

# Millermatic® 210

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**MIG Arc Welding  
Power Source** 

## Quick Specs

### Industrial Applications

Light Fabrication  
Garages/Body Shops  
Vocational/Technical Schools  
Farm/Ranch

### Processes

MIG (GMAW)  
Flux Cored (FCAW)

**Rated Output** 160 A at 24.5 VDC, 60% Duty Cycle

**Max. Open-Circuit Voltage** 34.5

**Amperage Range** 30 – 210 A

**Wire Feed Speed** 35 – 700 IPM (0.9 – 17.8 m/min)

**Weight** 200 lb (91 kg)

## The Power of Blue.®



**Removable consumable compartment and access to wire drive system** located under side door.



Add the Spoolmate™ 3035 spool gun for aluminum welding. Easy to install with new, direct hook up. And with Miller's exclusive Gun-On-Demand™, simply pull the trigger for either gun and you're ready to weld. No time wasted toggling switches!



**Industrial, dual-gear-driven, cast-aluminum drive system** features no-tool, quick-change drive rolls and an easy-to-set tension adjustment knob with a scale for consistent settings.

**Thermal overload protection** shuts down unit if necessary to protect the machine.

**Reversible drive rolls** with dual grooves allow one set of drive rolls for both .030 and .035 in wire.

**Built-in dual gun and cable holder** for your MIG gun, spool gun and cables.



### Comes Complete With:

- Industrial power cord and plug
- 12 ft (3.7 m), 250 amp M-25 MIG gun for .030/.035 in wire
- Factory-installed dual gas solenoids
- 10 ft (3 m) work cable and clamp
- Argon mix regulator/flow gauge and hose
- Extra contact tips
- Factory-installed running gear/cylinder rack
- .030/.035 in reversible dual groove drive rolls
- Set-up and operation video

**Seven taps** provides wider welding range of 30–210 amps with improved high and low ends to weld materials from 22 gauge up to 3/8 in (9.5 mm) thick in a single pass.

**Easily accessible primary voltage switchover board** for quick set up.

**12 ft, 250 amp M-25 MIG gun** features durable one-piece handle, uncable outer jacket, trigger rated for one million cycles, and steel spring coils protecting cable ends.

**TRUE BLUE®**  
3YR. WARRANTY

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.

MADE IN **USA**  
APPLETON, WI



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

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International FAX: 920-735-4125

**Web Site**  
www.MillerWelds.com



# Specifications (Subject to change without notice.)

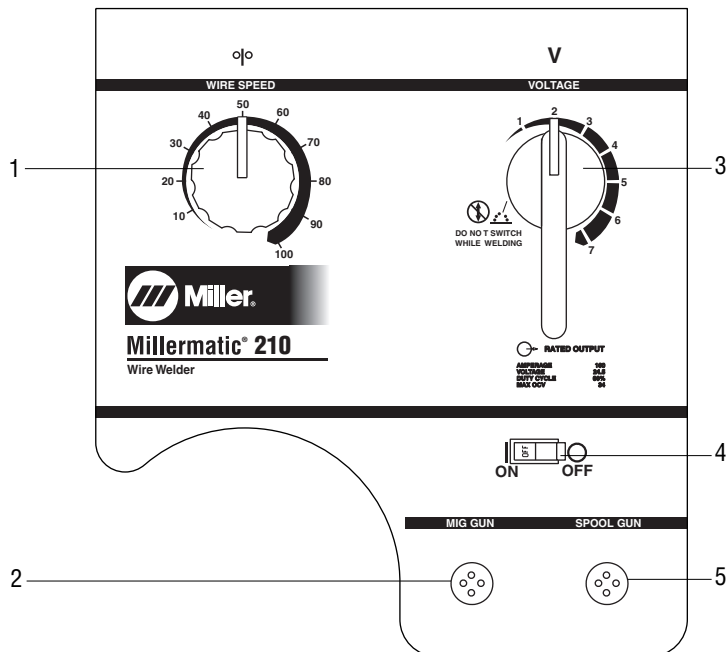


Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz				Wire Type and Diameter	Wire Feed Speed	Dimensions	Net Weight
			200 V	230 V	KVA	KW				
160 A at 24.5 VDC, 60% Duty Cycle	30–210 A	34.5	31	27	6.5	5.5	Mild Steel/Stainless Steel: .023–.035 in (0.6–0.9 mm) Flux Cored: .030–.045 in (0.8–1.2 mm)	35–700 IPM (0.9–17.8 m/min)	H: 32 in (813 mm) W: 19 in (483 mm) D: 39 in (991mm)	200 lb (91 kg)

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

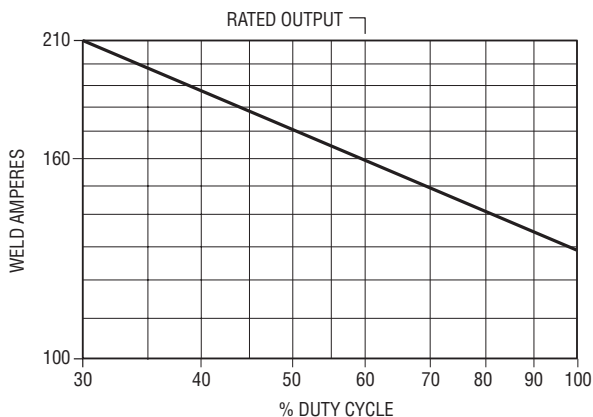
## Control Panel

1. Wire Speed Control
2. MIG Gun Connector
3. Voltage Control
4. Power Switch
5. Spool Gun Connector

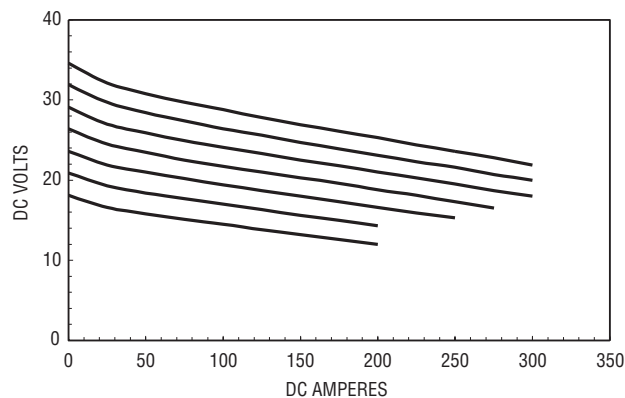


## Performance Data

**DUTY CYCLE CHART**



**VOLT/AMP CURVES**



## Genuine Miller Accessories

### M-25 Replacement Gun

#169 594 10 ft (3 m)

#169 596 12 ft (3.7 m) standard

Gun shipped to run .030–.035 in (0.8–0.9 mm) wire.



### Dual Cylinder Rack #042 758

Converts single cylinder rack to a dual rack.

### Spoolmate™ 3035 Spool Gun #195 016

Spool gun for aluminum and other wires. 4 in spools; .023–.035 in (0.6–0.9 mm) aluminum, steel and stainless steel. Rated at 150 amps, 60% duty cycle with 20 ft (6 m) cable assembly.

### Spoolmate™ 3035 25 ft Extension Cable Kit #194 996

Extends Spoolmate 3035 an additional 25 ft (7.6 m) from power source.

### NEW! Heavy-Duty Barrel for Spoolmate 3035 #195 375

Use for demanding applications, rated at 200 A, 60% duty cycle.

### Adapter Cable #195 287

Allows Spoolmatic® 15A or 30A to be used with Millermatic 210.

*Note: WFS is controlled at the machine, not the gun.*



### Protective Cover with Helmet Bag #195 142

Features side pocket, helmet bag and Chopper graphic on side panel.

### CO<sub>2</sub> Regulator/Flow Gauge #212 492

Required if using 100% CO<sub>2</sub> gas. (Order from Miller Service Parts.)

## Consumables (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 (1.1 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.*

#### #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.

#### Spot Nozzles

#176 238 Flat

#176 240 Inside corner

#176 242 Outside corner

#### 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



### Gun Convenience Kit #193 975

Contains:

5 – .035 in (0.9 mm) contact tips (#000 068)

5 – .045 in (1.2 mm) contact tips (#000 069)

2 – Tip adapters (#169 728)

1 – Nozzle adapter (#169 729)

3 – O-rings (#170 468)

2 – Shock washers (#169 730)

1 – 5/8 in (16 mm) diameter orifice nozzle (#169 726)

### 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)

#### V-Knurled Drive Roll Kits

(Flux Cored or difficult-to-feed wire)

#079 606 .035 in (0.9 mm)

### For Spoolmate™ 3035 Gun



#### Contact Tips (5 per package)

#199 730 For .023 in (0.6 mm) wire.

#186 419 For .030 in (0.8 mm) wire.

#186 406 For .035 in (0.9 mm) wire.



#### Nozzle #186 405



#### Drive Roll (1)

#199 731 For .023 in (0.6 mm) wire.

#186 413 For .030/.035 in (0.8/0.9 mm) wire.



#### Push Roll (1)

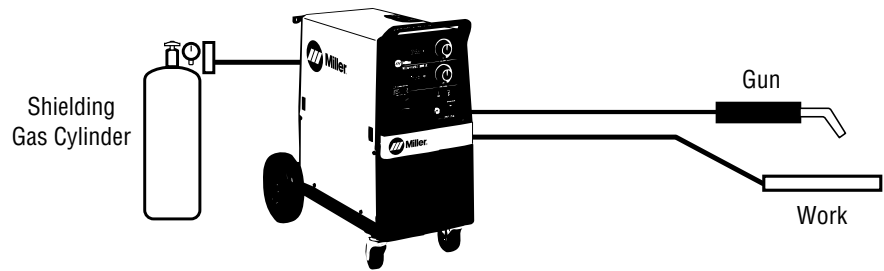
#199 732 For .023 in (0.6 mm) wire.

#186 414 For .030/.035 in (0.8/0.9 mm) wire.

# Typical Installations



**MIG (GMAW) or Flux Cored (FCAW)  
Basic Equipment**



## Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>Millermatic® 210</b>	<b>#907 046</b>	200(208)/230 V, 60 Hz		
<b>Millermatic® 210 Package</b>	<b>#951 006</b>	200(208)/230 V, 60 Hz with Spoolmate™ 3035, dual cylinder rack, and Argon mix regulator/flow gauge and hose		
<b>Guns</b>				
M-25 Gun	<b>#169 594</b>	10 ft (3 m), .023–.035 in (0.6–0.9 mm)		
	<b>#169 596</b>	12 ft (3.7 m), .023–.035 in (0.6–0.9 mm)		
Spoolmate™ 3035	<b>#195 016</b>	Spool gun for aluminum		
25 ft Extension Kit	<b>#194 996</b>	For Spoolmate 3035		
Heavy-Duty Barrel for Spoolmate™ 3035	<b>#195 375</b>	200 A, 60% Duty Cycle		
Adapter Cable	<b>#195 287</b>	Allows Spoolmatic® 15A or 30A to be used with Millermatic 210		
<b>Accessories</b>				
Protective Cover with Helmet Bag	<b>#195 142</b>	Features side pocket, helmet bag and Chopper graphic		
CO <sub>2</sub> Regulator/Flow Gauge	<b>#212 492</b>	Required if using 100% CO <sub>2</sub> gas ( <i>Order from Miller Service Parts.</i> )		
Electrode Wire				
Dual Cylinder Rack	<b>#042 758</b>	Field installed		
Shielding Gas Cylinder				
Helmet/Gloves/Wire Brush				
<b>Consumables</b> ( <i>Order from Miller Service Parts.</i> )				
Contact Tips				
Contact Tip Adapter				
Replacement Liners				
Nozzle				
Spot Nozzles				
Gun Convenience Kit	<b>#193 975</b>			
Drive Rolls				

Date:

Total Quoted Price:



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