

# **AMERICAN TORCH TIP ATTTC<sup>®</sup>**

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



## **B - 350 MIG GUN**

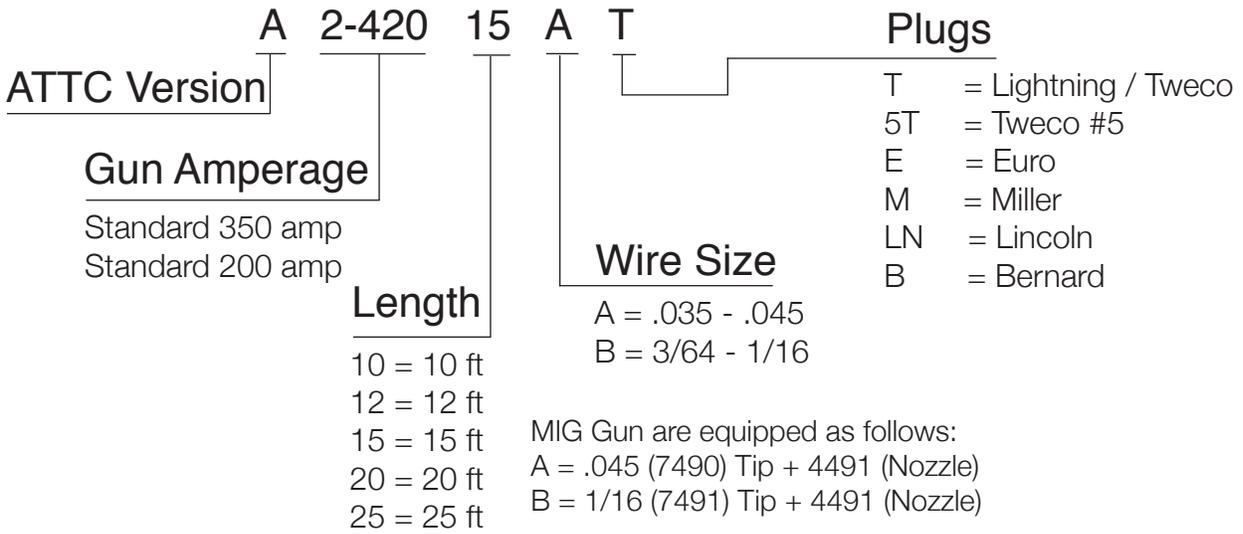
**Compatible with Bernard<sup>®</sup> 350 AMP**

