

# S-Gun™ Series

## 250 Amp MIG Gun

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Bernard S-Gun 250 amp MIG Gun



The Bernard S-Gun 250 amp MIG Gun is ideal for use in the shipbuilding and construction industries to reduce downtime and increase productivity.

### All Guns are Not Created Equal.

Designed specifically for shipbuilding and construction industries, the S-Gun 250 Amp MIG Gun Series is built for exceptional performance and comfort in the most demanding environments.

**Locked rotatable neck** eliminates downtime at start of shift due to missing necks resulting in reduced operator costs

**Locked rotatable neck is easily serviceable by maintenance**

**Steel monocoil power cable** is composed of lightweight steel coils that provide an exceptional conduit for shielding gas flow and wire feeding

**Steel monocoil power cable** is engineered to run commonly used wire sizes (.045-1/16 in.) with optimal flexibility and weight

**Advanced molded handle design** can withstand rough conditions and is ergonomically designed to offer better comfort and control even after extended use

**Quik Tip™ Series Consumables** are designed with a threaded taper lock that increases tip life by providing excellent heat transfer and electrical conductivity and only takes a quick twist to install

### Amperage Ratings

MIG Gun	Duty Cycle		Description
	100% CE	60% CE	
S25	225	275	CO <sub>2</sub> Gas

### S-Gun 250 Amp MIG Gun Part Number

Amp	Cable Length	Handle & Trigger	Neck	Contact Tip	Wire Size	Direct Plug
S25	08 8' (2.44 m)	T Standard Trigger	E Rotatable, Locking, Medium, 45° F Rotatable, Locking, Medium, 60°	5 Quik Tip™ Series	E .045" - 1/16" (1.2 mm-1.6 mm)	B Bernard™
	10 10' (3.05 m)					E Euro®
	12 12' (3.66 m)					H Hobart®
	15 15' (4.57 m)					L Lincoln®
	20 20' (6.16 m)					M Miller®
	25 25' (7.63 m)					N National®
						O OXO™
						S Tweco® 4 (Lincoln lead)
						T Tweco® 4 (std. lead)
						U Tweco® 4 (two prong twist-lock lead)
						W Tweco® 5 (std. lead)

\*Standard configuration is for .045" (1.2 mm) wire. Can be converted to run .052" (1.4 mm) or 1/16" (1.6 mm) by simply changing the contact tip.

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### Bernard

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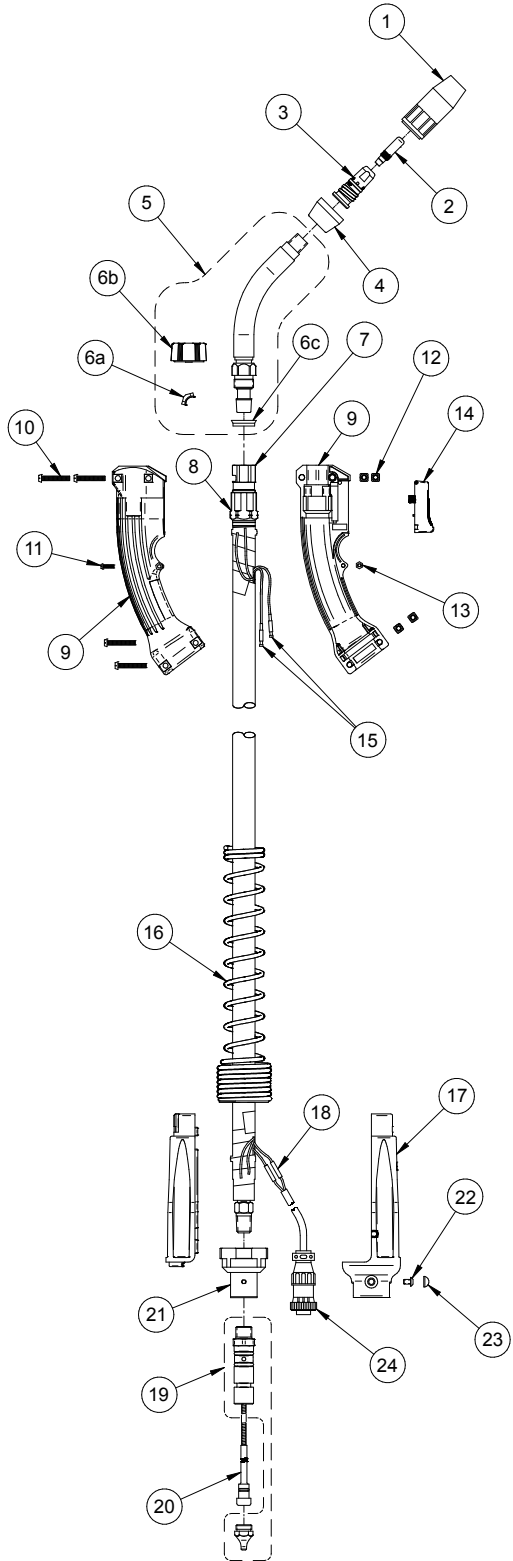
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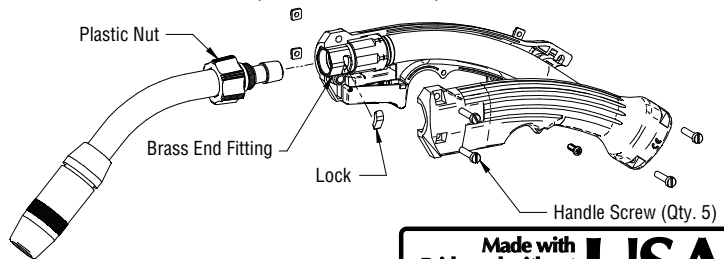
# Replacement Parts List



