

VELOCITY2 Classic No. Series

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



WELDING PROCESSES:

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

Standard Options Include:

- Dual Schedule On/Off Control, Rear Connector and Knucklehead™ Flexible Conductor Tube
- Standard Conductor Tube — VCTLS6460 (Stock No. 1640-1400) on all guns up to 15ft (4.6 m)
- VCTLS6445 (Stock No. 1640-1401) on all guns over 15ft (4.6 m)
- Conduit Liner— 44 Series

Industry

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

VELOCITY2 CLASSIC NO. MIG GUN SERIES

FEATURES

- **THE INDUSTRY STANDARD** for over 40 years
- **INCORPORATING VELOCITY2 CONSUMABLES** with new ground breaking innovation inspired by welders for welders
- **SOLID COPPER CONDUCTOR PATH** with fewer connections for optimized electrical surface contact.
- **FEWER CONSUMABLES PARTS** means less complexity and lower cost of ownership
- **GAS PORTED VELOCITY2 CONTACT TIPS** stay cooler and last longer
- **EASY TO USE VELOCITY2 TIPS** eliminates threads and requires no tools
- **TIPS CAN BE ROTATED** to prolong life requiring fewer changes
- **EXCELLENT WIRE FEED** ability with centered liner with the conduit liner fitting inside the tip
- **SUPERIOR WELDING PERFORMANCE** from a smoother, more stable arc
- **LARGE COPPER TO COPPER** surface contact for superior thermal and electrical efficiency
- **PROVEN CONTACT TIP LIFE IMPROVEMENTS** with Short Arc Solid Wire 2 to 3 times life, Spray Transfer 4 to 5 times life and Gas Shielded Flux Core 8 to 10 times life

VELOCITY2 CLASSIC NO. 4 400 AMP

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.

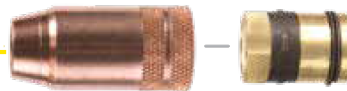
ADJUSTABLE SLIP allows welder to adjust the flushness relationship and provides improved access for cleaning.

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

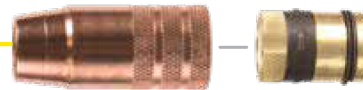
FIXED THREADED maintains a fixed, consistent flushness relationship between nozzle opening and contact tip.

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

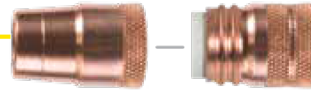
FIXED THREADED (2 piece) (2 piece) maintains flushness relationship and provides for easier cleaning and maintenance.



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 CLASSIC NO.4 400 AMP

SPECIFICATIONS	
Description	VELOCITY2 Classic No.4 400 Amp
Welding Output CO ₂ Gas	400 A at 60%
Wire Diameter, Mild Steel	Up To 5/64" (2.0mm)
Wire Diameter, Stainless	Up To 5/64" (2.0mm)
Wire Diameter, Aluminum	Up To 1/16" (1.6mm)
Wire Diameter, Flux Core	Up To 5/64" (2.0mm)
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)	15 ft (4.6 m)	VDS415-3545	1040-1904
	15 ft (4.6 m)	V415-3545K4**	1040-1905
	25 ft (7.6 m)	V425-3545	1040-1907
Up To 1/16" (1.6 mm)	10 ft (3 m)	V410-116	1040-1908
	12 ft (3.6 m)	V412-116	1040-1909
	15 ft (4.6 m)	V415-116	1040-1900
	20 ft (6.1 m)	VDS420-116	1040-1911
5/64" (2.0 mm)	15 ft (4.6 m)	V415-564	1040-1912

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)	VL412-3545	1040-1928
	15 ft (4.6 m)	VL415-3545	1040-1929
	15 ft (4.6 m)	VL415-3545K4**	1040-1930
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	VL412-116	1040-1931
	15 ft (4.6 m)	VL415-116	1040-1932

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.

