

## ST-23A

- Designed for use with Migmaster 250, MultiMaster 260, also for 353cv, 350mpi, SVI-450i, 453cv Multipower 460, 653cvcc with MIG-28A control package.
- Weighs less than 3 lbs.
- Uses durable contact tips and nozzles
- Powerful gear motor in handle pulls welding wire from 4 in. diameter spool in the molded gun case
- Partial depression of the torch trigger controls gas pre- and post-flow operations - full depression provides wire feeding as well as gas flow
- Wire feed control mounted on gun provides precise adjustment of wire feed rate at torch

## ST-23A Spool Gun

- Rugged 250 amp, 100% duty cycle performance
- Service lines enter the rear of gun instead of handle for improved balance and accessibility
- Inching pushbutton mounted on bottom of handle
- 30 ft. service lines

## Mig-28A Packages

- Super convenient - includes Mig-28A control and spool-on-gun type torch
- Use for short arc or spray arc welding with CV power source or for spray arc welding with CC power source
- Select type of welding power by simply flipping the selector switch

## Ordering Information

<b>Mig-28A, ST-23A Package</b> - Includes Mig-28-A control, spool gun, three 3/64 in. contact tips, drive roll, liner, control cable, gas hose and #10 nozzle and 30 ft. service lines .....	19163
<b>Mig-28A Control</b> .....	2075159
<b>ST-23A Spool Gun</b> - Includes one 3/64 in. contact tip, drive roll, liner, control cable, gas hose and #10 nozzle and 30 ft. service lines .....	19164
<b>Control Cable</b> - 6 ft. for ESAB CV Power Sources.....	36618
<b>Control Cable</b> - 6 ft. for non-ESAB Power Sources .....	996736
<b>Secondary Contactor Kit</b> - 300 Amp. ....	677333
<b>Secondary Contactor Control Cable</b> - 1.5 ft.....	677389
<b>Anti-Stick (Burnback) Kit</b> .....	2075076



## Options & Accessories

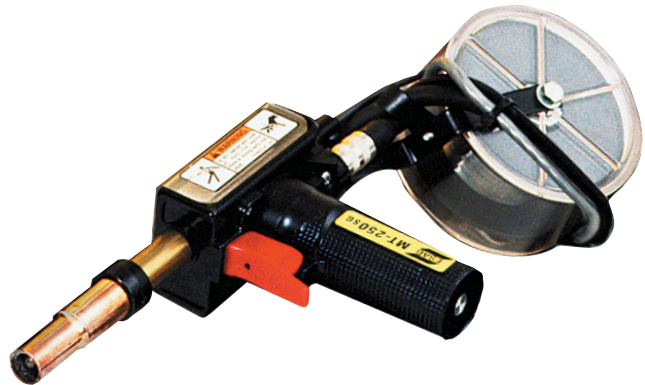
<b>Zippered Hose Sheath</b> - 25 ft. for gun service line protection.....	35454
<b>ST-23A Control Cable Extension</b> - Extends the spool gun control cable by 30 ft. (9.1 m) .....	636968
<b>ST-23A Power Cable &amp; Gas Hose Extension</b> - Includes coupling 11N19 for extending 30 ft. (9.1 m) .....	15626
<b>ST-23A to MultiMaster 260 Adaptor</b> - This would also fit MigMaster 203 and 253's .....	37301
<b>ST-23 Feed Roll</b> - .030-.035 in. (.8-.9 mm).....	636343
<b>Torch Liner</b> - .030-.035 in. (.8-.9 mm) .....	19166
<b>ST-23 Feed Roll</b> - .045-.062 in. (1.2-1.6 mm) .....	*996112
<b>Torch Liner</b> - .045-.062 in. (1.2-1.6 mm).....	*19167
<b>Contact Tips</b> - .....	see Table 1, page 4-69
<b>Nozzles</b> - .....	see Table 2, page 4-69
* - As delivered.	

