

Miller® MIGmatic™ M-Series to Miller MDX™ MIG Guns and Consumables Cross Reference

» Converting from M-Series to MDX Series Guns

The following tables are provided to help users familiar with the M-Series guns to select a new MDX gun of a similar wire size, amperage, length, etc. Miller machine compatibility is also noted by gun model.

M-100 to MDX™-100 MIG Gun

M-100 Part #	Description	MDX-100 Part #	Description	Miller Machine Compatibility
248282	M-100 Gun, 10 ft, .030"-.035"	1770028	MDX-100 Gun, 10 ft, 100A, .030"-.035", AccuLock™ MDX Consumables	Millermatic® 141, 211 Multimatic® 215, 220 AC/DC

M-25 to MDX™-250 MIG Guns

M-25 Part #	Description	MDX-250 Part #	Description	Miller Machine Compatibility
169594	M-25 Gun, 10 ft, .030"-.035"	1770035	MDX-250 Gun, 10 ft, 250A, .030"-.035", AccuLock MDX Consumables	Millermatic 212, 252 Multimatic 200
169596	M-25 Gun, 12 ft, .030"-.035"	1770036	MDX-250 Gun, 12 ft, 250A, .030"-.035", AccuLock MDX Consumables	Millermatic 212, 252 Multimatic 200
169598	M-25 Gun, 15 ft, .030"-.035"	1770037	MDX-250 Gun, 15 ft, 250A, .030"-.035", AccuLock MDX Consumables	Millermatic 212, 252 Multimatic 200
169599	M-25 Gun, 15 ft, .035"-.045"	1770038	MDX-250 Gun, 15 ft, 250A, .035"-.045", AccuLock MDX Consumables	Millermatic 212, 252 Multimatic 200

MDX™-250 Guns with AccuLock™ S Consumables

Millermatic® and Multimatic® 255 machines include an MDX-250 gun with Bernard AccuLock S consumables. Below are MDX-250 replacement guns with AccuLock S consumables.

MDX-250 Part #	Description	Miller Machine Compatibility
1770041	MDX-250 Gun, 10 ft, 250A, .035"-.045", AccuLock S Consumables	Millermatic 255 Multimatic 255
1770042	MDX-250 Gun, 12 ft, 250A, .035"-.045", AccuLock S Consumables	Millermatic 255 Multimatic 255
1770043	MDX-250 Gun, 15 ft, 250A, .035"-.045", AccuLock S Consumables	Millermatic 255 Multimatic 255
1770046	MDX-250 Gun, EZ-Select™, 15 ft, 250A, .035"-.045", AccuLock S Consumables	Millermatic 255 Multimatic 255
1770047	MDX-250 Gun, EZ-Select, 15 ft, 250A, .030"-.035", AccuLock MDX Consumables	Millermatic 255 Multimatic 255

» Converting from M-Series to AccuLock™ Series Nozzles and Contact Tips

The following tables are provided to help users convert their existing M-Series Guns to new AccuLock Nozzles and Contact Tips.

IMPORTANT: Do not use AccuLock Liners. M-Series Guns with AccuLock Consumables must continue to use their existing liner and power pin.

M-Series Gun to AccuLock Nozzles and Contact Tips Conversion Kits

Kit Part #	Kit Description	Component Part #	Component Description	Quantity
1880269	M-100 to AccuLock MDX	1070115	Diffuser, M-100 to AccuLock MDX Nozzles and Tips	1
		T-M030	Contact Tip, AccuLock MDX, .030" (0.8mm)	5
		T-M035	Contact Tip, AccuLock MDX, .035" (0.9mm)	5
		NS-M1200C	Nozzle, AccuLock MDX, 1/2 Orifice, Flush, Copper, MDX-100	1

Kit Part #	Kit Description	Component Part #	Component Description	Quantity
1880270	M-25 to AccuLock MDX	1070116	Diffuser, M-25 to AccuLock MDX Nozzles and Tips	1
		T-M030	Contact Tip, AccuLock MDX, .030" (0.8mm)	5
		T-M035	Contact Tip, AccuLock MDX, .035" (0.9mm)	5
		T-M045	Contact Tip, AccuLock MDX, .045" (1.2mm)	5
		N-M1200C	Nozzle, AccuLock MDX, 1/2 Orifice, Flush, Copper, MDX-250	1
		4623RM	Neck Insulator	1

Kit Part #	Kit Description	Component Part #	Component Description	Quantity
1880271	M-25 to AccuLock S	1070117	Diffuser, M-25 to AccuLock S Nozzles and Tips	1
		T-A035CHM	Contact Tip, AccuLock HD, .035" (0.9mm)	5
		T-A045CHM	Contact Tip, AccuLock HD, .045" (1.2mm)	5
		N-A5800CM	Nozzle, AccuLock S, Large, 5/8 Orifice, Flush, Copper	1
		4623RM	Neck Insulator	1

How to Install AccuLock Consumables on M-Series MIG Guns

1. Remove the contact tip, diffuser, and nozzle.
2. Leave the liner in place. There should also be no need to trim the liner as long as it was trimmed correctly during initial installation.
3. If damaged, the M-25 Shock Washer (169730) should be replaced with a 4623RM Neck Insulator.
4. Install the new AccuLock diffuser, contact tip and nozzle.



Miller Electric Mfg. LLC
 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

MillerWelds.com