Euro-Kwik Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	VX410-3545	1040-1934
	12 ft (3.6 m)	VX412-3545	1040-1935
	15 ft (4.6 m)	VX415-3545	1040-1936
	25 ft (7.6 m)	VX425-3545	1040-1937
Up To 1/16" (1.6 mm)	12 ft (3.6 m)	VX412-116	1040-1938
	15 ft (4.6 m)	VX415-116	1040-1939
5/64" (2.0 mm)	15 ft (4.6 m)	VX415-564	1040-1940

Suffix "K4" = Knucklehead Conductor Tube—
Part No. V64SFLXC480 (Stock No. 1640-1124)
Prefix "DS" = Dual Schedule

Miller® Style Rear Connector

Wire Size	Length	Part No.	Stock No.
Up To .045" (1.2 mm)	10 ft (3 m)	VM410-3545	1040-1914
	15 ft (4.6 m)	VM415-3545	1040-1916
	15 ft (4.6 m)	VM415-3545K4**	1040-1917
	20 ft (6.1 m)	VM420-3545	1040-1918
	25 ft (7.6 m)	VM425-3545	1040-1919
Up To 1/16" (1.6 mm)	10 ft (3 m)	VM410-116	1040-1920
	12 ft (3.6 m)	VM412-116	1040-1921
	15 ft (4.6 m)	VM415-116	1040-1922
	20 ft (6.1 m)	VM420-116	1040-1923
5/64" (2.0 mm)	15 ft (4.6 m)	VM415-564	1040-1925

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
.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" (1.6 mm)	15 ft (4.6 m)	44N-116-15	1440-1012

VELOCITY2 CLASSIC NO.4 400 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

Use VNH2PC & VNHXXRC series nozzles with the extended HD Taper Contact Tips

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
----------------------	--------------	-----------

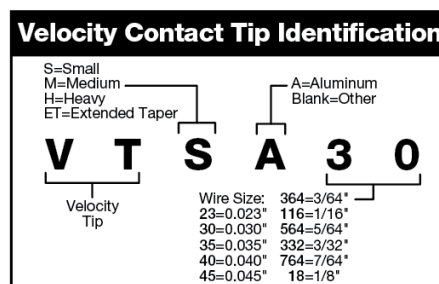
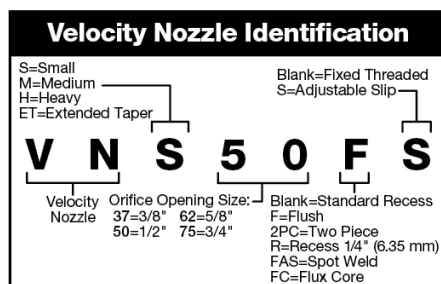
Note: VELOCITY2 medium and heavy duty contact tips and nozzles are for use with Tweco Classic® No. series, Spray Master® series and Supra® XT series MIG Guns.

Heavy Duty Nozzles

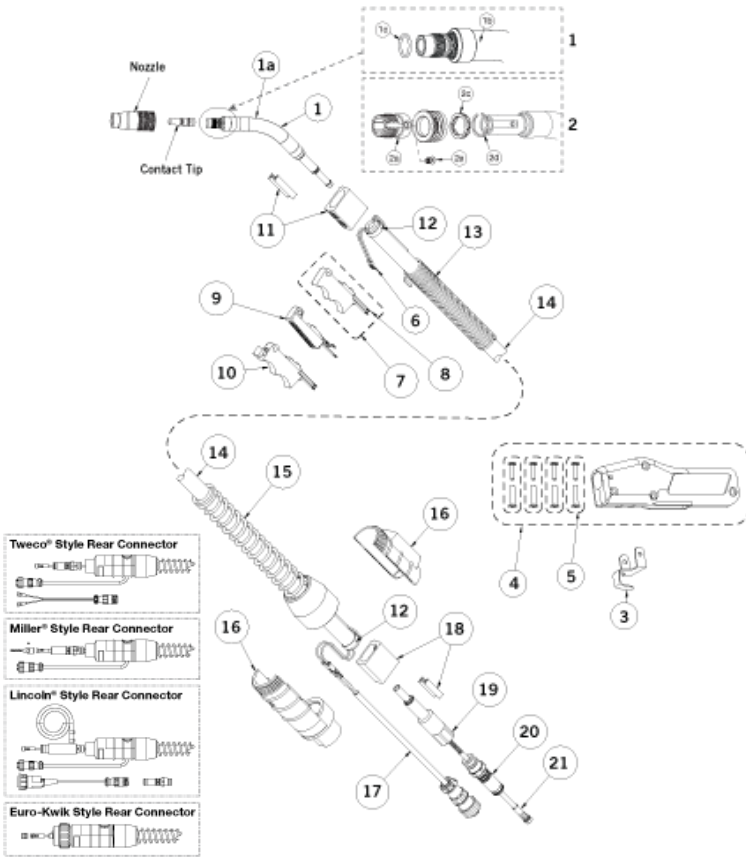
Self Insulated Nozzles. 2 per pack

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	VNH75R	1240-1899
1/2" (12.7 mm) Recess	VNH62S	1240-1893
5/8" (15.9 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	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	VNH75RC	1240-1871
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