RATING:  
350 A CO2 250A MIXED GAS  
@ 100% DUTY CYCLE  
.30" 0.8MM TO .062" 1.6MM WIRE

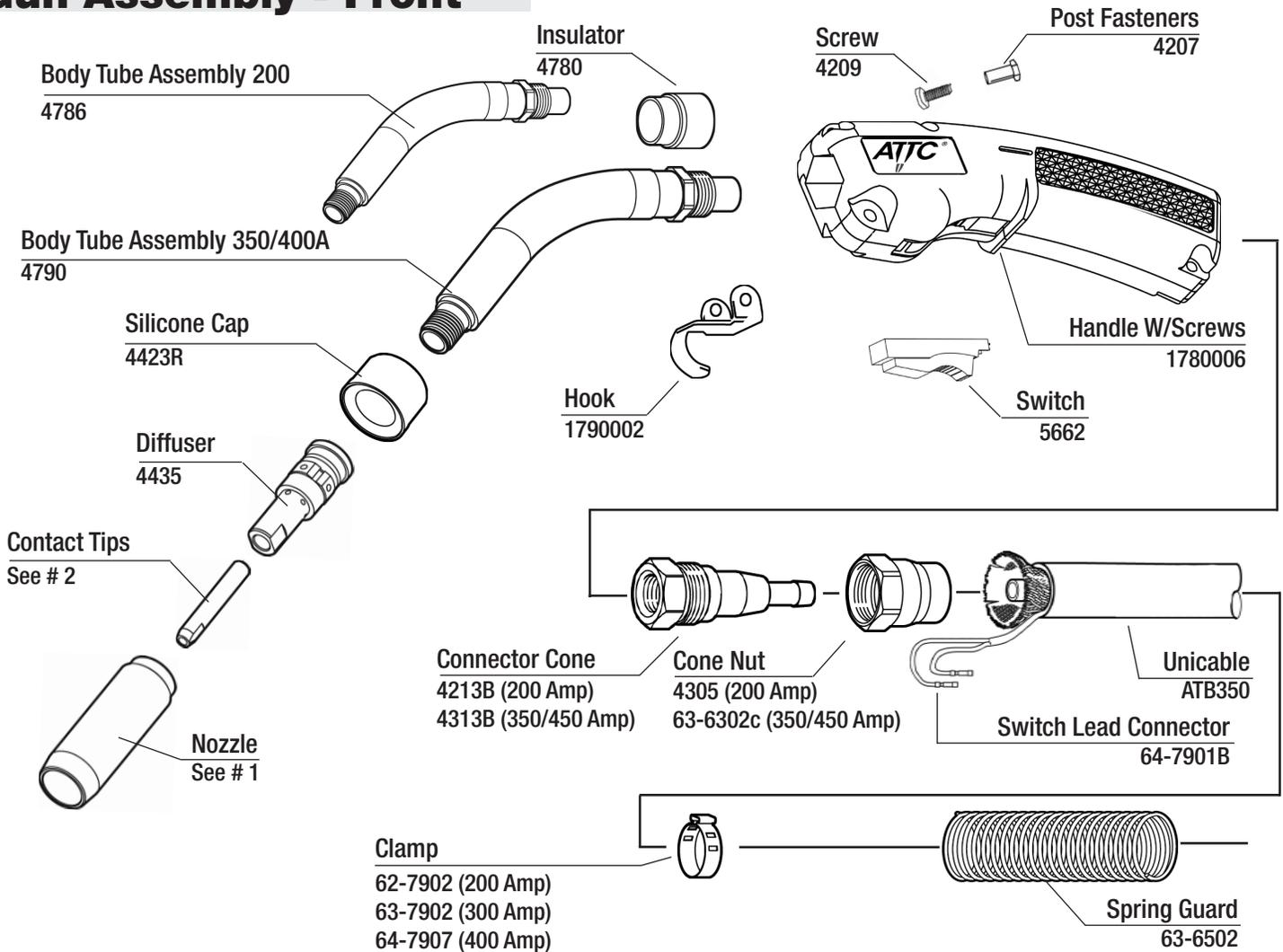
**Parts Manual**

# MIG Gun Part Numbering System

Bernard EZ Feed II 350 Amp



## Gun Assembly - Front

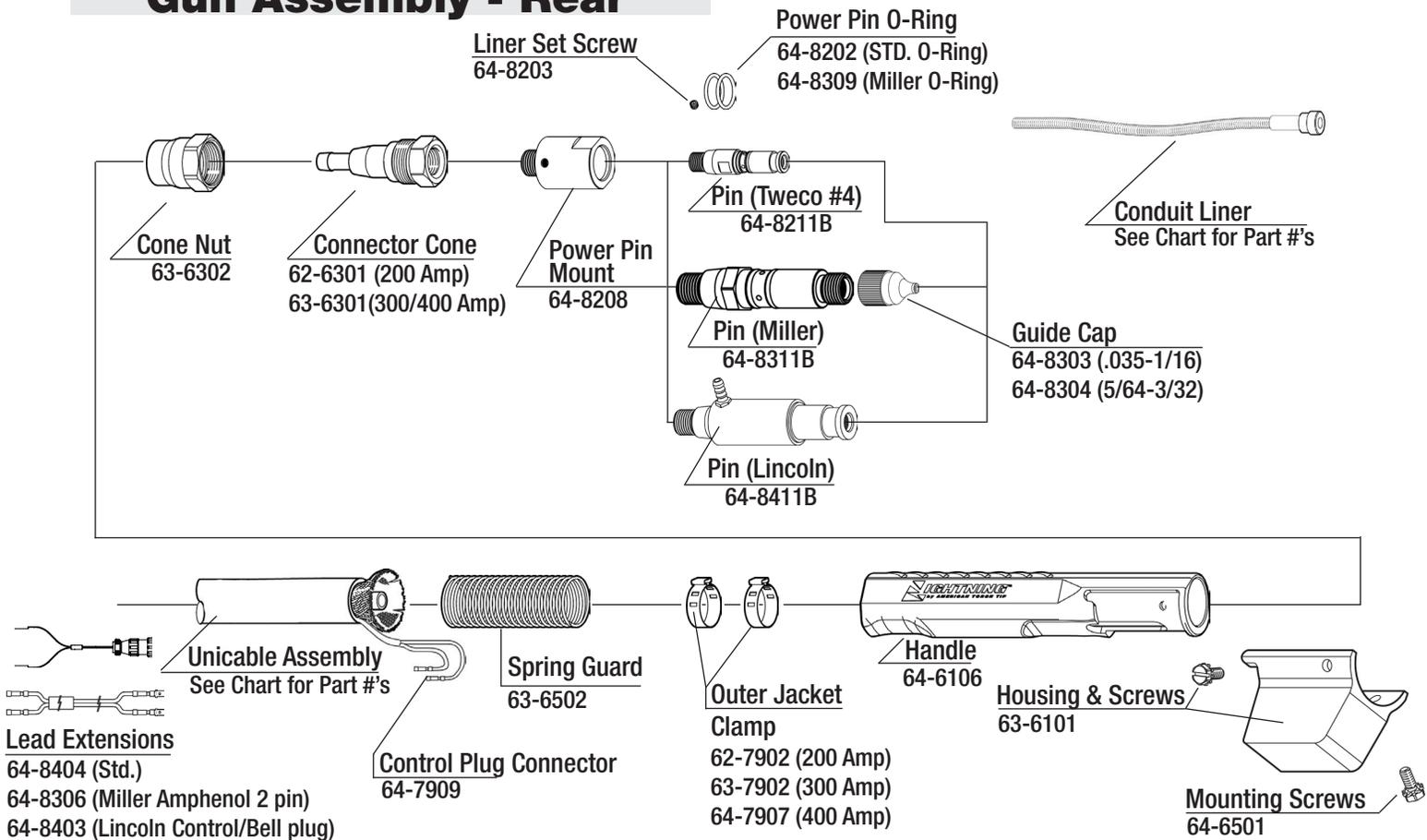


No.	Part No.	Description
<b>1</b>	4491	Nozzle- Brass 3/4" I.D. BND 350A
	4492	Nozzle- Brass 9/16" I.D. BND 350A
	4591	Nozzle- Copper 3/4" I.D. BND 350A
	4592	Nozzle- Copper 9/16" I.D. BND 350A

No.	Part No.	Description	Wire Size	Length	Parts No.
<b>2</b>	7488	Contact Tip	.030"	0.8mm	
	7498	Contact Tip	.035"	0.9mm	
	7490	Contact Tip	.045"	1.2mm	
	7491	Contact Tip	.063"	1.6mm	
	7496	Contact Tip	.040"	1.0mm	
	7497	Contact Tip	.023"	0.6mm	
	7498	Contact Tip	.052"	1.4mm	

Wire Size	Length	Parts No.	Wire Size	Length	Parts No.
.023-.030	10'	43010	1/16"Al	15'	44215X
.023-.030	15'	43015	1/16"	25'	44225
.023-.030	10'	43110	5/64"	15'	44310
.035-.045	15'	43115	5/64"	10'	44315
3/64" Al	15'	43115X	3/32"	15'	45410
.035-.045	25'	43125	3/32"	15'	45615
1/16"	15'	43215	7/64"	10'	45610
.035-.045	10'	44110	7/64"	15'	45615
.035-.045	15'	44115	.035-.045	15'	43115T
.035-.045	25'	44125	.035-.045	15'	44115T
1/16"	10'	44210	1/16"	15'	44215T
1/16"	15'	44215	1/16"	15'	44215T
			1/16"	25'	44225T

## Gun Assembly - Rear



**Please note:** Power Pins are also available for: Hitachi (64-8426), Daiden (64-8601), Panasonic (64-8701) and Thermal Arc 2410 (64-8901).

# GENERAL SAFETY

For our warranty, go to <http://americantorchtip.com/warranty/>

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

### 1. Poor Wire Feed

- Conduit liner clogged or kinked
- Incorrect liner size or contact tip
- Line cut too short and not seating properly in gas diffuser
- Drive rolls too tight resulting in scoring of welding wire
