Auto-Set™ automatically provides the right settings to weld mild steel while infinite voltage control allows the flexibility to manually set your own parameters.

- Set the wire diameter, a blue light shows Auto-Set is activated
- Dial in the thickness of what you’re welding
- Start welding with the exact parameters you need!

Miller inverter technology combines best-in-class arc characteristics with the portability of a 35-pound machine. The arc is extremely forgiving to variations in arc length and travel speeds.

Angled cast-aluminum drive system with calibrated tension knob creates consistent feeding and easy setup for up to 15-foot MIG guns.

Quick Select™ drive roll makes setup quicker by offering three grooves — two for different size solid wire and a third for flux-cored wire.

Auto Spool Gun Detect™ automatically detects when a MIG gun or spool gun is connected eliminating the need for a switch.

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

Smooth-Start™ provides a smooth, spatter-free start. It’s the best-starting machine in the small MIG machine category.

Thermal overload protection shuts down unit and activates the over temperature light if airflow is blocked or duty cycle is exceeded. Automatically resets when unit cools.

Uses 4- or 8-inch (102 or 203 mm) spools and can be set up to weld with .024—.035 inch (0.6—0.9 mm) solid wire and .030—.045 inch (0.8—1.2 mm) flux-cored wire.
**Operation Modes**

**Auto-Set™ Mode**

Auto-Set eliminates guesswork and saves you time on setup. Turn wire speed control fully clockwise to select Auto-Set mode, and set the wire diameter to either .024 or .030 in. The Auto-Set light indicates mode is activated. Then select material thickness using the Auto-Set control.

Use Auto-Set when you want the speed, convenience and confidence of pre-set controls. Auto-Set automatically sets your welder to the proper parameters. It’s available for welding 24-gauge through 5/16-inch mild steel, and only works with .024 and .030 solid wires and C25 shielding gas (75% argon, 25% CO₂).

**Manual Mode**

When welding outside of Auto-Set’s capabilities, or if you prefer custom parameters, use manual mode. The parameter chart on the inside of the access door is an easy-to-use guide for determining your voltage and wire feed speed settings. Reference the white areas on the controls when welding in manual mode.

**Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Amperage Range</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output, 60 Hz</th>
<th>Wire Feed Speed</th>
<th>Wire Type and Diameter</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>30–190 A</td>
<td>140 A at 21 VDC, 40% duty cycle</td>
<td>21 5.0 3.8</td>
<td>60–600 ipm (1.5–15.2 m/min.)</td>
<td>Solid: .024–.035 in. (0.6–0.9 mm) Stainless: .024–.035 in. (0.6–0.9 mm) Flux-cored: .030–.035 in. (0.8–0.9 mm)</td>
<td>45</td>
<td>H: 12.5 in. (318 mm) W: 11.25 in. (286 mm) D: 20.5 in. (521 mm)</td>
<td>35 lb. (15.9 kg)</td>
</tr>
</tbody>
</table>

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

**Control Panel**

1. Power On Light
2. Over Temperature Light
3. Auto-Set Light
4. Wire Speed/Wire Diameter Control
5. Voltage/Material Thickness Control
6. Plastic Hub with Retaining Ring for 8-inch Spools (shaft also accepts 4-inch spools)
7. Calibrated Tension Knob
8. T-Knob (secures torch)
9. Drive Roll
10. Trigger Control Connector
11. Polarity Changeover Terminals

*Note: Power switch and gas solenoid are on machine back panel.*

**Performance Data**

**Duty Cycle Chart**

**Volt/Amp Curves**
## Genuine Miller® Accessories

### Spoolmate™ 100 Spool Gun

- **Model:** 300371
- **Direct-connect spool gun for all Millermatic 140, 141, 180, 190, 211 and Multimatic 200 models.**
- **Handles:** .030–.035 inch (0.8–0.9 mm) aluminum (4043 only) and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 135 amps, 30-percent duty cycle. Includes 12-foot (3.7 m) cable assembly and custom carrying case.

### Replacement/Optional MIG Gun

- **M-100 (Standard)**
  - Model: 248282
  - 10 ft. (3 m)

- **M-150 (Optional)**
  - Model: 249040
  - 12 ft. (3.7 m)
  - Model: 249041
  - 15 ft. (4.5 m)

- **All ship with liner 194011.**

### Running Gear/ Cylinder Rack

- **Model:** 301239
- **Heavy-duty construction with 8-inch rubber rear wheels. Convenient front handles, cable holders and plastic consumable box.** For gas cylinders no greater than 7 inches (178 mm) in diameter or 65 pounds (29.5 kg) in weight.

### Millermatic Protective Cover

- **Model:** 301262

### Purchase the Millermatic 190 package (951602) and receive the Millermatic 190 and running gear/cylinder rack (301239) packaged together!

