

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.

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



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.*

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

Bernard®

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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.

