

TWECO®



FABRICATOR® 141i

Multi Process Welding System

3^{IN}

MIG • STICK • TIG

Fabricator® 141i

Part No. W1003141

Comes Complete with:

- Fabricator 141i Power Supply
- 10 ft Tweco Fusion™ 140 Amp MIG Gun
- Bonus Contact Tips (1 each):
 - .023 (0.6 mm)
 - .030 (0.8 mm) Installed
 - .035 (0.9 mm)
- Victor® Argon Flowgauge Regulator & 12.5 ft (3.8 m) Hose
- Electrode Holder with 13 ft (4 m) Lead
- Ground Clamp with 10 ft (3 m) Lead
- Drive Rolls:
 - .023" / .030" (0.6 mm / 0.8 mm) V Groove (Installed)
 - .030" / .035" (0.8 mm / 0.9 mm) for Flux Cored Wire
- 4 General Purpose Stick Electrodes (E6013)
- Operator's Manual & CD
- 10 ft (3 m) Power Cord and NEMA 5-20P 115V AC Plug
- Power adapter - 115V, 20A to 15A
- Shoulder Strap



QUICK SPECIFICATIONS

PROCESSES

MIG (GMAW)
Flux Cored (FCAW)
Lift TIG (GTAW)
STICK (SMAW)

APPLICATIONS

Home Hobbyists (DIY)
Automotive Repair & Customization
Farms & Ranches
Maintenance & Repair
Sheet Metal & Light Fabrication
On-site & Portable Welding Applications

RATED OUTPUT

140A / 19V @ 15% Duty Cycle
90A / 18.5V @ 20% Duty Cycle

MAX. OPEN CIRCUIT VOLTAGE

53V DC

AMPERAGE RANGE

10 - 140 Amps

WIRE FEED SPEED

90 - 400 IPM (2.3 - 10.2 m/min)

WEIGHT

32.2 lbs (14.6 kg)

ORDER INFORMATION

Part No: W1003141

Description: Fabricator 141i Package

Part No: W1003142

Description: Fabricator 141i Package w/Cart

Three Process Capability:

MIG (GMAW/FCAW), **STICK** (SMAW), **TIG** (GTAW).

MIG

- **Infinite Voltage Control** for precise voltage settings.
- **Inductance Control** for arc stability and spatter control.
- **Tweco Fusion MIG Gun** w/10 ft cable and industry standard #4 connection.
- **Durable Metal Feed Plate** features 2 roll drive system, quick change reversible drive rolls and easy-to-set single scaled wire tension knob.
- **4" or 8" Spool Capacity** allows easy installation of wire spool sizes.
- **Spool Gun** ready.
- **Adjustable Burnback Control.**

STICK

- **Adjustable Arc Force Control** for optimum STICK electrode performance.
- Built in **Hot Start** for easy arc starting.

TIG

- **Lift TIG Start:** Provides TIG arc starting without use of high frequency.
- **Downslope:** Eliminates the crater that can form at the completion of a weld.

Other Features:

- **Digital Meters:** Voltage and Amperage; Preview and Hold capability.
- **Excellent Portability:** Lightweight, less than 33 lbs includes shoulder strap.
- **Comprehensive Setup Chart:** Weld set up guide for optimum welding performance over a wide range of materials and shielding gases.
- **Trigger Control:** 4T (Latch) eliminates operator fatigue.
- **Remote Receptacle:** Enables connection of remote control devices and Spool Gun.
- **Quick Change Polarity:** Simple quick change polarity (no tools required) from the front of the power source.
- **Overload Protection:** Shuts down the power source to protect the internal electrical components from overheating.
- **IP23S:** Suitable for outdoor use.
- **Intelligent Fan Control:** Operates when welding commences to cool components & reduce airborne contaminants pulled through the power source.



U.S. Customer Care: 800-426-1888
Canada Customer Care: 905-827-4515
International Customer Care: 940-381-1212



CONTROL PANEL

Digital Meters WFS / Amps and Volt Meters

WFS / Amps Control Knob

Voltage / Arc Force Control / Down Slope Control Knob



Process Button Select MIG, STICK or Lift TIG

Trigger 2T (ON/OFF) or 4T (Trigger Hold) selection

Inductance Control Knob

SYSTEM FEATURES

Local/Remote Switch

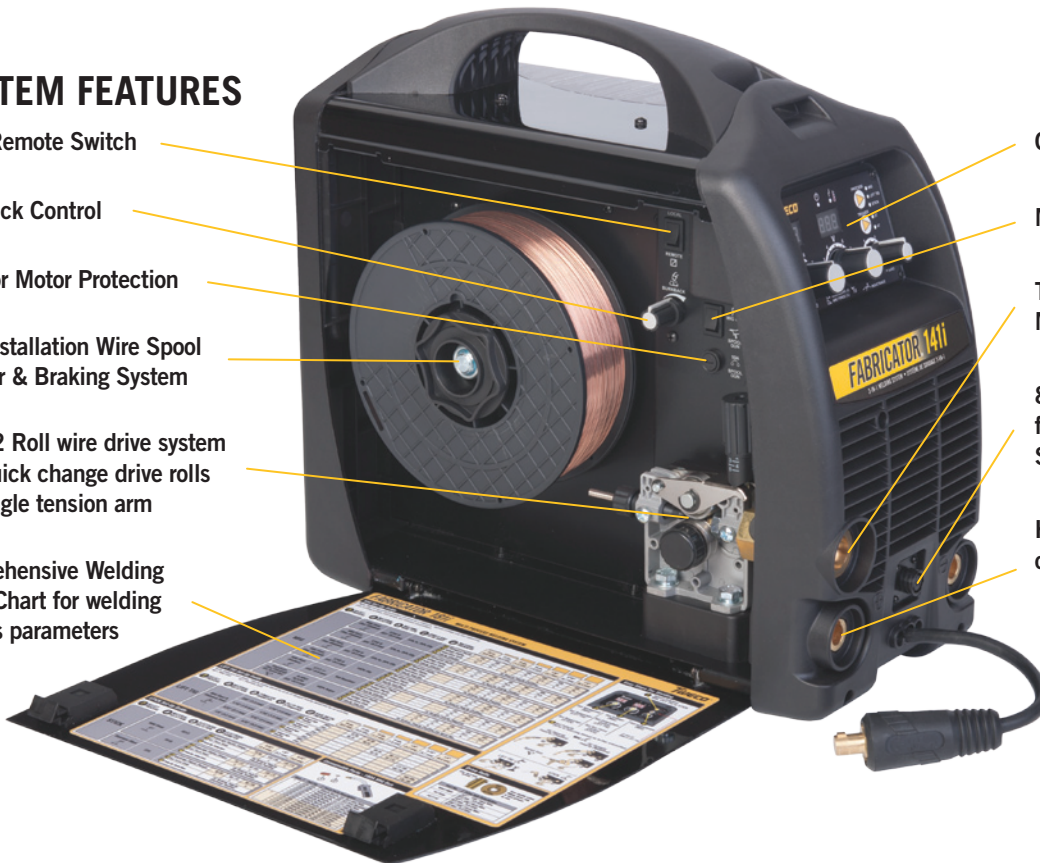
Burnback Control

Fuse for Motor Protection

Easy installation Wire Spool Adaptor & Braking System

Metal 2 Roll wire drive system with quick change drive rolls and single tension arm

Comprehensive Welding Setup Chart for welding process parameters



Control Panel (Refer Above)

MIG Gun/Spool Gun Switch

Tweco® Style MIG Gun Connection

8 pin Remote Receptacle for remote devices & Spool Gun

Heavy Duty Welding output terminals with polarity reversal capability

SPECIFICATIONS

WELDING DC	
Maximum Output	140 Amp
MIG (GMAW/FCAW) Welding Output @104°F (40°C)	140A / 19V @ 15% Duty Cycle 90A / 18.5V @ 20% Duty Cycle
STICK (SMAW) Welding Output @104°F (40°C)	90A / 23V @ 15% Duty Cycle 80A / 23.2V @ 35% Duty Cycle
TIG (GTAW) Welding Output @104°F (40°C)	140A / 15.6V @ 15% Duty Cycle 100A / 14V @ 20% Duty Cycle
Current Range	10A - 140 Amp
MIG Welding Voltage Range	14.5V - 19V
Wirefeed Speed Range	90 - 400 IPM (2.3 - 10.2 m/min)
Nominal OCV Volt/DC	53V
Maximum Plate Thickness	3/16" (4.8 mm)
Wire Diameter Range	
Solid:	.023" - .030" (0.6 - 0.8 mm)
Stainless Steel:	.023" - .030" (0.6 - 0.8 mm)
Flux cored:	.030" - .035" (0.8 - 0.9 mm)
Spool Size Capacity	4" & 8" (100 & 200 mm)
Power Source Dimensions (HxWxD)	16.2" x 8.3" x 17.7" (410 mm x 210 mm x 450 mm)
Power Source Weight	32.2 lb (14.6 kg)
Warranty Period	3 Years*
Approvals	IEC 60974-1, CSA E60974-1, UL 60974-1
Protection Class	IP23S









PRIMARY POWER	
Primary Voltage	115 VAC
Supply Voltage Range	95 - 140 VAC
Number of Phases	Single Phase
Supply Frequency	50/60Hz
Supply Plug	NEMA 5-20P
Rated kVA @ 140 Amps	5 kVA
Lead Cord Length	10 ft (3 m)
REPLACEMENT ITEMS & CONSUMABLES	
Tweco Fusion™ 140 Amp MIG Gun, 10 ft	1017-1321
Velocity™ Nozzle 1/2" Bore	1220-1200
Universal Conduit Liner	1420-1113
Velocity Contact Tip, .023"	1110-1308
Velocity Contact Tip, .030"	1110-1309
Velocity Contact Tip, .035"	1110-1310
Electrode Holder w/ Lead, 13 ft, 25 mm Dinse	W7003106
Ground Clamp w/ Lead, 10 ft, 25 mm Dinse	W7003105
Victor® Argon Flowgauge Regulator	0781-9411
Gas Hose, 12.5 ft, Male 5/8-18UNF	W4013900
Power Adapter - 115V, 20A to 15A	W4013300
Dinse Adapter, 50 mm to 25 mm	W4017500

* Limited Warranty, refer to warranty schedule.



Comes Complete with:

- 1 Fabricator® 141i Power Supply
- 2 Victor Argon Flowgauge Regulator & 12.5 ft (3.8 m) Hose
- 3 Electrode Holder with 13 ft (4 m) Lead
- 4 Bonus Contact Tips (1 each):
 .023 (0.6 mm)
 .030 (0.8 mm) Installed
 .035 (0.9 mm)
- 5 Drive Rolls:
 .023" / .030" (0.6 mm / 0.8 mm)
 V Groove (Installed)
 .030" / .035" (0.8 mm / 0.9 mm) for Flux Cored Wire
- 6 10 ft Tweco Fusion 140 Amp MIG Gun
- 7 4 General Purpose Stick Electrodes (E6013)
- 8 Power Adapter - 115V, 20A to 15A
- 9 Ground Clamp with 10 ft (3 m) Lead
- 10 Shoulder Strap
- 11 Operator's Manual & CD
- 10 ft (3 m) Power Cord and NEMA 5-20P 115V AC Plug (*not shown*)

ORDERING INFORMATION		
Equipment Option	Part No.	Description
<i>Fabricator® 141i Package</i>	W1003141	Includes Fabricator 141i, Tweco Fusion™ 140 Amp MIG Gun, Victor® Argon Flowgauge Regulator & 12.5 ft (3.8 m) Hose, Electrode Holder & Ground Clamp, Drive Rolls & Contact Tips, Sample Electrodes, Shoulder Strap, Power Adapter and Operator's Manual & CD
<i>Fabricator 141i Package w/Cart</i>	W1003142	Includes contents of W1003141 with Utility Cart W4014700
ACCESSORIES		
TIG Torch & Accessories <i>(required for TIG welding)</i> 	W4013802	TIG Torch, 17V, 12.5 ft, 8 pin and accessory kit with 1/16", 3/32", 1/8" thoriated tungstens; 1/16", 3/32", 1/8" collets; 1/16", 3/32", 1/8" collet bodies; No. 5, 6, 7 Alumina nozzles; short back cap; long back cap
Spool Gun <i>(required for aluminum MIG welding)</i> 	1027-1390	Tweco Spool Gun 160A, 12 ft (3.6 m) Length, suits 4" (100 mm) spools
Basic Utility Cart 	W4014700	Utility Cart, accommodates maximum 7" diameter cylinder
Foot Control 	600285	Contacter On/Off and current control with 15 ft cable and 8-pin male plug
Helmet 	4100-1002	Tweco Helmet, New Eagle/Stars & Stripes
Helmet 	4100-1004	Tweco Helmet, New Skull & Fire
Helmet 	4100-1008	Tweco Helmet, New Dragon
Tweco Carry Bag 	W4015301	Protective Carry Bag & Parts Storage
DRIVE ROLLS		
Drive Roll .023" / .030" (0.6/0.8 mm)	7977036	V groove for steel & stainless steel wires (Installed)
Drive Roll .030" / .035" (0.8/0.9 mm)	7977731	U grooved for aluminum wires
Drive Roll .030" / .035" (0.8/0.9 mm)	7977732	V knurled groove for flux cored wires

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