

Liners

MIG Welding Accessory

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All Consumables are Not Created Equal.

It's important to choose longer lasting consumables. They can make the difference between repeated consumable replacement and rework, or more arc time and better bottom line.

Proprietary in-house coiling process and unique composition eliminates flat spots or sharp edges inside liner to improve wire feed performance.

100 Percent tested prior to shipment to ensure the smoothest wire feed in the industry.

Liners won't gap when bent.

Quick and simple replacement without gas diffuser set-screw for reduced downtime.

Replacement Liner



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

Bernard®

An Illinois Tool Works Company
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Beecher, Illinois 60401 USA

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For more information, visit us at BernardWelds.com



Available Liners

| Standard Liners | | | | | |
|------------------------------------|---------------------------|---------------------------|--------------|--------------|--------------|
| Wire Size | Gun Amperage | Direct Plug | 10' (3.05 m) | 15' (4.57 m) | 25' (7.62 m) |
| .023" - .030" (.6 mm - .8 mm) | 150A - 600A | All except Tweco 4, L-Tec | *N/A | 43015 | 43025 |
| | | Tweco 4, L-Tec | *N/A | **43015T | **43025T |
| .035" - .045" (.9 mm - 1.2 mm) | 150A | All except Tweco 4, L-Tec | 43110 | 43115 | 43125 |
| | | Tweco 4, L-Tec | *N/A | **43115T | **43125T |
| | 200A - 600A | All except Tweco 4, L-Tec | 44110 | 44115 | 44125 |
| | | Tweco 4, L-Tec | *N/A | **44115T | **44125T |
| .045" - 1/16" (1.2 mm - 1.6 mm) | 200A - 600A | All except Tweco 4, L-Tec | 44210 | 44215 | 44225 |
| | | Tweco 4, L-Tec | *N/A | **44215T | **44225T |
| 5/64" (2.0 mm) | 200A - 400A | All except Tweco 4, L-Tec | *N/A | 1920356 | 1920357 |
| | | Tweco 4, L-Tec | *N/A | **†1920296 | **†1920298 |
| | 500A - 600A | All except Tweco 4, L-Tec | *N/A | 44315 | 44325 |
| | | Tweco 4, L-Tec | *N/A | **44315T | **44325T |
| 3/32" (2.4 mm) | 500A - 600A | All except Tweco 4, L-Tec | *N/A | 45415 | 45425 |
| | 400A Clean-Air | All except Tweco 4, L-Tec | *N/A | †1920175 | †1920177 |
| 7/64" (2.8 mm) | 600A Air-Cooled Only | All except Tweco 4, L-Tec | *N/A | 45615 | 45625 |
| 1/8" (3.2 mm) | 600A Air-Cooled Only | All except Tweco 4, L-Tec | *N/A | 46715 | 46725 |
| Aluminum / Soft Wire Liners | | | | | |
| Wire Size | Gun Amperage | Direct Plug | 10' (3.05 m) | 15' (4.57 m) | 25' (7.62 m) |
| .035" (.9 mm) | 150A - 600A Nylon | All except Tweco 4, L-Tec | *N/A | 43015X | N/A |
| | | Tweco 4, L-Tec | *N/A | **43015XT | N/A |
| | 200A - 600A Steel Coil | All except Tweco 4, L-Tec | *N/A | 1920343 | N/A |
| | | Tweco 4, L-Tec | *N/A | **1920346 | N/A |
| 3/64" (1.2 mm) | 200A - 600A Nylon | All except Tweco 4, L-Tec | *N/A | 43115X | N/A |
| | | Tweco 4, L-Tec | *N/A | **43115XT | N/A |
| | 200A - 600A Steel Coil | All except Tweco 4, L-Tec | *N/A | 1920344 | 1920350 |
| | | Tweco 4, L-Tec | *N/A | **1920347 | N/A |
| 1/16" (1.6 mm) | 200A - 600A Nylon | All except Tweco 4, L-Tec | *N/A | 44215X | N/A |
| | | Tweco 4, L-Tec | *N/A | **44215XT | N/A |
| | 200A - 600A Steel Coil | All except Tweco 4, L-Tec | *N/A | 1920345 | 1920351 |
| | | Tweco 4, L-Tec | *N/A | **1920348 | N/A |

*10' (3.05 m) liner not available. Order 15' (4.57 m) liner and trim to size.

†Liners without outer jacket.

**For use only with Bernard guns with Tweco 4 or L-Tec direct plugs manufactured prior to 2008.

Replacement Instructions and Service

Remove Existing Liner

Turn off power. Remove nozzle, tip, gas diffuser and insulator cap (guns with jump liner remove neck). Lay cable straight. Grasp liner lock which protrudes from power pin (some direct plugs may require removal of additional components to access the liner lock) and remove from cable assembly.

Install Replacement Liner

Insert liner into power pin with cable laying straight. Continue until liner lock is fully seated into power pin. A twisting motion may be necessary to seat O-ring (some direct plugs may require installation of additional components to secure liner).

Making sure cable is straight, trim liner at the nozzle of the neck as follows:

- DS-1 and D-1 Centerfire™ gas diffusers (used with Centerfire™ series tips) = between 5/8" and 3/4"
- 4235 and 4635 gas diffusers (used with 1500 series tips) = 3/8"

- 4335 and 4435 gas diffusers (used with 7400 or 4200 series tips) = 1-3/8"
- D118Q gas diffusers (used with Quik Tips™) = 7/8"
- D114Q gas diffusers (used with Quik Tips™) = 3/4"

File the cut end of liner to eliminate burrs and reinstall insulator cap, gas diffuser, tip and nozzle.

When using Jump Liner: Trim and deburr liner with 1/4" (6.4 mm) extending beyond the gun handle and reinstall neck.

Service

Inspect for excessive wear and debris on the inside diameter. Do not dip liner in solvents for cleaning. Liner may be periodically blown out with shop air. Replace with new liner when excessive wear or debris produces poor electrode feed.