Conductor Tubes – Air Cooled

VELOCITY2 Classic No. 4 with machined copper threads

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads
60 Degree with 3" (76.2 mm) Radius	VCTLS64-60	1640-1400	Metal with High Temperature Silicon Rubber	I.D. 3/8"-24 UNF-2B I.D.
45 Degree with 3" (76.2 mm) Radius	VCTLS64-45	1640-1401	Metal with High Temperature Silicon Rubber	I.D. 3/8"-24 UNF-2B I.D.

VELOCITY2 Classic No. 4 with machined stainless steel sleeve

Description	Part No.	Stock No.	Outer Jacket Material	Back End Threads
60 Degree with 3" (76.2 mm) Radius	VCTL64-60SS	1640-1406	Metal	I.D. 3/8"-24 UNF-2B I.D.
45 Degree with 3" (76.2 mm) Radius	VCTL64-45SS	1640-1407	Metal	I.D. 3/8"-24 UNF-2B I.D.

#	DESCRIPTION	VELOCITY2 CLASSIC NO.4	
		PART NO	STOCK No.
	Contact Tip	Refer To Page 4	
	Nozzle	Refer To Page 4	
1	60° VELOCITY2 Conductor Tube Assy.	VCTLS6460	1640-1400
	45° VELOCITY2 Conductor Tube Assy.	VCTLS6445	1640-1401
	80° VELOCITY2 Conductor Tube Assy.	VCTL6480	1640-1393
	180° VELOCITY2 Conductor Tube Assy.	VCTL64180	1640-1394
1a	Silicone Tubing (Sold/Foot)	VCTLJBLK	1640-1409
1b	Insulator, VELOCITY2 Conductor Tube Assy.	VCTLSI	1640-1408
1c	O-Ring (Pkg. Of 10 each)	VCTLS015	1640-1410
2	60° VELOCITY2 Stainless Steel Conductor Tube Assy.	VCTL6460SS	1640-1401
	45° VELOCITY2 Stainless Steel Conductor Tube Assy.	VCTL6445SS	1640-1407
	KNUCKLEHEAD Conductor Tube Assy.	V64SFLXC360 V64SFLX480	1640-1123 1640-1124
2a	Threaded Stainless Sleeve	VCTL6SL	1640-1395
2b	Nozzle Collar	VCTLSLK	1640-1398
2c	Wave Spring	VCTLSPR	1640-1399
2d	Wave Spring Retainer	PMA64RS	1640-1396
2e	Sleeve Screw	VCT41CS	2040-2048
3	Gun Hanger	154B	2040-2156
4	Handle (Standard)	84RC	2040-2087
	Handle (Dual Schedule)	84RC-DS	2040-2088
5	Binder Posts & Screws	124FM	2040-2124
6	Trigger Control Wire Terminal (Standard—2 ea.)	244	2040-2244
	Trigger Control Wire Terminal (Dual Schedule—4 ea.)	244LK	2040-2246
7	Trigger Assembly (Standard)	94RR	2040-2098
8	Trigger Blades	94RC	2040-2100
9	Trigger Assembly (Dual Schedule)	94RDS	2040-2101
10	Trigger Assembly (Locking)	94R-L	2040-2102
11	Front Cable Connector	104	2040-2104
12	Cable Clamp	136	2060-2690
13	Front Strain Relief Spring	142-6-SPR	2040-2146
14	Cablehoz® (Sold by the Foot)	400	1740-2100
15	Rear Strain Relief Spring	235RSSR	2060-2035
16	Rear Strain Relief Spring	R6RC	2060-2040
	Rear Case (Euro)	X6RC	2060-2006
17	Control Wire (Standard)	MS354-DSM	2060-2140
	Control Wire (Dual Schedule)	194DS	2040-2195
18	Rear Cable Connector (Direct Plug)	104	2040-2104
	Rear Cable Connector (Euro)	174X-M	2040-2181
19	Adapter (Direct Plug)	M170-4H	2020-2166
NS	Repair/Conversion Kits	84R-CK	2040-2089
20	Connector Plug	Refer To Full Line Catalog	
21	Conduit Assembly	Refer To Page 3	
NS	Protective Cable Wrap, 50 ft (15.2 m) per box	TCR50	9900-1150



ESAB / esab.com

