**Millermatic® 252**

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

**Input Power**
- 200(208)/230 V, single-phase, 60 Hz
- 230/460/575 V, single-phase, 60 Hz

**Amperage Range**
- 30–300 A

**Rated Output**
- 200 A at 28 VDC, 60% duty cycle
- 250 A at 28 VDC, 40% duty cycle

**Wire Feed Speed**
- 50–700 ipm (1.3–17.8 m/min.)

**Max. Open-Circuit Voltage**
- 38 V

**Net Weight**
- 207 lb. (94 kg)

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

**Highest output in its class (250 A at 28 VDC).** Weld longer on high-end applications.

**Infinite voltage control with self-calibrating digital meters** that permit presetting of voltage and wire feed speed. Ensures precise parameters and accuracy.

**Integrated digital timers** come complete with presettable preflow/postflow, burnback, spot and delay (stitch) timers. Independent timers for MIG and spool gun.

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

**Active Arc Stabilizer™** minimizes weld cleanup, and provides excellent starts proven superior to the competition.

**Auto Gun Detect™** allows operator to simply pull trigger on MIG gun, spool gun or push/pull gun. Automatically detects and recalls the voltage, wire feed speed and timer of the active gun. See page 3 for more information.

**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 through the machine.

**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.
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. Spool Size</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>30–300 A</td>
<td>200 A at 28 VDC, 60% duty cycle</td>
<td>200(208) V 230 V 460 V 575 V KVA 0.33* 0.44*</td>
<td>50–700 ipm (1.3–17.8 m/min.)</td>
<td>Solid/stainless steel: .030–.045 in. (0.8–1.2 mm) Flux-cored: .023–.045 in. (0.6–1.2 mm)</td>
<td>12 in. (305 mm)</td>
<td>38</td>
<td>H: 30 in. (762 mm) W: 19 in. (483 mm) D: 40 in. (1,016 mm)</td>
<td>207 lb. (94 kg)</td>
</tr>
<tr>
<td>30–300 A</td>
<td>250 A at 28 VDC, 40% duty cycle</td>
<td>42 21 17 9.8 7.5</td>
<td>2.3* 1* 8.4* 0.46* 0.13*</td>
<td>Solid/stainless steel: .030–.045 in. (0.8–1.2 mm) Flux-cored: .023–.045 in. (0.6–1.2 mm)</td>
<td>12 in. (305 mm)</td>
<td>38</td>
<td>H: 30 in. (762 mm) W: 19 in. (483 mm) D: 40 in. (1,016 mm)</td>
<td>207 lb. (94 kg)</td>
</tr>
</tbody>
</table>

*While idling.

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.

Control Panel

1. Voltmeter
2. Voltage Control
3. Wire Speed Meter
4. Wire Speed Control

Performance Data

Duty Cycle Chart

Volt/Amp Curves
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.

**Auto-Gun Detect™**
- Simply pull the trigger for either the MIG, spool gun or any Miller® push-pull gun. The Millermatic 252 automatically recalls voltage, wire feed speed and timer of the active gun.
- Reduces setup time!
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.
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 14-50R to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.

### 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 14-50R 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 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

**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.

**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.

## Push-Pull Guns

**XR-Aluma-Pro™ Lite Push-Pull Gun**
- 300948 25 ft. (7.6 m)
Air-cooled gooseneck-style gun for .030–.047 in. (0.8–1.2 mm) aluminum. Rated at 175 amps at 60 percent duty cycle.

**XR-Aluma-Pro™ Push-Pull Gun**
- 300000 15 ft. (4.6 m)
- 300001 25 ft. (7.6 m)
Air-cooled gooseneck-style gun for .030–.047 in. (0.8–1.2 mm) aluminum. Rated at 300 amps at 100 percent duty cycle.

**U-Grooved Aluminum Drive Roll and Accessory Kits for XR-Aluma-Pro Push-Pull Guns**
- 195311 .035 in. (0.9 mm)
- 195313 .047 in. (1.2 mm)
Kits include Millermatic U-grooved drive rolls, nylon wire guides and contact tips.

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

**Female Receptacle**
## 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-MS5800C Copper, 5/8 in. ID, flush
- N-MS5818C Copper, 5/8 in. ID, 1/8 in. recess
- N-MS58XTC Copper, 5/8 in. ID, 1/8 in. stickout

**Diffuser D-M250**

### For Spoolmatic® Spool Guns and XR™ Push-Pull 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)
- 206189 Heavy-duty, 3/64 in. (1.2 mm)
- 206191 Heavy-duty, 1/16 in. (1.6 mm)

**Nozzles**
- N-MA250

**Diffuser D-MA250**

### For Millermatic® 252

**Note:** Machine drive roll kits include two drive rolls and an inlet guide.

**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)
  - 079596 .045 in. (1.2 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)

**U-Grooved Drive Roll Kits** (aluminum wire)
- 044749 .035 in. (0.9 mm)
- 079599 .047 in. (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-035AL .035 in. (0.9 mm)
- T-047AL .047 in. (1.2 mm)
- T-062AL 1/16 in. (1.6 mm)

**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

**Bernard® Centerfire™ “T” Series Contact Tips**
- T-035AL .035 in. (0.9 mm)
- T-047AL .047 in. (1.2 mm)
- T-062AL 1/16 in. (1.6 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 Spoolmate™ 200 Spool Gun

**Note:** Spoolmate 200 spool guns ship 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, 5-inch, and 9-inch extension head tubes.

**Contact Tips (5 per package)**
- 199730 .024 in. (0.6 mm)
  (requires V-knurled drive roll 136135)
- 186419 .030 in. (0.8 mm)
- 186406 .035 in. (0.9 mm)

**Nozzle 186405**

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

#### Steel Configuration

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>907321</td>
<td>200(208)/230 V, 60 Hz</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907322</td>
<td>230/460/575 V, 60 Hz</td>
<td></td>
<td></td>
</tr>
<tr>
<td>087131</td>
<td>.024 in. (0.6 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079594</td>
<td>.030 in. (0.8 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079595</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>079596</td>
<td>.045 in. (1.2 mm)</td>
<td></td>
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<tr>
<td>079606</td>
<td>.035 in. (0.9 mm)</td>
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<tr>
<td>079607</td>
<td>.045 in. (1.2 mm)</td>
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<tr>
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<tr>
<td>079595</td>
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<tr>
<td>079596</td>
<td>.045 in. (1.2 mm)</td>
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</tr>
</tbody>
</table>

#### Aluminum Configuration (Spool Gun)

For MDX-250 gun consumables and non-aluminum Millermatic 252 drive rolls, see steel configuration chart above.

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>951066</td>
<td>200(208)/230 V, 60 Hz with Spoolmatic® 30A, dual cylinder rack, elevated gun and cable rack, regulator and hose</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951065</td>
<td>230/460/575 V, 60 Hz with Spoolmatic® 30A, dual cylinder rack, elevated gun and cable rack, regulator and hose</td>
<td></td>
<td></td>
</tr>
<tr>
<td>206187</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>206188</td>
<td>.040 in. (1.0 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>206189</td>
<td>.047 in. (1.2 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>198855</td>
<td>5/8 in. (16 mm) diameter</td>
<td></td>
<td></td>
</tr>
<tr>
<td>199618</td>
<td>5/8 in. (16 mm) diameter, HD</td>
<td></td>
<td></td>
</tr>
<tr>
<td>199616</td>
<td>3/4 in. (19 mm) diameter</td>
<td></td>
<td></td>
</tr>
<tr>
<td>199617</td>
<td>3/4 in. (19 mm) diameter, HD</td>
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</tr>
</tbody>
</table>

#### Aluminum Configuration (Push-Pull Gun)

For MDX-250 gun consumables and non-aluminum Millermatic 252 drive rolls, see steel configuration chart above.

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>907321</td>
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<tr>
<td>907322</td>
<td>230/460/575 V, 60 Hz</td>
<td></td>
<td></td>
</tr>
<tr>
<td>300948</td>
<td>25 ft. (7.6 m)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>300000</td>
<td>15 ft. (4.6 m)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>300001</td>
<td>25 ft. (7.6 m)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>044749</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
<td></td>
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<tr>
<td>079599</td>
<td>.047 in. (1.2 mm)</td>
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<tr>
<td>195311</td>
<td>.035 in. (0.9 mm)</td>
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<tr>
<td>195313</td>
<td>.047 in. (1.2 mm)</td>
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<tr>
<td>T-035AL</td>
<td>.035 in. (0.9 mm)</td>
<td></td>
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</tr>
<tr>
<td>T-047AL</td>
<td>.047 in. (1.2 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>206187</td>
<td>.035 in. (0.9 mm)</td>
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<td></td>
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<tr>
<td>206188</td>
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</tr>
<tr>
<td>199616</td>
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</tr>
<tr>
<td>199617</td>
<td>3/4 in. (19 mm) diameter, HD</td>
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</table>

### Date:                                                                                   Total Quoted Price:
## Ordering Information

<table>
<thead>
<tr>
<th>Accessories</th>
<th>Stock No.</th>
<th>Description</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>
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<tr>
<td>Elevated Gun and Cable Rack</td>
<td>300335</td>
<td>For use with single cylinder rack</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(included with dual EZ-Change low cylinder rack)</td>
<td></td>
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<tr>
<td>Protective Cover</td>
<td>195142</td>
<td>Features side pocket</td>
<td></td>
<td></td>
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<tr>
<td>Argon/Mixed Gas Regulator and Gas Hose</td>
<td>195050</td>
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<tr>
<td>Full KVA Adapter Cord</td>
<td>300517</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Guns

#### MDX™-250 MIG Gun with AccuLock™ MDX Consumables
- Stock No.: 1770035
- Description: 10 ft. (3 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire
- Description: 12 ft. (3.7 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire
- Description: 15 ft. (4.6 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire

#### MDX™-250 MIG Gun with Industrial AccuLock™ S Consumables
- Stock No.: 1770041
- Description: 10 ft. (3 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire
- Description: 12 ft. (3.7 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire
- Description: 15 ft. (4.6 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire

#### Spoolmatic® 15A
- Stock No.: 195156
- Description: 15 ft. (4.6 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum wire

#### Spoolmatic® 30A
- Stock No.: 130831
- Description: 30 ft. (9 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum wire

#### Spoolmate™ 200
- Stock No.: 300497
- Description: 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

#### Optional Spoolmate™ 200 Head Tubes
- Stock No.: 300591
- Description: 45-degree head tube
- Stock No.: 300592
- Description: 9 in. extension head tube
- Stock No.: 243385
- Description: 5 in. head tube

#### XR-Aluma-Pro™ Lite Gun (air-cooled)
- Stock No.: 300948
- Description: 25 ft. (7.6 m), 175 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire

#### XR-Aluma-Pro™ Gun (air-cooled)
- Stock No.: 300000
- Description: 15 ft. (4.6 m), 300 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire
- Stock No.: 300001
- Description: 25 ft. (7.6 m), 300 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire

Note: See page 7 for ordering information on the Millermatic 252 — available packages, steel and aluminum configurations, and drive roll kits/consumables.

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The Power of Blue