	1/8" (3.2mm) Tip Bevel		61-40	1600-1105	61-40

NOTE: Slip-On (S) nozzles require a nozzle insulator - Part No. 32 (Stock No. 1200-1100)  
 The (F) after the Gas Diffuser Part No. indicates the series of Contact Tip that can be used with the particular diffuser. Refer to Contact Tip Chart - column "Gas Diffuser".

### 200 Amp - No. 2 MIG Guns

Nozzle Style	Bore Diameter (in/mm)	Part No.	Stock No.	Nozzle/Contact Tip Relationship	Gas Diffuser		Conductor Tube	
					Part No.	Stock No.	Part No.	Stock No.
Slip-On (S)	3/16" (9.5mm)	22-35	1200-1201	1/8" (3.2mm) Tip Bevel	92 (S)	1500-1101	62-40	1600-1101
	1/4" (12.7mm)	22-35	1200-1200	1/8" (3.2mm) Tip Bevel		62-40	1600-1102	62-40
	3/8" (9.5mm)	22-35	1200-1200	1/8" (3.2mm) Tip Bevel		62-40	1600-1103	62-40
	1/2" (12.7mm)	22-35	1200-1202	1/8" (3.2mm) Tip Bevel		62-40	1600-1104	62-40
	5/8" (15.9mm)	22-35	1200-1202	1/8" (3.2mm) Tip Bevel		62-40	1600-1105	62-40

NOTE: Slip-On (S) nozzles require a nozzle insulator - Part No. 32 (Stock No. 1200-1100)  
 The (S) after the Gas Diffuser Part No. indicates the series of Contact Tip that can be used with the particular diffuser. Refer to Contact Tip Chart - column "Gas Diffuser".

### 300 Amp - No. 3 MIG Guns

Nozzle Style	Bore Diameter (in/mm)	Part No.	Stock No.	Nozzle/Contact Tip Relationship	Gas Diffuser		Conductor Tube	
					Part No.	Stock No.	Part No.	Stock No.
Thread-On	3/16" (9.5mm)	23-37	1200-1200	1/8" (3.2mm) Tip Bevel	54P (S)	1500-1101	63-40	1600-1101
	1/4" (12.7mm)	23-37	1200-1200	1/8" (3.2mm) Tip Bevel		63-40	1600-1102	63-40
	3/8" (9.5mm)	23-37	1200-1200	1/8" (3.2mm) Tip Bevel		63-40	1600-1103	63-40
	1/2" (12.7mm)	23-37	1200-1202	1/8" (3.2mm) Tip Bevel		63-40	1600-1104	63-40
	5/8" (15.9mm)	23-37	1200-1202	1/8" (3.2mm) Tip Bevel		63-40	1600-1105	63-40

NOTE: Slip-On (S) nozzles require a nozzle insulator - Part No. 32 (Stock No. 1200-1100)  
 The (S) after the Gas Diffuser Part No. indicates the series of Contact Tip that can be used with the particular diffuser. Refer to Contact Tip Chart - column "Gas Diffuser".

- Determine the style of MIG Gun
- Select the nozzle style - bore diameter
- Select the nozzle/contact tip relationship
- Select the gas diffuser based on nozzle style
- Select contact tip based on wire diameter

### 400 Amp - No. 4 MIG Guns

Nozzle Style	Bore Diameter (in/mm)	Part No.	Stock No.	Nozzle/Contact Tip Relationship	Gas Diffuser		Conductor Tube	
					Part No.	Stock No.	Part No.	Stock No.
Slip-On (S)	3/16" (9.5mm)	24-37	1200-1201	1/8" (3.2mm) Tip Bevel	54P (S)	1500-1101	64-40	1600-1101
	1/4" (12.7mm)	24-37	1200-1200	1/8" (3.2mm) Tip Bevel		64-40	1600-1102	64-40
	3/8" (9.5mm)	24-37	1200-1200	1/8" (3.2mm) Tip Bevel		64-40	1600-1103	64-40
	1/2" (12.7mm)	24-37	1200-1202	1/8" (3.2mm) Tip Bevel		64-40	1600-1104	64-40
	5/8" (15.9mm)	24-37	1200-1202	1/8" (3.2mm) Tip Bevel		64-40	1600-1105	64-40

NOTE: Slip-On (S) nozzles require a nozzle insulator - Part No. 32 (Stock No. 1200-1100)  
 The (S) after the Gas Diffuser Part No. indicates the series of Contact Tip that can be used with the particular diffuser. Refer to Contact Tip Chart - column "Gas Diffuser".

