**Diversion™ 180**

**TIG Welding Power Source**

### Quick Specs

**Personal User Applications**
- Chassis/frame fabrication
- Aluminum oil pans
- Stainless exhaust
- Weld repair on home equipment
- Metal art
- Vocational training

**Process**
- TIG (GTAW)

**Input Power**
- 115 and 230 V, 1-phase

**Rated Output**
- 150 A at 16 V, 20% duty cycle

**Amperage Range**
- 10 – 125 A (115 V)
- 10 – 180 A (230 V)

**Max. Open-Circuit Voltage**
- 80

**Net Weight**
- 50 lb. (23 kg)

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**The Personal User’s TIG Machine.**

**DIVERSION™**

**Easy-to-understand operator interface.**
1. Power-up
2. Select material type
3. Set amperage based on material thickness — then weld! It’s as easy as 1, 2, 3.

**Inverter-based AC/DC power source** provides a more consistent welding arc while using less power.

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

**High-frequency arc starting** provides non-contact arc initiation that reduces tungsten and material contamination.

**Auto-postflow** adjusts the length of postflow time based on the amperage setting, shielding your tungsten and eliminating the need to set the postflow time.

**Portable.** Whether it’s in the shop, garage or at the race track, at 50 pounds they can be taken anywhere.

**Advanced squarewave AC** provides a fast freezing weld puddle and deeper penetration.

**Comes complete with:**
- Power source with primary cord and MVP™ plugs for 120 V and 240 V
- 12.5 ft. (3.8 m) Weldcraft™ A-150 (WP-17) TIG torch with backcap, nozzle, 3/32 in. (2.4 mm) collet and collet body, and 2% ceriated tungsten
- RFCS-RJ45 remote foot control
- 12 ft. (3.7 m) work cable with clamp
- Flow gauge regulator with hose

**Just supply argon gas, filler rod, gloves and helmet and you’re ready to weld!**

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**Power source is warranted for three years, parts and labor. Original main power rectified parts are warranted for five years.**

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**Miller Electric Mfg. Co.**
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

**Equipment Sales US and Canada**
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125**
Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Welding Amp Range</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output</th>
<th>KVA</th>
<th>KW</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>115 V</td>
<td>10 – 125 A</td>
<td>60 A at 12.4 V, 100% duty cycle</td>
<td>11.3 (.88)*</td>
<td>1.3 (.1)*</td>
<td>1.2 (.03)*</td>
<td>80 VDC</td>
<td>H: 17 in. (433 mm) W: 9.875 in. (251 mm) D: 23.875 in. (608 mm)</td>
<td>50 lb. (23 kg)</td>
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<tr>
<td></td>
<td></td>
<td>125 A at 15 V, 35% duty cycle</td>
<td>26.5 (.88)*</td>
<td>3.1 (.1)*</td>
<td>3.0 (.03)*</td>
<td></td>
<td></td>
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<tr>
<td>230 V</td>
<td>10 – 180 A</td>
<td>60 A at 12.4 V, 100% duty cycle</td>
<td>5.6 (.44)*</td>
<td>1.3 (.1)*</td>
<td>1.2 (.03)*</td>
<td></td>
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<tr>
<td></td>
<td></td>
<td>150 A at 16 V, 20% duty cycle</td>
<td>16 (.44)*</td>
<td>3.7 (.1)*</td>
<td>3.6 (.03)*</td>
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<tr>
<td></td>
<td></td>
<td>180 A at 17.2 V, 10% duty cycle</td>
<td>20.5 (.44)*</td>
<td>4.7 (.1)*</td>
<td>4.6 (.03)*</td>
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</table>

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

1. While idling.

Control Panel

1. Digital Display
2. Output Indicator LED
3. Power Switch
4. Amperage Control
5. Material Selection Button
6. Material Thickness/Amperage Chart

Performance Data

Duty Cycle Chart

- 115 V
- 230 V

Output Amperes (A) vs. % Duty Cycle
Genuine Miller® Accessories

**MVP™ Plugs**

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

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

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

**Remote Controls**

- **RCCS-RJ45 Remote Fingertip Control** 301146
  - North/south rotary-motion fingertip current and contactor control attaches to TIG torch using two hook-and-loop fasteners. Great for applications that require a finer amperage control. Includes 13.25-foot (4 m) cord with plug.

- **RFCS-RJ45 Remote Foot Control** 300432
  - Foot pedal current and contactor control. Includes 14-foot (4.3 m) cord with plug. Included with Diversion.

- **RJ45 to 14-Pin Adapter Cord** 300688
  - 12-inch (305 mm) adapter cord allows Miller® 14-pin heavy-duty wired foot control (194744) or 14-pin wireless foot control (300429) to be used with the Diversion 180.

**Running Gear/Cylinder Rack** 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.

**TIG Gloves**

- **263346** Small (Women’s)
- **263347** Medium
- **263348** Large
- **263349** X-Large
  - Completely unlined, goat grain leather with triple-padded palm.

**TIG/Multitask Gloves**

- **263352** Small
- **263353** Medium
- **263354** Large
- **263355** X-Large
  - Goat grain leather with dual-padded palm and wool back.

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

**Weldcraft™ A-125 Torch Body** WP-9
- 125-amp air-cooled torch body. 13N Series consumables are sold separately.

**Weldcraft™ A-150 Torch Body** WP-17
- 150-amp air-cooled torch body (included with Diversion 180). 10N Series consumables are sold separately.

**Weldcraft** A-125 Torch Body  WP-9
125-amp air-cooled torch body. 13N Series consumables are sold separately.

**Weldcraft™ A-150 Torch Body** WP-17
150-amp air-cooled torch body (included with Diversion 180). 10N Series consumables are sold separately.

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# Ordering Information

<table>
<thead>
<tr>
<th>Power Source</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tr>
<td>Diversion™ 180</td>
<td>907627</td>
<td>Single-phase, 120 and 240 V, 50/60 Hz</td>
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<tr>
<td><strong>MVP® Plugs</strong></td>
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<tr>
<td>MVP 240 V 6-50P</td>
<td>219258</td>
<td>Used to connect power source to 6-50R receptacle (included with machine)</td>
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<td>MVP 120 V 5-15P</td>
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<tr>
<td>MVP 120 V 5-20P</td>
<td>219259</td>
<td>Used to connect power source to 5-20R receptacle (optional, not included with machine)</td>
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<tr>
<td><strong>Remote Controls</strong></td>
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<td>RCCS-RJ45</td>
<td>301146</td>
<td>Remote fingertip control (optional, not included with machine)</td>
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<td>300688</td>
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<tr>
<td><strong>Accessories</strong></td>
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<td>Protective Cover</td>
<td>300579</td>
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<td>Running Gear/Cylinder Rack</td>
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<td>TIG Welding Gloves</td>
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<td>See page 3</td>
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<tr>
<td>Weldcraft™ A-125 (WP-9) Torch Body</td>
<td>WP-9</td>
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<td>Weldcraft™ A-150 (WP-17) Torch Body</td>
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<td>TIG Torch Accessory Kits</td>
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