Big Blue® 400 PipePro®

Diesel Engine-Driven Welder/AC Generator

Quick Specs

Heavy Industrial Applications
Cross-country pipeline
Process pipe welding

Processes
Stick (SMAW)
MIG (GMAW)*
Flux-cored (FCAW)*
RMD**
Pulsed MIG (GMAW-P)**
DC TIG (GTAW)
Air carbon arc (CAC-A)
Rated: 1/4-inch (6.4 mm) carbons

Output Range
DC stick 20–400 A
MIG/flux-cored 14–40 V
DC TIG 20–400 A

Generator Output Rated at 104°F (40°C)
12,000 watts peak, 10,000 watts continuous

Accu-Rated—Not Inflated Generator Power

*With wire feeder. **With ArcReach Smart Feeder.

Designed for the transmission pipeline welder.
The Big Blue 400 PipePro offers superior downhill stick arc characteristics, as well as MIG/flux-cored capabilities, to meet high-strength steel requirements for the most demanding pipeline jobs.

Heavy-duty low-speed T4F industrial diesel engines designed to operate over 10,000 hours before the first basic overhaul. Backed by worldwide support and service.

MITSUBISHI ENGINE NORTH AMERICA, INC.
Mitsubishi S4L2 four-cylinder diesel.

CATERPILLAR
C1.5T turbo-charged three-cylinder diesel.

DYNAMIC DIG

Optimized arc control for stick welding applications. See page 2.

ArcReach
Parameter control at the wire feeder or pendant without needing a control cord. See page 2.

Also available with stainless steel enclosure. See page 8.

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

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

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MillerWelds.com
Big Blue® 400 PipePro® Features and Controls

Digital meters with SunVision™ technology enable welding parameters to be viewed with greater clarity than analog meters — at virtually any angle. Meters can be seen clearly even in direct sunlight.

Meters display
- Process settings for quick and easy setup
- Preset and actual amperage

Simple-to-set controls require no elaborate procedure — just select process and weld.

10,000 watts of pure generator power. Plug in an extra Miller® inverter-based power source for a second welding arc.

Industrial USB port. Quickly upload the latest software and download machine log files.

Thermal overload protection prevents machine damage if the duty cycle is exceeded or airflow is blocked.

Quiet operation. Improves jobsite communication.

Optional stainless steel enclosure. Enhances durability and adds to the look and resale value of the machine.

Arc control allows arc characteristics to be adjusted in stick and wire processes. In stick modes, unlock the benefits of Dynamic DIG, which gives welders the fine-tuning they need to overcome issues related to fitup and inconsistencies in the pipe.

Standard 14-pin receptacle with Auto-Remote Sense™ for simple connection of remote controls and wire feeders.

Low OCV stick (VRD), when enabled, reduces the open-circuit voltage to 30 volts when the welding power source is not in use, increasing operator safety without compromising arc starts.

LINE-X® top cover is workbench tough and provides superior impact, corrosion and abrasion protection.

Standard features include wireless interface control, adjustable Hot Start™, automatic idle, thermal overload protection, 120-volt block heater, Dynamic DIG™ engine coolant temperature gauge and lift-off service door.

Big Blue® 400 PipePro® Technologies

Dynamic DIG™ technology

Ultra-adaptive arc control. Unlike conventional DIG that provides a preset amount of short-clearing current, Miller-exclusive Dynamic DIG technology works on a time-based algorithm that automatically adjusts the amount of current required to clear a short. Delivers a smoother more consistent arc that can be tailored to match application, material, fit-up and welder technique.

ArcReach® technology

Parameter control at the wire feeder or pendant without needing a control cord.

An ArcReach system allows you to change weld settings from your ArcReach feeder or Stick/TIG remote, saving a trip to the power supply. ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or Stick/TIG remote and the power source. This technology eliminates the need for control cords, and their associated problems and costs.

ArcReach-equipped power sources work with non-ArcReach accessories; however the ArcReach benefit is only realized with the complete ArcReach system. This includes an ArcReach-equipped machine and one or more of the following accessories:
- ArcReach SuitCase feeder
- ArcReach Smart Feeder
- ArcReach Stick/TIG Remote

See pages 6 and 7 for more information.
Big Blue® 400 PipePro® Technologies

Wireless interface control

Elevate your performance. Now get full control of your Big Blue 400 PipePro in the palm of your hand.

