

Dura-Flux™

350 Amp Self-Shielded FCAW Guns

Issued August 2007 • Index No. SPEC DF-1.2

350 Amp Dura-Flux™ gun shown with Centerfire™ contact tip, sleeved 6 inch neck with 60° bend and trigger guard.



Built for welders using self-shielded flux-cored wire, Dura-Flux guns are designed for exceptional performance and comfort in the most demanding industrial environments.

All Guns are Not Created Equal.

A welding gun should be durable, easy to use and customized to your specific application. Our guns put you in control: you choose the options you need and we'll build a gun to last. We even ship most of our guns within 24 hours.

Centerfire™ contact tips are easy-to-use and high performing - they provide better arc starts, less spatter and more consistent welds - and also last up to three times longer than competitive brands.

Sleeved and aluminum armored necks available in multiple length options for optimal weld accessibility and improved operator comfort.

Trigger is sealed from outside contaminants, simply replaced and absorbs less heat than a metal trigger for long-life, greater arc-on time and lower heat output.

Trigger guard instead of full size heat shield allows access to tight spaces while protecting trigger from damage.

Ultra heavy-duty steel monocoil power cables are highly resistant to kinking for exceptional wire feed in abusive environments.

Back end with durable rigid strain relief and easily interchangeable direct plugs and trigger leads connect to wire feeders and machines from major manufacturers and allow simple maintenance.

Power pin liner changes quickly without set screw for user-friendly maintenance and reduced downtime.

Dura Flux™ Gun Part Numbers - 350 Amp				
Part Number	Cable Length	Neck	Direct Plug	Duty Cycle
FLX3510AM	10' (3.05 m)	6" (15.2 cm) x 60°	Miller	60% NEMA at 350 Amps
FLX3515AM	15' (4.57 m)	6" (15.2 cm) x 60°	Miller	
FLX3510DM	10' (3.05 m)	12" (30.5 cm) x 30°	Miller	
FLX3515DM	15' (4.57 m)	12" (30.5 cm) x 30°	Miller	
FLX3510AL	10' (3.05 m)	6" (15.2 cm) x 60°	Lincoln	
FLX3515AL	15' (4.57 m)	6" (15.2 cm) x 60°	Lincoln	
FLX3510DL	10' (3.05 m)	12" (30.5 cm) x 30°	Lincoln	
FLX3515DL	15' (4.57 m)	12" (30.5 cm) x 30°	Lincoln	

All guns listed above are compatible with 1/16" - 3/32" (1.6 mm - 2.4 mm) wire.