## Instruction Manuals

<b>ST-23A</b> .....	F-14-353
<b>Mig-28A</b> .....	F-12-728
<b>Mig-28A Secondary Contactor Kit</b> .....	F-12-825
<b>Sales Literature</b> .....	(12-01-2006) ARC-23066

## MT-250 SG Spool Gun

- Designed for use with the Migmaster 250, Migmaster 203, Migmaster 253, MultiMaster 260, and also for 353cv, 350mpi, SVI-450i, 453cv Multi-power 460, 653cvcc with MIG-28A control package.
- Weighs less than 3 lbs.
- Uses durable MT contact tips and nozzles
- Powerful gear motor in handle pulls welding wire from 4 in. diameter spool in the molded gun case
- Partial depression of the torch trigger controls gas pre- and post-flow operations - full depression provides wire feeding as well as gas flow
- Wire feed control mounted on gun provides precise adjustment of wire feed rate at torch



## MT-250 SG

- Medium-duty 200 amp, 100% duty performance
- Spool holder adjusts to balance in the operator's hand
- 25 ft. service lines

## Ordering Information

<b>Mig-28A, MT-250SG Package</b> - Includes Mig-28A control, spool gun, three 3/64 in. contact tips, drive roll, liner, control cable, gas hose and #10 nozzle and 25 ft. service lines. ....	37707
<b>MT-250 SG Spool Gun</b> - Includes three 3/64 in. contact tips, drive roll, liner, control cable, gas hose and #10 nozzle and 25 ft. service lines .....	36779
<b>Control Cable</b> - 6 ft. for ESAB CV Power Sources.....	36618

<b>Control Cable</b> - 6 ft. for non-ESAB Power Sources.....	996736
<b>Secondary Contactor Kit</b> - 300 Amp. ....	677333
<b>Secondary Contactor Control Cable</b> - 1.5 ft.....	677389
<b>Anti-Stick (Burnback) Kit</b> .....	2075076

## Options & Accessories

<b>MT-250 SG</b>	
<b>Zippered Hose Sheath</b> - 25 ft. for gun service line protection.....	35454
<b>Gun Extension Lines</b>	
Gas Hose Assembly, 25 ft. ....	34V38
Coupling, Gas Hose (5/8 in. - 18 in.) .....	11N17
Quick Connector, Male #2 - 1/0 .....	13733936
Quick Connector, Female #2 - 1/0.....	13735632
Gas Meter (measures gas flow at the gun) .....	19043
<b>Feed Roll</b> - .030-3/64 in. Soft wire (.8-1.2 mm).....	*36866
<b>Feed Roll Knurled</b> - .030-.045 in. Hard wire (.8-1.2 mm).....	36867
<b>Inlet Guide Liner</b> - .030-3/64 in. (.8-1.2 mm) Gray.....	36869
<b>Barrel Liner</b> - .030-3/64 in. (.8-1.2 mm) White.....	36871
<b>Contact Tips</b> - .....	see Table 1, page 4-69
<b>Nozzles</b> - .....	see Table 2, page 4-69

<b>Instruction Manuals</b>	
MT-250SG.....	F-15-380
Mig 28A .....	F-12-728
<b>Sales Literature</b> .....	(12-01-2006) ARC-23211



## MIG Spool Gun Accessories

### ST-23A, MT-250SG Spool Guns

**Table 1. Contact Tips**

Wire Size	Inside Diameter	Contact Tips			
		Short	*Standard Duty Medium	Long	**Heavy Duty Medium
.023 in. (0.6mm)	0.031	–	20543	999742	–
.030 in. (0.8mm)	0.037	–	20544	996994	0558002367
.030 in. (Notched)	0.043	–	36884	–	–
.035 in. (0.9mm)	0.043	–	996995	996996	0558002368
.035 in. (Notched)	0.048	–	36885	–	–
.040 in. (1.0mm)	0.048	–	37287	37288	0558002369
.045 in. (1.2mm)	0.054	999578	37290	996998	37286
3/64 in. (Notched)	0.060	–	36886 <sup>(b)</sup>	–	–
3/64 in. (1.2mm)	0.058	–	996999 <sup>(a)</sup>	–	17765

\*Requires Tip Adapter 17983    \*\*Requires Tip Adapter 17984

(a) Included with ST-23A

(b) Included with MT-250SG

**Table 2. Nozzles**

Size	Inside Diameter	Standard Duty	Heavy Duty	Super Duty
No. 6	3/8 in. (10mm)	998895	–	–
No. 8	1/2 in. (13mm)	998893	–	–
No. 8 HD	1/2 in. (13mm)	–	999471	–
No. 10	5/8 in. (16mm)	998894	–	–
No. 10 HD	5/8 in. (16mm)	–	999472**	–
No. 12 HD	3/4 in. (20mm)	–	999473	17350
No. 12 Spot	3/4 in. (20mm)	17316*	999625	–

\* Requires 17293 Tip Adapter and 17321 Adapter

\*\* Included with ST-23A and MT-250SG