### Quick Specs

<table>
<thead>
<tr>
<th>Industrial Applications</th>
<th>Processes</th>
<th>Input Power</th>
<th>Amperage Range</th>
<th>Rated Output</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Precision fabrication</td>
<td>DC TIG (GTAW)</td>
<td>208–575 V, 3-phase or 1-phase power</td>
<td>1–280 A (DC)</td>
<td>250 A at 20 V, 60% duty cycle</td>
<td>47 lb. (21.3 kg)</td>
</tr>
<tr>
<td>Petro chemical</td>
<td>Pulsed TIG (GTAW-P)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Aerospace</td>
<td>Stick (SMAW)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Food/beverage industry</td>
<td>Air carbon arc (CAC-A)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dairy</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Shipboard</td>
<td></td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

**Update and expand.** Front panel memory card data port provides the ability to easily update software and expand product features. Visit MillerWelds.com/TIGSoftware for the latest software updates and expansions.

**Pro-Set™** eliminates the guesswork when setting weld parameters. Use Pro-Set when you want the speed, convenience and confidence of preset controls. Simply select the feature and adjust until Pro-Set appears on the display.

**Sleep timer** conserves electricity. This programmable feature will power down the machine if it sits idle for a specific time.

**AUTO-LINE™ Technology** allows for any input voltage hookup (208–575 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

**Cooler Power Supply (CPS)** is an integrated 120-volt dedicated-use receptacle for the Coolmate™ 1.3. Available on select models, see page 6.

**Cooler-On-Demand™** feature operates the auxiliary cooling system only when needed, reducing noise, energy use, and airborne contaminants pulled through the cooler. Available on CPS models only.

**Blue Lightning™** high-frequency (HF) arc starter for non-contact arc initiation. Provides more consistent arc starts and greater reliability compared to traditional HF arc starters.

**Meter calibration** allows digital meters to be calibrated for certification.

**Wind Tunnel Technology™** protects internal electrical components from airborne contaminants, extending the product life.

**Fan-On-Demand™** power source cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled though the machine.

### DC TIG Features

**Pulse.** Pulsing can increase puddle agitation, arc stability and travel speeds while reducing heat input and distortion. DX models provide extended ranges.

**Exceptionally smooth** and precise arc for welding exotic materials.

### DC Stick Features

**Dual schedule** allows operators to switch welding parameters for specific electrodes without readjusting the machine, minimizing downtime and enhancing quality. Base model only (not DX).

**DIG control** allows the arc characteristics to be changed for specific applications and electrodes. Lower the DIG setting for smooth running electrodes like E7018 and increase the DIG setting for stiffer, more penetrating electrodes like E6010.

**Hot Start™** adaptive control provides positive arc starts without sticking.

**Stick-Stuck** detects if the electrode is stuck to the part and turns the welding output off to safely and easily remove the electrode. Menu selectable.

---

**Power source is warranted for three years, parts and labor.**

---

Miller Electric Mfg. LLC
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

MillerWelds.com

---

[9001 Quality]
### Specifications

<table>
<thead>
<tr>
<th>Welding Mode</th>
<th>Input Power</th>
<th>Welding Amperage Range</th>
<th>Rated Output</th>
<th>Amps Input at Rated Load Output, 50/60 Hz</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>TIG (GTAW)</td>
<td>3-phase</td>
<td>1–280 A</td>
<td>250 A at 20 V, 60% duty cycle</td>
<td>21 19 11 9 7 7.6 7.3</td>
<td>60 VDC (11 VDC**)</td>
<td>H: 13.6 in. (346 mm) W: 8.6 in. (219 mm) D: 22.5 in. (569 mm)</td>
<td>47 lb. (21.3 kg)</td>
</tr>
<tr>
<td></td>
<td>1-phase</td>
<td>1–280 A</td>
<td>250 A at 20 V, 60% duty cycle</td>
<td>35 32 18 16 13 7.3 7.1</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Stick (SMAW)</td>
<td>3-phase</td>
<td>5–280 A</td>
<td>250 A at 30 V, 60% duty cycle</td>
<td>* * 14 13 10 9.9 9.6</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1-phase</td>
<td>5–280 A</td>
<td>180 A at 27.2 V, 60% duty cycle*</td>
<td>32 29 * * 6.7 6.5</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* Refer to owner’s manual for complete ratings. ** Low OCV sense voltage for stick and Lift-Arc™ TIG.

**IP23 rating** — This equipment is designed for outdoor use. It may be stored, but is not intended to be used outside during precipitation unless sheltered.

Operating temperature range is 14 to 104°F (-10 to 40°C). Storage temperature range is -22 to 149°F (-30 to 65°C). Portions of the preceding text are contained in EN 60974-1: “Welding power sources for arc welding equipment.”

### Performance Data

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>380–575 V</td>
<td>280 A, 40% 250 A, 60% 200 A, 100%</td>
<td>280 A, 35% 200 A, 60% 160 A, 100%</td>
<td>0.004–3/8 in. (0.1–9.5 mm)</td>
<td>6010: 1/4 in. (6.4 mm) 7018: 7/32 in. (5.6 mm) 7024: 3/16 in. (4.8 mm)</td>
<td>3/16 in. (4.8 mm)</td>
<td>12.5 kW</td>
</tr>
<tr>
<td>208–240 V</td>
<td>280 A, 40% 250 A, 60% 200 A, 100%</td>
<td>280 A, 15% 180 A, 60% 160 A, 100%</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. All CE models conform to the applicable parts of the IEC 60974 series of standards.
Coolmate® 1.3 Cooler

- Maxstar® models with CPS turn Coolmate 1.3 on and off
- Power indicator light
- Fluid level sight window
- Rustproof polyethylene-molded coolant tank and filler spout
- 1/4 hp motor is thermally protected to guard against overheating
- Efficient fin and tube heat exchanger
- Factory-set pressure relief valve (55 psi) maintains consistent pressure during operation
- Filter and coolant filling spout are conveniently located
- Brass-body, positive displacement rotary vane pump provides consistent coolant flow and pressure rating with long pump-life expectancy

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Maximum Current Draw</th>
<th>Maximum Cooling Capacity</th>
<th>Rated Cooling Capacity</th>
<th>Tank Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>115 V, 60 Hz</td>
<td>4.7 A (60 Hz)</td>
<td>3,400 W (11,600 Btu/hr.)</td>
<td>1,330 W (4,540 Btu/hr.)</td>
<td>1.3 gal. (4.9 L)</td>
<td>H: 11.25 in. (286 mm) W: 10.375 in. (264 mm) D: 24 in. (610 mm)</td>
<td>43 lb. (20 kg)</td>
</tr>
</tbody>
</table>

Weldcraft® W-280 (WP-280) TIG Torch

- Two-piece torch head and exclusive Super Cool™ Technology provides additional surface area to increase cooling efficiency and capacity
- Torch body includes an anti-rotation feature and multi-position locking to prevent handle movement during welding and improve operator control
- Secure mechanical fittings and connections minimize leakage

<table>
<thead>
<tr>
<th>Cooling Method</th>
<th>AC Rating</th>
<th>DC Rating</th>
<th>Consumables</th>
<th>Electrode Range</th>
<th>Cable</th>
</tr>
</thead>
<tbody>
<tr>
<td>Water-cooled</td>
<td>195 A, 100% duty cycle</td>
<td>280 A, 100% duty cycle</td>
<td>13N</td>
<td>.020–1/8 in. (0.5–3.2 mm)</td>
<td>Three-piece</td>
</tr>
</tbody>
</table>
Maxstar® 280 Control Panel

1. Standby Switch
2. Voltmeter Display
3. Ammeter Display
4. Output Contactor “On” Indicator
5. DC TIG (HF Start) Process Menu Parameters
   - Amperage: 1–280 A**
   - Pulse*: Off–250 pps
   - Postflow: Auto/Off–50 seconds
6. DC Stick (Schedule 1) Process Menu Parameters
   - Amperage: 5–280 A
   - DIG*: Off–100%

User Menu (Hold Menu button three seconds.)

DC TIG (HF Start)
1. Tungsten Size = .020–1/8 in. or .05–3.2 mm
2. Remote Trigger = STD/HOLD/OUTPUT ON

DC TIG (Lift-Arc)
1. Tungsten Size = .020–1/8 in. or .05–3.2 mm
2. Remote Trigger = STD/HOLD/OUTPUT ON

DC Stick (Schedule 1 and 2)
1. Hot Start = ON/OFF
2. Remote Trigger = OUTPUT ON/HOLD/STD

7. Memory Card Port
8. Activity Indicator
9. Encoder Control
10. Menu Ranges
11. DC TIG (Lift-Arc) Process Menu Parameters
    - Amperage: 1–280 A**
    - Pulse*: Off–250 pps
    - Postflow: Auto/Off–50 seconds
12. DC Stick (Schedule 2) Process Menu Parameters
    - Amperage: 5–280 A
    - DIG*: Off–100%
13. Process Selector

*Pro-Set parameter selectable.  **Amperage range is tungsten size dependent.

Tech Menu (Hold Menu button five seconds.)

1. Arc Time 0.0–9,999 hours
    0.0–59 minutes
    0–999,999 cycles
    Resettable
2. Error Log = Error event recorder
3. Sleep Timer = 1/5/10/15/30/45MIN/1HR
4. Stick Stuc = OFF/ON
5. OCV = LOW/NORM
6. Cooler Power = AUTO/OFF (only on Maxstar models with CPS )
7. Machine Reset
8. Software Number
9. Serial Number
Maxstar® 280 DX Control Panel

1. Standby Switch
2. Voltmeter Display
3. Ammeter Display

4. Process/Arc Starting
   TIG: HF impulse, Lift-Arc
   Stick: Adaptive Hot Start

5. Output Control
   Standard remote,
   2T trigger hold,
   Output on

6. Pulser Control
   Pulses per Second*
   DC: 0.1–500 pps
   Peak Time*
   5–95%
   Background Amps*
   5–95%

User Menu (Press Gas and Amperage buttons.)

1. Tungsten Size = .020–1/8 in./GEN or .05–3.2 mm
2. Remote Trigger = 3T/4T/4TL/4TE/4Tm
3. Stick Hot Start = ON/OFF

7. Memory Card Port
8. Activity Indicator
9. Encoder Control
10. Amperage Button

11. Gas/DIG
   Preflow 0.0–25.0 seconds
   Postflow Auto/Off–50 seconds
   DIG* Off–100%

12. Sequencer Control
   Initial Amps 1–280 A
   Initial Time 0.0–25.0 seconds
   Initial Slope 0.0–50.0 seconds
   Weld Time 0.0–999 seconds
   Final Slope 0.0–50.0 seconds
   Final Amps 1–200 A
   Final Time 0.0–25.0 seconds

   *Pro-Set parameter selectable.

Tech Menu (Hold Gas and Amperage buttons five seconds.)

1. Arc Time 0.0–9,999 hours
   0.0–59 minutes
   0–999,999 cycles
   Resettable
2. Error Log = Error event recorder
3. Sleep Timer = 1/5/10/15/30/45MIN/1HR
4. Stick Stuc = OFF/ON
5. OCV = LOW/NORM
6. Weld Timers = OFF/ON
7. Cooler Power = AUTO/ON/OFF (only on Maxstar models with CPS)
8. Locks = OFF/1–4
9. Meter Display
10. External Pulse Control = OFF/ON
11. Machine Reset
12. Software Number
13. Serial Number
## Maxstar® 280 Models/Packages

### Build an Air-Cooled Package
Select desired stock number for each step.

**Step 1 • Select Maxstar**

<table>
<thead>
<tr>
<th>Model</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maxstar 280</td>
<td>907552</td>
</tr>
<tr>
<td>Maxstar 280 with CPS</td>
<td>907538</td>
</tr>
<tr>
<td>Maxstar 280 DX</td>
<td>907553</td>
</tr>
<tr>
<td>Maxstar 280 DX with CPS</td>
<td>907539</td>
</tr>
</tbody>
</table>

Maxstar comes with adjustable shoulder strap, 8 ft. power cord (no plug) and two 50 mm Dinse-style connectors.

**Step 2 • Select Contractor Kit**

<table>
<thead>
<tr>
<th>Contractor Kit</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>A-150 TIG Torch and RFCS-14 HD Foot Control</td>
<td>301309</td>
</tr>
<tr>
<td>A-150 TIG Torch with RCCS-14 Fingertip Control</td>
<td>301311</td>
</tr>
<tr>
<td>A-200 TIG Torch with RFCS-14 HD Foot Control</td>
<td>301549</td>
</tr>
<tr>
<td>A-200 TIG Torch with RCCS-14 Fingertip Control</td>
<td>301550</td>
</tr>
</tbody>
</table>

Note: For models without the Cooler Power Supply (CPS), the Coolmate 1.3 must be powered through an external 120-volt facility power.

See page 7 for kit contents.

### Build a Water-Cooled Package
Select desired stock number for each step.

**Step 1 • Select Maxstar TIGRunner® and Coolant**

<table>
<thead>
<tr>
<th>Model</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maxstar 280 (with CPS) TIGRunner®</td>
<td>907538002</td>
</tr>
<tr>
<td>Maxstar 280 DX (with CPS) TIGRunner®</td>
<td>907539001</td>
</tr>
<tr>
<td>Low-Conductivity Coolant (must be ordered in quantities of 4)</td>
<td>043810</td>
</tr>
</tbody>
</table>

Maxstar TIGRunner comes with 8 ft. power cord (no plug), Coolmate™ 1.3 and Small Runner™ cart.

**Step 2 • Select Remote Control**

<table>
<thead>
<tr>
<th>Control</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wireless Foot</td>
<td>301580</td>
</tr>
<tr>
<td>RFCS-14 HD Foot</td>
<td>194744</td>
</tr>
<tr>
<td>RCC-14 E/W Fingertip</td>
<td>151086</td>
</tr>
<tr>
<td>RCCS-14 N/S Fingertip</td>
<td>043688</td>
</tr>
<tr>
<td>RMS-14 Pushbutton</td>
<td>187208</td>
</tr>
<tr>
<td>RMLS-14 Momentary/Maintained</td>
<td>129337</td>
</tr>
<tr>
<td>RHC-14 Hand</td>
<td>242211020</td>
</tr>
<tr>
<td>Wireless Hand</td>
<td>301582</td>
</tr>
</tbody>
</table>

See page 7 for remote descriptions.

**Step 3 • Select Torch Kit**

<table>
<thead>
<tr>
<th>Kit</th>
<th>Stock No.</th>
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</thead>
<tbody>
<tr>
<td>W-250 Kit</td>
<td>300185</td>
</tr>
<tr>
<td>W-280 Kit (recommended for 280 model)</td>
<td>300990</td>
</tr>
<tr>
<td>W-375 Kit</td>
<td>301268</td>
</tr>
</tbody>
</table>

See page 7 for kit contents.
Genuine Miller® Accessories

Protective Cover  301382
Fits Dynasty 210/280 and Maxstar 280.

Small Runner™ Cart  301318
Designed for Dynasty/Maxstar 210 and 280 with or without Coolmate® 1.3 cooler. Cart features single-cylinder rack, foot pedal holder, two cable/torch holders, and two TIG filler rod holders.

Coolmate® 1.3  300972  120 V
1.3-gallon cooler designed to cool torches up to 280 amps.

Performance TIG Gloves 263346 Small
263347 Medium
263348 Large
263349 X-Large
Completely lined, goat grain leather with triple-padded palm.

Memory Cards

Memory Card Expansion 301151 14-Pin Automation Expansion
Provides the ability to access common automation functions through the 14-pin connection.

301152 14-Pin Modbus® Expansion
Provides the ability to access basic and advanced functions through the 14-pin connection.

Memory Card (Blank)  301080
A blank, commercially available memory card used for transferring software updates and expandable features from your computer to the machine.

TIG Torches, Kits and Connectors

Weldcraft® A-200 (WP-26) TIG Torch
WP-26-12-R (12 ft.)
WP-26-25-R (25 ft.)
200-amp air-cooled torch. Torch body gas valve models also available.

Note: A-200 (WP-26) torches require 195379 connector.

Weldcraft® A-250 TIG Torch
301525025 No valve
301526025 With valve
250-amp air-cooled two-piece torch with 25-foot (7.6 m) cable.
Note: Two-piece torches require connector:
042533 Dinse-style
191981 Tweeco-style

Air-Cooled TIG Torch Connectors 195379 A-200 (WP-26)
195378* All others
50 mm Dinse-style for one-piece air-cooled torch.
*A-80 (WP-24) torches require 24-5 connector.

Water-Cooled TIG Torch Connectors 195377
Includes 20-foot (6 m) cord and 14-pin plug.

Weldcraft® A-200 (WP-26)
Torch kit 300990 shown.

Remote Controls and Switches

Remote Controls and Switches
Wireless Remote Foot Control  301580
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

Educational Materials

To order, please call Miller Literature at 866-931-9732 or visit MillerWelds.com/resources/tools.

Gas Tungsten Arc Welding (TIG) Publication 250833
Setup DVD  251116
Video topics include tungsten selection, setup menus, DC pulse, sequencer, balance and frequency settings.
### Equipment and Options

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>907552</td>
<td>Maxstar® 280 Auto-Line™ 208–575 V, 50/60 Hz, CSA. 8 ft. power cord</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907538</td>
<td>Maxstar® 280 with CPS Auto-Line™ 208–575 V, 50/60 Hz, CSA. 8 ft. power cord</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907553</td>
<td>Maxstar® 280 DX Auto-Line™ 208–575 V, 50/60 Hz, CSA. 8 ft. power cord</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907539</td>
<td>Maxstar® 280 DX with CPS Auto-Line™ 208–575 V, 50/60 Hz, CSA. 8 ft. power cord</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907539002</td>
<td>Maxstar® 280 DX with CPS International Auto-Line™ 208–575 V, 50/60 Hz, CE. 8 ft. power cord</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Water-Cooled Packages

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>907538002</td>
<td>Maxstar® 280 (with CPS) TIGRunner® Auto-Line™ 208–575 V, 50/60 Hz, CSA. 8 ft. power cord (Torch kit, accessories and coolant sold separately.)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907539001</td>
<td>Maxstar® 280 DX (with CPS) TIGRunner® Auto-Line™ 208–575 V, 50/60 Hz, CSA. 8 ft. power cord (Torch kit, accessories and coolant sold separately.)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Accessories

<table>
<thead>
<tr>
<th>Description</th>
<th>Stock No.</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>Protective Cover</td>
<td>301382</td>
<td>For Dynasty 210/280 and Maxstar 280</td>
<td></td>
</tr>
<tr>
<td>Small Runner® Cart</td>
<td>301318</td>
<td>For Dynasty/Maxstar 210 and 280 with or without Coolmate 1.3</td>
<td></td>
</tr>
<tr>
<td>Coolmate® 1.3</td>
<td>300972</td>
<td>120 V, 60 Hz, CSA. Requires coolant</td>
<td></td>
</tr>
<tr>
<td>TIG Coolant (must be ordered in quantities of 4)</td>
<td>043810</td>
<td>1-gallon plastic bottle. Protects against freezing to -37°F (-38°C) or boiling to 227°F (108°C)</td>
<td></td>
</tr>
<tr>
<td>TIG Gloves</td>
<td></td>
<td>See page 7</td>
<td></td>
</tr>
<tr>
<td>Memory Cards</td>
<td></td>
<td>See page 7</td>
<td></td>
</tr>
</tbody>
</table>

### TIG Torches, Kits and Connectors

**Air-Cooled Contractor Kits**

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>WP-17-12-R</td>
<td>Weldcraft® A-150 (WP-17) TIG Torch 12 ft. (3.7 m) cable. Requires 195378 connector</td>
<td></td>
<td></td>
</tr>
<tr>
<td>WP-17-25-R</td>
<td>Weldcraft® A-200 (WP-26) TIG Torch 12 ft. (3.7 m) cable. Requires 195379 connector</td>
<td></td>
<td></td>
</tr>
<tr>
<td>WP-26-12-R</td>
<td>Weldcraft® A-200 (WP-26) TIG Torch 12 ft. (3.7 m) cable. Requires 195379 connector</td>
<td></td>
<td></td>
</tr>
<tr>
<td>WP-26-25-R</td>
<td>Weldcraft® A-250 TIG Torch No valve. 25 ft. (7.6 m) cable With valve. 25 ft. (7.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Air-Cooled TIG Torch Connectors</td>
<td>195379 195378</td>
<td>Connects Weldcraft® A-200 (WP-26) torch to Dinse-style connector</td>
<td></td>
</tr>
<tr>
<td>Water-Cooled Torch Kits</td>
<td></td>
<td>See page 7</td>
<td></td>
</tr>
<tr>
<td>Water-Cooled TIG Torch Connector</td>
<td>195377</td>
<td>Connects Weldcraft® water-cooled torches to Dinse-style connector</td>
<td></td>
</tr>
<tr>
<td>Tungsten</td>
<td></td>
<td>See above</td>
<td></td>
</tr>
<tr>
<td>Remote Controls</td>
<td></td>
<td>See page 7</td>
<td></td>
</tr>
<tr>
<td>Educational Materials</td>
<td></td>
<td>See page 7</td>
<td></td>
</tr>
</tbody>
</table>

**Date: Total Quoted Price:**