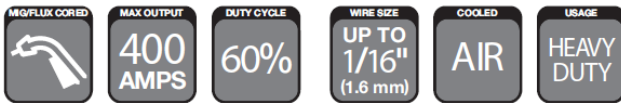


# VELOCITY2 SUPRA® XT SEHD SERIES

Supra XT SEHD 400 AMP MIG Gun  
Air-Cooled

**TWECO**  
AN ESAB BRAND



## WELDING PROCESSES:

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

## Standard Options Include:

- Rear Connector
- Heavy-Duty VELOCITY2 Front End Consumables
- Standard Conductor Tube –  
Part No. SEVCT64-60 (Stock No. 1640-1160)  
on all guns up to 15 ft (4.6 m)
- Part No. SEVCT64-45 (Stock No. 1640-1161)  
on all guns up to 15 ft (4.6 m)
- "LM" Long reach conductor tube are available

## Industry

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

## FEATURES

- **High Impact-Resistant One-Piece “Straight” Handle** allows the welder to locate the trigger at the bottom or top of handle
- **Metal “Paddle” Style Trigger Lever**
- **Three-Layer Conductor Tube Construction** (Copper tube/silicon-resin glass insulator/metal jacket) threads into front block front block for improved electrical conductivity
- **Front & Rear Spring Strain Relief** provides support to eliminate kinking
- **Micro-Switch Trigger Design** incorporates a button style switch for start/ stop wire feed
- **Spray Transfer Mode and Pulse Welding**
- **Straight CO<sub>2</sub> or Mixed Gases**

# 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.

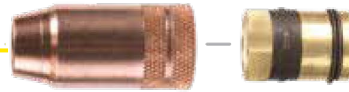
**ADJUSTABLE SLIP** allows welder to adjust the flushness relationship and provides improved access for cleaning.

**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

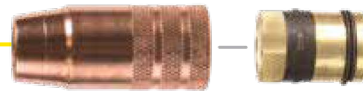
**FIXED THREADED** maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

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

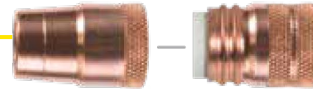
**FIXED THREADED (2 Piece)** maintains flushness relationship and provides for easier cleaning and maintenance.



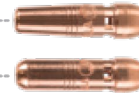
Fixed Threaded



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 SUPRA XT SEHD 400 AMP

SPECIFICATIONS	
<b>Description</b>	<b>VELOCITY2 Supra XT SEHD 400 Amp</b>
Welding Output Mixed 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-cored	Up To 1/16" (1.6mm)
Certification Mark (Standards)	CE IEC 60974-7
Operating Temperature	-10 to +40 °C
Cable Length	15 ft. (4.6 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 1/16" (1.6 mm)	15 ft (4.6m)	VSEHD400-5M16	1040-1880
	25 ft (7.6m)	VSEHD400-8M16	1040-1881
	15 ft (4.6m)	VSEHD400-5M16LM*	1040-1882
	25 ft (7.6m)	VSEHD400-8M16LM*	1040-1883

\* "LM": Long reach Conductor Tube

## Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6m)	VSEHD400M-5M16	1040-1884
	25 ft (7.6m)	VSEHD400M-8M16	1040-1885
	15 ft (4.6m)	VSEHD400M-5M16LM*	1040-1886
	25 ft (7.6m)	VSEHD400M-8M16LM*	1040-1887

## Lincoln® Style Rear Connector

Fits LN7, 8, 9, SP200

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6m)	VSEHD400L-5M16	1040-1888
	25 ft (7.6m)	VSEHD400L-8M16	1040-1889
	15 ft (4.6m)	VSEHD400L-5M16LM*	1040-1890
	25 ft (7.6m)	VSEHD400L-8M16LM*	1040-1891

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.

\* "LM": Long reach Conductor Tube

## Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To 1/16" (1.6 mm)	15 ft (4.6m)	VSEHD400X-5M16	1040-1892
	25 ft (7.6m)	VSEHD400X-8M16	1040-1893
	15 ft (4.6m)	VSEHD400X-5M16LM*	1040-1894
	25 ft (7.6m)	VSEHD400X-8M16LM*	1040-1895

\* "LM": Long reach Conductor Tube

## Conduit Liners – For Use With Steel Welding Wires

300-450 Amp – Steel Wound

Wire Size	Length	Part No.	Stock No.
.035" - .045" (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
5/64" (2.0 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" (1.6 mm)	15ft (4.6 m)	44N-116-15	1440-1012

## Conductor Tubes – Air Cooled

VELOCITY2 Supra® - SEHD

Description	Part No.	Stock No.	Outer Jacket Material	Black End Threads	Front End Threads
60 Degree with 3" (76.2 mm) Radius	SEVCT64-60	1640-1160	Metal	O.D. 9/16"-18 UNF-2A	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
45 Degree with 3" (76.2 mm) Radius	SEVCT64-45	1640-1161	Metal	O.D. 9/16"-18 UNF-2A	I.D. 3/8"-24 UNF-2B O.D. 9/16"-18UNF-2A
Long Reach Heavy Duty 60 Degree with 3" (76.2 mm) Radius	SEVCT64-60LM	1640-1162	Metal	O.D. 9/16"-18 UNF-2A	I.D. 3/8"-24 UNF-2B
Long Reach Heavy Duty 45 Degree with 3" (76.2 mm) Radius	SEVCT64-45LM	1640-1163	Metal	O.D. 9/16"-18 UNF-2A	I.D. 3/8"-24 UNF-2B

# VELOCITY2 SUPRA XT SEHD 400 AMP

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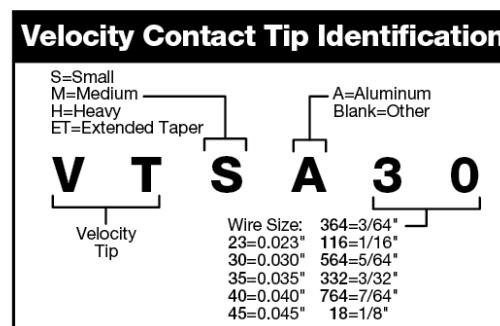
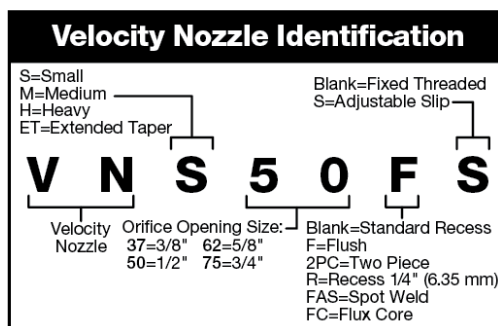
Note: VELOCITY2 medium and heavy duty contact tips and nozzles are for use with Tweco Classic® No. series, Spray Master® series and Supra® XT series MIG Guns.

### Heavy Duty Nozzles

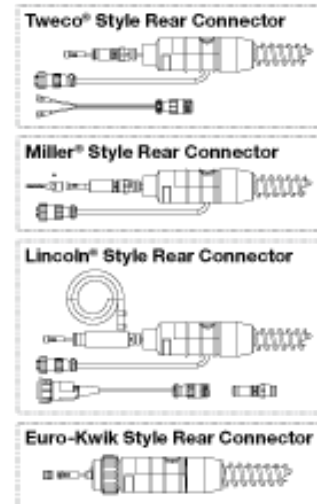
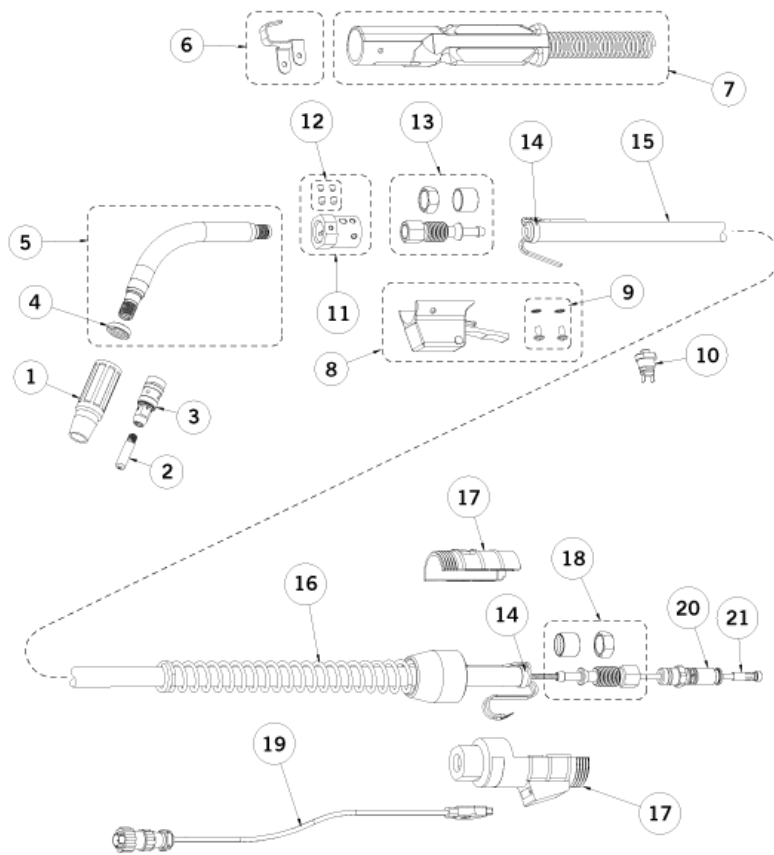
Self Insulated Nozzles. 2 per pack

Description	Part No.	Stock No.
5/8" (15.9 mm) Threaded Nozzle Recess	VNH62	1240-1877
5/8" (15.9 mm) Threaded Nozzle Flush	VNH62F	1240-1878
5/8" (15.9 mm) Threaded Nozzle Recess .350" (9 mm) Recess	VNH62R	1240-1898
3/4" (19.1 mm) Threaded Nozzle Recess	VNH75	1240-1875
3/4" (19.1 mm) Threaded Nozzle Flush	VNH75F	1240-1876
3/4" (19.1 mm) Threaded Nozzle 1/2" (12.7 mm) Recess	VNH75R	1240-1899
5/8" (15.9 mm) Slip Nozzle	VNH62S	1240-1893
3/4" (19.1 mm) Slip Nozzle	VNH75S	1240-1894
Slip Nozzle Base	VNS	1240-1864
5/8" (15.9 mm) Slip Nozzle Cone Only	VNH62SC	1240-1895
3/4" (19.1 mm) Slip Nozzle Cone Only	VNH75SC	1240-1896
1/2" (12.7 mm) 2 Piece Nozzle Cone Only Recess	VNH50RC	1240-1867
5/8" (15.9 mm) 2 Piece Nozzle Assembly Recess	VNH622PC	1240-1880
5/8" (15.9 mm) 2 Piece Nozzle Cone Only Recess	VNH62C	1240-1884
5/8" (15.9 mm) 2 Piece Nozzle Cone Only 1/2" (12.7 mm) Recess	VNH62RC	1240-1870
5/8" (15.9 mm) 2 Piece Nozzle Assembly Flush	VNH62F2PC	1240-1881
5/8" (15.9 mm) 2 Piece Nozzle Assembly Flush	VNH62FC	1240-1885
3/4" (19.1 mm) 2 Piece Nozzle Assembly Recess	VNH752PC	1240-1882
3/4" (19.1 mm) 2 Piece Nozzle Cone Only Recess	VNH75C	1240-1886
3/4" (19.1 mm) 2 Piece Nozzle Cone Only 1/2" (12.7 mm) Recess	VNH75RC	1240-1871
3/4" (19.1 mm) 2 Piece Nozzle Assembly Flush	VNH75F2PC	1240-1883
3/4" (19.1 mm) 2 Piece Nozzle Cone Only Flush	VNH75FC	1240-1887
Nozzle Retainer	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	Refer to Page 3	
1a	Silicone Tubing (Sold/Foot)	VCTLJBLK	1640-1409
1b	Insulator, Conductor Tube	VCTLSI	1640-1408
1c	O-Ring (Pkg. Of 10 each)	VCTLS015	1640-1410
2	Gun Hanger	154	2040-2154
3	Handle Assembly	SE86-H	2060-2052
4	Trigger Assembly	SE96	2060-2056
5	Trigger Housing Screws	SE96-SW	2060-2055
6	Trigger Switch	SE96-B	2060-2054
7	Front Pivot Block Assembly	SE66	2060-2051
8	Pivot Block Set Screw	SE66-B	2060-2050
9	Front Cable Connector	SE104	2060-2057
10	Cable Clamp	136	2060-2690
11	Cablehoz®	400	1740-2100

#	Description	Part No.	Stock No.
12	Rear Strain Relief Spring	235RSSR	2060-2035
13	Rear Case	M6RC	2660-2018
14	Rear Cable Connector	350-170HK	2035-2169
15	Control Wire (Tweco®)	MAK-354	2642-2460
	Control Wire (Miller®)	MSAK-354	2642-2470
	Control Wire (Lincoln®)	LAK-354	2642-2450
16	Connector Plug	Refer To Full Line Catalog	
17	Conduit Assembly	Refer to Page 3	
NS	Protective Cable Wrap, 50 ft (15 m) per box	TCR50	9900-1150



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