Syncrowave® 250 DX/350 LX

TIG/Stick Welding
Power Source

Quick Specs

Light Industrial Applications
- Precision Metal Fabrication
- Maintenance and Repair
- Light and Heavy Manufacturing
- Aerospace
- Shipbuilding
- Tube and Pipe
- Automotive
- Vocational

Processes
- TIG (GTAW)
- Stick (SMAW)
- Pulsed TIG (GTAW-P) (Optional on 250 DX models)
- Air Carbon Arc (CAC-A)

Amperage Range
- 250: 3 – 310
- 350: 3 – 400

Max. Open-Circuit Voltage
- 80 VDC

Rated Output
- 250: 250 A at 30 VAC, 40% Duty Cycle
- 200 A at 28 VAC, 60% Duty Cycle
- 350: 350 A at 34 VAC, 40% Duty Cycle
- 300 A at 32 VAC, 60% Duty Cycle

Net Weight
- Standard: 250: 378 lb. (172 kg)
- 350: 496 lb. (225 kg)
- TIGRunner®: 250: 478 lb. (217 kg)
- 350: 596 lb. (270 kg)

Input Power
- 1-Phase Power

AC balance control provides adjustable oxide removal which is essential for creating the highest quality aluminum welds.

Syncro Start™ allows the choice of Soft, Medium or Hot TIG starts based on the tungsten size and application.

Digital welding meters display both amperage and voltage for viewing of the actual and preset values for greater accuracy and repeatability in your welding procedure.

High frequency for non-contact arc initiation that reduces tungsten and material contamination.

Last procedure recall simplifies changing your Syncrowave back and forth from aluminum TIG to stainless TIG to Stick welding. One switch makes all the control panel changes.

Syncrowave Complete Package comes complete with:
- Syncrowave® power source
- Coolmate™ 3CS cooler
- No. 37 running gear
- TIG torch kit with accessories
- Remote foot control
- Four gallons of coolant

Power source is warranted for 3 years, parts and labor. Original main power rectifier parts are warranted for 5 years.

See Page 2 for Additional Features

Standard Machine

Syncrowave® 250D X / 350LX
TIG/Stick Welding
Power Source

Miller Electric Mfg. Co.
An ITW Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

MillerWelds.com
**Additional Features**

**Pulse.** Pulsing can increase puddle agitation, arc stability and travel speeds while reducing heat input and distortion (optional on 250 DX model).

**TIGRunner™ system packages with Coolmate™ 3CS cooler.** A three-gallon cooling system equipped with a visual flow indicator ensures that the coolant is flowing. An external coolant filter stops foreign objects from entering the water-cooled torch cable for better flow and longer life. Extended cooling capacity ensures maximum productivity. Three-year cooler warranty.

**Hot Start™** adaptive control provides positive arc starts without sticking.

**Tilted operator interface** provides added convenience to your welding experience.

**Arc timer/cycle counter** records actual welding time and number of arc starts. Great for estimating job costs.

**Squarewave technology.** Developed by Miller in 1976 to improve your weld quality and make TIG welding easier. Provides arc stability when welding aluminum, prevents arc rectification and eliminates tungsten erosion.

**Welding aluminum?** Oxides that form on aluminum melt at temperatures over 3700 degrees Fahrenheit. The aluminum material that is located under this layer of oxide melts at 1200 degrees Fahrenheit. The Syncrowave’s **AC Squarewave welding current** automatically removes the layer of oxide which is necessary for producing high quality welds.

**Do you have power fluctuations?** The Syncrowave compensates for power fluctuation without changing your welding parameters. **Line voltage compensation** works on fluctuating power ±10 percent.

