

# Pipeworx 400

## Bernard® PipeWorx Guns Features



As the preferred hand-held MIG gun and consumable manufacturer of Miller, Bernard is proud to provide its durable and innovative products for use with Miller® wire feeders and machines. Each Bernard product is versatile, dependable and built with the goal in mind of improving your welding productivity and performance.

The Bernard PipeWorx gun with a tapered tip and nozzle is recommended for root pass welding, especially in fixed-position applications where visibility is difficult. Switch to a standard tip and nozzle for fill and cap pass welding with flux-cored or pulsed MIG welding processes. This allows one gas and one wire to make the weld.

<b>Versatility</b>	Can be used for MIG, pulsed MIG, and flux-cored.
<b>Ergonomics</b>	Compact, lightweight gun with high-amperage capability reduces operator fatigue improving productivity.
<b>Visibility</b>	The combination of tapered tips and nozzles and 60-degree neck provides excellent visibility on root passes in pipe joints.
<b>Centerfire™ Tip</b>	Provides “drop-in” tip with no threads providing quick changeover. No tools are required.

### Specifications (Subject to change without notice.)

Bernard Model	100% Duty Cycle NEMA	100% Duty Cycle CE	60% Duty Cycle CE	35% Duty Cycle CE	Gas Type	Cable Length	Net Weight
PipeWorx 250-15 195399 (root pass only)	300 A	250 A	300 A	365 A	100% CO <sub>2</sub>	15 ft. (4.6 m)	9 lb. (4.1 kg)
	—	210 A	250 A	300 A	80% argon/20% CO <sub>2</sub>		
PipeWorx 300-15 195400	350 A	320 A	370 A	470 A	CO <sub>2</sub> gas	15 ft. (4.6 m)	10 lb. (4.6 kg)
	—	270 A	310 A	390 A	80% argon/20% CO <sub>2</sub>		

### Key Gun Consumables

Description	Part Number	Package Quantity
.035 in. tapered tip	TT-035 <sup>1</sup>	10
.040 in. tapered tip	TT-039	10
.045 in. tapered tip	TT-045	10
.035 in. tip	T-035	10
.040 in. tip	T-039	10
.045 in. tip	T-045 <sup>2</sup>	10
.052 in. tip	T-052	10
1/16 in. tip	T-062	10
.035–.045 in. liner	43115 <sup>1,2</sup>	1
.045–.062 in. liner	44215	1

<sup>1</sup>Standard part on PipeWorx 250-15.

<sup>2</sup>Standard part on PipeWorx 300-15.

Description	Part Number	Package Quantity
Nozzle 5/8 in. ID	NS-5818C <sup>2</sup>	10
Nozzle 5/8 in. ID	N-5818C	10
Nozzle 1/2 in. ID	NS-1218C	10
Nozzle 3/4 in. ID	N-3418C	10
Nozzle 3/8 in. ID tapered tip	NT-3800C	10
Nozzle 3/8 in. ID tapered tip	NST-3800B	10
Nozzle 3/8 in. ID extended tapered tip	NST-38XTB <sup>1</sup>	10
Diffuser	D-1	10
Diffuser	DS-1 <sup>1,2</sup>	10
Q tube assembly 60°	QT2-60 <sup>1,2</sup>	1
Q tube assembly 80°	QT2-80	1
O-ring	4929	10





## Weldcraft™ TIG Torches



Complete your PipeWorx Welding System with a Weldcraft TIG torch. These torches use high-quality, durable components combined with innovative designs to ensure long, trouble-free performance, better productivity and lower costs.

Stock No.	Model	Connector
WP1725RM	Air-cooled (one cable) 150 amp	105Z57
WP2625RM	Air-cooled (one cable) 200 amp	45V62
WP1825RM	Water-cooled (one cable) 350 amp	45V11
WP2025RM	Water-cooled (one cable) 250 amp	45V11
<b>Cable Cover: WC-3-22</b>		

