

Big Blue® 400 and 500

Issued June 2012 • Index No. ED/10.8

**Diesel Engine-Driven
Welder/AC Generator**



Quick Specs

Heavy Industrial Applications

Heavy Construction
Structural Steel
Maintenance and Repair Rigs
Mining Maintenance
Process Piping
Sheet Metal

Processes

Stick (SMAW)
MIG (GMAW)
Flux-Cored (FCAW)
DC TIG (GTAW)
Submerged Arc (SAW)
Stud Welding
Air Carbon Arc (CAC-A)
400:
Rated: 5/16-inch (8 mm) carbons
Capable: 3/8-inch (9.5 mm) carbons
500:
Rated: 3/8-inch (9.5 mm) carbons

Output Range

400 CC: DC Stick 55–500 A DC/TIG 55–500 A
400 CC/CV: DC Stick 40–500 A DC/TIG 15–350 A
MIG/FCAW 14–40 V
500 CC: DC Stick 55–600 A DC/TIG 55–600 A
500 CC/CV: DC Stick 40–600 A DC/TIG 20–425 A
MIG/FCAW 14–40 V

Generator Output Rated at 104° F (40° C)

5500 Watts Peak—4000 Watts Continuous
400: 15,000 Watts 3-Phase/12,000 Watts 1-Phase*
500: 20,000 Watts 3-Phase/12,000 Watts 1-Phase*
**Deluxe models only.*

**Accu-Rated™—Not Inflated
Generator Power**

The Power of Blue.®

Engine gauges standard on all models indicate engine oil pressure and coolant temperature.

Designed for fleet owners that demand the ultimate in reliability and performance.

Enclosed robust case design protects internal components from impact and allows air flow to cool and prolong the life of the engine. Also reduces sound levels.

Quick and easy maintenance with single-side access to oil level check, oil fill, oil filter, fuel filter and air cleaner.

Remote toolless oil drain allows oil to be drained without getting under the engine and reduces the chance of oil spillage.



CC/CV Models: The Vault—ultimate control board reliability. See page 3.



BUILT TOUGH

Big Blue 500 CC/CV Deluxe Model shown.

TRUE BLUE
3YR. WARRANTY



Perkins

Heavy-duty low-speed industrial diesel engines are designed, built and proven to operate over 10,000 hours before the first basic overhaul.

Meter maintenance displays

- Fuel gauge
- Hour meter function
- Oil change interval
- High coolant temperature and low oil pressure shutdowns
- Low fuel shutdown—engine shuts down before system runs out of fuel, making restarts easy.

Hot Start™ provides positive Stick electrode starts making it easy to start all types of electrodes and it also works great for bead tie-ins.

Arc-Drive™ makes welding easy. Automatically enhances Stick welding, especially on pipe, by focusing the arc and preventing the electrode from going out.

Weatherproof Lexan® nameplate resists cracking and fading, and is color-coded for ease of operation.

GFCI receptacle as required on most jobsites to protect operators from electrical hazards.

CSA, IEC, and NEMA compliant for welders. Degree of protection provided by enclosure IP23.

Welder/generator is warranted by Miller for 3 years, parts and labor.
Engine is warranted separately by engine manufacturer.



Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

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Big Blue® 400 and 500 CC Specifications (Subject to change without notice.)

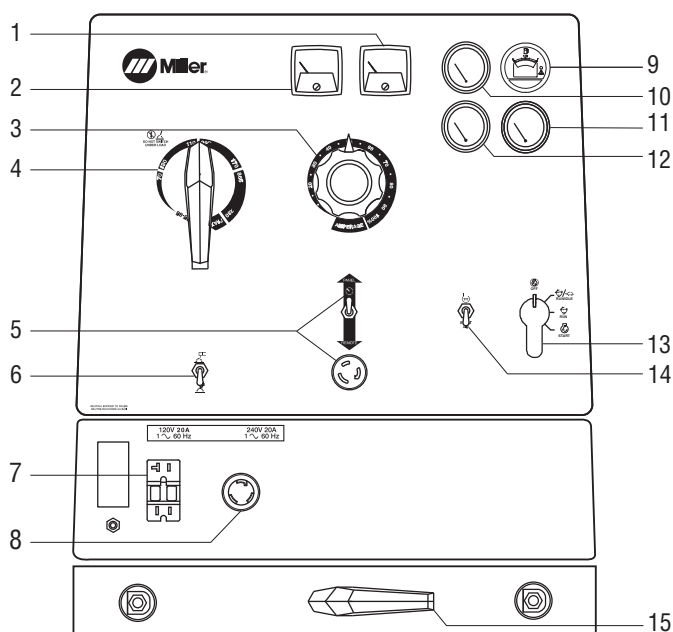


Model	Welding Mode/Process	Weld Output Range	Weld Output Rated at 104° F (40° C)	Max. Open-Circuit Voltage	Generator Power Output Rated at 104° F (40° C)	Dimensions**	Weight (without fuel)***
Big Blue 400 CC	CC/DC (Stick/TIG)	55–500 A	400 A at 36 V (14.4 kW),* 100% Duty Cycle 450 A at 38 V (17.1 kW),* 60% Duty Cycle 500 A at 30 V (15 kW), 40% Duty Cycle	95	Peak: 5500 watts Continuous: 4000 watts, 1-phase, 34/17 A, 120/240 VAC, 50/60 Hz while welding	H: 43 in. (1092 mm) W: 28.5 in. (724 mm) D: 65.125 in. (1654 mm)	Perkins: 1545 lb. (701 kg) Deutz: 1655 lb. (751 kg)
Big Blue 500 CC	CC/DC (Stick/TIG)	55–600 A	500 A at 40 V (20 kW),* 100% Duty Cycle 550 A at 34 V (18.7 kW), 60% Duty Cycle 600 A at 30 V (18 kW), 40% Duty Cycle				Deutz: 1695 lb. (769 kg)

*Meets NEMA and IEC ratings. **Additional 7 in. (178 mm) to top of exhaust. ***Additional 190 lb. (86 kg) when fuel tank is full.

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

Big Blue® 400 and 500 CC Control Panel



1. DC Ammeter*
2. DC Voltmeter*
3. Amperage Adjust Control
4. Amperage Range Switch
5. Amperage Adjust Switch and Remote Amperage Adjust Receptacle
6. Stick/TIG Selector Switch
7. 120V 20A, 20 A GFCI Duplex Receptacle
8. 240 VAC, 30 A TwistLock Receptacle (NEMA L6-30)
9. Fuel Gauge/Hour Meter/Oil Change Interval Engine Shutdown Indicator
10. Engine Oil Pressure Gauge
11. Battery/Voltmeter*
12. Engine Coolant Temperature Gauge
13. Engine Control Switch
14. Starting Aid Switch (standard on Perkins model)
15. Polarity Switch*

*Optional.

Additional Features

Proven, rugged rheostat control technology that has been in Miller engine drives for over 60 years. Contains no printed control boards.

A **Stick/TIG switch** optimizes open-circuit voltage for Stick welding and allows the open-circuit voltage to be lowered for scratch start TIG welding.

Provisions are provided to plug a **RHC3GD34A remote control** that will allow precise adjustment of amperage without walking back to the machine.

Big Blue® 400 and 500 CC/CV Specifications (Subject to change without notice.)

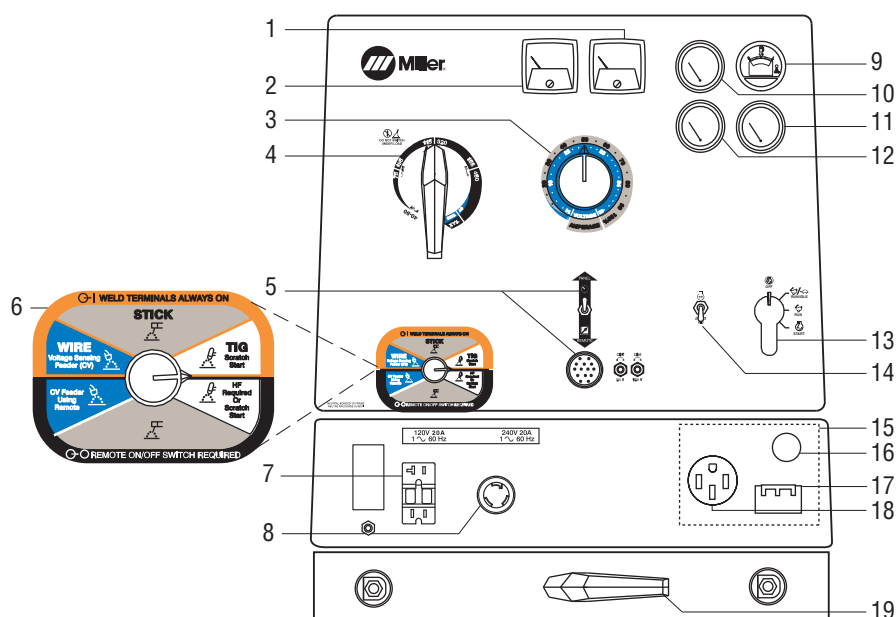


Model	Welding Mode/Process	Weld Output Range	Weld Output Rated at 104° F (40° C)	Max. Open-Circuit Voltage	Generator Output Rated at 104° F (40° C)	Dimensions**	Weight (without fuel)***
Big Blue 400 CC/CV	CC/DC (Stick/TIG)	15–500 A	400 A at 36 V (14.4 kW),* 100% Duty Cycle 450 A at 38 V (17.1 kW),* 60% Duty Cycle	95	Peak: 5500 watts Continuous: 4000 watts, 1-phase, 34/17 A, 120/240 VAC, 50/60 Hz while welding Additional Generator Power for Deluxe Models (while NOT welding) Big Blue 400: 3-phase: 15 kW, 36 A, 240 VAC or 1-phase: 12 kW, 50 A, 120/240 VAC Big Blue 500: 3-phase: 20 kW, 48 A, 240 VAC or 1-phase: 12 kW, 50 A, 120/240 VAC	H: 43 in. (1092 mm) W: 28.5 in. (724 mm) D: 65.125 in. (1654 mm)	Perkins: 1545 lb. (701 kg) Deutz: 1655 lb. (751 kg)
	CV/DC (MIG/FCAW)	14–40 V	500 A at 34 V (17 kW), 40% Duty Cycle				
Big Blue 500 CC/CV	CC/DC (Stick/TIG)	20–600 A	500 A at 40 V (20 kW),* 100% Duty Cycle 550 A at 42 V (23.1 kW), 60% Duty Cycle				Deutz: 1695 lb. (769 kg)
	CV/DC (MIG/FCAW)	14–40 V	600 A at 34 V (20.4 kW), 40% Duty Cycle				

*Meets NEMA and IEC ratings. **Additional 7 in. (178 mm) to top of exhaust. ***Additional 190 lb. (86 kg) when fuel tank is full.

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

Big Blue® 400 and 500 CC/CV Control Panel



1. DC Ammeter
2. DC Voltmeter
3. Amperage/Voltage Adjust Control
4. Amperage Range Switch
5. Amperage/Voltage Adjust Switch and Remote Amperage/Voltage Adjust Receptacle
6. Process/Contactor Selector Switch
7. 120 VAC, 20 A GFCI Duplex Receptacle
8. 240 VAC, 30 A TwistLock Receptacle (NEMA L6-30)
9. Fuel Gauge/Hour Meter/Oil Change Interval Engine Shutdown Indicator
10. Engine Oil Pressure Gauge
11. Battery/Voltmeter*
12. Engine Coolant Temperature Gauge
13. Engine Control Switch
14. Starting Aid Switch
15. 3-Phase Power Generator Option
16. Strain Relief
17. 50 A, 3-Phase Circuit Breaker
18. 50 A, 120/240 V Receptacle (NEMA 14-50)
19. Polarity Switch*

*Optional.

Additional Features

One MIG welding range allows precise voltage control for welding with .023–.120 inch (0.6–3.2 mm) wires.

A multi-colored **process selector control** allows quick and easy process changes without having to use multiple switches.

14-pin remote control allows precise adjustment of amperage or voltage, along with contactor control, without walking back to the machine.

The Vault — Superior Circuit Board Design

Our critical circuit boards are engineered to carry *low power* and *low heat* to reduce thermal stress and minimize expansion and contraction. In contrast, our competitor's

boards carry *high power* and *high heat*, making them more vulnerable to failure.

“The Vault” Makes Upgrading to Miller® CC/CV Units Worry-Free

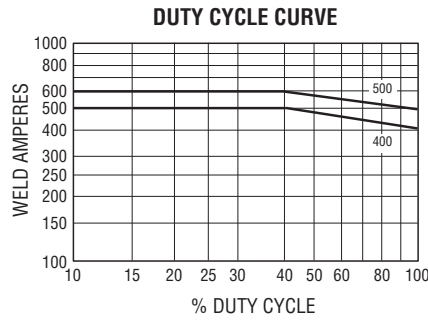
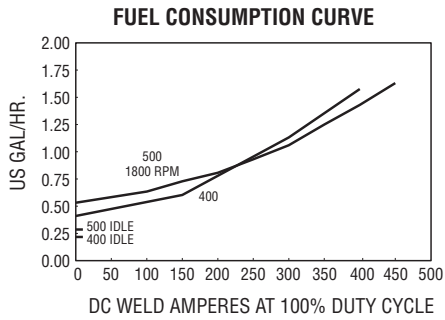
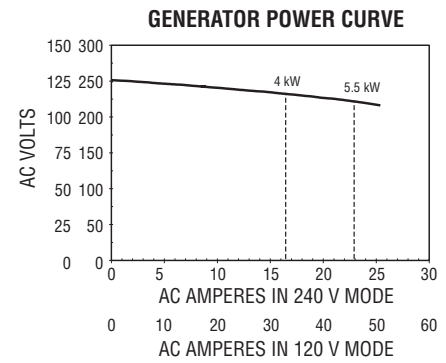
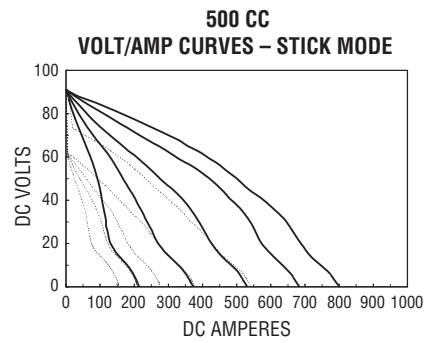
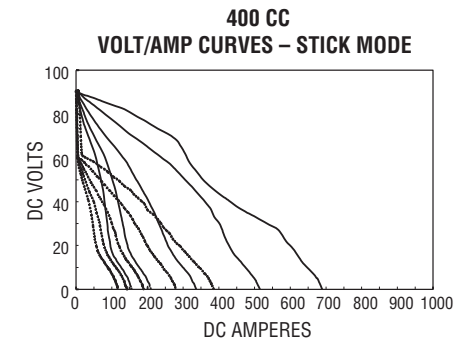
Concerns with circuit board reliability have resulted in some operators steering clear of CC/CV welder/generators — even though they offer a superior arc and multiple welding processes. Miller circuit board reliability isn't a concern since all Big Blue multiprocess industrial engine drives feature the Vault.

Created out of two aluminum halves sealed with silicone, as well as watertight harness connections, the Vault provides a clean circuit

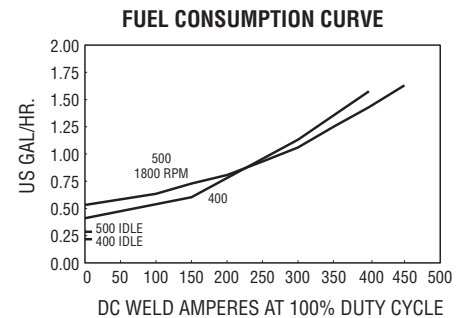
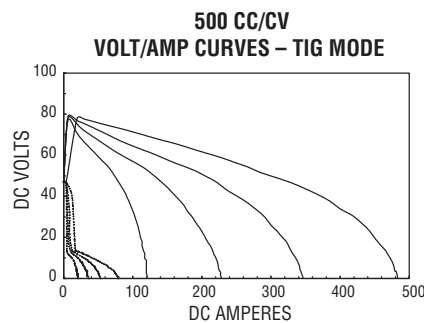
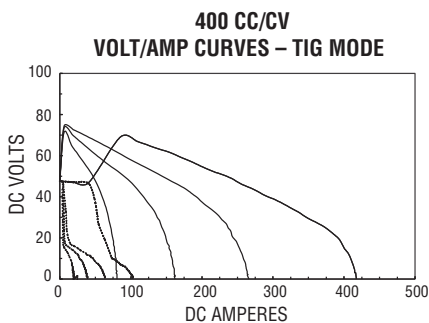
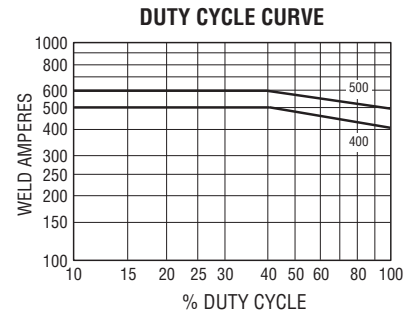
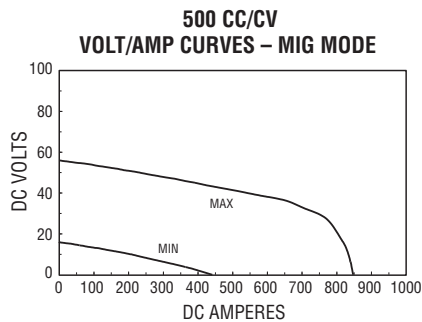
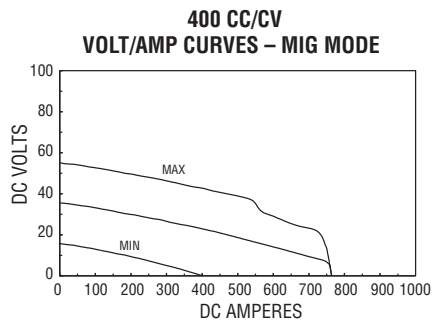
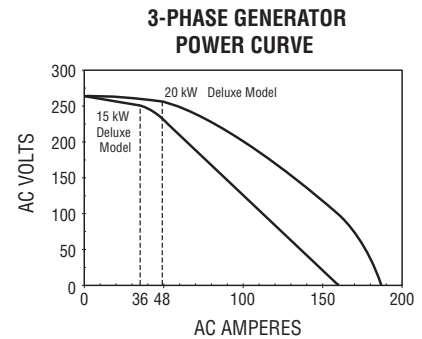
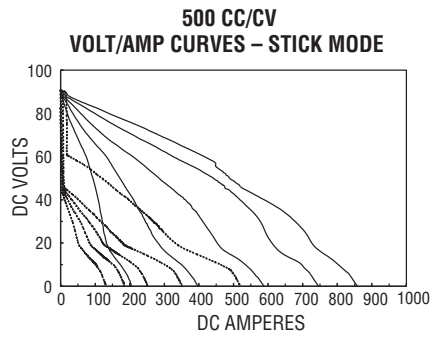
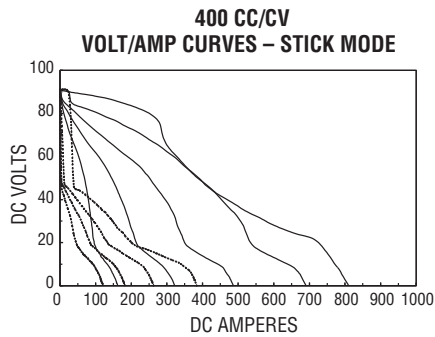


board environment, protecting the electronics — and controlling output — in heavy industrial applications. No other competitor protects their electronics with a sealed vault, leaving critical circuit boards exposed to harsh elements that can disrupt the machine's electronics, and therefore, its operation.