**Easy load dual cylinder rack** (see photo at right) minimizes cylinder lifting. Cylinder is not included.

### AC Output: Balance Control

**AC Balance**

**Balanced Wave Function**

- **Balanced Wave**
  - 50% Electrode Positive
  - 50% Electrode Negative

- **More Heat into Work**
  - 32% Electrode Positive
  - 68% Electrode Negative

- **Greatest Cleaning Action**
  - 55% Electrode Positive
  - 45% Electrode Negative
## Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Welding Amperage Range</th>
<th>Rated Output</th>
<th>Amps Input at AC Balance, Rated Load</th>
<th>Max. OCV</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
</table>
| Syncro 250       | 1-phase, 60 Hz | 3–310 A                | 250 A at 30 V, 40% duty cycle | 110 — 96 — — 48 — 38 22 12 | 80 V     | H: 33.25 in. (845 mm)*  
|                  |             |                        | 225 A at 29 V, 40% duty cycle | 101 — 88 — — 44 — 35 20 10 |           | W: 22.5 in. (572 mm)  
|                  |             |                        |              |                                      |          | D: 25 in. (635 mm)**       |
|                  | 1-phase, 50 Hz | 3–310 A                | 250 A at 30 V, 40% duty cycle | 110 — 96 — — 48 — 38 22 12 | 80 V     | H: 46 in. (1168 mm)*  
|                  |             |                        | 225 A at 29 V, 40% duty cycle | 101 — 88 — — 44 — 35 20 10 |           | W: 28.5 in. (724 mm)  
|                  |             |                        |              |                                      |          | D: 40.5 in. (1029 mm)**       |
| Syncro 350       | 1-phase, 50 or 60 Hz | 3–400 A                | 250 A at 30 V, 40% duty cycle | 146 120 128 66 60 65 51 50 30 14 | 80 V     | H: 33.25 in. (845 mm)*  
|                  |             |                        | 350 A at 34 V, 40% duty cycle | 146 120 128 66 60 65 51 50 30 14 |           | W: 22.5 in. (572 mm)  
|                  |             |                        |              |                                      |          | D: 25 in. (635 mm)**       |
| Syncro 250 IEC   | 1-phase, 50 or 60 Hz | 3–310 A                | 250 A at 30 V, 40% duty cycle | 110 — 96 — — 48 — 38 22 12 | 80 V     | H: 33.25 in. (845 mm)*  
|                  | 220/400/440/520 |                        | 250 A at 30 V, 40% duty cycle | 110 — 96 — — 48 — 38 22 12 |           | W: 22.5 in. (572 mm)  
|                  |             |                        |              |                                      |          | D: 25 in. (635 mm)**       |

**Notes:** See page 6 for Power Factor Correction Kit.

*Add 3 inches (76 mm) for lift eye.  **Add 1.5 inches (38 mm) for handle.

IEC models conform to the following standards: IEC 60974-1: 2005, IEC 60974-10: 2004, and EN 50445

*Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

## Performance Data

### DUTY CYCLE CHART

![Duty Cycle Chart](image)

**Syncrowave 350 LX**

**Syncrowave 250 DX**
1. Voltmeter Display
2. Start Mode Control  
   (Lift-Arc™, HF Start, HF Continuous)
3. Output Control
4. Amperage Control (Panel/Remote)
5. Process Control (Stick/TIG)
6. Balance/Dig Control (0–10)
7. Postflow Time Control (0–50 seconds)
8. Ammeter Display
9. Pulser Control*
10. Background Amps Control (0–100%)*
11. Pulse-Per-Second Control (0.25–10 Hz)*
12. Peak Time Control (5–95%)*
13. Spot Time Control (0–5 seconds)**
14. Final Slope Control (0–25 seconds)**
15. Initial Time Control (0–15 seconds)**
16. Final Amperage Control (0–100%)**
17. Initial Amperage Control (0–100%)**
18. Amperage Adjustment Control (3–310/400 A)
19. Output Selector Switch (AC/DC+/DC+)
20. Power Switch (On/Off)

*Optional Pulser for 250 DX
**Optional Sequencer
Syncrowave® 250 DX and 350 LX Models/Packages

Syncrowave Power Sources

Syncrowave 250 DX
#907 194 (200/230/460 VAC)
#907 195 (230/460/575 VAC)
#907 516 (220/400/440/520 VAC) IEC

Syncrowave 350 LX
#907 198 (200/230/460 VAC)
#907 199 (230/460/575 VAC)
#907 517 (220/400/440/520 VAC) IEC

TIG torch connector sold separately. Power cord NOT included.

TIGRunner® Packages

Syncrowave 250 DX TIGRunner 3CS
#907 194 032 (200/230/460 VAC)
#907 195 032 (230/460/575 VAC)

Syncrowave 350 LX TIGRunner 3CS
#907 198 032 (200/230/460 VAC)
#907 199 032 (230/460/575 VAC)

Completely assembled. TIGRunner includes Syncrowave power source, Coolmate™ 3CS cooler, No. 37 running gear, and RFCS-14 HD remote foot control.

TIG torch connector, Dinse-style connector and TIG coolant sold separately. Power cord NOT included.

Complete Packages

Syncrowave 250 DX Complete
#951 117 (200/230/460 VAC)
#951 118 (230/460/575 VAC)

Syncrowave 350 LX Complete W-375
#951 622 (200/230/460 VAC)
#951 623 (230/460/575 VAC)

Completely assembled. Includes TIGRunner above (Syncrowave, Coolmate™ 3CS cooler, No. 37 running gear, and RFCS-14 HD remote foot control), plus four gallons of TIG coolant and a water-cooled torch kit (see kits at left) consisting of TIG torch, cable cover, accessory kit, flowmeter regulator, gas hose, torch connector, and work clamp with cable and Dinse-style connector.

Power cord NOT included.

TIG Coolant

W-250 (WP-20) Torch Kit for Syncrowave 250 DX TIGRunner

W-375 Torch Kit for Syncrowave 350 LX TIGRunner
Genuine Miller® Options

Field Options

Sequencer Module
#300 547 Field. For Syncrowave 250/350 Effective with serial number LE282983. Provides a starting current higher or lower than the welding current. Provides final slope and final current for trailing the weld. Provides a spot timer for TIG spot application.

Pulser Module
#300 548 Field. For Syncrowave 250 DX Effective with serial number LE282983. For welding of thin materials. Provides a heating and cooling effect of the weld puddle to reduce heat input and control distortion of the material. Provides 0.25 to 10 pulses per second.

Power Factor Correction Kit
#194 692 Field. For Syncrowave 250 DX
#043 757 Field. For Syncrowave 350 LX Reduces primary amperage draw by approximately 25 percent allowing the use of smaller breakers/fuses and smaller power cord. Kit does NOT reduce the power consumption/electrical bill.

Genuine Miller® Accessories

No. 37 Running Gear #195 282 Includes two 10-inch (254 mm) wheels, two 5-inch (127 mm) casters, two-compartment rack (for gas cylinder(s), and handles. Provides excellent mobility and easy to install.

Protective Cover #195 320 Heavy-duty, water- and mildew-resistant. Protects and maintains the finish of the welder.

Remote Controls and Switches

Wireless Remote Foot Control #300 429 For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

RCCS-14 Remote Contactor and Current Control #043 688 North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Great for applications that require a finer amperage control. Includes 26.5-foot (8 m) cord and 14-pin plug.

RMS-14 On/Off Control #187 208 Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control #151 086 East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Great for production or contractors that need quick ramp-up. Includes 26.5-foot (8 m) cord and 14-pin plug.

RMLS-14 Switch #129 337 Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.

RFCS-14 HD Foot Control #194 744 Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.

RHC-14 Hand Control #242 211 020 Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 83 mm). Includes 20-foot (6 m) cord and 14-pin plug.

Coolant Systems

For more information, see the Miller Coolant Systems literature sheet, Index No. AY/7.2.

Coolmate™ 3X #300 419 Includes easy-load dual cylinder rack, running gear, handles and 3CS industrial water cooler—a perfect solution for water-cooled TIG torches.

Low-Conductivity TIG Coolant #043 810 Sold in multiples of four in one-gallon recyclable plastic bottles. Miller coolants contains a base of ethylene glycol and deionized water to protect against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C).

Coolant Systems

Extension Cables for 14-Pin Remote Controls
#242 208 025 25 ft. (7.6 m)
#242 208 050 50 ft. (15.2 m)
#242 208 080 80 ft. (24.4 m)
Genuine Miller™ Accessories (continued)

TIG (GTAW) Torch Connectors

Water-Cooled TIG Torch Connector #195 377
50-mm Dinse-style with water return line. For use with all Weldcraft™ water-cooled torches.

Air-Cooled TIG Torch Connector #195 379
Used to adapt a Weldcraft™ A-200 (WP-26) torch to a Dinse-style connector.

Educational Materials

To order, please call Miller Literature at 866-931-9732 or visit MillerWelds.com/resources/tools.

Gas Tungsten Arc Welding (TIG) Publication #250 833

TIG Training DVD #196 567
Designed for anyone who’s looking to better understand the TIG process. Easy to understand instruction, proven teaching steps, and expert advice help to create a more effective academic approach to training. Subject areas covered include system components, process fundamentals, electrical theory, safety, power source operation.

Video – GTAW Setup Procedures #108 241
A detailed demonstration on preparing your equipment for TIG welding. Uses a Syncrowave 250 power source, but topics fit any TIG setup including air- or water-cooled systems. In-depth discussion of tungstens and gases. 13:00 minutes.

TIG Welding Gloves

Performance TIG Gloves #263 345  X-Small (Women’s)
#263 346  Small (Women’s)
#263 347  Medium
#263 348  Large
#263 349  X-Large
Completely unlined, goat grain leather with triple-padded palm.