Delivering full weld process and parameter control, customizable presets and engine start/stop, wireless interface control eliminates the need to go back to your machine or climb into the truck to make adjustments — maximizing efficiency and saving you money on fuel.

Remote process and parameter changes. With wireless interface control, you can remotely make changes to critical processes and arc control parameters between passes or weld joints from wherever you are on the jobsite.

Programmable weld settings. You can also customize and save up to four different weld programs with the push of a button, saving you time, effort and adding consistency to your setup between welds.

VIEW STATUS
View engine status, fuel level, and battery charge level of remote.

SELECT PROCESSES
View and select between all available processes.

CONTACTOR ON/OFF
Turn contactor on/off manually in remote welding mode.

ENGINE ON/OFF
Turn engine on/off with remote.

CUSTOM PROGRAMS
Save custom presets in up to four programs and easily switch between pre-programmed settings.

FINE-TUNE ARC
Quickly adjust and save arc control settings including DIG, DIG range inductance and Auto-Stop.

AMP/VOLT ADJUST
Adjust amperage or voltage, by increments or percentage, while welding.

Wireless interface control is factory installed on all Big Blue 400 PipePro machines.

Big Blue® 400 PipePro® Benefits

Optimized processes for pipeline welding
Tailor your arc and increase deposition rates with welding processes and technologies optimized for pipe welding. Dynamic DIG offers ultimate flexibility in arc characteristic and penetration control. Advanced processes, available with the ArcReach® Smart Feeder, help operators improve quality and productivity on the right of way.

Easily update technology
With the industrial USB port, you can easily upload the latest software and download machine log files to retrieve in-depth information from your machine such as diagnostics and statistics.

Visit MillerWelds.com/support to download the latest software updates.

Built for the welding rig
The Big Blue 400 PipePro is the smallest, lightest and most powerful welder in its class. This means less wear and tear on the truck chassis, more room and capacity for equipment, and greater visibility out the rear window of the truck. The LINE-X® top cover and optional stainless steel enclosure provides additional durability for tough environments.

Jobsite safety
Reduce the need to walk back to or climb into the truck bed to make process and parameter changes, or turn your machine on/off. ArcReach® technology provides parameter control at the wire feeder or Stick/TIG remote and wireless interface control provides full front panel control in the palm of your hand, so you can lower the risk of encountering potential jobsite hazards.
### Engine Specifications (Engines warranted separately by the engine manufacturer.)

<table>
<thead>
<tr>
<th>Engine Brand</th>
<th>Features</th>
<th>HP</th>
<th>Type</th>
<th>Engine Speeds</th>
<th>Capacities</th>
<th>Automatic Engine Shutdown</th>
</tr>
</thead>
<tbody>
<tr>
<td>Caterpillar C1.5T</td>
<td>EPA Tier 4 Final compliant, includes 120 V block heater</td>
<td>24.7</td>
<td>Turbo-charged three-cylinder, liquid-cooled industrial diesel</td>
<td>Idle: 1,500 rpm  Weld: 1,800 rpm</td>
<td>Fuel: 11.5 gal. (43.5 L)  Oil: 5.9 qt. (5.6 L)  Coolant: 6 qt. (5.7 L)</td>
<td>Low oil pressure, high coolant temperature, low fuel level</td>
</tr>
<tr>
<td>Mitsubishi S4L2</td>
<td></td>
<td></td>
<td>Four-cylinder, liquid-cooled industrial diesel</td>
<td></td>
<td>Fuel: 11.5 gal. (43.5 L)  Oil: 5.8 qt. (5.5 L)  Coolant: 10 qt. (9.5 L)</td>
<td></td>
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</tbody>
</table>

### Performance Data

#### Fuel Consumption Curve

![Fuel Consumption Curve](image)

#### Simultaneous Welding and Power

<table>
<thead>
<tr>
<th>Weld Amperes</th>
<th>Total Aux. Power Available (Watts)</th>
</tr>
</thead>
<tbody>
<tr>
<td>25 A</td>
<td>10,000</td>
</tr>
<tr>
<td>75 A</td>
<td>10,000</td>
</tr>
<tr>
<td>125 A</td>
<td>10,000</td>
</tr>
<tr>
<td>175 A</td>
<td>9,000</td>
</tr>
<tr>
<td>225 A</td>
<td>7,500</td>
</tr>
<tr>
<td>300 A</td>
<td>4,500</td>
</tr>
<tr>
<td>350 A</td>
<td>1,000</td>
</tr>
</tbody>
</table>
1. Self-calibrating digital weld meters with fault code indication display preset or actual weld parameters.