# Ordering Information (Most popular model ←. Select a power source, wire feeder and cable package for complete system.)

PipeWorx Package	Stock No.	Description	Qty.	Price
<b>PipeWorx Welding System</b> <i>(Does not include input power cable, input gas hoses, gas flowmeter regulators, work cable and clamp, stick electrode holder and cable, TIG torch and cable, TIG remotes)</i>	<b>951381</b> ← <b>951382</b>	230/460 V, 3-phase, 50/60 Hz, air-cooled 575 V, 3-phase, 50/60 Hz, air-cooled Systems include power source (with side-mount cable hangers), running gear and handles (300368), dual feeder (300366), cable kit with 25 ft. (7.6 m) work sense lead (300367) and two PipeWorx 300-15 guns (195400)		
<b>PipeWorx Accessories Kit for Dual Feeder</b>	<b>300568</b>	Includes 25 ft. (7.6 m) work cable, EG500 work clamp, two flowmeter regulators and two 4 ft. (1.2 m) gas hoses		
<b>To Configure a Custom PipeWorx System — see page 6 for typical system configurations</b>				
<b>1 Select a Power Source</b> 	<b>PipeWorx 400 Power Source</b>	<b>907382</b> 230/460 V, 3-phase, 50/60 Hz. Includes side-mount cable hangers <b>907384</b> 575 V, 3-phase, 50/60 Hz. Includes side-mount cable hangers <b>907475</b> 400 V, 3-phase, 50/60 Hz. Includes side-mount cable hangers <i>Includes one blank memory card (301080) and short gas hose for connecting output gas connection on power source to TIG block. Does not include an input power cable</i>		
<b>2 Select a Feeder</b> 	Dual-Wire Bench-Style Feeder	<b>300366</b> Includes .035/.045 in. combination smooth V-drive rolls (for solid wire), .045 in. knurled V-drive rolls (for flux-cored wire), and Y-hose for single gas input		
<b>3 Select a Cable Kit</b>  See page 3	Cable Kit <i>(For feeder used on power source)</i>	<b>300367</b> 5 ft. (1.5 m) feeder control cable, weld cable and 25 ft. (7.6 m) work sense lead		
	Composite Cable Kit <i>(For remote feeder applications)</i>	<b>300454</b> 25 ft. (7.6 m) composite cable with feeder control cable, gas hose and weld cable in protective sheath and 25 ft. work sense lead		
		<b>300456</b> 50 ft. (15.2 m) composite cable with feeder control cable, gas hose and weld cable in protective sheath and 50 ft. work sense lead		
<b>4 Select a MIG Gun</b>  See page 7	Bernard® PipeWorx 250-15 Gun <i>(Recommended for root pass only)</i>	<b>195399</b> 15 ft. (4.6 m), 250 A air-cooled MIG gun		
	Bernard® PipeWorx 300-15 Gun <i>(Included in pkgs)</i>	<b>195400</b> 15 ft. (4.6 m), 300 A air-cooled MIG gun		
<b>System Options</b>				
PipeWorx Running Gear	<b>300368</b>	See page 2/3. For power source. Includes gas cylinder rack and handles		
PipeWorx Cooler <i>(Coolant sold separately)</i>	<b>300370</b>	See page 6. For MIG or TIG welding		
Coolant	<b>043810</b>	One gallon of low-conductivity coolant. Must be ordered in multiples of four (one case)		
Feeder Cart	<b>300467</b>	See page 3. For remote feeder applications. Includes cable hangers and consumables drawer		
<b>Accessories</b>				
Spool Covers for 12 in. (305 mm) spool		See page 3		
Reel Covers for 60 lb. (27 kg) coil		See page 3		
Wire Reel Assembly	<b>108008</b>	For 60 lb. (27 kg) coil		
DSS-9 Dual Schedule Switch	<b>071833</b>	See page 3. Used to change weld parameters during welding		
PipeWorx Remote Feeder Interface w/Gun Triggers and Cable	<b>300597</b>	For mechanized systems		
Wire Feeder Consumables		See page 6 for drive rolls, inlet guides and intermediate guides		
Weldcraft™ TIG Torches		See page 7		
RFCS-14 HD Remote Control	<b>194744</b>	See page 2/3. Heavy-duty foot current/contacter control		
Foot Control Bracket	<b>300676</b>	Used to hold RFCS-14 HD remote foot control		
RPBS-14 On-Off Switch Remote	<b>300666</b>	See page 3. TIG welding remote		
Wireless Remote Foot Control	<b>300429</b>	See page 3. Wireless foot current/contacter control		
PipeWorx Memory Cards		See page 3		
Flowmeter Regulator <i>(Gas hose sold separately)</i>	<b>194738</b>			
Gas Hose	<b>144108</b>	5 ft. (1.5 m)		
Work Sense Lead <i>(Volt sense)</i>	<b>300461</b>	25 ft. (7.6 m)		
	<b>300462</b>	50 ft. (15.2 m)		

Date:

Total Quoted Price:

Distributed by:

