## Quick Specs

<table>
<thead>
<tr>
<th>Processes</th>
<th>MIG (GMAW)</th>
<th>Flux-cored (FCAW)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Input Power</td>
<td>200(208)/230 V, single-phase, 60 Hz</td>
<td></td>
</tr>
</tbody>
</table>

| Industrial Applications | Metal fabrication | Maintenance and repair | Farm/home | Light industrial |

| Amperage Range | 30–210 A |
| Rated Output | 160 A at 24.5 VDC, 60% duty cycle |
| Wire Feed Speed | 50–700 ipm (1.3–17.8 m/min.) |
| Max. Open-Circuit Voltage | 34.5 V |
| Net Weight | 178 lb. (81 kg) |

### Processes

- MIG (GMAW)
- Flux-cored (FCAW)

### Quick Specs

- **Auto-Set™** makes setup quick and easy and works with .030- and .035-inch wire. See page 2 for more information.

- **Infinite voltage control.** When used in manual mode provides broader operating range with finer control than a tap machine.

- **Line voltage compensation** keeps power constant even if power input varies by ±10 percent.

- **No more replacing mechanical output contactors.** Our built-in solid-state contactor circuit makes wire electrically “cold” until trigger is pulled, and gives you life-long welding output and performance.

- **Gun-On-Demand.™** Simply pull the trigger for either gun and you’re ready to weld. No wasted time installing modules and using gas valve kits.

- **Heavy-duty aluminum two-drive-roll system.**

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

- Compatible with Bobcat™ welder/generators.

### Comes Complete With:

- 15 ft. (4.6 m), 250-amp MDX™-250 MIG gun
- 10 ft. (3 m) work cable with clamp
- 7 ft. (2.1 m) power cord with plug
- Flow gauge regulator and gas hose for argon or AR/CO2 mix
- Factory-installed lowered running gear/cylinder rack
- .030/.035 in. reversible dual-groove drive rolls
- Extra contact tips
- Material thickness gauge (229895) ➤

### Improvements

- **IMPROVED!**

### New Features

- **Now with NEW! MDX Series MIG gun.**

- **EZ-Access™ consumable compartment and parameter chart.** Set weld parameters right the first time with convenient flip-down compartment that provides fast access to parameter chart and consumables. See page 3 for more information.

- **Aluminum MIG welding with optional Spoolmate™ 200 spool gun.** Wire feed speed control on the gun saves time by reducing trips back to the machine. Also compatible with more industrial Spoolmatic® spool guns.

### Welder Warranty

Welder is warranted for three years, parts and labor. Original main power rectifier parts are warranted for five years. Gun warranted for 90 days, parts and labor.
**Operation Modes**

Auto-Set™ eliminates guesswork and saves you time on setup.

Use Auto-Set when you want the speed, convenience and confidence of preset controls. Simply set the wire diameter, set the material thickness, and go! Auto-Set automatically sets your welder to the proper parameters. It’s available when welding mild steel with .030 or .035 solid wires and C25 shielding gas (75 percent argon, 25 percent CO₂).

You can also set the weld parameters manually. Simply refer to the flip-down parameter chart, and set the voltage and wire feed speed to the recommended settings for your application.

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

![Specification Table]

**Performance Data**

![Duty Cycle Chart]

**Control Panel**

![Control Panel Diagram]

1. Infinite Voltage Control/Material Thickness
2. Diagnostic Indicator Light
3. Wire Feed Speed Control/Wire Diameter
4. Auto-Set Light
5. Power On Indicator Light

Note: Operating temperature range: -4° to +104°F (-20° to +40°C). Storage temperature range: -22° to +122°F (-30° to +50°C).

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.
Standard Fully Loaded Features

**EZ-Change™ low cylinder rack**
- Operators no longer need to lift cylinders. Cylinders now easily roll on and off our EZ-Change™ low cylinder rack.

**Angled wire drive**
- Angled industrial aluminum dual-gear drive system significantly improves wire feeding and runs large spools of wire.
- Allows quick change of drive rolls without tools.
- Drive roll storage — no more lost drive rolls, extra drive rolls are conveniently stored next to drive motor.
- Operators no longer bump into and bend MIG gun and gun liner.

**Dual front handles**
- Split handle with rubber grips designed to move machine easily and allow work lead and MIG gun to be stored independently.
- Handles provide protection for front panel and MIG gun during transportation.

**EZ-Access™ consumable compartment and parameter chart**
- Convenient flip-down compartment holds parameter chart and storage for consumables.
Optional Fully Loaded Features

Elevated gun and cable rack

300335
- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.
- No more running over spool gun cables or cables dragging on the floor.
- Elevated gun and cable rack can be used with either a single or dual cylinder rack. (Elevated gun and cable rack is included with the dual EZ-Change™ low cylinder rack.)

Dual EZ-Change™ low cylinder rack with elevated gun and cable rack

300337
- Dual cylinder rack allows for easy storage of two cylinders.
- EZ-Change™ low cylinder rack eliminates the need to lift cylinders on and off cylinder rack.
- No more running over spool gun cables or cables dragging on the floor.
- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.
**Genuine Miller® Accessories**

**Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack**  300337
Dual cylinder rack allows operators to easily roll cylinders on and off the rack with no lifting. Gun and cable rack keeps cables off the floor and tangle free.

**Elevated Gun and Cable Rack**  300335
For use with single cylinder rack. *(Included with dual EZ-Change low cylinder rack.)*

**Protective Cover**  195142
Features side pocket. *(Not for use with dual cylinder rack or elevated gun and cable rack.)*

**Argon/Mixed Gas Regulator and Gas Hose**  195050

**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.

**MIG Guns**

**MDX™-250 MIG Gun**

- **MDX™-250 MIG Gun**
  - **with AccuLock™ MDX Consumables**
    - 1770035 10 ft. (3 m)
    - 1770036 12 ft. (3.7 m)
    - 1770037 15 ft. (4.6 m), standard
  - Industrial 250-amp MIG gun with consumables for .030/.035 in. (0.8/0.9 mm) wire.

**MDX™-250 MIG Gun**

- **with Industrial AccuLock™ S Consumables**
  - 1770041 10 ft. (3 m)
  - 1770042 12 ft. (3.7 m)
  - 1770043 15 ft. (4.6 m)
  - Industrial 250-amp MIG gun with consumables for .035/.045 in. (0.9/1.2 mm) wire.

**Spool Guns**

**Spoolmate™ 200 Spool Gun**  300497
Reliable and economical spool gun perfect for hobbyists and light fabricators who weld aluminum. Handles .030–.035 inch (0.8–0.9 mm) aluminum wires and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 160 amps, 60 percent duty cycle with 20-foot cable assembly. For detailed information, see Spoolmate literature M/1.47.

**Optional Spoolmate™ 200 Head Tubes**
- 300591 45-degree head tube
- 300592 9-inch extension head tube
- 243385 5-inch head tube

**Spoolmatic® 15A Spool Gun**  195156
**Spoolmatic® 30A Spool Gun**  130831
Ideal for aluminum welding jobs. Air-cooled, one-pound spool gun with 15-foot (4.6 m) or 30-foot (9.1 m) cable assembly. Rated at 200 amps at 100 percent duty cycle. For detailed information, see Spoolmatic literature M/1.73.
## Consumables

### For MDX™-250 MIG Guns

**Standard Miller® AccuLock™ MDX Consumables**
Smaller consumables and components to access hard-to-reach weldments.

**Contact Tips (10 per package)**
- **T-M023**: 0.023 in. (0.6 mm)
- **T-M030**: 0.030 in. (0.8 mm)
- **T-M035**: 0.035 in. (0.9 mm)
- **T-M045**: 0.045 in. (1.2 mm)

**Nozzles**
- **N-M1200C**: Copper, 1/2 in. ID, flush, standard
- **N-M1218C**: Copper, 1/2 in. ID, 1/8 in. recess
- **N-M5800C**: Copper, 5/8 in. ID, flush
- **N-M5818C**: Copper, 5/8 in. ID, 1/8 in. recess
- **N-M58XTC**: Copper, 5/8 in. ID, 1/8 in. stickout

**Diffuser D-M250**

### Monocoil Replacement Liners

- **10 ft. Liner**
  - **LM1A-10**: .023/.025 in. (0.6 mm)
  - **LM2A-10**: .030/.035 in. (0.8/0.9 mm)
  - **LM3A-10**: .035/.045 in. (0.9/1.2 mm)

- **12 ft. Liner**
  - **LM1A-12**: .023/.025 in. (0.6 mm)
  - **LM2A-12**: .030/.035 in. (0.8/0.9 mm)
  - **LM3A-12**: .035/.045 in. (0.9/1.2 mm)

- **15 ft. Liner**
  - **LM1A-15**: .023/.025 in. (0.6 mm)
  - **LM2A-15**: .030/.035 in. (0.8/0.9 mm)
  - **LM3A-15**: .035/.045 in. (0.9/1.2 mm)

### Optional Bernard® AccuLock™ Consumables
Consumables for increased durability and longer life when guns are used in industrial applications.

**Contact Tips (10 per package)**
- **T-A023CH**: .023 in. (0.6 mm)
- **T-A030CH**: .030 in. (0.8 mm)
- **T-A035CH**: .035 in. (0.9 mm)
- **T-A039CH**: .039 in. (1.0 mm)
- **T-A045CH**: .045 in. (1.2 mm)

**Nozzles**
- **N-A5800C**: Copper, 5/8 in. ID, flush, standard
- **N-A5818C**: Copper, 5/8 in. ID, 1/8 in. recess
- **N-A5814C**: Copper, 5/8 in. ID, 1/4 in. recess

**Diffuser D-MA250**

### For Spoolmate® 200 Spool Gun

**Note:** Spoolmate 200 spool gun ships with (2) .030 in. and (2) .035 in. contact tips and (1) nozzle.

**For Standard Heavy-Duty Head Tube**

**Contact Tips (5 per package)**
- **199387**: .030 in. (0.8 mm)
- **199388**: .035 in. (0.9 mm)

**Nozzle 050622**

**For Optional Head Tubes**
Note: The same consumables are used on 45-degree, 9-inch extension and 5-inch head tubes.

**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**

### For Spoolmatic® Spool Guns

**For Aluminum Wire**

**FasTip™ Contact Tips (25 per package)**
- **206186**: Heavy-duty, .030 in. (0.8 mm)
- **206187**: Heavy-duty, .035 in. (0.9 mm)
- **206188**: Heavy-duty, .040 in. (1.0 mm)
- **209026**: Tapered, .030 in. (0.8 mm)
- **209027**: Tapered, .035 in. (0.9 mm)

**Screw-On Nozzles**
- **199610**: Brass, 1/2 in. orifice, tapered
- **199613**: Brass, 5/8 in. orifice, tapered
- **199614**: Brass, 5/8 in. orifice, tapered HD
- **199611**: Brass, 3/4 in. orifice, straight
- **199612**: Brass, 3/4 in. orifice, straight HD
- **209035**: Copper, 3/8 in. orifice, tapered
- **199615**: Copper, 1/2 in. orifice, tapered
- **209036**: Copper, 1/2 in. orifice, tapered HD
- **199618**: Copper, 5/8 in. orifice, tapered HD
- **207313**: Copper, 5/8 in. orifice, tapered 15/16 OD
- **199616**: Copper, 3/4 in. orifice, straight
- **199617**: Copper, 3/4 in. orifice, straight HD

**Bernard® Centerfire™ “T” Series Contact Tips**
**T-035AL**: .035 in. (0.9 mm)

**Bernard® Centerfire™ Small Nozzles**
- **NST-3818B**: Brass, 3/8 in. ID, 1/8 in. tip recess
- **NS-1218B**: Brass, 1/2 in. ID, 1/8 in. tip recess
- **NS-1200B**: Brass, 1/2 in. ID, flush tip
- **NS-5818B**: Brass, 5/8 in. ID, 1/8 in. tip recess
- **NS-1218C**: Copper, 1/2 in. ID, 1/8 in. tip recess

### For Millermatic® 212 Auto-Set™

**V-Grooved Drive Roll Kits (solid wire)**
- **204579**: .030 and .035 in. (0.8 and 0.9 mm) combination (reversible)
- **087131**: .024 in. (0.6 mm)
- **079594**: .030 in. (0.8 mm)
- **079595**: .035 in. (0.9 mm)

**V-Knurled Drive Roll Kits**
( flux-cored or difficult-to-feed wire)
- **079606**: .035 in. (0.9 mm)
- **079607**: .045 in. (1.2 mm)

**Note:** Miller® FasTip™, M-Series and Bernard Centerfire™ diffusers and consumables are NOT compatible with MDX Series guns.

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**Note:** Miller® FastTip™, M-Series and Bernard Centerfire™ diffusers and consumables are NOT compatible with MDX Series guns.
## Steel Configuration

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>907405</td>
<td><strong>Millermatic® 212 Auto-Set™</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>087131</td>
<td>Millermatic V-Grooved Drive Roll Kits (solid wire)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079594</td>
<td>.024 in. (0.6 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079595</td>
<td>.030 in. (0.8 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>204579</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079606</td>
<td>Millermatic V-Knurled Drive Roll Kits (flux-cored)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079607</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
<td></td>
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<tr>
<td>T-M023</td>
<td><strong>Miller® AccuLock™ MDX™ Contact Tips</strong> (10 per package)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>T-M030</td>
<td>.023 in. (0.6 mm)</td>
<td></td>
<td></td>
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<tr>
<td>T-M035</td>
<td>.030 in. (0.8 mm)</td>
<td></td>
<td></td>
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<tr>
<td>T-M045</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
<td></td>
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<tr>
<td>T-M045</td>
<td>.045 in. (1.2 mm)</td>
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<tr>
<td>N-M1200C</td>
<td><strong>Miller® AccuLock™ MDX™ Nozzles</strong></td>
<td></td>
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<tr>
<td>N-M1218C</td>
<td>Copper, 1/2 in. ID, flush, standard</td>
<td></td>
<td></td>
</tr>
<tr>
<td>N-M5800C</td>
<td>Copper, 5/8 in. ID, flush</td>
<td></td>
<td></td>
</tr>
<tr>
<td>N-M5818C</td>
<td>Copper, 5/8 in. ID, 1/8 in. recess</td>
<td></td>
<td></td>
</tr>
<tr>
<td>N-M58XTC</td>
<td>Copper, 5/8 in. ID, 1/8 in. stickout</td>
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</table>

## Aluminum Configuration

For MDX-250 gun consumables and Millermatic 212 Auto-Set drive rolls, see steel configuration chart above.

<table>
<thead>
<tr>
<th>Stock No.</th>
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<tbody>
<tr>
<td>951177</td>
<td><strong>Millermatic® 212 Spool Gun Package</strong> (includes standard MDX®-250 MIG gun)</td>
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<tr>
<td>199387</td>
<td>Spoolmate® 200 Contact Tips (5 per package)</td>
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<tr>
<td>199388</td>
<td>.030 in. (0.8 mm) wire</td>
<td></td>
<td></td>
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<tr>
<td>199389</td>
<td>.035 in. (0.9 mm) wire</td>
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<tr>
<td>050622</td>
<td>Spoolmate® 200 Nozzle</td>
<td></td>
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<tr>
<td>300591</td>
<td>Optional Spoolmate® 200 Head Tubes</td>
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<tr>
<td>300592</td>
<td>45-degree head tube</td>
<td></td>
<td></td>
</tr>
<tr>
<td>243838</td>
<td>9 in. extension head tube</td>
<td></td>
<td></td>
</tr>
<tr>
<td>243838</td>
<td>5 in. head tube</td>
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## Accessories

<table>
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<tr>
<th>Description</th>
<th>Stock No.</th>
<th>Qty.</th>
<th>Price</th>
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<tbody>
<tr>
<td>Dual EZ-Change® Low Cylinder Rack with Elevated Gun and Cable Rack</td>
<td>300337</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Elevated Gun and Cable Rack</td>
<td>300335</td>
<td></td>
<td></td>
</tr>
<tr>
<td>For use with single cylinder rack (included with dual EZ-Change low cylinder rack)</td>
<td></td>
<td></td>
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</tr>
<tr>
<td>Protective Cover</td>
<td>195142</td>
<td></td>
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<tr>
<td>Argon/Mixed Gas Regulator and Gas Hose</td>
<td>195050</td>
<td></td>
<td></td>
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<tr>
<td>Full KVA Adapter Cord</td>
<td>300517</td>
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## Guns

<table>
<thead>
<tr>
<th>Description</th>
<th>Stock No.</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>MDX-250 MIG Gun</strong> with AccuLock™ MDX Consumables</td>
<td>1770035</td>
<td>10 ft. (3 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire</td>
<td></td>
</tr>
<tr>
<td><strong>MDX-250 MIG Gun</strong> with Industrial AccuLock™ S Consumables</td>
<td>1770036</td>
<td>12 ft. (3.7 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire</td>
<td></td>
</tr>
<tr>
<td><strong>MDX-250 MIG Gun</strong> with Industrial AccuLock™ S Consumables</td>
<td>1770037</td>
<td>15 ft. (4.6 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire</td>
<td></td>
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<tr>
<td><strong>MDX-250 MIG Gun</strong></td>
<td>1770041</td>
<td>10 ft. (3 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire</td>
<td></td>
</tr>
<tr>
<td><strong>MDX-250 MIG Gun</strong></td>
<td>1770042</td>
<td>12 ft. (3.7 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire</td>
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</tr>
<tr>
<td><strong>MDX-250 MIG Gun</strong></td>
<td>1770043</td>
<td>15 ft. (4.6 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire</td>
<td></td>
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<tr>
<td>Spoolmate® 200</td>
<td>300497</td>
<td>20 ft. (6 m), 160 A, .030–.035 in. (0.8–0.9 mm) for aluminum wire, .023–.035 in. (0.6–0.9 mm) for steel/stainless steel wires</td>
<td></td>
</tr>
<tr>
<td>Spoolmatic® 15A</td>
<td>195156</td>
<td>15 ft. (4.6 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum wire</td>
<td></td>
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<tr>
<td>Spoolmatic® 30A</td>
<td>130831</td>
<td>30 ft. (9 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum wire</td>
<td></td>
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