



**Roughneck® C-Series**  
300–500 Amp, Semi-Automatic,  
Air-Cooled MIG Welding Guns

## Roughneck® MIG Guns

Model	Stock #	Length	Rating and Duty Cycle (CO <sub>2</sub> ) <sup>1</sup>	Standard Wire Size
C-3010	194 751	10 ft (3 m)	300 A at 100% Duty Cycle	.035–.045 in (0.9–1.2 mm)
C-3012	194 752	12 ft (3.7 m)		
C-3015	194 753	15 ft (4.6 m)		
C-4010	194 754	10 ft (3 m)	400 A at 100% Duty Cycle	.035–.045 in (0.9–1.2 mm)
C-4012	194 755	12 ft (3.7 m)		
C-4015	194 756	15 ft (4.6 m)		
C-5010	194 757	10 ft (3 m)	500 A at 100% Duty Cycle	.052–1/16 in (1.3–1.6 mm)
C-5012	194 758	12 ft (3.7 m)		
C-5015	194 759	15 ft (4.6 m)		

<sup>1</sup>Ratings with mixed gas are reduced by 10–50% depending on gas mixture and welding parameters.

### Roughneck Contact Tips

(10 p/pkg)	(25 p/pkg)	Description	(10 p/pkg)	(25 p/pkg)	Description
<b>Heavy-Duty FasTip™</b>			<b>Tapered FasTip™</b>		
—	#206 184	.023 in (0.6 mm)	—	#209 024	.023 in (0.6 mm)
—	#206 185	.030 in (0.8 mm)	—	#209 025	.030 in (0.8 mm)
#223 016	#206 186	.035 in (0.9 mm)	—	#209 026	.035 in (0.9 mm)
#223 017	#206 187	.040 in (1.0 mm)	—	#209 027	.045 in (1.2 mm)
#223 018 <sup>1</sup>	#206 188 <sup>1</sup>	.045 in (1.2 mm)	—	#209 028	3/64 in (1.2 mm)
#223 019	#206 189 <sup>(B)</sup>	.052 in (1.3 mm) or 3/64 in (1.2 mm) alum wire	—	#209 029	.052 in (1.3 mm)
#223 200 <sup>2</sup>	#206 190 <sup>2</sup>	1/16 in (1.6 mm)	—	#209 030	1/16 in (1.6 mm)
—	#206 191	.068 in (1.7 mm)	<b>Value Multi-Turn</b>		
—	#206 192	5/64 in (2.0 mm)	—	#087 300	.023 in (0.6 mm)
—	#206 193	3/32 in (2.4 mm)	—	#071 825	.030 in (0.8 mm)
<b>Extra Heavy-Duty FasTip™</b>			—	#054 202	.035 in (0.9 mm)
—	#199 605	.035 in (0.9 mm)	—	#054 201	.045 in (1.2 mm)
—	#199 606	.040 in (1.0 mm)	—	#199 593	3/64 in (1.2 mm) alum wire
—	#198 851	.045 in (1.2 mm)	—	#044 006	.052 in (1.3 mm)
—	#198 852	.052 in (1.3 mm) or 3/64 in (1.2 mm) alum wire	—	#047 566	1/16 in (1.6 mm)
—	#198 853	1/16 in (1.6 mm)	—	#199 594	.068 in (1.8 mm)
—	#198 854	.068 in (1.7 mm)	—	#047 565	5/64 in (2.0 mm)
—	#199 607	5/64 in (2.0 mm)			
—	#199 608	3/32 in (2.4 mm)			
—	#199 609	7/64–1/8 in (2.8 mm)			

<sup>1</sup>Optional

<sup>2</sup>For all gun lengths

<sup>(B)</sup>Available in bulk quantities — see page 22 for more information.

### Options & Accessories

#### Locking Trigger Switch #199 661

Allows trigger to be locked for long welds.

#### Gun Hook #199 662

Enables gun to be stored between welds.

#### Machine Adapter Kit #199 663

Allows Roughneck welding guns to adapt to Lincoln products (Power MIG 255; Wirematic 250, 255 and SP-T Series) and ESAB products (Migmaster 180); Hobart and Thermal Arc products (BETA-MIG II, 200, 250, 251; Hefty; 2000 Series; Dual/Digital 2000; Porta-Feed and Ultra-Feed); Tweco style 5/8 in direct plug.

#### Machine Adapter Kit #199 664

Allows Roughneck welding guns to adapt to Lincoln products (LN-7, LN-8, LN-9, LN-22, LN-25 and LN-742). Requires ordering a new replacement liner.

#### Aluminum Adapter Kit #202 895

Steel wrapped nylon liner allows 10 ft Roughneck welding guns to feed 3/64–1/16 in (1.2–1.6 mm) aluminum wire.