- Welding wire dirty, rusty and/or too much cast

### 2. Short Tip Life

- Drive rolls too tight resulting in scoring of the welding wire
- Welding wire dirty, rusty and/or too much cast
- Uncoated wire being used, increasing usage
- Wrong tip size
- Over torch rated duty cycle
- Loose contact tip and/or retaining head

### 3. Gun Overheating

- Loose retaining screw on quick connect block
- Insufficient gauge power cable and/or ground cable
- Loose connector cone and/or cone nut
- Gun being run beyond its amperage range
- Electrical malfunction in power source

### 4. Switch Malfunctioning

- Bad connection of leads to switch terminals
- Spatter built up between lever and switch housing
- Contacts dirty in switch
- Switch housing screws loose
- Broken or worn switch lead

### 5. Weld Porosity

- Spatter built up in nozzle blocking gas
- Leaks in gas hose or improper connection
- O-rings on power pin are cut or damaged
- Inner tube loose from connector cone
- Improper shielding gas or welding wire
- Rusty or poor quality welding wire
- Parent metal rusty or contaminated or high in Sulfur content
- Flow improperly set

### 6. Contact Tip Burn Back

- Improper voltage and/or wire feed speed
- Erratic wire feeding
- Improper tip stick-out
- Improper electrode stick-out
- Faulty ground

### 7. Erratic Arc

- Worn contact tip
- Buildup inside of line
- Wrong tip size
- Not enough bend in neck

### 8. Extreme Spatter

- Improper machine parameters
- Improper tip installation
- Improper tip shielding
- Contaminated wire or work piece

## CONTACT US

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## The **LIGHTNING** Family of MIG Guns



Straight



Large Curve



Small Curve



Robotic

LightningMIG.com