Big Blue® 400 and 500 CC Performance Data



Big Blue® 400 and 500 CC/CV Performance Data



Engine Specifications (Subject to change without notice.)

Model	Engine Brand	Features	HP	Type	Engine Speeds	Capacities	Automatic Engine Shutdowns
Big Blue 400	Perkins 404D.22	EPA Tier 4i compliant, indirect-injected, liquid-cooled engine with full load sound levels of 73.2 dB @ 7 m (98 Lwa) . Right-side service access with intervals of 500 hours for oil and filters .	32.6	4-cylinder, industrial, liquid-cooled diesel	Weld: 1850 RPM Idle: 1250 RPM*	Fuel: 25 gal. (95 L) Oil: 9 qt. (8.5 L) Coolant: 9 qt. (8.5 L)	Low Oil Pressure, High Coolant Temperature, Low Fuel Level
	Deutz D2011L03i	EPA Tier 4i compliant, direct-injected, air/oil-cooled engine with full load sound levels of 76.8 dB @ 7 m (101.7 Lwa) . Right-side service access with intervals of 1000 hours for oil and filters . Approved underground operation with the purchase of a MSHA (30 CFR part 7) certificate.	32.0	3-cylinder, industrial, air/oil-cooled diesel	Weld: 1850 RPM Idle: 1250 RPM*	Fuel: 25 gal. (95 L) Oil: 6.2 qt. (5.9 L) Coolant: Integrated oil	Low Oil Pressure, High Coolant Temperature, Low Fuel Level
Big Blue 500	Deutz D2011L04i	EPA Tier 4i compliant, direct-injected, air/oil-cooled engine with full load sound levels of 76 dB @ 7 m (101 Lwa) . Right-side service access with intervals of 1000 hours for oil and filters .	48.6	4-cylinder, industrial, air/oil-cooled diesel	Weld: 1850 RPM Idle: 1250 RPM*	Fuel: 25 gal. (95 L) Oil: 9 qt. (8.5 L) Coolant: Integrated oil	Low Oil Pressure, High Coolant Temperature, Low Fuel Level

*Optional on select models.

Genuine Miller® Options

Weld Ammeter and Voltmeter Kit

#195 131 Field

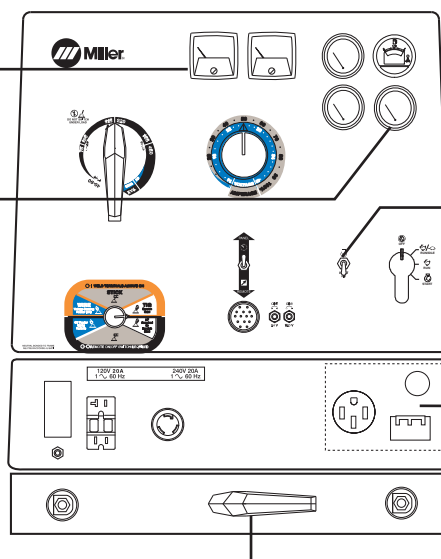
Panel-mounted analog meters monitor welding output.

Installation time: 35 minutes

Battery Voltmeter

#195 454 Field

Monitors battery charging circuit.



Cold Weather Starting Aid Kit

Note: Perkins 404D.22 models come standard with glow plugs.

#195 056 Field

Perkins. 120 V block heater.

#195 307 Field

Deutz D2011L03i/D2011L04i. 12 V intake manifold heater.

#195 086 Field

Deutz D2011L03i/D2011L04i. 120 V oil pan heater.

3-Phase Power Generator Factory (Deluxe CC/CV model only)

For Big Blue 400 CC/CV. 15,000 watts.
For Big Blue 500 CC/CV. 20,000 watts.

Adds three-phase, 240 V power to CC/CV units. 12 kW, 120/240 V single-phase power from a 50-amp receptacle. Optimum kW performance achieved while not welding. This option also includes a 50-amp on/off circuit breaker for both single- and three-phase power, and a strain relief for hard wiring into the unit.

Note: Available as factory option. See Ordering Information on back page.

For matching plug, order #119 172

Polarity Reversing Switch Kit

#043 942 Field

Changes DC polarity without the use of tools.

Installation time: 35 minutes

AC/DC Polarity Reversing Switch Kit

#195 095 Field

Select AC output or DC polarity without the use of tools.

Genuine Miller® Accessories



Full KVA Plug Kit #119 172 Field
1-phase, 120/240 VAC, 50 A plug
(NEMA 14-50P) to fit full KVA
receptacle.

Engine Filter Kit

#246 988 Field. For Deutz
#246 985 Field. For Perkins
Includes all filters required for proper
engine maintenance. Oil filter, primary and
secondary fuel filter, and primary air filter.



Spark Arrestor Muffler Kit

#195 012 Field
Prevents particles

from leaving the muffler that could
potentially start a fire. Mandatory when
operating on California grasslands, brush,
or forest-covered land, and in all National
Forests. For other areas, check your state
and local laws. Meets U.S. Forest Service
standard 5100-1B.



FA-1D Lockable Flame Arrestor

Fuel Cap #043 947 Field
Fuel cap can be padlocked to
prevent vandalism. A built-in
flame arrestor prevents flames or
sparks from entering the fuel tank.



Vandalism Lockout Kit

#195 118 Field
Lockable hinged steel
panels cover and protect
name plate gauges and
ignition switch (padlock
included). Also includes
engine compartment door
lock and key.



Cable Holder

#043 946 Field
Saddle-bag-style cable
holder. Convenient wrap-
around storage of coiled
cable for transportation.
Stores 100 feet of 2/0
cable on each side.

*Note: For best results do not weld when cable is coiled!
Protective cover cannot be used with cable holder.*



Protective Cover

#194 683 Field
Blue water-resistant
canvas cover resists
stains and mildew,
and protects the
finish of your welder.

Note: Protective cover cannot be used with cable holder.

Stick (SMAW) Welding

Weld Leads

**2/0 Stick Cable Set, 50 ft. (15 m)
#173 851**

Consists of 50-foot (15 m) 2/0 electrode
cable with holder, and 50-foot (15 m) work
cable with clamp. 350 A, 100% duty cycle.

**2/0 Stick Cable Set, 100/50 ft. (30.5/15 m)
#043 952**

Consists of 100-foot (30.5 m) 2/0 electrode
cable with holder, and 50-foot (15 m) work
cable with clamp. 300 A, 100% duty cycle.

MIG (GMAW) or Flux-Cored (FCAW)



**SuitCase® X-TREME™ 8VS Wire Feeder
#951 182**

**SuitCase® X-TREME™ 12VS Wire Feeder
#951 184**

Lightweight, voltage-sensing wire feeders
include secondary contactor, gas valve and
drive roll kit. See Lit. Index No. M/6.41.



SuitCase® 8RC Wire Feeder #951 186

SuitCase® 12RC Wire Feeder #951 188
Lightweight and flexible enough to run a
variety of wires up to .062-inch diameter.
Includes remote voltage control and drive
roll kit. See Lit. Index No. M/6.5.

MIG (GMAW)/Flux-Cored (FCAW) Guns

Miller produces a complete line of
dependable MIG guns. See Lit. Index Nos.
AY/15.0, AY/16.0 and AY/17.0.



**Spoolmatic® 30A
Spool Gun
#130 831**

Air-cooled, 200-amp,
1-pound spool gun
for aluminum MIG. See Lit. Index No. M/1.73.

WC-24 Control #137 549

Use with Spoolmatic 30A.

XR™ Wire Feeders and Guns

Push-pull system designed to handle
difficult-to-feed soft alloy wires such as
aluminum. See Lit. Index No. M/1.7,
M/1.71, and M/1.73.

TIG (GTAW) Welding



Dynasty® 200 Series
For premium portable
AC/DC TIG arc quality.
See Lit. Index No.
AD/4.8.



HF-251 Series

#042 388
HF-251D-1, 115 VAC
#042 387
HF-251D-2, 230 VAC
High-frequency arc
starter and stabilizer.

See Accessory Lit. Index No. AY/5.0.

Plasma Cutting



Spectrum 375 X-TREME and 625 X-TREME shown.

Spectrum® 375 X-TREME™ #907 529

See Lit. Index No. PC/9.2.

Spectrum® 625 X-TREME™ #907 531

See Lit. Index No. PC/9.6.

Spectrum® 875 #907 390-01-1

See Lit. Index No. PC/9.8.

The Spectrum 375 X-TREME and 625
X-TREME come complete with protective
X-CASE™ (not shown).

Genuine Miller® Accessories (Continued)

Remote Controls (CC models only)



RHC-3GD34A Remote Hand Control #041 122
Allows for precise adjustment of amperage. Includes 20-foot (6 m) cord.



Includes 20-foot (6 m) cord and 14-pin plug.

RFCS-14 HD Foot Control #194 744
Heavy-duty foot control for remote current, voltage and contactor control.



Side-to-side rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control #151 086



RCLS-14 #129 337
Fingertip momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and back for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.



Up-and-down rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 26.5-foot (8 m) cord 14-pin plug.

RCCS-14 Remote Contactor and Current Control #043 688

Remote Controls (CC/CV models)



RHC-14 Hand Control #242 211 020
Miniature hand control for remote current, voltage and contactor control.

Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 82 mm). Includes 20-foot (6 m) cord and 14-pin plug.

Extension Cables for 14-Pin Remote Controls or 24 VAC Wire Feeders
#242 208 025 25 ft. (7.6 m)
#242 208 050 50 ft. (15.2 m)
#242 208 080 80 ft. (24.4 m)

Trailers and Hitches (Note: Trailers are shipped unassembled.)



4 West Four-Wheel Steerable Off-Road Trailer #042 801
A heavy-duty 2570-pound (1166 kg) capacity trailer designed for use in mines, quarries, and other rough terrain. Has narrow 22-foot (6.7 m) turning radius. Includes 3-inch (76 mm) lunette eye, universal hitch and safety chains.



HWY-224 Trailer #043 805 For highway use.

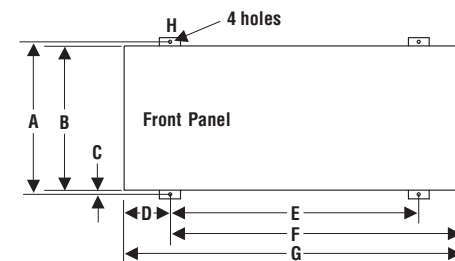
OFR-224 Trailer #043 802 For off-road use.
A 2650-pound (1202 kg) capacity trailer. Welded steel tubing frame, heavy-duty axle with roller bearing hubs and leaf-spring suspension. Includes jack stand and 2-inch (50 mm) ball hitch. *HWY-224 also includes fenders and lights.*

Cable Tree #043 826
Provides an area to conveniently wrap weld cables and extension cords.



Dual Hitch #300 831
2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye in one reversible assembly.

Mounting Specifications



A. 29.812 in. (757 mm)
B. 27.5 in. (699 mm)
C. 1 in. (25 mm)
D. 9.625 in. (244 mm)*
E. 46.5 in. (1181 mm)*
F. 56 in. (1422 mm)*
G. 65.125 in. (1654 mm)
H. .562 in. (14 mm) diameter

Height: 50 in. (1270 mm) (to top of exhaust)
Width: 28.5 in. (724 mm)
(mounting brackets turned in)
30.75 in. (781 mm)
(mounting brackets turned out)
Depth: 65.125 in. (1654 mm)

*With mounting brackets in center position.
Dimensions vary with location of mounting brackets.

Trailer Specifications (Subject to change without notice.)

Model	Gross Axle Weight Rating	Gross Vehicle Weight Rating	Net Payload	Height of Bed	Road Clearance	Track (Center to center of tires)	Standard Tires (Standard rating or P-size rating)	Dimensions	Net Weight
4 West	2000 lb./axle (907 kg/axle)	3000 lb. (1361 kg)	2570 lb. (1166 kg)	21.25 in. (540 mm)	8 in. (203 mm)	55.25 in. (1403 mm)	B78-13	Length: 91 in. (2311 mm)* Width: 61.25 in. (1556 mm)	430 lb. (195 kg)
HWY-224 OFR-224	3500 lb. (1588 kg)	2960 lb. (1343 kg)	2650 lb. (1202 kg)	18.5 in. (470 mm)	7.5 in. (191 mm)	52 in. (1321 mm)	B78-13	Length: 105 in. (2667 mm) Width: HWY-59.5 in. (1511 mm)** OFR-58.438 in. (1484 mm)	320 lb. (145 kg)

*Does not include tongue. **Width at outside of fenders.

Ordering Information

Equipment and Factory Options	Stock No.	Description	Qty.	Price
Big Blue® 400 CC	#907 173 #907 175	Deutz D2011L03i with Engine Gauges Perkins 404D.22 with Engine Gauges		
Big Blue® 400 CC/CV Deluxe Model	#907 327 #907 329	Deutz D2011L03i with Engine Gauges, Automatic Idle, Weld Meters and 15 kW Perkins 404D.22 with Engine Gauges, Automatic Idle, Weld Meters and 15 kW		
Big Blue® 500 CC	#907 181	Deutz D2011L04i with Engine Gauges		
Big Blue® 500 CC/CV Deluxe Model	#907 331	Deutz D2011L04i with Engine Gauges, Automatic Idle, Weld Meters and 20 kW		
Field Accessories				
Weld Ammeter and Voltmeter Kit	#195 131	For all models. Analog welding meters		
Battery Voltmeter	#195 454	For all models. Analog		
Polarity Reversing Switch Kit	#043 942 #195 095	For all models. DC polarity switch For all models. AC/DC polarity switch		
Cold Weather Starting Kit	#195 056 #195 307 #195 086	Perkins. 120 V block heater Deutz. 12 V intake manifold heater Deutz. 120 V oil pan heater		
Full KVA Plug Kit	#119 172	1-phase, 120/240 VAC, 50 A		
Engine Filter Kit	#246 988 #246 985	Deutz. Includes air, oil and fuel filters Perkins. Includes air, oil and fuel filters		
Spark Arrestor Muffler Kit	#195 012	For all models. Horizontal externally mounted		
Lockable Flame Arrestor Fuel Cap	#043 947	For all models. Padlock not included		
Vandalism Lockout Kit	#195 118	For all models. Lockable front control panel and engine compartment		
Cable Holder	#043 946	For all models. Stores up to 200 ft. of 2/0 weld cable		
Protective Cover	#194 683	For all models. Will not work with cable holder accessory		
Stick Welding Leads				
		See page 6		
MIG/Flux-Cored Welding				
SuitCase® X-TREME™ 8VS and 12VS	#951 182/#951 184	See Lit. Index No. M/6.41		
SuitCase® 8RC and 12RC	#951 186/#951 188	See Lit. Index No. M/6.5		
MIG (GMAW)/Flux-Cored (FCAW) Guns		See Lit. Index Nos. AY/15.0, AY/16.0 and AY/17.0		
Spoolmatic® 30A Spool Gun	#130 831	Requires WC-24 Control. See Lit. Index No. M/1.73		
WC-24 Control	#137 549	See Lit. Index No. M/1.5		
XR™ Wire Feeder Control and Guns		See Lit. Index No. M/1.7, M/1.71, and M/1.73		
TIG Welding				
Dynasty® 200 Series		See Lit. Index No. AD/4.8		
High-Frequency Arc Starters		See Lit. Index No. AY/5.0		
Plasma Cutting				
Spectrum® 375 X-TREME™	#907 529	Includes X-CASE™. See Lit. Index No. PC/9.2		
Spectrum® 625 X-TREME™	#907 531	Includes X-CASE™. See Lit. Index No. PC/9.6		
Spectrum® 875	#907 390-01-1	See Lit. Index No. PC/9.8		
Remote Controls				
	See page 7			
Trailers and Hitches				
4 West Four-Wheel Steerable Trailer	#042 801	Trailer with lunette eye, universal hitch and safety chains. For off-road use		
HWY-224 Trailer	#043 805	Trailer with lights, fenders and 2-in. (50 mm) ball hitch. For highway use		
OFR-224 Trailer	#043 802	Trailer with 2-in. (50 mm) ball hitch. For off-road use		
Cable Tree	#043 826	Trailer mounted cable holder for HWY-224 or OFR-224		
Dual Hitch	#300 831	Combination 2-in. (50 mm) ball hitch and 3-in. (76 mm) lunette eye in one reversible assembly. For HWY-224 or OFR-224		

Date:

Total Quoted Price:



Distributed by:

Miller[®] 350P

Issued September 2010 • Index No. DC/12.51

**MIG Arc Welding Power Source,
Wire Feeder and Gun Package**



Quick Specs

Industrial Applications

Fabrication
Maintenance and Repair
Farm
Manufacturing
Industrial

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
Flux Cored (FCAW)

Rated Output 300 A at 32 VDC, 60% Duty Cycle, 60 Hz, 1- or 3-Phase Input Power

Amperage Range 25–400 A

Wire Feed Speed 50–700 IPM (1.3–18 m/min) MIG Gun
50–800 IPM (1.3–20 m/min) Spool Gun/Push-Pull Gun

Weight 181 lb (82 kg)

The Power of Blue.[®]

Built-in Pulsed MIG programs

- .035 and .045 in (0.9 and 1.2 mm) for mild or stainless steel.
- .035 and .047 in (0.9 and 1.2 mm) for 4000 and 5000 series aluminum.
- .045 in (1.2 mm) for metal core.

All programmed information is stored for MIG, push-pull and spool guns, and is restored after each power up.

1- or 3-phase input power with **line voltage compensation** for constant output even with fluctuations to the input power.

Aluminum Pulse Hot Start[™]

automatically provides more arc power to eliminate a “cold start” that is inherent with aluminum starts.

Superior aluminum performance .

Direct connection for optional XR[™] push-pull guns or Spoolmatic[®] spool gun. With **Gun-On-Demand**, simply pull the trigger for the gun to be used and you're ready to weld.

Fan-On-Demand cooling only operates when needed, reducing power consumption and contaminants inside the unit.

Industrial, 4-roll wire drive system features two easy-to-set, scaled, tension adjustments and quick-change reversible drive rolls for .035 and .045 in (0.9 and 1.2 mm) wire.



Welds materials 22 gauge up to 1/2 in (12.7 mm) thick.



Power source is warranted for 3 years, parts and labor.
Original main power rectified parts are warranted for 5 years.
Gun warranted for 90 days, parts and labor.

Standard MIG System Comes Complete with:

- Bernard[®] Q300 15 ft (4.6 m) MIG gun with extra Centerfire[™] contact tips
- 10 ft (3 m) Industrial power cord (without plug) for single- or three-phase
- 10 ft (3 m) work cable with clamp
- Factory-installed gas solenoid
- Argon mix regulator/flow meter
- Factory-installed, low-mounted running gear/cylinder rack
- .035/.045 in (0.9/1.2 mm) reversible V-groove drive rolls (order U-groove drive roll kits for aluminum welding)
- Set-up and operation CD

Special features

- Run-in adjustment for MIG, push-pull and spool guns.
- Built-in 2-minute spot timer.
- Pre-flow and post-flow adjustment.
- View actual welding amperage/voltage during welding, and 5 seconds after arc has shutoff.
- SharpArc[™] controls welding arc cone width in pulsed MIG welding mode.
- Inductance control customizes weld output characteristics in MIG welding mode.

Internal timers

- **Adjustable crater** feature optimizes crater size for steel, stainless, aluminum and metal-core applications.
- **Crater time delay** allows deactivation of crater feature for tack or small welds.

Compatible with the Miller[®] Reach Wire Feeder. MIG Gun sold separately. (See pg. 3 for more information.)



Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

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Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

Web Site
www.MillerWelds.com



MADE IN USA
APPLETON, WI

Specifications (Subject to change without notice.)

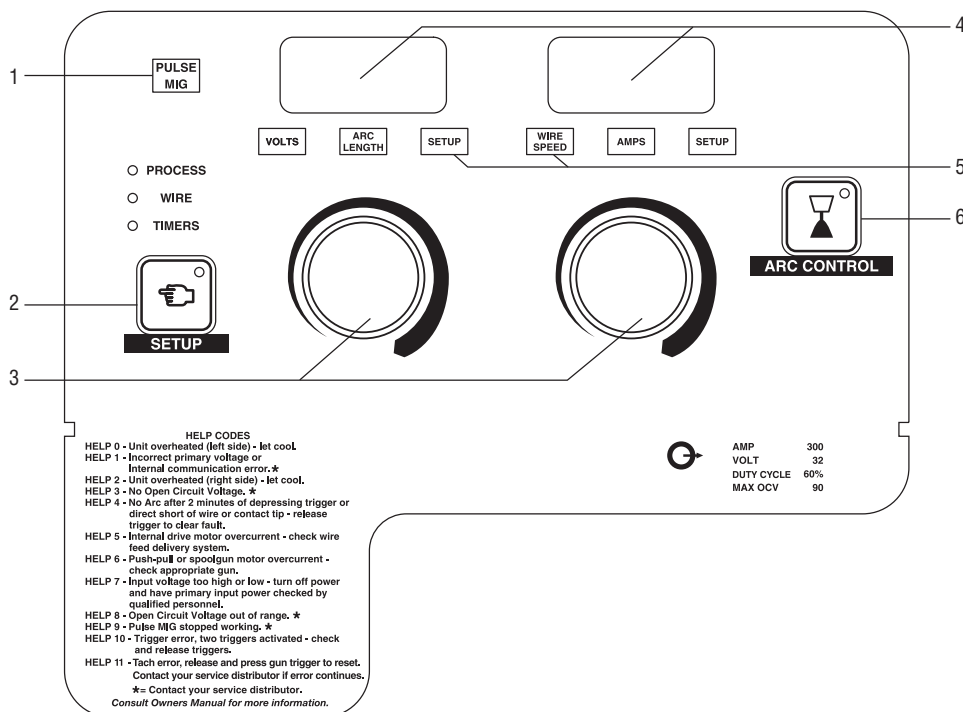


Rated Output	Amperage Range	Amps Input at Rated Output, 60 Hz					Wire Type and Diameter	Wire Feed Speed	Dimensions	Net Weight
Three-phase 300 A at 32 V 60% Duty Cycle	25–400 A	34	30	15	11.6	11.5	Solid Steel: .023–.045 in (0.6–1.2 mm) Aluminum: .035–.047 in (0.9–1.2 mm) Flux Core: .030–.045 in (0.8–1.2 mm) Metal Core: .035–.052 in (0.9–1.3 mm)	MIG Gun: 50–700 IPM (1.3–18 m/min) Spool Gun and Push-Pull Gun: 50–800 IPM (1.3–20 m/min)	H: 34 in (863 mm) W: 19 in (483 mm) D: 41 in (1041 mm)	181 lb (82 kg)
Single-phase 300 A at 32 V 60% Duty Cycle		69	61	30	13.1	11.2				

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

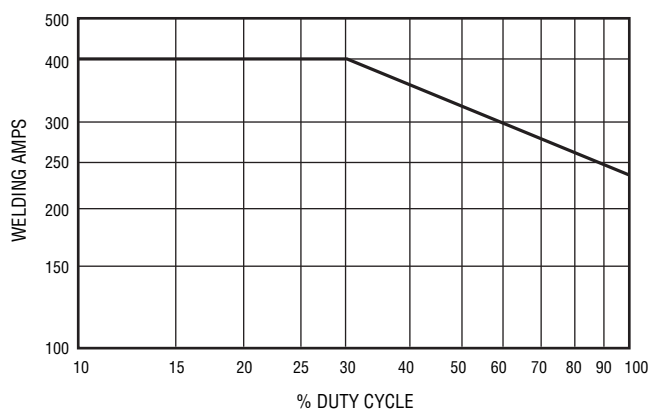
Control Panel

1. Weld Mode Indicator Lights
2. Menu Set-Up Button
3. Adjustment Knobs
4. Weld Parameter Displays
5. Weld Function Indicator Lights
6. Arc Control Button

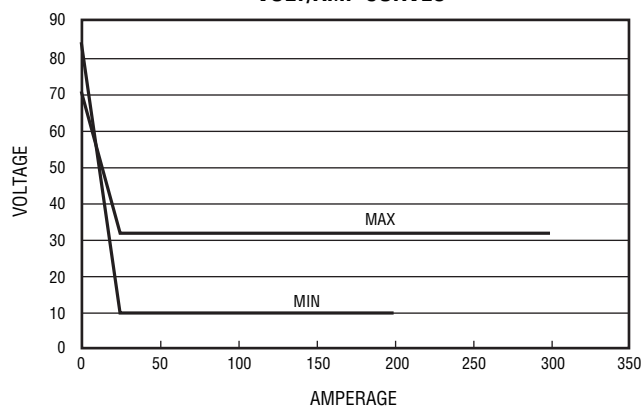


Performance Data

DUTY CYCLE CHART



VOLT/AMP CURVES



Aluminum Welding System



Millermatic 350P/XR-Aluma-Pro™ Push-Pull Gun Aluminum System
#907 379 200/230/460 V
 The ideal aluminum welding package. Includes Millermatic 350P, 25 ft XR-Aluma-Pro™ push-pull gun, .035 and .047 (3/64) FastTip™ contact tips, and .035/.047 (3/64) reversible U-groove drive rolls. (*Q300 MIG gun not included.*)

Genuine Miller Accessories

*Order from Miller Service Parts.

Wire Feeder



Millermatic Reach
#907 438 25 ft (7.6 m)
 Extend your Millermatic work envelope up to 40 feet! No more moving the machine and pulling primary power cables around the shop. Or use as a dual feeder option! No more downtime changing spools and drive rolls. For use with Millermatic 212 Auto-Set, 251, 252 and 350P. (*MIG Gun sold separately.*)

Guns

Bernard® Q300 MIG Gun **#229 560**
 15 ft (4.6 m), 300 amp gun handles standard wire size .035–.045 in (0.9–1.2 mm). Includes Centerfire™ contact tips.



Ideal for aluminum welding jobs. 200 amp, 100% duty cycle, air-cooled, 1 lb spool gun with your choice of 15 or 30 ft (4.6 m or 9.1 m) cable assembly. For detailed information, see Spoolmatic literature, Index No. M/1.5.

Spoolmatic® 15A Spool Gun
#195 156

Spoolmatic® 30A Spool Gun
#130 831

XR-A Aluma-Pro Push-Pull Gun

#300 000 15 ft (4.6 m)
#300 001 25 ft (7.6 m)
#300 264 35 ft (10.7 m)

XR-A Pistol Push-Pull Gun

#198 127 15 ft (4.6 m)
#198 128 30 ft (9 m)

U-Groove Aluminum Drive Roll and Accessory Kits

Note: XR-A Pistol kits include U-groove machine drive rolls, nylon wire guides, gun drive rolls and contact tips. XR-A Aluma-Pro kits include U-groove machine drive rolls, nylon wire guides and contact tips.

For XR-A Pistol

#195 201 .035 in (0.9 mm)
#195 202 .047 in (1.2 mm)

For XR-A Aluma-Pro

#195 311 .035 in (0.9 mm)
#195 313 .047 in (1.2 mm)

Dual Cylinder Rack **#195 299**

Replaces single cylinder rack.

Millermatic® Protective Cover **#195 142**

CO₂ Regulator/Flow Gauge **#212 492***

Required if using 100% CO₂ gas.

Power Cord Plug **#213 380***

For 200 or 230 V, single-phase application. Rated at 250 VAC/50 A NEMA-style 6-50P.

Consumables (Order from Miller Service Parts.)

For Bernard Q300 MIG Gun

Centerfire Contact Tips (10 per package)

#T-023 .023 in (0.6 mm)
#T-030 .030 in (0.8 mm)
#T-035 .035 in (0.9 mm)
#T-039 .039 in (1.0 mm) steel and for .035 in (0.9 mm) aluminum or stainless wires or metal core
#T-045 .045 in (1.2 mm)
#T-052 .052 in (1.3 mm) steel and for .047 in (1.2 mm) aluminum or stainless wires or metal core

Nozzle **#N-5800C**

Screw-type copper, 5/8 in (15.9 mm) orifice flush

Nozzle Insulator Cap **#10012**

Diffuser **#D-1**

Large Centerfire gas diffuser

Replacement Jump Liners

#QJL-2330 .023–.030 in. (0.6–0.8 mm)
#QJL-3545 Standard .035–.045 in. (0.9–1.2 mm)

Replacement Liners

#43015 .023–.030 in (0.6–0.8 mm)
#44115 Standard .035–.045 in. (0.9–1.2 mm)

Drive Roll Kits

Note: Drive roll kits include 4 drive rolls, an intermediate guide, and an inlet guide.

V-Grooved Drive Roll Kits

#087 132 .023/.025 in (0.6 mm)
#046 780 .030 in (0.8 mm)
#046 781 .035 in (0.9 mm)
#046 782 .045 in (1.2 mm)
#227 061 .035/.045 in (0.9/1.2 mm)
#046 783 .052 in (1.3 mm)
#046 784 1/16 in (1.6 mm)

U-Grooved Drive Roll Kits

#044 750 .035 in (0.9 mm)
#046 785 .047 in (1.2 mm)
#046 786 .052 in (1.3 mm)
#046 787 1/16 in (1.6 mm)

V-Knurled Drive Roll Kits

#046 792 .035 in (0.9 mm)
#046 793 .045 in (1.2 mm)
#046 794 .052 in (1.3 mm)
#046 795 1/16 in (1.6 mm)



Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Millermatic® 350P	#907 300	200/230/460 V, MIG/Pulsed MIG unit		
Millermatic® 350P/XR-Aluma-Pro™ Push-Pull Gun Aluminum Welding System	#907 379	200/230/460 V. Includes Millermatic 350P, 25 ft XR-Aluma-Pro™ push-pull gun, .035 and .047 (3/64) FasTip™ contact tips, and .035/.047 (3/64) reversible U-groove drive rolls. (MIG gun not included.)		
Feeders and Guns				
Millermatic Reach Wire Feeder	#907 438	25 ft (7.6 m) cable assembly. <i>(MIG Gun sold separately.)</i>		
Bernard® Q300 MIG Gun	#229 560	15 ft (4.6 m), 300 A, .035–.045 in (0.9–1.2 mm)		
Spoolmatic® 15A Spool Gun	#195 156	15 ft (4.6 m), 200 A, .023–1/16 in (0.6–1.6 mm) for aluminum		
Spoolmatic® 30A Spool Gun	#130 831	30 ft (9 m), 200 A, .023–1/16 in (0.6–1.6 mm) for aluminum		
XR™-A Aluma-Pro Push-Pull Gun	#300 000	15 ft (4.6 m), 200 A, .030–1/16 in (0.8–1.6 mm) for aluminum		
	#300 001	25 ft (7.6 m), 200 A, .030–1/16 in (0.8–1.6 mm) for aluminum		
	#300 264	35 ft (10.7 m), 200 A, .030–1/16 in (0.8–1.6 mm) for aluminum		
XR™-A Pistol Push-Pull Gun	#198 127	15 ft (4.6 m), 200 A, .030–1/16 in (0.8–1.6 mm) for aluminum		
	#198 128	30 ft (9 m), 200 A, .030–1/16 in (0.8–1.6 mm) for aluminum		
U-Groove Aluminum Drive Roll and Accessory Kit	#195 201	For XR-A Pistol Gun, .035 in (0.9 mm)		
	#195 202	For XR-A Pistol Gun, .047 in (1.2 mm)		
	#195 311	For XR-A Python/Aluma-Pro Gun, .035 in (0.9 mm)		
	#195 313	For XR-A Python/Aluma-Pro Gun, .047 in (1.2 mm)		
Accessories				
Dual Cylinder Rack	#195 299	Field installed, replaces single cylinder rack		
Protective Cover	#195 142			
CO ₂ Regulator/Flow Gauge	#212 492	Required if using 100% CO ₂ gas <i>(Order from Miller Service Parts.)</i>		
Power Cord Plug	#213 380	For 200/230 V, single-phase. NEMA-style 6-50P <i>(Order from Miller Service Parts.)</i>		
Electrode Wire				
Shielding Gas Cylinder				
Helmet/Gloves/Scratch Brush				
Consumables <i>(Order from Miller Service Parts.)</i>				
Centerfire™ Consumables		See page 3		
Contact Tips				
Tapered Contact Tips				
Contact Tip Adapter				
Replacement Liners				
Nozzles				
Tapered Nozzles				
Drive Rolls				

Date: Total Quoted Price:



Distributed by:

Miller[®] 252

Issued September 2010 • Index No. DC/12.49

**MIG Arc Welding Power Source,
Wire Feeder and Gun Package**



Quick Specs

Industrial Applications

Metal Fabrication
Maintenance and Repair
Farm/Home
Light Industrial

Processes

MIG (GMAW)
Flux Cored (FCAW)

Input Power

200(208)/230 V
230/460/575 V

Rated Output 200 Amps at 28 VDC, 60% Duty Cycle
250 Amps at 28 VDC, 40% Duty Cycle

Max. Open-Circuit Voltage 38

Amperage Range 30–300 Amps

Wire Feed Speed 50–700 IPM (1.3–17.8 m/min)

Weight 207 lb (94 kg)

The Power of Blue.[®]

Highest output in its class (250 A at 28 VDC).

Weld longer on high-end applications.

Large, digital front panel with built-in digital timers menu enables operator to preset voltage and wire feed speed. Standard run-in, pre/postflow, burnback, spot/delay (stitch) timer menu.

Auto Gun Detect™ allows operator to simply pull trigger on MIG gun, spool gun or push/pull gun. Automatically detects and recalls the voltage, wire feed speed and timer of the active gun. [See page 3 for more information.](#)



Push-pull gun direct connection.

Now directly connects your push-pull gun, no extra module required.



Compatible with the Miller[®] Reach Wire Feeder. Extend your Miller[®] work envelope up to 40 feet! No more moving the machine and pulling primary power cables

around the shop. Or use as a dual feeder option! No more downtime changing spools and drive rolls. *MIG Gun sold separately.*



Fan-On-Demand™ cooling system only operates when needed, reducing power consumption and contaminants drawn into the machine.



Welder is warranted for 3 years, parts and labor.

Original main power rectified parts are warranted for 5 years.

Gun warranted for 90 days, parts and labor.

Comes Complete With:

- 10 ft (3 m) power cord and plug (200/230 V model only)
- 15 ft (4.6 m), 250 amp M-25 MIG gun for .030/.035 in wire
- 10 ft (3 m) work cable and clamp
- Argon mix regulator/flow gauge and hose
- Extra contact tips
- Factory-installed running gear with EZ-Change™ Low Cylinder Rack
- .030/.035 in reversible drive rolls
- Set-up and operation interactive CD



EZ-Access™ consumable compartment and parameter chart. Set weld parameters right the first time with convenient new flip-down compartment that provides fast access to parameter chart and consumables. [See page 3 for more information.](#)

Active Arc Stabilizer™ minimizes weld cleanup, and provides excellent starts proven superior to the competition.

Line voltage compensation keeps power constant even if power input varies by $\pm 10\%$.



Miller Electric Mfg. Co.

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

Equipment Sales US and Canada

Phone: 866-931-9730
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International FAX: 920-735-4125

Web Site

www.MillerWelds.com



MADE IN USA
APPLETON, WI

Specifications (Subject to change without notice.)



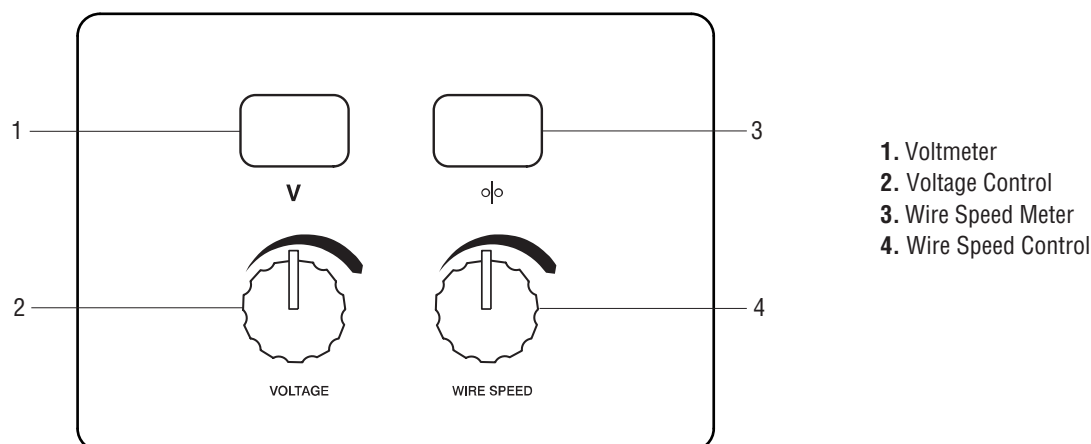
Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz						Wire Type and Diameter	Wire Feed Speed	Max. Spool Size	Dimensions	Net Weight
200 A, 28 VDC at 60% Duty Cycle 250 A, 28 VDC at 40% Duty Cycle	30–300 A	38	200(208) V	230 V	460 V	575 V	KVA	KW					
			48 2.3*	42 2*	21 1*	17 0.8*	9.8 0.46*	7.5 0.13*	Solid/Stainless Steel: .023–.045 in (0.6–1.2 mm) Flux Cored: .030–.045 in (0.8–1.2 mm)	50–700 IPM (1.3–17.8 m/min)	12 in (305 mm)	H: 30 in (762 mm) W: 19 in (483 mm) D: 40 in (1016 mm)	207 lb (94 kg)

*While idling.

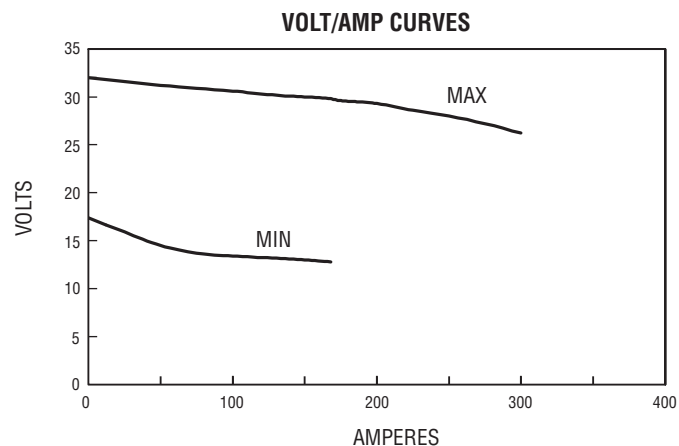
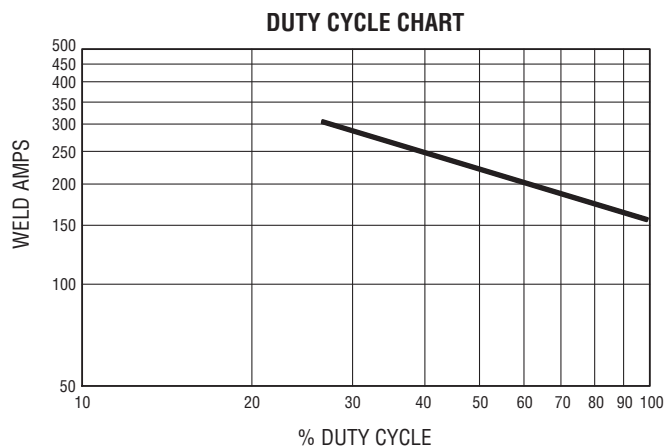
Note: Operating Temperature Range: -4° to +104° F (-20 to +40° C) Storage Temperature Range: -22° to +122° F (-30 to +50° C)

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

Control Panel



Performance Data



Standard Fully Loaded Features

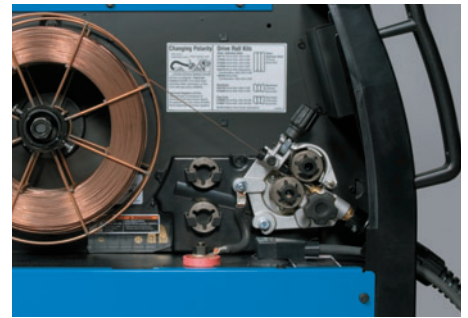
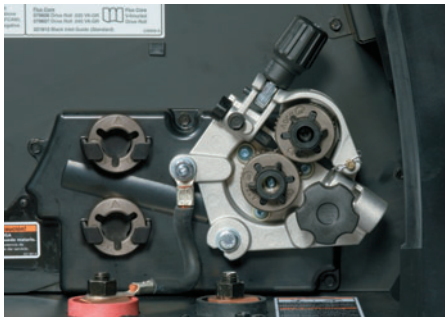
EZ-Change™ Low Cylinder Rack

- Operators no longer need to lift cylinders. Cylinders now easily roll on and off our EZ-Change™ Low Cylinder Rack.



Angled Wire Drive

- Angled industrial aluminum dual-gear drive system significantly improves wirefeeding and runs large spools of wire.
- Allows quick change of drive rolls without tools.
- Drive roll storage — no more lost drive rolls, extra drive rolls are conveniently stored next to drive motor.
- Operators no longer bump into and bend MIG gun and gun liner.



Dual Front Handles

- Split handle with rubber grips designed to move machine easily and allow work lead and MIG gun to be stored independently.
- Handles provide protection for front panel and MIG gun during transportation.



EZ-Access™ Consumable Compartment and Parameter Chart

- Convenient flip-down compartment holds parameter chart and storage for consumables.



Auto-Gun Detect™

- Simply pull the trigger for either the MIG, spool gun or any Miller push-pull gun. The Millermatic 252 automatically recalls voltage, wire feed speed and timer of the active gun.
- Reduces setup time!



Optional Fully Loaded Features

Elevated Gun and Cable Rack

#300 335

- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.
- No more running over spool gun cables or cables dragging on the floor.
- Elevated Gun and Cable Rack can be used with either a single or dual cylinder rack. (Elevated Gun and Cable Rack is included with the Dual EZ-Change™ Low Cylinder Rack.)



Dual EZ-Change™ Cylinder Rack with Elevated Gun and Cable Rack

#300 337

- Dual cylinder rack allows for easy storage for two cylinders.
- EZ-Change™ Low Cylinder rack eliminates the need to lift cylinders on and off cylinder rack.
- No more running over spool gun cables or cables dragging on the floor.
- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.



Genuine Miller Accessories

Direct connection for all Miller push-pull guns.

- Able to utilize 12 in rolls of aluminum wire inside the Millermatic 252 for extended aluminum welding time.
- Wire feed speed is adjustable at the gun and actual speed can be seen on the digital display on the Millermatic 252.
- Adjustable run-in control to fine tune arc starting.



XR-A Aluma-Pro Gun
#300 000 15 ft (4.6 m) Cable
#300 001 25 ft (7.6 m) Cable
 300 amps at 100% duty cycle.



XR-A Pistol Gun
#198 127 15 ft (4.6 m) Cable
#198 128 30 ft (9 m) Cable
 200 amps at 100% duty cycle.

U-Groove Aluminum Drive Roll and Accessory Kits

Note: XR-A Pistol kits include U-groove machine drive rolls, nylon wire guides, gun drive rolls and contact tips. XR-A Aluma-Pro kits include U-groove machine drive rolls, nylon wire guides and contact tips.

For XR-A Pistol

#195 201 .035 in (0.9 mm)
#195 273 .040 in (1 mm)
#195 202 .047 in (1.2 mm)

For XR-A Aluma-Pro

#195 311 .035 in (0.9 mm)
#195 312 .040 in (1 mm)
#195 313 .047 in (1.2 mm)

M-25 Replacement Gun

#169 594 10 ft (3 m)
#169 596 12 ft (3.7 m)
#169 598 15 ft (4.6 m) standard
 Gun shipped to run .030–.035 in (0.8–0.9 mm) wire.



Spoolmatic® 15A Spool Gun #195 156
Spoolmatic® 30A Spool Gun #130 831
 Ideal for aluminum welding jobs. 200 amp, 100% duty cycle, air-cooled, 1 lb spool gun with your choice of 15 ft or (4.6 m) 30 ft (9.1 m) cable assembly. For detailed information, see Spoolmatic literature, Index No. M/1.2.



Spoolmate™ 200 Spool Gun #300 497
 Reliable and economical spool gun perfect for hobbyists and light fabricators who weld aluminum. Handles .030–.035 in (0.8–0.9 mm) aluminum and .023–.035 in (0.6–0.9 mm) steel/stainless steel wires. Rated at 160 amps, 60% duty cycle with 20 ft cable assembly. For detailed information, see Spoolmate literature, Index No. M/1.47.



Millermatic Reach #907 438 25 ft (7.6 m)
 Extend your Millermatic work envelope up to 40 feet! No more moving the machine and pulling primary power cables around the shop. Or use as a dual feeder option! No more downtime changing spools and drive rolls. For use with Millermatic 212 Auto-Set, 251, 252 and 350/350P. (MIG Gun sold separately.)



Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack #300 337
 Dual cylinder rack allows operators to easily roll cylinders on and off the rack with no lifting. Gun and cable rack keeps cables off the floor and tangle free.

Elevated Gun and Cable Rack #300 335
 For use with single cylinder rack. (Included with Dual EZ-Change Low Cylinder Rack.)



Protective Cover #195 142
 Features side pocket.
 (Not for use with Dual Cylinder Rack or Elevated Gun and Cable Rack.)

Argon/Mixed Gas Regulator and Gas Hose #195 050
 (Order from Miller Service Parts.)

CO₂ Regulator/Flow Gauge #237 702
 Required if using 100% CO₂ gas.
 (Order from Miller Service Parts.)

For M-25 Gun



Contact Tips

- #087 299 .023/.025 in (0.6 mm)
- #000 067 .030 in (0.8 mm)
- #000 068 .035 in (0.9 mm)
- #000 069 .045 in (1.2 mm)
- #187 117 .035 in (0.9 mm) heavy-duty tip
- #187 118 .045 in (1.2 mm) heavy-duty tip

Tapered Contact Tips

- #176 797 .030 in (0.8 mm)
- #176 793 .035 in (0.9 mm)
- #176 794 .045 in (1.2 mm)



Contact Tip Adapter #169 728



Replacement Liners

- #194 010 .023/.025 in
- #194 011 .030–.035 in (standard)
- #194 012 .035–.045 in



Nozzles

Note: Flush or stickout nozzles should be used for the short-circuit process. Recessed nozzles should be used for the spray arc process.

#200 258 Standard

1/2 in (13 mm) diameter orifice. Nozzle flush with contact tip.

#169 726

5/8 in (16 mm) diameter orifice. Nozzle flush with contact tip.

#169 727

5/8 in (16 mm) diameter orifice. Contact tip sticks out of nozzle 1/8 in (3.2 mm).

#169 724

1/2 in (13 mm) diameter orifice. Contact tip recessed 1/8 in (3.2 mm) into nozzle.

#169 725

5/8 in (16 mm) diameter orifice. Contact tip recessed 1/8 in (3.2 mm) into nozzle.

Tapered Nozzles

Note: Tapered tips are recommended when using a tapered nozzle.

#176 243 3/8 in (9.5 mm) diameter orifice

#178 386 11/32 in (8.7 mm) diameter orifice



M-Series Consumable Kits

#234 610 .030 in (0.8 mm)

#234 611 .035 in (0.9 mm)

#234 612 .045 in (1.2 mm)

Contains 10 contact tips, 1 nozzle, 1 contact tip adapter, and 1 nozzle adapter.

Drive Rolls

Note: Drive roll kits include two drive rolls and an inlet guide.

V-Grooved Drive Roll Kits (solid wire)

#204 579 .030 & .035 in (0.8 & 0.9 mm) Combination (Reversible)

#087 131 .023/.025 in (0.6 mm)

#079 594 .030 in (0.8 mm)

#079 595 .035 in (0.9 mm)

#079 596 .045 in (1.2 mm)

V-Knurled Drive Roll Kits

(Flux Cored or difficult-to-feed wire)

#079 606 .035 in (0.9 mm)

#079 607 .045 in (1.2 mm)

Ordering Information

Steel Configuration

	Stock No.	Description	Qty.	Price
Miller[®] 252	#907 321	200(208)/230 V, 60 Hz		
	#907 322	230/460/575 V, 60 Hz		
V-Groove Drive Roll Kits (solid wire)	#087 131	.023/.025 (0.6 mm)		
	#079 594	.030 (0.8 mm)		
	#079 595	.035 (0.9 mm)		
	#079 596	.045 (1.2 mm)		
V-Knurled Drive Roll Kits (flux cored)	#079 606	.035 (0.9 mm)		
	#079 607	.045 (1.2 mm)		
Contact Tips (10 per package)	#087 299	.023/.025 (0.6 mm)		
	#000 067	.030 (0.8 mm)		
	#000 068	.035 (0.9 mm)		
	#000 069	.045 (1.2 mm)		
Nozzles	#169 724	1/2 in (13 mm) diameter, 1/8 in (3.2 mm) recessed		
	#169 725	5/8 in (16 mm) diameter, 1/8 in (3.2 mm) recessed		
	#200 258	1/2 in (13 mm) diameter, flush. <i>Included with standard configuration</i>		
	#169 726	5/8 in (16 mm) diameter, flush		
	#169 727	5/8 in (16 mm) diameter, 1/8 in (3.2 mm) exposed		
M-Series Gun Consumable Kits (for M-25)	#234 607	.030 in (0.8 mm)		
	#234 608	.035 in (0.9 mm)		
	#234 609	.045 in (1.2 mm)		

Aluminum Configuration (Spool Gun)

Miller[®] 252 Spool Gun Packages (Also includes standard M-25 MIG gun)	#951 066	200(208)/230 V, 60 Hz with Spoolmatic [®] 30A, dual cylinder rack, elevated gun and cable rack, regulator and hose		
	#951 065	230/460/575 V, 60 Hz with Spoolmatic [®] 30A, dual cylinder rack, elevated gun and cable rack, regulator and hose		
Spool Gun Contact Tips (10 per package)	#206 187	.035 (0.9 mm)		
	#206 188	.040 (1.0 mm)		
	#206 189	.047 (1.2 mm)		
Spool Gun Nozzles	#198 855	5/8 in (16 mm) diameter		
	#199 618	5/8 in (16 mm) diameter, HD		
	#199 616	3/4 in (19 mm) diameter		
	#199 617	3/4 in (19 mm) diameter, HD		

For M-25 gun consumables and Miller[®] 252 drive rolls, see steel configuration chart above.

Aluminum Configuration (Push-Pull Guns)

Miller[®] 252 (Includes standard M-25 MIG gun)	#907 321	200(208)/230 V, 60 Hz		
	#907 322	230/460/575 V, 60 Hz		
XR[™]-A Aluma-Pro Gun	#300 000	15 ft (4.6 m)		
	#300 001	25 ft (7.6 m)		
XR[™]-A Pistol	#198 127	15 ft (4.6 m)		
	#198 128	30 ft (9.1 m)		
XR [™] -A Pistol U-Groove Drive Roll Kits (required)	#195 201	.035 (0.9 mm)		
	#195 273	.040 (1.0 mm)		
	#195 202	.047 (1.2 mm)		
XR [™] -A Aluma-Pro U-Groove Drive Roll Kits (required)	#195 311	.035 (0.9 mm)		
	#195 312	.040 (1.0 mm)		
	#195 313	.047 (1.2 mm)		
Contact Tips (10 per package)	#206 187	.035 (0.9 mm)		
	#206 188	.040 (1.0 mm)		
	#206 189	.047 (1.2 mm)		
Nozzles	#198 855	5/8 in (16 mm) diameter		
	#199 618	5/8 in (16 mm) diameter, HD		
	#199 616	3/4 in (19 mm) diameter		
	#199 617	3/4 in (19 mm) diameter, HD		
Dual EZ-Change [™] Low Cylinder Rack with Elevated Gun and Cable Rack	#300 337			
Elevated Gun and Cable Rack	#300 335	For use with single cylinder rack. (Included with Dual EZ-Change Low Cylinder Rack.)		

For M-25 gun consumables and Miller[®] 252 drive rolls, see steel configuration chart above.

Date:

Total Quoted Price:



Ordering Information

Accessories

	Stock No.	Description	Qty.	Price
XR™-A Aluma-Pro™	#300 000	15 ft (4.6 m)		
	#300 001	25 ft (7.6 m)		
XR™-A Pistol Gun	#198 127	15 ft (4.6 m)		
	#198 128	30 ft (9 m)		
M-25 Gun	#169 594	10 ft (3 m), .023–.035 in (0.6–0.9 mm)		
	#169 596	12 ft (3.7 m), .023–.035 in (0.6–0.9 mm)		
	#169 598	15 ft (4.6 m), .023–.035 in (0.6–0.9 mm)		
Spoolmatic® 15A	#195 156	15 ft (4.6 m), 200 A, .023–1/16 in (0.6–1.6 mm) for aluminum		
Spoolmatic® 30A	#130 831	30 ft (9 m), 200 A, .023–1/16 in (0.6–1.6 mm) for aluminum		
Spoolmate™ 200	#300 497	20 ft (6 m), 160 A, .030–.035 in (0.8–0.9 mm) for aluminum, .023–.035 in (0.6–0.9 mm) for steel/stainless steel wires		
Optional Spoolmate 200 Barrel Assemblies	#300 591	45-degree barrel		
	#300 592	9 in extension barrel		
	#300 593	Heavy-duty barrel		
Millermatic Reach Wire Feeder	#907 438	25 ft (7.6 m) cable assembly <i>(MIG gun sold separately.)</i>		
Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack	#300 337			
Elevated Gun and Cable Rack	#300 335	For use with single cylinder rack. <i>(Included with Dual EZ-Change Low Cylinder Rack.)</i>		
Protective Cover	#195 142	Features side pocket		
Argon/Mixed Gas Regulator and Gas Hose	#195 050			
CO ₂ Regulator/Flow Gauge	#237 702	Required if using 100% CO ₂ gas. <i>(Order from Miller Service Parts.)</i>		

Date:

Total Quoted Price:

Note: See page 7 for ordering information on the Millermatic 252 — available packages, steel and aluminum configurations, and drive roll kits/consumables.



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