

AMERICAN TORCH TIP ATTTC[®]

ALL GUNS ARE MADE BY ATTTC TO OUR
HIGHEST QUALITY STANDARDS AND ARE GUARANTEED
AGAINST ALL MATERIAL OR MANUFACTURING DEFECTS



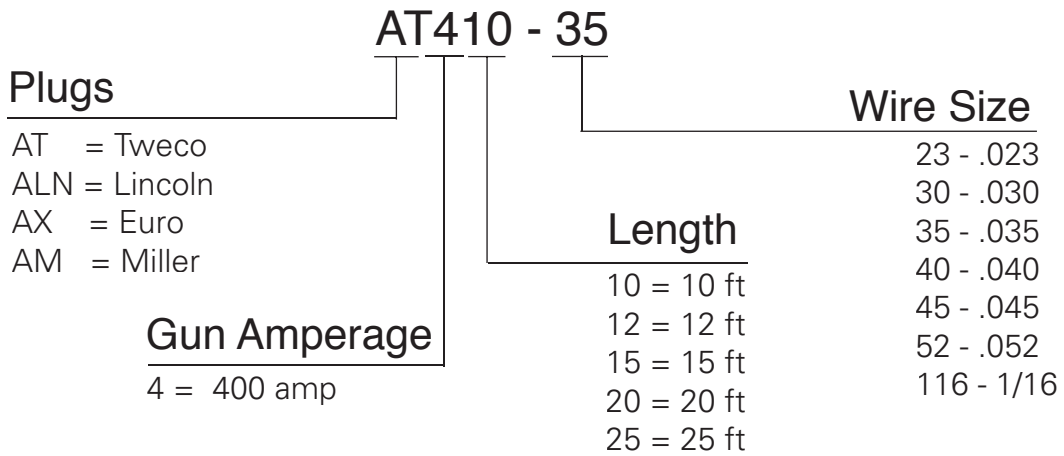
T-400 MIG GUN

Compatible with Tweco[®] 400 AMP

RATING:
400A C02 300A MIXED GAS
@ 100% DUTY CYCLE
.030" 0.8mm TO 5/64" 2.0mm WIRE

Parts Manual

MIG Gun Part Numbering System 400 AMP



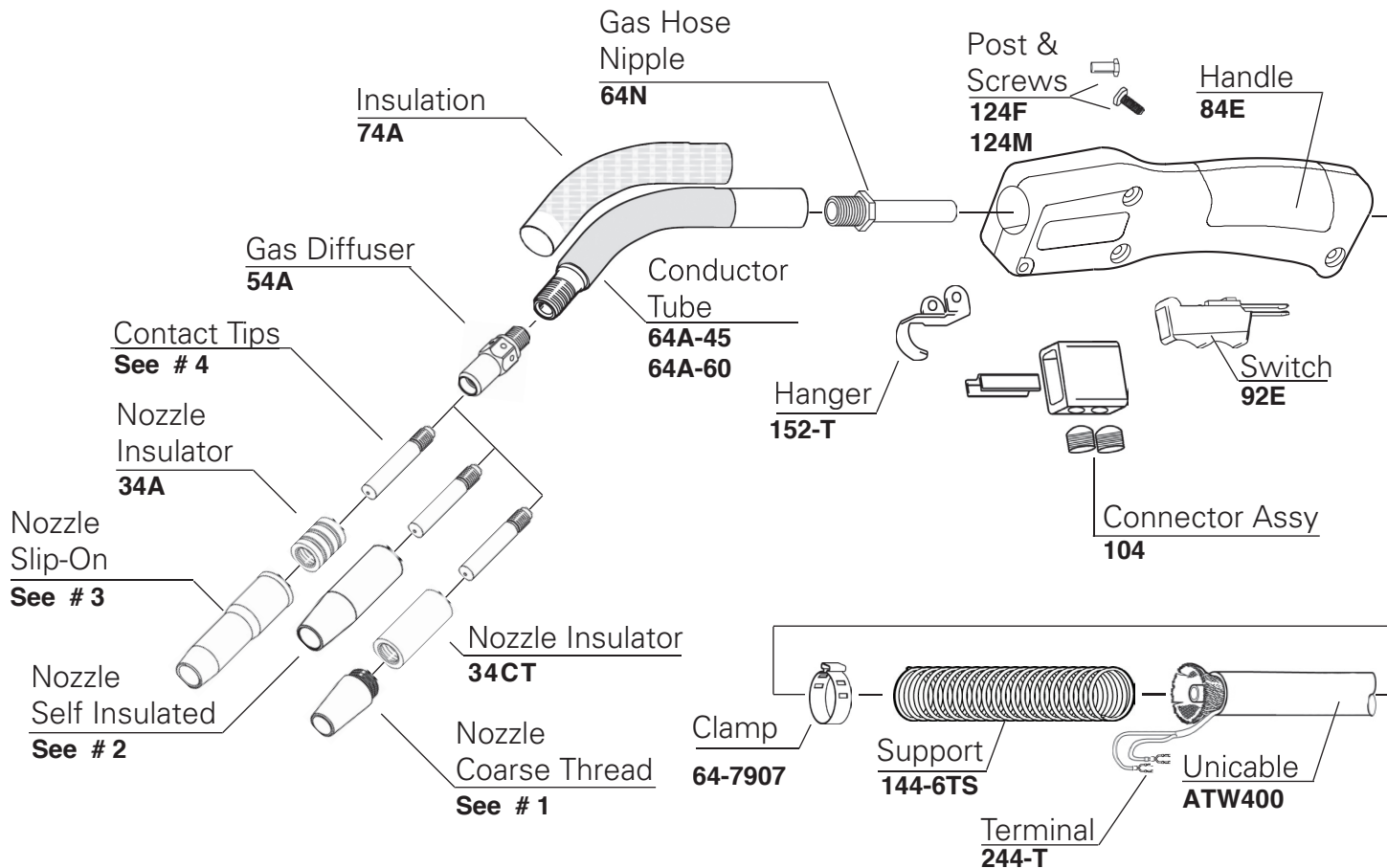
Special Part Numbering System

ATFN410 - 35 - X

Fixed Nozzle

Special Set Up
If Required

Gun Assembly - Front



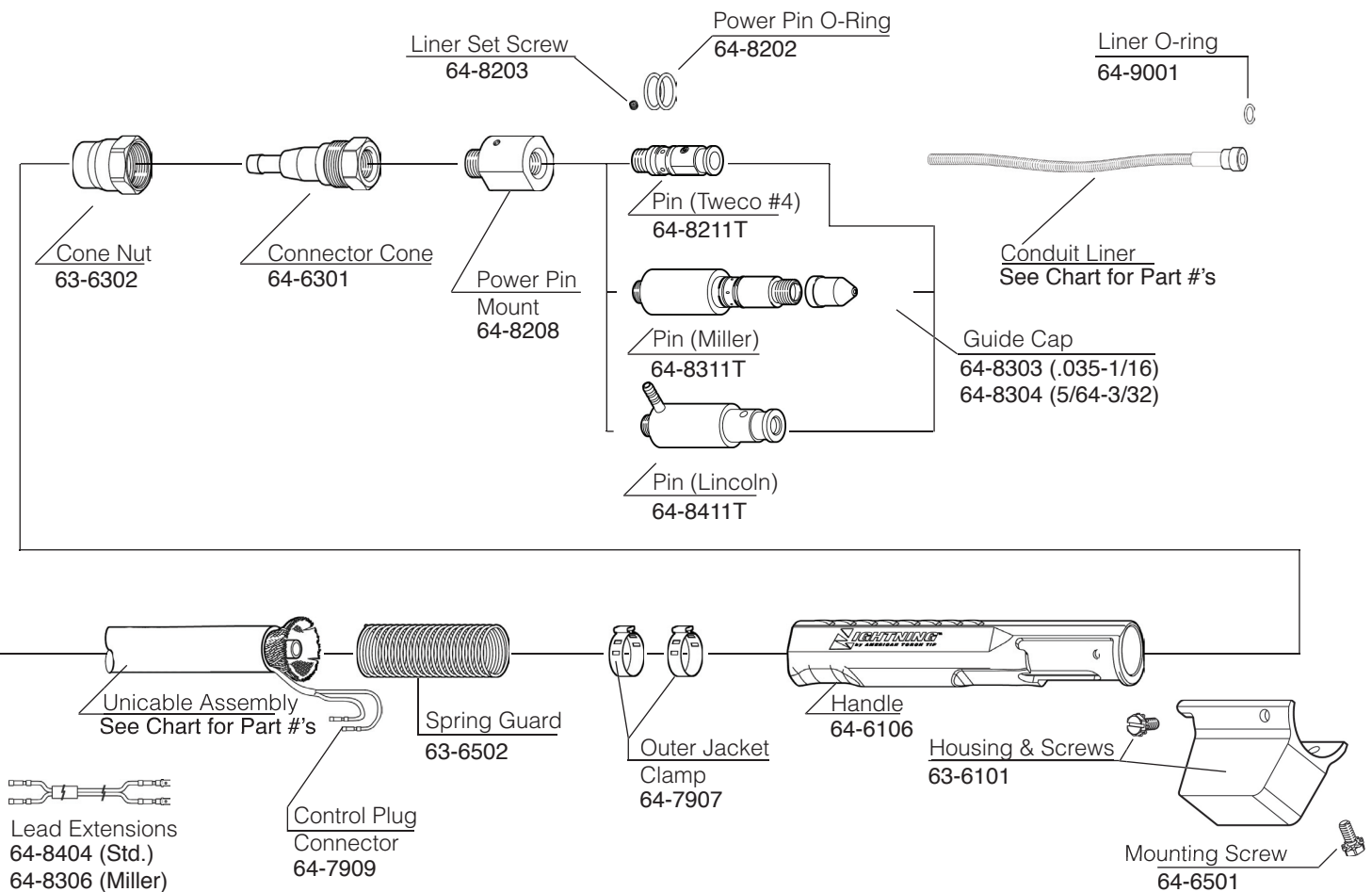
No.	Part No.	Description
1	24CT-37-S	Nozzle, Coarse Thread, 3/8" I.D.
	24CT-50-S	Nozzle, Coarse Thread, 1/2" I.D.
	24CT-62-S	Nozzle, Coarse Thread, 5/8" I.D.
	24CT-75-S	Nozzle, Coarse Thread, 3/4" I.D.

No.	Part No.	Description
4	14-30	Contact Tip .030" 0.8mm
	14-35	Contact Tip .035" 0.9mm
	14-40	Contact Tip .040" 1.0mm
	14-45	Contact Tip .045" 1.2mm
	14-52	Contact Tip .052" 1.3mm
	14-116	Contact Tip .062" 1.5mm

No.	Part No.	Description
2	23-37	Nozzle, Self Insulated, 3/8" I.D.
	23-50	Nozzle, Self Insulated, 1/2" I.D.
	23-62	Nozzle, Self Insulated, 5/8" I.D.
	23-75	Nozzle, Self Insulated, 3/4" I.D.
3	24A-50	Nozzle, Adjustable, 1/2" I.D.
	24A-62	Nozzle, Adjustable, 5/8" I.D.
	24A-75	Nozzle, Adjustable, 3/4" I.D.
	24A-37-SS	Nozzle, Short Stop, 3/8" I.D.
	24A-50-SS	Nozzle, Short Stop, 1/2" I.D.
	24A-62-SS	Nozzle, Short Stop, 5/8" I.D.

No.	Part No.	Description
5	44-3545-15	Liner Assy., 15' .035-.045"
	44-116-15	Liner Assy., 15' .062"
	44-564-15	Liner Assy., 15' 5/64"
	44-3545-25	Liner Assy., 25' .035-.045"
	44-116-25	Liner Assy., 25' .062"
	44-564-25	Liner Assy., 25' 5/64"
	44N-3545-15	Nylon Liner Assy., 15' .035-.045"
	44N-116-15	Nylon Liner Assy., 15' .062"

Gun Assembly - Rear



GENERAL SAFETY

1. Disconnect all power before servicing or changing welding gun components. Failure to disconnect power can lead to dangerous electrical shock which can kill.
2. Smoke, fumes and gases can be dangerous to your health. Keep smoke, fumes and gases from the breathing area. Fumes from welding are of various types and strengths, depending on the kind of base metal being welded.
3. Arc welding produces dangerous light radiation. Adequate eye protection must be worn.
4. All exposed skin must be covered with flame resistant, protective clothing. Do not wear clothing made from flammable synthetic fibers.
5. Protective screens or barriers should be used to protect others from spatter, flash and glare while welding.

TROUBLESHOOTING

Poor Wire Feed:

Liner clogged or kinked. Incorrect liner size or contact tip size. Liner cut to short and not seating properly in gas diffuser.

Gun Overheating:

Loose connection at the wire feeder. Gun being run beyond its amperage range. Insufficient gauge power cable or ground cable.

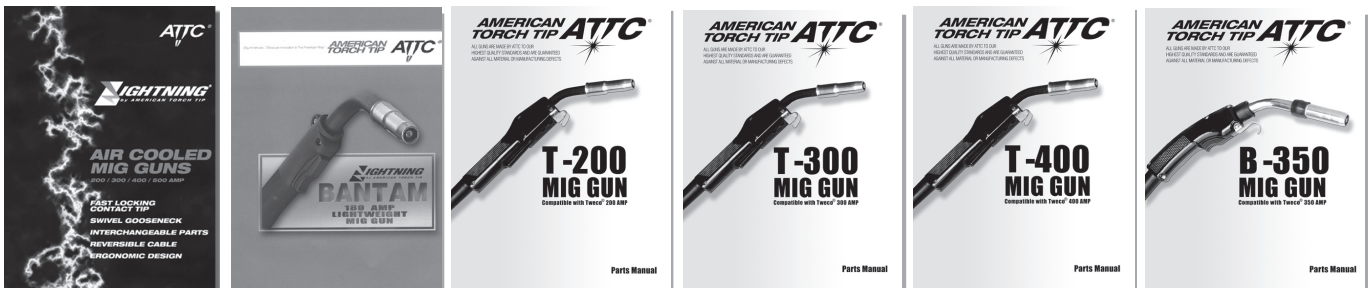
Weld Porosity:

spatter built up in nozzle blocking gas. Leaks in gas hose or improper connection.

Short Tip Life:

Drive rolls too tight resulting in scoring of welding wire. Welding wire dirty, rusty or too much cast. Wrong tip size. Torch over rated duty cycle.

MIG GUNS AVAILABLE FROM ATTC



CONTACT US

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