ITEM #	S250 PART #	DESCRIPTION
1	N1C58Q	Nozzle Assy
2	T1045	Contact Tip, Quik Tip, .045" (1.2 mm) <i>(Installed On Gun)</i>
	T1052	Contact Tip, Quik Tip, .052" (1.4 mm) <i>(Included with Gun)</i>
	T1162	Contact Tip, Quik Tip, 1/16" (1.6 mm) <i>(Purchased Separately)</i>
3	D118Q	Gas Diffuser
4	10012	Cap
5	QT3-45L	Neck, Rotatable/Locking, Medium, 45°
	QT3-60L	Neck, Rotatable/Locking, Medium, 60°
6a	1680074-2	End Fitting Lock <i>(Included w/Neck)</i>
6b	1840057	Hand Nut <i>(Included w/Neck)</i>
6c	1840031	Insulator <i>(Included w/Neck)</i>
7	1680074-1	Stay-Tite™ End Fitting
8	1540007	Stay-Tite™ Cone Nut
NS	407709-013	Jacket Clamp, <i>(4 Req'd)</i>
9	1880219	Handle Kit-Std. Trigger
10	203296-005	Handle Screw, Large <i>(4 Req'd)</i>
11	2280044	Handle Screw, Small
12	177272	Handle Nut <i>(4 Req'd)</i>
13	2030029	Handle Nut, Small
14	177488	Trigger, Standard
15	177271	Trigger Pin <i>(2 Req'd)</i>
16	2520056	Spring, Strain Relief
17		Rigid Strain Relief Kit, <i>(Includes Top &amp; Bottom Halves)</i>
	2520073	Strain Relief with Installed Gas Pin <i>(Bernard Direct Plug)</i>
	2520069	Strain Relief <i>(Euro Direct Plug)</i>
	2520066	Strain Relief <i>(All Other DP's)</i>
18	4932	Butt Connector <i>(2 Req'd)</i>
19	<i>(See Direct Plug Spec Sheet)</i>	Direct Plug Components
20	<i>(See Liner Spec Sheet)</i>	Liner
21	1010036	Adapter Block
22	2280056	Screw, Strain Relief
23	1620003	Screw Cover, Strain Relief
24	GN2021	Electrical Plug - Non D/S <i>(Not Req'd on Bernard or Euro DP)</i>
	20006A	Electrical Plug - Non D/S <i>(Not Req'd on Bernard or Euro DP)</i>

## Neck Removal and Installation Instructions

- Loosen the neck by rotating the plastic nut counter-clockwise until neck rotates freely
- Remove handle screws to separate handle halves
- Locate lock on brass end fitting and remove it by unwrapping clear tape and gently tapping on end fitting until lock falls out
- Continue rotating the plastic nut and pull on neck to remove
- To reinstall neck, complete the above steps in the reverse order



Made with  
Pride and without  
Compromise in the **USA**

### CALIFORNIA PROPOSITION 65 WARNING

This product contains chemicals, including lead, known to the state of California to cause cancer, and birth defects or other reproductive harm. *Wash hands after use.*