### Contact Tips

Wire Size (in/mm)	Tip Lt. (in/mm)	Part No.	11T Series		11H Series		14 Series		15E Series		16S Series		Part No.	Stock No.	Gas Diffuser
			Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.	Part No.	Stock No.					
0.031 (0.8mm)	11-30	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101	1110-1101

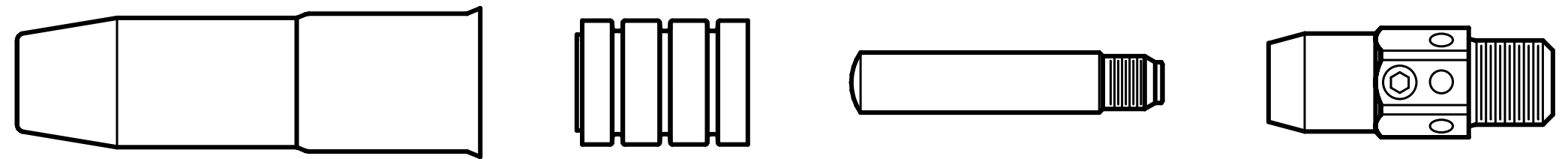
NOTE: "E" - COPPER-SILVER MATERIAL "H" - CHROME-ZINC/NICKEL MATERIAL "C" - ELECTRODEPOSITED "T" - TAPERED "L" - AS - LUMINOUS

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### 500 Amp - No. 5 MIG Guns

Nozzle Style	Bore Diameter (in/mm)	Part No.	Stock No.	Nozzle/Contact Tip Relationship	Gas Diffuser		Conductor Tube	
					Part No.	Stock No.	Part No.	Stock No.
Thread-On (H)	3/16" (9.5mm)	25-37	1200-1201	1/8" (3.2mm) Tip Bevel	55 (H)	1500-1101	65-40	1600-1101
	1/4" (12.7mm)	25-37	1200-1200	1/8" (3.2mm) Tip Bevel		65-40	1600-1102	65-40
	3/8" (9.5mm)	25-37	1200-1200	1/8" (3.2mm) Tip Bevel		65-40	1600-1103	65-40
	1/2" (12.7mm)	25-37	1200-1202	1/8" (3.2mm) Tip Bevel		65-40	1600-1104	65-40
	5/8" (15.9mm)	25-37	1200-1202	1/8" (3.2mm) Tip Bevel		65-40	1600-1105	65-40

NOTE: Thread-On (H) nozzles require a nozzle insulator - Part No. 32CT (Stock No. 1200-1400)  
 Gas Diffuser Part No. 55S is used with 424-332, 424-333, 424-334, 424-335, 424-336, 424-337, 424-338, 424-339, 424-340, 424-341, 424-342, 424-343, 424-344, 424-345, 424-346, 424-347, 424-348, 424-349, 424-350, 424-351, 424-352, 424-353, 424-354, 424-355, 424-356, 424-357, 424-358, 424-359, 424-360, 424-361, 424-362, 424-363, 424-364, 424-365, 424-366, 424-367, 424-368, 424-369, 424-370, 424-371, 424-372, 424-373, 424-374, 424-375, 424-376, 424-377, 424-378, 424-379, 424-380, 424-381, 424-382, 424-383, 424-384, 424-385, 424-386, 424-387, 424-388, 424-389, 424-390, 424-391, 424-392, 424-393, 424-394, 424-395, 424-396, 424-397, 424-398, 424-399, 424-400, 424-401, 424-402, 424-403, 424-404, 424-405, 424-406, 424-407, 424-408, 424-409, 424-410, 424-411, 424-412, 424-413, 424-414, 424-415, 424-416, 424-417, 424-418, 424-419, 424-420, 424-421, 424-422, 424-423, 424-424, 424-425, 424-426, 424-427, 424-428, 424-429, 424-430, 424-431, 424-432, 424-433, 424-434, 424-435, 424-436, 424-437, 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