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#263 348  Large
#263 349  X-Large
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Water-Cooled Torch Kits

W-250 (WP-20) Torch Kit #300 185
Recommended for Syncrowave 250 DX
- Weldcraft™ W-250 (WP-20) 25-foot (7.6 m) TIG torch with Dinse-style connector
- Torch cable cover
- Work clamp with 15-foot (4.6 m) 1/0 cable and Dinse-style connector
- Flowmeter regulator
- Gas hose (regulator to machine)
- AK4C torch accessory kit includes nozzles, collets, collet bodies and 2% ceriated tungsten electrodes (1/16, 3/32 and 1/8 inch)

W-375 Torch Kit #301 268
Recommended for Syncrowave 350 LX
- Weldcraft™ W-375 25-foot (7.6 m) TIG torch with Dinse-style connector
- Torch cable cover
- Work clamp with 15-foot (4.6 m) 1/0 cable and Dinse-style connector
- Flowmeter regulator
- Gas hose (regulator to machine)
- AK4C torch accessory kit includes nozzles, collets, collet bodies and 2% ceriated tungsten electrodes (1/16, 3/32 and 1/8 inch)

W-400 (WP-18SC) Torch Kit #300 186
Weldcraft™ W-400 (WP-18SC) 25-foot (7.6 m) TIG torch with thread lock connector
- Torch cable cover
- Work clamp with 12-foot (3.7 m) 4/0 cable with thread lock connector
- Flowmeter regulator
- Gas hose (regulator to machine)
- AK18C torch accessory kit includes nozzles, collets, collet bodies and 2% ceriated tungsten electrodes (3/32, 1/8 and 5/32 inch)
Note: Requires Water-Cooled TIG Torch Connector #195 377 (sold separately) for Syncrowave 250 DX and 350 LX.

Tungsten

<table>
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<th>Tungsten</th>
<th>Amp Range</th>
<th>2% Ceriated (AC/DC)</th>
<th>2% Lanthanated (AC/DC)</th>
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<td>70 – 150 A</td>
<td>WC116X7</td>
<td>WL2116X7</td>
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<td>3/32 in. (2.4 mm)</td>
<td>140 – 250 A</td>
<td>WC332X7</td>
<td>WL2332X7</td>
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<td>1/8 in. (3.2 mm)</td>
<td>225 – 400 A</td>
<td>WC018X7</td>
<td>WL2018X7</td>
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<td>5/32 in. (4.0 mm)</td>
<td>300 – 500 A</td>
<td>WC532X7</td>
<td>WL2532X7</td>
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<td>Syncrowave® 250 DX</td>
<td>#907 194</td>
<td>200/230/460 V, 50/60 Hz, Standard Model</td>
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<td>#043 757</td>
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<td>TIG Torch Kits and Connectors</td>
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<td>Water-Cooled Torch Kits</td>
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<td>W-250 (WP-20) (recommended for Syncrowave 250 DX)</td>
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<tr>
<td>Water-Cooled TIG Torch Connector</td>
<td>#195 377</td>
<td>Connects Weldcraft™ water-cooled torches to Dinse-style connector</td>
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<td>Air-Cooled TIG Torch Connector</td>
<td>#195 379</td>
<td>Connects Weldcraft™ A-200 (WP-26) torch to Dinse-style connector</td>
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<td>Tungsten</td>
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<td>See page 7</td>
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<td>Remote Controls</td>
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<tr>
<td>Wireless Remote Foot Control</td>
<td>#300 429</td>
<td>Foot control with wireless 90-ft. (27.4 m) operating range</td>
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<td>Hand control with wireless 300-ft. (91.4 m) operating range</td>
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<td>RCCS-14</td>
<td>#043 688</td>
<td>North/south fingertip control</td>
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<td>RCC-14</td>
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<td>RFCS-14 HD</td>
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<td>RHC-14</td>
<td>#242 211 020</td>
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<td>RMLS-14</td>
<td>#129 337</td>
<td>Momentary/maintained rocker switch</td>
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<td>RMS-14</td>
<td>#187 208</td>
<td>Momentary rubber dome switch</td>
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<td>Extension Cables</td>
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<td>No. 37 Running Gear</td>
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<td>Protective Cover</td>
<td>#195 320</td>
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<tr>
<td>Coolmate™ 3X</td>
<td>#300 419</td>
<td>Coolmate 3CS with cart and dual cylinder rack</td>
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<tr>
<td>TIG Coolant (Must be ordered in quantities of four)</td>
<td>#043 810</td>
<td>1-gallon plastic bottle. Protects against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C)</td>
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<tr>
<td>Cable Connectors</td>
<td></td>
<td>Supplied with power source and torch kits</td>
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<tr>
<td>Dinse-Style Connector 50 mm (1 male)</td>
<td>#042 418</td>
<td>Used to connect weld lead to Dinse terminal machine</td>
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<tr>
<td>Dinse-Style Connector 50 mm (1 male, 1 female)</td>
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<td>Video – GTAW Setup Procedures</td>
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<td>TIG Welding Gloves</td>
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Date: Total Quoted Price: