

MIGmatic™ M-Series

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Air-Cooled MIG (GMAW) Welding Guns 

Quick Specs

Industrial Applications

Auto Body
Fabrication
Hobby
Maintenance and Repair

Process

MIG (GMAW)
Flux Cored (FCAW)

Rated Output M-100: 100 A, M-150: 150 A, M-25/M-25M: 250 A

Duty Cycle 100% with CO₂ gas, 60% with mixed gas

Weight 3.2–7.5 lb (1.5–3.4 kg) depending on gun

The Power of Blue.®

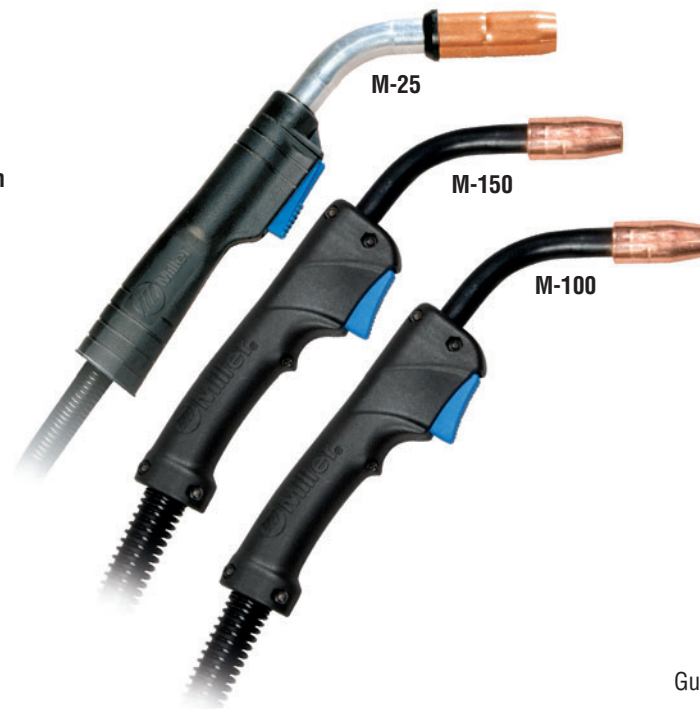
M-Series welding guns are an ideal match for Miller integrated MIG packages or other Miller wire feeders.

Three-piece nozzle construction extends nozzle life by reducing wear and helps prevent rocking of nozzle on contact tip adapter.

Interchangeable contact tips help reduce parts inventory.

Brass contact tip adapter helps prevent galling, sticking and stripping of threads.

Single-piece high-impact handle is almost indestructible with ergonomic design.



Steel spring strain relief protects power cable from wear and helps prevent liner from kinking, allowing better wire feedability. (Not available on M-100).

360-degree rotatable gooseneck permits trigger activation with either the finger or thumb

Interchangeable monocoil liners help reduce parts inventory and are available in most wire sizes.

Optional adapter kits are also available that enable M-Series guns to adapt to other brands of welding equipment.



Guns are warranted for 90 days parts and labor.

Specifications (Subject to change without notice.)

Model	Stock No.	Cable Length	Rated Output	Duty Cycle	Standard Wire Size	Weight	
M-100	#248 282	10 ft (3 m)	100 A	100% with CO ₂ gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	3.2 lb (1.5 kg)	
M-150	#249 039	10 ft (3 m)	150 A	100% with CO ₂ gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	4.4 lb (2.0 kg)	
	#249 040	12 ft (3.7 m)				4.7 lb (2.1 kg)	
	#249 041	15 ft (4.6 m)				6.0 lb (2.7 kg)	
M-25	#169 594	10 ft (3 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	5.4 lb (2.5 kg)	
	#169 596	12 ft (3.7 m)				6.0 lb (2.7 kg)	
	#169 598	15 ft (4.6 m)				.030–.035 in (0.8–0.9 mm)	7.2 lb (3.3 kg)
	#169 599					.035–.045 in (0.9–1.2 mm)	
M-25M	#169 601	15 ft (4.6 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	7.5 lb (3.4 kg)	



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Genuine Miller Accessories (Order from Miller Service Parts.)



M-Series Gun Consumable Kits

For M-100 and M-150.

#234 607 .023/.025 in (0.6 mm)

#234 608 .030 in (0.8 mm)

#234 609 .035 in (0.9 mm)

Kits contain 10 contact tips, 1 nozzle, and 1 contact tip adapter.

For M-25.

#234 610 .030 in (0.8 mm)

#234 611 .035 in (0.9 mm)

#234 612 .045 in (1.2 mm)

Kits contain 10 contact tips, 1 nozzle, 1 contact tip adapter, and 1 nozzle adapter.

Machine Adapter Kit #201 723

Allows MIGmatic welding guns to adapt to older Hobart products (Handler, Handler 120 and 150, BETA-MIG 170, 1800, 200, 250, 251 and BETA-MIG II).

Machine Adapter Kit #201 722

Allows MIGmatic welding guns to adapt to older Miller products (10, 30, 70, and 80 Series wire feeders).

Machine Adapter Kit #201 724

Allows MIGmatic welding guns to adapt to Lincoln products (LN-7, LN-8, LN-9, LN-22 and LN-25 series wire feeders; and SP-150, SP-200 and SP-250 machines).

Aluminum Conversion Kit #172 136

For M-25 and M-40 only. Allows 10 ft (3 m) guns to feed 3/64 in (1.2 mm) aluminum wire.

Consumables (Order from Miller Service Parts.)

Consumable	M-100/150	M-25	M-40
Contact Tips			
.023/.025 in (0.6 mm)	#087 299	#087 299	#087 299
.030 in (0.8 mm)	#000 067	#000 067	#000 067
.030 in (0.8 mm) tapered		#176 797	#176 797
.035 in (0.9 mm)	#000 068	#000 068	#000 068
.035 in (0.9 mm) tapered		#176 793	#176 793
.035 in (0.9 mm) heavy-duty		#187 117	#187 117
.045 in (1.2 mm)	#000 069	#000 069	#000 069
.045 in (1.2 mm) tapered		#176 794	#176 794
.045 in (1.2 mm) heavy-duty		#187 118	#187 118
3/64 in (1.2 mm) aluminum wire		#172 034	#172 034
.052 in (1.3 mm)		#044 392	#044 392
1/16 in (1.6 mm)			#172 024
5/64 in (2.0 mm)			#172 025
Contact Tip and Nozzle Adapters			
Contact tip/nozzle adapter	#169 716		
Contact tip adapter		#169 728	#169 728
Nozzle adapter		#169 729	#169 729
Nozzles			
1/2 in (13 mm) orifice flush tip (standard on M-100/150)	#169 715		
1/2 in (13 mm) orifice flush tip (standard on M-25)		#200 258	#200 258
1/2 in (13 mm) orifice 1/8 in (3.2 mm) recessed tip		#169 724	#169 724
5/8 in (16 mm) orifice flush tip (standard on M-40)		#169 726	#169 726
5/8 in (16 mm) orifice 1/8 in (3.2 mm) recessed tip		#169 725	#169 725
5/8 in (16 mm) orifice 1/8 in (3.2 mm) stickout tip		#169 727	#169 727
Spot flat		#176 238	#176 238
Spot inside corner		#176 240	#176 240
Spot outside corner		#176 242	#176 242
3/8 in (9.5 mm) orifice tapered		#176 243	#176 243
11/32 in (8.7 mm) orifice tapered		#178 386	#178 386
Gasless nozzle	#213 077	#213 078	#213 078
Replacement Liners			
.023/.025 in (0.6 mm)	#194 010	#194 010	#194 010
.030-.035 in (0.8-0.9 mm)	#194 011	#194 011	#194 011
.035-.045 in (0.9-1.2 mm)	#194 012	#194 012	#194 012
1/16-5/64 in (1.6-2.0 mm)			#194 013
3/64 in (1.2 mm) 10 ft (3 m) steel-wrapped nylon		#194 014	#194 014

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
M-100	#248 282	10 ft (3 m). For .030-.035 in (0.8-0.9 mm) wire		
M-150	#249 039	10 ft (3 m). For .030-.035 in (0.8-0.9 mm) wire		
	#249 040	12 ft (3.7 m). For .030-.035 in (0.8-0.9 mm) wire		
	#249 041	15 ft (4.6 m). For .030-.035 in (0.8-0.9 mm) wire		
M-25	#169 594	10 ft (3 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 596	12 ft (3.7 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 598	15 ft (4.6 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 599	15 ft (4.6 m). For .035-.045 in (0.9-1.2 mm) and wire		
M-25M	#169 601	15 ft (4.6 m). For .030-.035 in (0.8-0.9 mm) wire		

Date: Total Quoted Price:

Distributed by:

