The Multimatic 220 AC/DC. It does... so you can too.

Ideal for hobbyists and small shops, the Multimatic 220 AC/DC gives you the freedom to weld any process — MIG, flux-cored, stick, and AC/DC TIG — with one portable, powerful, easy-to-use machine. Setup and switching processes are fast and easy, all while ensuring excellent arc quality using either 120- or 240-volt power.
Multimatic® 220 AC/DC Features and Benefits

All in One

Take on more projects with one machine that has MIG, DC stick, and AC/DC TIG.
- **MIG:** 24 ga.–3/8 in. steel
  18 ga.–3/8 in. aluminum
- **DC Stick:** 16 ga.–3/8 in. steel
- **AC/DC TIG:** 24 ga.–1/4 in. steel and aluminum

The Multimatic 220 AC/DC comes equipped with all accessories to weld any process, unlike other machines where you need to purchase additional accessories.

Easy to Use

**QuickTech™** technology, setup and changing processes is even easier.
- **Automatically** determines the polarity. Work is always connected to the bottom right receptacle. MIG gun and TIG torch can stay connected at the same time.
- **Automatically** switches to the right process. Just hit the trigger or the foot control and the machine automatically changes, eliminating the need to manually change processes.
- **Automatically** recalls the settings from the last process used.

**Auto-Set™ Elite** fast and easy predefined settings for multiple materials and processes to help you get welding quickly.
- Available for all processes (MIG, stick, AC TIG, DC TIG) with the ability to fine-tune your settings.
- Set weld parameters by selecting:
  - MIG (shown) – wire diameter and material thickness
  - Stick – electrode type, diameter and material thickness
  - AC/DC TIG – tungsten diameter and material thickness

**Pro-Set™** (TIG and stick manual modes) eliminates the guesswork when setting weld parameters. Simply adjust control until Pro-Set appears on the display and the number turns blue.
- **AC Balance** (AC TIG) — controls the cleaning action (Pro-Set 75%)
- **AC Frequency** (AC TIG) — controls the width of the arc cone (Pro-Set 120 Hz)
- **Pulse** (DC TIG) — helps focus the arc for increased stability, penetration and travel speed (Pro-Set 100 Hz)
- **DIG** (Stick) — lets you tailor arc characteristics for a wide range of applications (Pro-Set 30% 7018 electrodes)

**Robust, angled wire drive with Quick Select™ drive roll** for easily changing one wire type/diameter to another. Quick Select drive roll offers three grooves — two for different size solid wires and a third for flux-cored wire.

**Two shielding gas connections** so both gases can be left connected to the machine, no switching needed. One connection for MIG gas and one for TIG gas.

**Easy-to-understand interface** with 3.5-inch color LCD display and intuitive connection setup images.
Multimatic® 220 AC/DC Features and Benefits

Portable

Weighing only 56 pounds, the Multimatic 220 AC/DC can go where the work is, plus the added convenience of one machine versus two or more.

Optional dual cylinder rack cart

Dual cylinder rack cart offers portability while holding two gas cylinders.

Versatile

Operates on 120-volt or 240-volt power letting you work virtually anywhere. Multi-voltage plug (MVP™) easily connects to common 120-volt or 240-volt power outlets — no tools required. Choose the plug that fits the receptacle and connect it to the power cord.

14-pin controlled operator alternatives. The standard 14-pin connector on your Multimatic 220 AC/DC lets you choose your control for a customized experience, whether it’s a foot control, fingertip control, or wireless foot control.

Optional wireless foot control shown.

Wide range of TIG adjustability.

- AC Balance – adjustable from 60–80%
- AC Frequency – adjustable from 60–150 Hz
- DC Pulse – adjustable from Off–150 pulses per second (PPS)
- TIG Post-Flow – adjustable from Auto–25 seconds (accessible through service menu screen 12)
- Lift-Arc™ and high-frequency starts
- Tungsten size selection
Multimatic® 220 AC/DC Package

Comes complete with:
- Power source
- 6.5 ft. (2 m) power cord with MVP plugs for 120 V and 240 V
- 10 ft. (3 m) M-100 MIG gun and cable assembly
- 13 ft. (4 m) cable electrode holder and 25 mm Dinse-style connector
- 12.5 ft. (3.8 m) Weldcraft® A-150 (WP-17) TIG torch with 25 mm Dinse-style connector
- RFCS-14 HD foot control with 20 ft. (6 m) cord
- 10 ft. (3 m) work cable with clamp and 25 mm Dinse-style connector
- Two flow gauge regulators and gas hoses for argon and AR/CO2 mix
- Hobart® spool of .030 in. (0.8 mm) solid wire
- Two contact tips for .030 in. (0.8 mm) wire
- Quick Select™ drive roll for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire
- AK2C TIG torch accessory kit
- Material thickness gauge
- 229895
- Hook-and-loop cord wraps
- Note: Shielding gas and safety equipment not included.

Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Welding Mode/Process</th>
<th>Input Power</th>
<th>Welding Amperage Range</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output, 50/60 Hz</th>
<th>Wire Feed Speed</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>CV: MIG/flux-cored</td>
<td>120 V</td>
<td>30–125 A</td>
<td>105 A at 19.2 V, 60% duty cycle</td>
<td>23.3</td>
<td>60–600 ipm (1.5–15.2 m/min.)</td>
<td>45 VDC</td>
<td>H: 17.5 in. (445 mm) W: 11.25 in. (286 mm) D: 21.5 in. (546 mm)</td>
<td>56 lb. (25.3 kg)</td>
</tr>
<tr>
<td></td>
<td>240 V</td>
<td>30–230 A</td>
<td>200 A at 24 V, 20% duty cycle</td>
<td>27.2</td>
<td>24 VDC</td>
<td>—</td>
<td>—</td>
<td>—</td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>170 A at 21.5 V, 40% duty cycle</td>
<td>—</td>
<td>22.4</td>
<td>4.8</td>
<td>5.4</td>
<td></td>
</tr>
<tr>
<td>CC: TIG</td>
<td>120 V</td>
<td>20–140 A</td>
<td>130 A at 15.2 V, 40% duty cycle</td>
<td>24.0</td>
<td>46 VDC</td>
<td>24 VDC</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td></td>
<td>240 V</td>
<td>20–210 A</td>
<td>210 A at 18.4 V, 20% duty cycle</td>
<td>27.2</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td></td>
</tr>
<tr>
<td>CC: Stick</td>
<td>120 V</td>
<td>30–90 A</td>
<td>90 A at 23.6 V, 40% duty cycle</td>
<td>24.5</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td></td>
</tr>
<tr>
<td></td>
<td>240 V</td>
<td>30–200 A</td>
<td>200 A at 28.4 V, 15% duty cycle</td>
<td>31.3</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td></td>
</tr>
</tbody>
</table>

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

Performance Data

MIG Duty Cycle Chart

TIG Duty Cycle Chart

Stick Duty Cycle Chart
Control Panel

1. Material Thickness Buttons
2. Auto-Set™ Button
3. Wire/Rod/Tungsten Buttons
4. LCD Display Panel
5. Process Buttons
6. Adjustment Knobs
7. TIG Arc Start Buttons
   (Lift-Arc™ not available for TIG aluminum)
8. Plastic Hub with Retaining Ring
   for 8-inch Spools (shaft also accepts
   4-inch spools)
9. Calibrated Tension Knob
10. Drive Roll
11. Gun Securing Knob
12. Four-pin Trigger Control Cable Receptacle

Note: Power switch and gas solenoid are on power source rear panel.

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TIG Aluminum Manual Mode

Note: Button and knob functions change
in TIG manual modes from the main panel above.

1. Balance Adjustment Buttons (Pro-Set™ 75%)
2. Tungsten Size Buttons
3. Frequency Adjustment Knob (Pro-Set™ 120 Hz)
4. Amperage Adjustment Knob
5. TIG Arc Start Buttons
   (Lift-Arc™ not available for TIG aluminum)

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TIG Steel/Stainless Manual Mode

Note: Button and knob functions change
in TIG manual modes from the main panel above.

1. Tungsten Size Buttons
2. Pulse Adjustment Knob (Pro-Set™ 100 PPS)
3. Amperage Adjustment Knob
4. TIG Arc Start Buttons
Replacement/Optional MIG Gun

M-100 (Standard)  248282  10 ft. (3 m)
M-150 (Optional)  249040  12 ft. (3.7 m)
  249041  15 ft. (4.5 m)
All ship with liner 194011.

Spoolmate™ 100 Spool Gun  300371
Direct-connect spool gun 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.

Spoolmate™ 150 Spool Gun  301272
Direct-connect spool gun handles .030–.035 inch (0.8–0.9 mm) 4000/5000 series aluminum and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 150 amps, 60-percent duty cycle. Includes 20-foot (6.1 m) cable assembly.