2. Pushbutton main control knob used for adjusting amperage/voltage, adjusting arc control, and accessing the service menu.

3. LED process indicator. Front panel process selections are illuminated with an LED that identifies the active process. This enables the selected weld process to be seen at a distance from the power source.

4. Lift-Arc™ TIG with Auto-Stop™ and Auto-Crater™

5. USB port allows software updates from a USB drive. A summary file of recorded data from the unit will be saved to a USB drive that is inserted.

6. Weatherproof Lexan® nameplate is super durable and resists cracking and fading.

7. Adjustable arc control adjusts DIG when process control is in stick mode and adjusts inductance when process control is in FCAW or MIG mode. The amount of DIG determines how much amperage (heat) varies with stick arc length. Inductance determines the “wetness” of the weld puddle.

8. Maintenance interval reminder. Yellow and red indicator lights let an operator know when the machine is approaching and finally in need of routine maintenance.

9. Fuel indicator gauge. Low fuel shutdown shuts engine off prior to running out of fuel to prevent loss of fuel in the system, and make restarts easy.


11. Glow plugs assist in cold weather starting.

12. Engine control switch is used to start the engine and then select between auto idle and high speed lock.

13. Standard 14-pin receptacle for simple connection of remote controls and wire feeders. Includes Auto Remote Sense™ which automatically switches from panel to remote amperage/voltage (AV) control with remote connected. Eliminates confusion of a panel/remote switch.

14. 50 A, 120/240 V receptacle and 20 A, 120 V GFCI receptacles with circuit breakers

Note: For matching 240 V plug, order 119172.

15. Weld output terminals

ARC START with Lift-Arc™
- Touch or scratch
- Lift at any angle
- Workpiece
- Shielding gas
- Reduce or eliminates sticking
- Reduces or eliminates electrode-work contamination
- Low open-circuit voltage

ARC END with Auto-Stop™
- While welding
- For Auto-Stop, lift up to terminate arc
- Workpiece
- Shielding gas
- Lift up until arc ends
- Arc ends without flare
- Move back down to maintain gas coverage
- Eliminates need for a remote control
- Maintains shielding gas coverage
- Eliminates tungsten and workpiece contamination
- Eliminates unwanted arc strikes outside the weld area

ARC END with Auto-Crater™
- While welding
- To start Auto-Crater, press momentary contact switch
- Workpiece
- Shielding gas
- Welding current ramps down
- Maintain shielding gas coverage
- Maintains shielding gas coverage
- Eliminates tungsten and workpiece contamination
- Auto-Crater time allows for addition of filler
- Eliminates unwanted arc strikes outside the weld area
Genuine Miller® Accessories

Wireless Interface Control Protective Covers
287594 Field
Five-pack of screen protectors for wireless interface control remote.

MIG (GMAW) or Flux-cored (FCAW)

Full KVA Adapter Cord 300517 Field
NEMA 14-50P to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.

Full KVA Plug Kit 119172 Field
120/240 V, 50 A plug (NEMA 14-50P) to fit full KVA receptacle.

Engine Filter Kits Field
274427 For CAT Turbo
252782 For Mitsubishi
Includes all filters required for proper engine maintenance. Oil filter, primary and secondary fuel filter, and primary air filter.

ArcReach® SuitCase® 8
951726 With Bernard® BTB Gun 300 A
951727 With Bernard® S-Gun™
951728 With Bernard® Dura-Flux™ gun

ArcReach® SuitCase® 12
951729 With Bernard® BTB Gun 300 A
951730 With Bernard® S-Gun™
951731 With Bernard® Dura-Flux™ gun

Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature M/6.55.

ArcReach® Smart Feeder 951733
For use with ArcReach models only (see page 3 for more information). Includes drive rolls and Bernard® PipeWorx 300-15 MIG gun. For MIG, FCAW, and advanced RMD® and pulse processes. See literature M/6.55.

Spoolmatic® 30A Spool Gun 130831
Air-cooled, 200-amp, one-pound spool gun for aluminum and stainless MIG. See literature M/1.73. Requires WC-24 Control (137549).

