

Spool Gun 250

Easy setup and reliable performance



SG 250

Industry

- Ship and Offshore Yards
- Repair and Maintenance
- Steel Industry
- Industrial and General Fabrication
- Automotive

Compact and versatile, the Spool Gun 250 is designed for MIG welding aluminum and soft alloys, delivering smooth wire feeding and a stable arc. Built for simplicity, this MIG gun offers quick wire loading, easy operation, and precise wire feed speed control to boost productivity and reduce downtime.

The Spool Gun 250 offers direct plug-and-play compatibility with ESAB equipment, eliminating the need for additional adapters and reducing complexity while improving workflow efficiency.

Welds aluminum, stainless steel, and mild steel, making it the ideal MIG spool gun for light fabrication, automotive repair, trailer work, marine applications, and general maintenance.

- Integrated spool-on-gun design improves wire feeding performance
- Easy connection to ESAB equipment via OKC 50 adapter and 8-pin connector ensures faster setup and reliable performance
- Adjustable wire feed speed enables precise control across a range of materials and thicknesses
- Built-in gas valve simplifies setup and streamlines operation
- Transparent spool cover allows quick and easy monitoring of wire levels
- Durable conductor tube enhances reliability and extends service life
- Compatible with TWECO® consumables, including 11 Series contact tips, HD22-50 nozzle, and HD52-11 diffuser

Visit **esab.com** for more information.



Spool Gun 250

Specifications

Welding Output	250 A @ 40% 200 A @ 60%
Power Connection	OKC 50
Trigger and Wire Feed Speed Connection	8-pin
Gas Connection	5/8-18 with barb
Maximum Gas Flow	25 l/min (53 cfh)
Maximum Gas Pressure	5.5 bar (80 psi)
Recommended Wire Diameter, Mild Steel and Stainless	0.8 - 1.2 mm (0.030 - 0.045 in.)
Recommended Wire Diameter, Aluminum	0.8 - 1.2 mm (0.030 - 0.047 in.)
Maximum Wire Feed Speed	20 m/min (65 ft/min)
Compatible Wire Spools	100 mm (D100) (4 in.)

Ordering Information

Description	Part Number
Tweco SG 250, OKC 50 8pin 4 m (12.5 ft)	10271494
Tweco SG 250, OKC 50 8pin 8 m (25 ft)	10271495

Delivery includes: SG 250, Starter kit for welding with Mild Steel 0.8 - 1.2 mm (0.030 - 0.045 in.) and Aluminum 0.9 - 1.2 mm (0.035 - 0.047 in.): Contact Tips, Gas Nozzle, U and V-Groove Rollers.

Options & Accessories

Description	Part Number
Contact Tip 11H-30 0.8mm (.030 in.)	1110-1201
Contact Tip 11H-35 0.9 mm (.035 in.)	1110-1202
Contact Tip 11H-40 1.0 mm (.040 in.)	1110-1203
Contact Tip 11H-45 1.2 mm (.045 in.)	1110-1204
Contact Tip AL 11AH-364 1.2 mm (.047 in.)	1110-1213
Nozzle HD22-50	1220-1306
Diffuser HD52-11	1520-1130
Drive Roll V-shape for 0.8 mm (.030 in.)	1140-1134
Drive Roll V-shape for 0.9 mm (.035 in.)	1140-1135
Drive Roll V-shape for 1.0 mm (.040 in.)	1140-1136
Drive Roll V-shape for 1.2 mm (.045 in.)	1140-1137
Drive Roll U-shape for 0.8 mm (.030 in.)	1140-1130
Drive Roll U-shape for 0.9 mm (.035 in.)	1140-1131
Drive Roll U-shape for 1.0 mm (.040 in.)	1140-1132
Drive Roll U-shape for 1.2 mm (.047 in.)	1140-1133
Knurled drive roll kit, all sizes	1140-1138



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