Weldcraft™ A-150 (WP-17) TIG Torch
WP1712RDI25 (12.5 ft.)
150-amp air-cooled torch with 25 mm flow-through Dinse-style connector.

AK2C Accessory Kit
Includes one short back cap, one of each size (4, 5, 6) alumina nozzle, and one of each size (.040, 1/16, 3/32 inch) of the following: collet, collet body, and 7-inch 2% ceriated tungsten electrode. Order from Miller Service Parts.

TIG Torch Accessory Kit
AK-150MFC
Allows welding operators to customize their standard Weldcraft™ A-150 (WP-17) TIG torch for their specific application. Kit converts into 28 different torch styles while using the existing cable. Features nozzles, collets, collet bodies, torch heads, handle and more. Order from Miller Service Parts.

MVP™ Plugs

Order from Miller Service Parts.

219258
For power cable 6-50P (240 V/50 A). Included with machine.

219261
For power cable 5-15P (120 V/15 A). Included with machine.

219259
For power cable 5-20P (120 V/20 A). Optional, not included with machine.

Remote Controls

Wireless Remote Foot Control  300429
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

RFCS-14 HD Foot Control  194744
Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote current and contactor control. Includes 20-foot (6 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) control cord and 14-pin plug.

RCCS-14 Remote Contactor and Current Control  043688
North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) control cord and 14-pin plug.
**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

### For Spoolmate™ 150 Spool Gun

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

**Nozzle** 050622

### For Both Spool Guns

**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.
<table>
<thead>
<tr>
<th>Power Source and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>Multimatic® 220 AC/DC</td>
<td>907757</td>
<td>120/240 V, 50/60 Hz</td>
<td></td>
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<tr>
<td><strong>Guns</strong></td>
<td></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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<td></td>
<td>249041</td>
<td>15 ft. (4.5 m), .030 – .035 in. (0.8 – 0.9 mm)</td>
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<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>Spoolmate™ 150 Spool Gun</td>
<td>301272</td>
<td>20 ft. (6.1 m)</td>
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<tr>
<td><strong>Accessories</strong></td>
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<tr>
<td>Weldcraft™ A-150 (WP-17) TIG Torch</td>
<td>WP1712RDI25</td>
<td>12.5 ft. (3.8 m) cable</td>
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<tr>
<td>Protective Cover</td>
<td>301524</td>
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<tr>
<td>Dual Cylinder Rack Cart</td>
<td>951770</td>
<td>Includes running gear/cylinder rack 301239 and dual cylinder rack conversion kit 301454. Must be assembled together</td>
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<tr>
<td>Material Thickness Gauge</td>
<td>229895</td>
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<tr>
<td><strong>Remote Controls</strong></td>
<td></td>
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<tr>
<td>Wireless Remote Foot Control</td>
<td>300429</td>
<td>Foot control with wireless 90 ft. (27.4 m) operating range</td>
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<tr>
<td>RFCS-14 HD</td>
<td>194744</td>
<td>Heavy-duty foot control (included with TIG kit and TIG package)</td>
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<tr>
<td>RCC-14</td>
<td>151086</td>
<td>Fingertip control</td>
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<tr>
<td>RCCS-14</td>
<td>043688</td>
<td>Fingertip control</td>
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<tr>
<td>TIG Torch Accessory Kits</td>
<td>AK2C</td>
<td>For use with Weldcraft™ A-150 (WP-17) Torch</td>
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<td>AK-150MFC</td>
<td>For use with Weldcraft™ A-150 (WP-17) Torch</td>
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<td>Flow Gauge Regulator for Argon or AR/CO₂ Mix</td>
<td>268546</td>
<td>Replacement standard regulator</td>
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<tr>
<td>Flow Gauge Regulator for CO₂</td>
<td>212492</td>
<td>Required if using 100-percent CO₂ gas</td>
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<tr>
<td>Replacement Screen Cover</td>
<td>271493</td>
<td>Replacement cover for LCD display panel</td>
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<td>Contact Tip Adapter</td>
<td>169716</td>
<td>For M-100 and M-150 guns</td>
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<tr>
<td>Gasless Flux-Cored Nozzle</td>
<td>226190</td>
<td>For M-100 gun</td>
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<tr>
<td>Drive Rolls</td>
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<tr>
<td>M-Series Gun Consumable Kits</td>
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<td>See page 7</td>
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Date:  
Total Quoted Price:  

Distributed by:  

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