Made with
Pride and without
Compromise in the **USA**

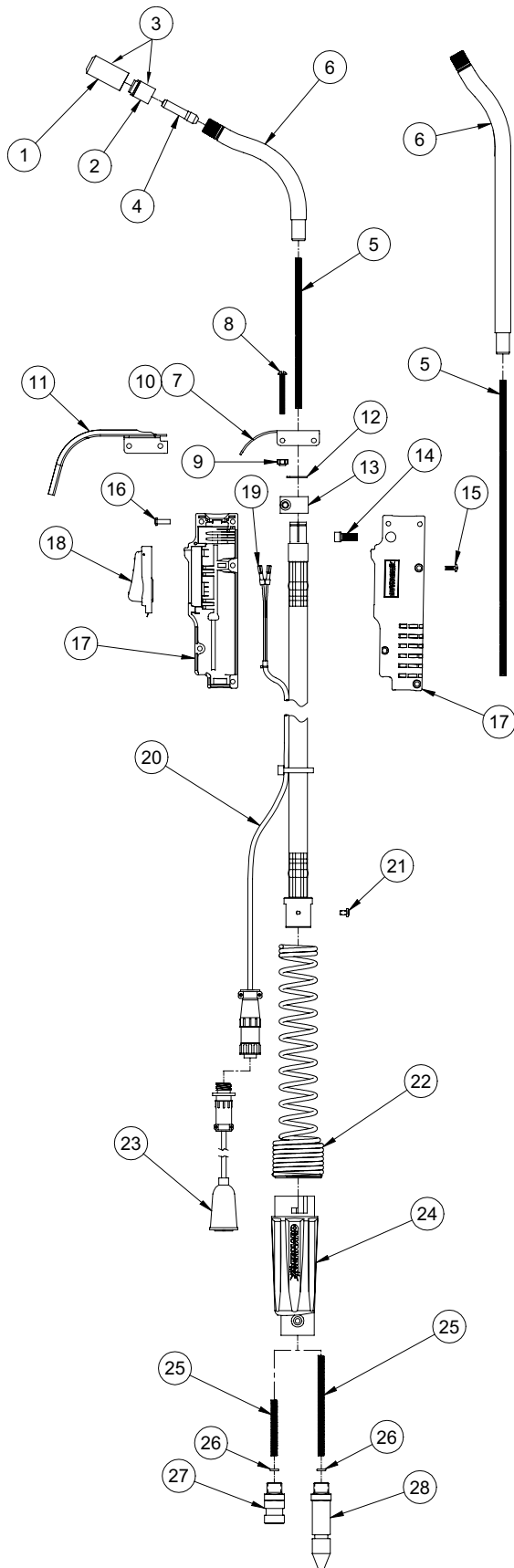
Bernard®

An Illinois Tool Works Company
449 West Corning Road, Box 667
Beecher, Illinois 60401 USA

Phone: 800-946-2281 (US Only) 708-946-2281 (Outside US)
Fax: 708-946-6726
For more information, visit us at BernardWelds.com



Replacement Parts List



ITEM #	PART #	DESCRIPTION
1	7010024	Insulator, Tip
2	7010026	Tip Holder, Slip-On
3	1880229	Tip Holder Kit (Includes: (1) #1, (1) #2)
4	T-062	Centerfire Contact Tip, 1/16" (1.6 mm)
	T-072	Centerfire Contact Tip, .072" (1.8 mm) (Included w/Gun)
	T-078	Centerfire Contact Tip, 5/64" (2.0 mm) (Included w/Gun)
	T-094	Centerfire Contact Tip, 3/32" (2.4 mm) (Included w/Gun)
5	7010031	Neck Liner, 6" (15.2 cm)
	7010032	Neck, Liner, 12" (30.5 cm)
6	Neck Replacement Kit (Includes: (1) #6, (1) #5)	
	1880232	Sleeved, 6" (15.2 cm) x 30°
	1880222	Sleeved, 6" (15.2 cm) x 60° (Pictured)
	1880230	Sleeved, 8" (20.3 cm) x 90°
	1880223	Sleeved, 12" (30.5 cm) x 30° (Pictured)
	1880231	Sleeved, 12" (30.5 cm) x 60°
	1880236	Aluminum Armored, 6" (15.2 cm) x 30°
	1880233	Aluminum Armored, 6" (15.2 cm) x 60°
	1880235	Aluminum Armored, 8" (20.3 cm) x 90°
1880234	Aluminum Armored, 12" (30.5 cm) x 30°	
1880237	Aluminum Armored, 12" (30.5 cm) x 60°	
7	7010034	Trigger Guard
8	2280047	Screw, #8-32 x 1-1/2 (2 Req'd)
9	2030030	Nut, #8-32 (2 Req'd)
10	1880224	Trigger Guard Kit (Includes: (1) #7, (2) #8, (2) #9)
11	1760002	Heat Shield (Optional)
12	2250017	Snap Ring
13	198820	Clamp
14	2280046	Screw, 1/4-20, Hex Socket
15	4209	Handle Screw (3 Req'd)
16	2030004	Post Fastener (3 Req'd)
17	1880225	Handle Kit (Includes: Handle Halves, (3) #16, (3) #15)
18	5662	Switch Assy, Trigger
19	2660001	Terminal, Quick Disconnect (2 Req'd)
20	7010018	Cord Assembly, 10' (3.05 m)
	7010015	Cord Assembly, 15' (4.57 m)
21	W11127-002	Screw, Strain Relief
22	2520056	Spring, Strain Relief
23	SCL1N	Trigger Cord Adapter (Lincoln Only)
24	2520047	Rigid Strain Relief
25	7010035	Liner, Power Pin, Miller
	7010036	Liner, Power Pin, Lincoln
26	2040017	O-Ring
27	1880227	Lincoln Power Pin Kit (Includes: Lincoln Power Pin, (1) #23, (1) #25, (1) #26)
28	1880226	Miller Power Pin Kit (Includes: Miller Power Pin, (1) #25, (1) #26)