## Consumables (Order from Miller Service Parts.)

### For M-100/M-150 Gun

#### Contact Tips

- **087299** .024 in. (0.6 mm)
- **000067** .030 in. (0.8 mm)
- **000068** .035 in. (0.9 mm)
- **000069** .045 in. (1.2 mm)

#### Contact Tip Adapter

- **169716**

#### Replacement Liners

- **194010** .024 in.
- **194011** .030–.035 in. (standard)
- **194012** .035–.045 in.
  - 15-foot length — trim to size needed.

#### Nozzle

- **169715**
  - 1/2-inch (13 mm) diameter orifice.
  - Nozzle flush with contact tip (standard).

#### Drive Rolls

- **Quick Select™ 261157**
  - For .024-inch (0.6 mm) or .030/.035-inch (0.8/0.9 mm) solid wire, and .030/.035-inch (0.8/0.9 mm) flux-cored wire.

- **Dual Groove, V-Knurled 202926**
  - For .030/.035-inch (0.8/0.9 mm) or .045-inch (1.2 mm) flux-cored wire.

#### M-Series Gun Consumable Kits

- **234607** .024 in. (0.6 mm)
- **234608** .030 in. (0.8 mm)
- **234609** .035 in. (0.9 mm)
  - Each kit contains ten contact tips, one nozzle, and one contact tip adapter.

### For Spoolmate™ 100 Spool Gun

#### Contact Tips (5 per package)

- **199730** .024 in. (0.6 mm)
- **186419** .030 in. (0.8 mm)
- **186406** .035 in. (0.9 mm)

#### Nozzle 186405

#### Drive Roll (1)

- **186413** For .030/.035-inch (0.8/0.9 mm) wire.

#### Push Roll (1)

- **186414** For .030/.035-inch (0.8/0.9 mm) wire.
## Power Source and Options

<table>
<thead>
<tr>
<th>Power Source and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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</thead>
<tbody>
<tr>
<td>Millermatic® 190</td>
<td>907613</td>
<td>240 V, 60 Hz</td>
<td></td>
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<tr>
<td>Millermatic® 190 with Running Gear/Cyl Rack</td>
<td>951602</td>
<td>Power source packaged with 301239 running gear/cylinder rack</td>
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### Guns

<table>
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<tr>
<th>Guns</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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</thead>
<tbody>
<tr>
<td>Spoolmate™ 100 Spool Gun</td>
<td>300371</td>
<td>12 ft. (3.7 m). Includes custom carrying case</td>
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<tr>
<td>M-100 Gun (Standard)</td>
<td>248282</td>
<td>10 ft. (3 m), .030 – .035 in. (0.8 – 0.9 mm)</td>
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<tr>
<td>M-150 Gun (Optional)</td>
<td>249040</td>
<td>12 ft. (3.7 m), .030 – .035 in. (0.8 – 0.9 mm)</td>
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<tr>
<td></td>
<td>249041</td>
<td>15 ft. (4.5 m), .030 – .035 in. (0.8 – 0.9 mm)</td>
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### Accessories

<table>
<thead>
<tr>
<th>Accessories</th>
<th>Stock No.</th>
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<td>Protective Cover</td>
<td>301262</td>
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<tr>
<td>Running Gear/Cylinder Rack</td>
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<td>Material Thickness Gauge</td>
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<tr>
<td>Flux-Cored Wire</td>
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<tr>
<td>Solid Wire</td>
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<tr>
<td>Shielding Gas Cylinder</td>
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<tr>
<td>Helmet/Gloves/Scratch Brush</td>
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### Available Through Miller Service Parts

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<td>Argon and AR/CO₂ Mix Flow Gauge Regulator</td>
<td>268546</td>
<td>Replacement standard regulator</td>
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<tr>
<td>CO₂ Flow Gauge Regulator</td>
<td>212492</td>
<td>Required if using 100-percent CO₂ gas</td>
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<tr>
<td>Contact Tips</td>
<td></td>
<td>See page 3</td>
<td></td>
<td></td>
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<tr>
<td>Contact Tip Adapter</td>
<td></td>
<td>See page 3</td>
<td></td>
<td></td>
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<tr>
<td>Replacement Liners</td>
<td></td>
<td>See page 3</td>
<td></td>
<td></td>
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<tr>
<td>Nozzles</td>
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<tr>
<td>Gasless Flux-Cored Nozzle</td>
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<tr>
<td>Drive Rolls</td>
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<tr>
<td>M-Series Gun Consumable Kits</td>
<td>234607</td>
<td>.024 in. (0.6 mm)</td>
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<tr>
<td></td>
<td>234608</td>
<td>.030 in. (0.8 mm)</td>
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<tr>
<td></td>
<td>234609</td>
<td>.035 in. (0.9 mm)</td>
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**Date:**

Total Quoted Price: