

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 ₂ 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°	5 Quik Tip™ Series	E .045" - 1/16" (1.2 mm-1.6 mm)	B Bernard™
	10 10' (3.05 m)					F Rotatable, Locking, Medium, 60°
	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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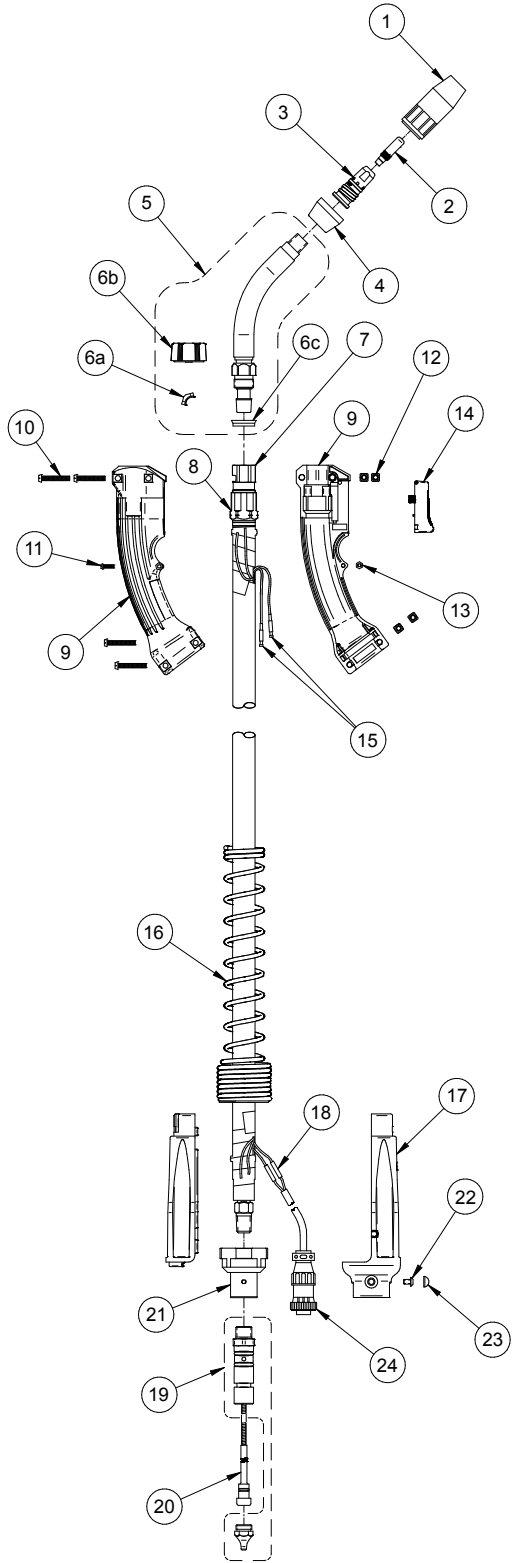
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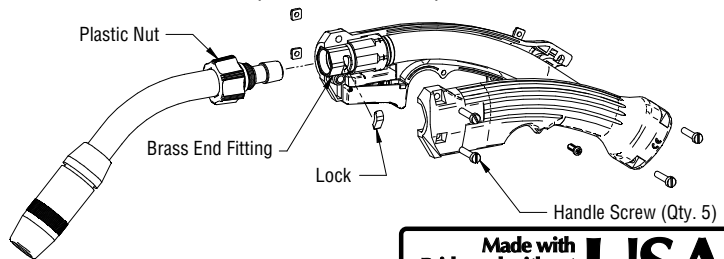
Replacement Parts List



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 & 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.*