XR™ Wire Feeders and Guns
Push-pull system designed to handle difficult-to-feed soft alloy wires such as aluminum. See literature M/1.7 through M/1.74.

AC TIG (GTAW) Welding

The Dynasty 210 power sources can be run off the engine drive’s generator to provide two arcs with only one engine.

Multiple Operator Welding

The XMT 350 FieldPro and CST 280 power sources can be run off the engine drive’s generator to provide two arcs with only one engine.

Protective Cover 195301 Field
Blue water-resistant cover with Miller logo resists stains and mildew, and protects the finish of your welder.
Plasma Cutting

Spectrum® 375 X-TREME™ 907529
See literature PC/9.2.
Spectrum® 625 X-TREME™ 907579
See literature PC/9.6.
Spectrum® 875 907583
See literature PC/9.8.

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

Stick/TIG Remote Controls

ArcReach® Stick/TIG Remote 301325
When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature AY/14.5.

RHC-14 Hand Control 24221020
Miniature hand control for remote current, voltage and contactor control. Dimensions: 4 x 4 x 3.25 in. (102 x 102 x 82 mm). Includes 20-foot (6 m) cord and 14-pin plug.

Wireless Remote Hand Control 300440
For remote current, voltage and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

Wireless Antenna Kit 300749
Recommended for improved reception.

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

HWY-Mid Frame Trailer 301438
1,424-pound (646 kg) capacity highway trailer with welded steel tubing frame, heavy-duty axle with roller bearing hubs and leaf-spring suspension. Includes jack stand, fenders, lights, and dual hitch with 2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye.

Dual Hitch 301441
Combination 2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye in one reversible assembly.

RMS-14 On/Off Control 187208
Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

PRHC-14 Hand Control 195511
Complete current or voltage control brings 120 volts GFCI power to work area in a single cord. Housed in a durable, light aluminum case and includes 125-foot (38 m) cord with plugs.

Wireless Remote Hand Control 300440
For remote current, voltage and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

Wireless Antenna Kit 300749
Recommended for improved reception.

Trailer Specifications (Subject to change without notice.)

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<tr>
<th>Model</th>
<th>Gross Axle Weight Rating</th>
<th>Gross Vehicle Weight Rating</th>
<th>Net Payload</th>
<th>Height of Bed</th>
<th>Road Clearance</th>
<th>Track (Center to center of tires)</th>
<th>Standard Tires (Standard rating or P-size rating)</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HWY-Mid Frame</td>
<td>1,605 lb. (728 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>19.5 in. (495 mm)</td>
<td>8 in. (203 mm)</td>
<td>46 in. (1,168 mm)</td>
<td>ST175/80D-13 Load Range C</td>
<td>Length: 101 in. (2,565 mm) Width: 55 in. (1,397 mm)*</td>
<td>181 lb. (82 kg)</td>
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</table>

*Width at outside of fenders.
<table>
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<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tbody>
<tr>
<td>Big Blue® 400 PipePro®</td>
<td>907806</td>
<td>CAT. Stainless steel with wireless interface control and ArcReach</td>
<td></td>
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<tr>
<td></td>
<td>907806001</td>
<td>CAT. Blue with wireless interface control and ArcReach</td>
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<tr>
<td></td>
<td>907805</td>
<td>Mitsubishi. Stainless steel with wireless interface control and ArcReach</td>
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<tr>
<td></td>
<td>907805001</td>
<td>Mitsubishi. Blue with wireless interface control and ArcReach</td>
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<td>Field Accessories</td>
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<tr>
<td>Wireless Interface Control Protective Covers</td>
<td>287594</td>
<td>Five-pack of screen protectors for wireless interface control remote</td>
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<tr>
<td>Full KVA Adapter Cord</td>
<td>300517</td>
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<tr>
<td>Full KVA Plug Kit</td>
<td>119172</td>
<td>120/240 V</td>
<td></td>
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<tr>
<td>Engine Filter Kits</td>
<td>274427</td>
<td>For CAT Turbo. Includes air, oil and fuel filters</td>
<td>252782</td>
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<tr>
<td>Spark Arrester (Muffler) Kit</td>
<td>300585</td>
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<tr>
<td>FA-1D Lockable Flame Arrester Fuel Cap</td>
<td>043947</td>
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<tr>
<td>Protective Cover</td>
<td>195301</td>
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<tr>
<td>MIG/Flux-cored Welding</td>
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<tr>
<td>ArcReach® SuitCase® 8</td>
<td>951726</td>
<td>With Bernard® BTB Gun 300 A. See literature M/6.55</td>
<td>951727</td>
<td></td>
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<td></td>
<td>951727</td>
<td>With Bernard® S-Gun™</td>
<td>951728</td>
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<td></td>
<td>951729</td>
<td>With Bernard® BTB Gun 300 A. See literature M/6.55</td>
<td>951730</td>
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<tr>
<td></td>
<td>951731</td>
<td>With Bernard® S-Gun™</td>
<td></td>
<td></td>
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<tr>
<td>ArcReach® SuitCase® 12</td>
<td>951729</td>
<td>With Bernard® BTB Gun 300 A. See literature M/6.55</td>
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<tr>
<td></td>
<td>951731</td>
<td>With Bernard® S-Gun™</td>
<td></td>
<td></td>
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<tr>
<td>ArcReach® Smart Feeder</td>
<td>951733</td>
<td>MIG/FCAW/RMD®/pulse feeder with Bernard® PipeWorx 300-15 MIG gun. Tweco®-style connectors. See literature M/6.55</td>
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<tr>
<td>SuitCase® 12RC</td>
<td>951580</td>
<td>With Bernard® BTB Gun 300 A. See literature M/6.5</td>
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<tr>
<td>MIG (GMAW) and Flux-cored (FCAW) Guns</td>
<td>130831</td>
<td>See Bernard® literature SP-BTB and SP-DF</td>
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<tr>
<td>Spoolmatic® 30A Spool Gun</td>
<td>130831</td>
<td>Requires WC-24 Control. See literature M/1.73</td>
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<tr>
<td>WC-24 Control</td>
<td>137549</td>
<td>See literature M/1.73</td>
<td></td>
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<tr>
<td>XR™ Wire Feeder Control and Guns</td>
<td>137549</td>
<td>See literature M/1.7 through M/1.74</td>
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<tr>
<td>AC TIG Welding</td>
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<tr>
<td>Multiple Operator Welding</td>
<td></td>
<td>See page 6</td>
<td></td>
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<tr>
<td>Plasma Cutting</td>
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<tr>
<td>Stick/TIG Remote Controls</td>
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<tr>
<td>ArcReach® Stick/TIG Remote</td>
<td>301325</td>
<td>Provides remote control of stick and TIG processes without a control cord</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RHC-14 Hand Control</td>
<td>242211020</td>
<td>Hand control with 20 ft. (6 m) cord</td>
<td></td>
<td></td>
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<tr>
<td>Wireless Remote Hand Control</td>
<td>300430</td>
<td>Hand control with wireless 300 ft. (91.4 m) operating range</td>
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<tr>
<td>Wireless Antenna Kit</td>
<td>300749</td>
<td>Recommended for improved reception</td>
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<tr>
<td>RMS-14 On/Off Control</td>
<td>187208</td>
<td>Remote contactor control</td>
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<tr>
<td>RCC-14 Remote Contactor and Current Control</td>
<td>151086</td>
<td>Fingertip control</td>
<td></td>
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<tr>
<td>PRHC-14 Hand Control</td>
<td>195511</td>
<td>Hand control with 120 V GFCI receptacle, 125 ft. (38 m)</td>
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<tr>
<td>Extension Cables</td>
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<tr>
<td>Trailers and Hitches</td>
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<td></td>
<td></td>
<td></td>
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<tr>
<td>HWY-Mid Frame</td>
<td>301438</td>
<td>Trailer with lights, fenders and dual hitch. For highway use</td>
<td></td>
<td></td>
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<tr>
<td>Dual Hitch</td>
<td>301441</td>
<td>Combination 2 in. (50 mm) ball hitch and 3 in. (76 mm) lunette eye in one reversible assembly</td>
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<tr>
<td>Cable Tree</td>
<td>043826</td>
<td>Trailer-mounted cable holder</td>
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<tr>
<td>2-In-1 Document/Fire Extinguisher Holder</td>
<td>301236</td>
<td>Stores documents and holds a 5 lb. fire extinguisher</td>
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</table>

**Date:**

**Total Quoted Price:**

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