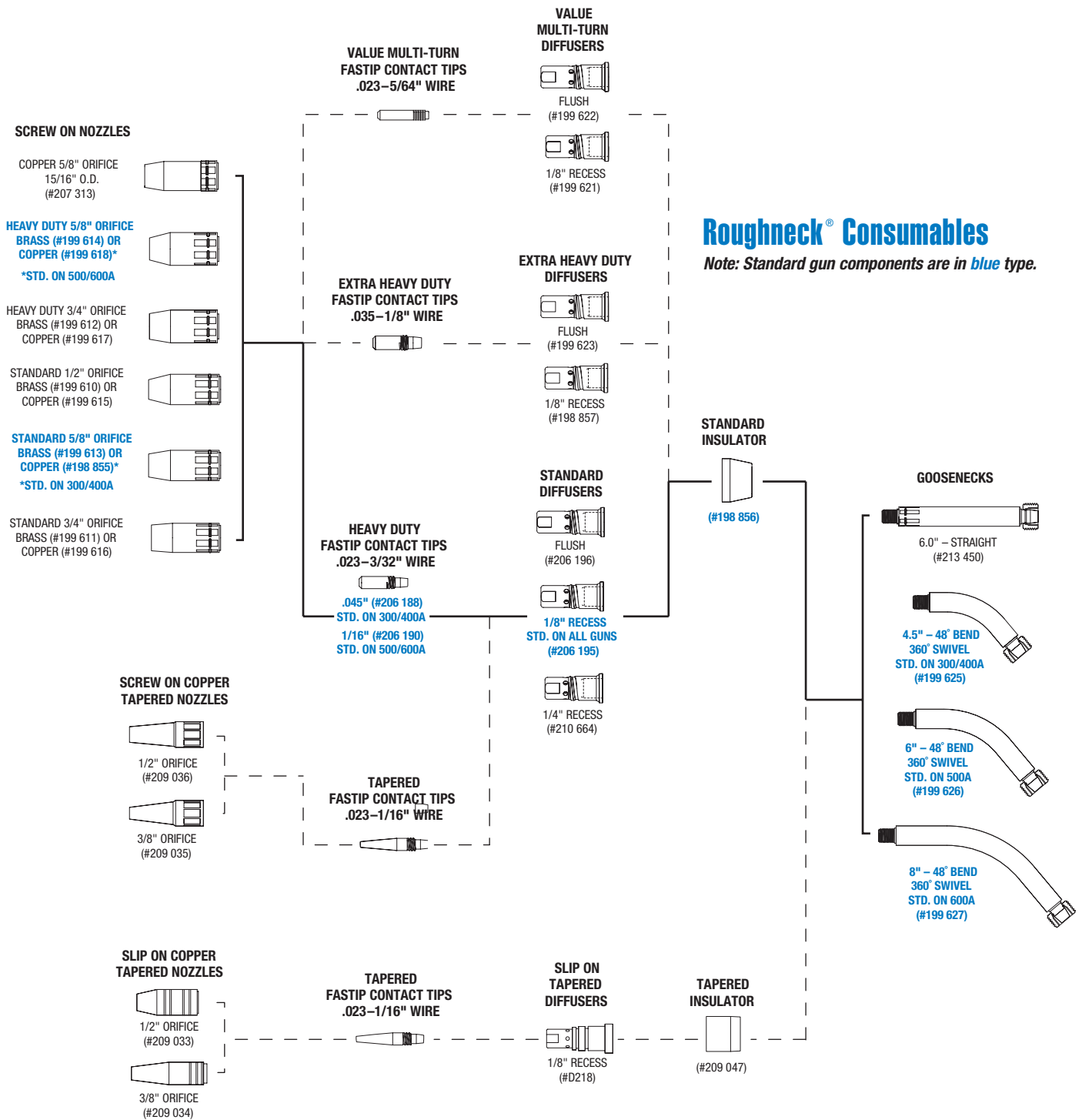
#### Tweco No. 3, 4 & 5 Upgrade Kit #214 893<sup>3</sup>

Upgrades Tweco No. 3, No. 4, and No. 5 guns to use Roughneck consumables. Includes insulator and diffuser.

<sup>3</sup>Nozzle (SCR type) and contact tip not included.

#### Consumable Kit #206 073 for Roughneck guns contains:

- 5–.281 OD, .035 (0.9 mm) contact tips
- 5–.281 OD, .045 (1.2 mm) contact tips
- 5–.312 OD, .035 (0.9 mm) contact tips
- 5–.312 OD, .045 (1.2 mm) contact tips
- 1–.625 orf tapered copper nozzle
- 1–FasTip diffuser, flush
- 1–Nozzle insulator
- 1–Gun hook





## Roughneck® C-Series Service Parts/Consumables

Item #	Part #	Description	Quantity
1*	<b>198 855</b> <sup>1</sup>	Nozzle, scr type copper 5/8 in orifice	1
	<b>199 618</b> <sup>2(B)</sup>	Nozzle, scr type copper 5/8 in orifice heavy-duty	1
2*	<b>223 018</b> <sup>1</sup>	Tip, contact, .045 in (1.2 mm) heavy-duty FasTip™	1 (10 per pkg)
	<b>206 188</b> <sup>1</sup>	Tip, contact, .045 in (1.2 mm) heavy-duty FasTip™	1 (25 per pkg)
	<b>223 200</b> <sup>2</sup>	Tip, contact, 1/16 in (1.6 mm) heavy-duty FasTip™	1 (10 per pkg)
	<b>206 190</b> <sup>2</sup>	Tip, contact, 1/16 in (1.6 mm) heavy-duty FasTip™	1 (25 per pkg)
3*	<b>206 195</b> <sup>3(B)</sup>	Diffuser, gas 1/8 in tip recess – for standard and heavy-duty FasTip™	1
4	<b>202 889</b>	Liner, monocoil .023–.030 wire x 15 ft round wound	1
	<b>202 890</b> <sup>1</sup>	Liner, monocoil .035–.045 wire x 15 ft round wound	1
	<b>202 891</b> <sup>2</sup>	Liner, monocoil .052–1/16 wire x 15 ft round wound	1
	<b>202 892</b>	Liner, monocoil 1/16–.078 wire x 15 ft flat wound	1
	<b>202 893</b>	Liner, monocoil 5/64–3/32 wire x 15 ft flat wound	1
	<b>202 894</b>	Liner, monocoil 7/64–1/8 wire x 15 ft flat wound	1
	<b>202 895</b>	Liner, monocoil 3/64–1/16 wire x 15 ft aluminum wires	1
5	<b>199 625</b>	Gooseneck, jacketed 4.5 in/50° wrench swivel (C-30 / C-40) (includes)	1
	<b>199 626</b>	Gooseneck, jacketed 6 in/50° wrench swivel (C-50) (includes)	1
	<b>199 627</b>	Gooseneck, jacketed 8 in/50° wrench swivel (C-60) (includes)	1
	<b>213 450</b>	Gooseneck, jacketed 6 in/straight (optional for C-30 / C-40 / C-50 / C-60) (includes)	1
6	<b>198 856</b> <sup>3</sup>	Insulator, rubber	1
7	<b>202 292</b>	Cover, nut	1
8	<b>199 630</b>	Handle, small pair flared P style (C-30 / C-40 includes)	1
8	<b>199 631</b>	Handle, large pair (C-50 / C-60 includes)	1
	<b>199 634</b>	Screw, M3 x 11 (for #199 630 C-30 / C-40 Handle only)	1
	<b>199 635</b>	Nut, M3 Hex (for #199 630 C-30 / C-40 Handle only)	1
	<b>199 632</b>	Screw, M4 x 18	4
	<b>199 633</b>	Nut, M4 square	4
	<b>199 647 (N/A)</b>	Label, gun handle Miller Roughneck	2
9	<b>199 628</b>	Switch, blue trigger	1
	<b>199 661</b>	Switch, locking trigger (optional)	1
10	<b>199 629</b>	Switch, contact pin	2
11	<b>079 531</b>	Conn, circ cpc clamp str rlf size 11.453 OD	1
12	<b>079 878</b>	Housing plug + pins (service kit)	1
13	<b>199 637</b>	Screw, machine binding head	1
14	<b>199 640</b>	Adapter, Miller power pin (includes)	1
15	<b>079 974</b>	O-ring, Miller power pin	2
16	<b>2520033</b>	Cable Strain Relief 2 & 3 (300 Amp)	1
	<b>2520041 (N/A)</b>	Strain Relief Assy – Contact Bernard (400, 500, 600 Amp)	
17	<b>GN2021</b>	Electrical Plug – Non D/S (Includes items 11 & 12)	1
18	<b>227 650</b>	Strain Relief, Rear (works on all Amp guns)	1

<sup>1</sup>Standard on 300 and 400 amp guns

<sup>2</sup>Standard on 500 and 600 amp guns

<sup>3</sup>Standard on all guns

<sup>(B)</sup>Available in bulk quantities — see page 22 for more information.

\*Items 1, 2 & 3 will work on Bernard as a set.

**Note:** For a complete listing of Roughneck consumables see page 24.

