**Multimatic® 220 AC/DC**

**Light Industrial Applications**
- Light fabrication
- Maintenance and repair
- Auto body
- Farm/home

**Processes**
- MIG (GMAW)
- Flux-cored (FCAW)
- AC/DC TIG (GTAW)
- Pulsed TIG (GTAW-P)
- DC stick (SMAW)

**Input Power**
- 120/240 V, 1-phase, 50/60 Hz

**Amperage Range**
- **MIG:** 30–230 A
- **AC/DC TIG:** 20–210 A
- **DC stick:** 30–200 A

**Net Weight**
- 56 lb. (25.4 kg)

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**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, AC/DC TIG, and stick — 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.

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**All in One**
- **MULTIPROCESS** (MIG, STICK, AC/DC TIG)
  - Multiple processes with only one machine

**Easy to Use**
- **QUICKTECH™**
  - Auto polarity, process and settings

**Portable**
- **WEIGHS 56 lb.**
  - Light enough to easily move around your garage or shop

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Welder is warranted for three years, parts and labor.
Gun warranted for 90 days, parts only.
Multimatic® 220 AC/DC Features and Benefits

All in One

Take on more projects with one machine that has MIG, AC/DC TIG, and DC stick.

- **MIG:** 24 ga.–3/8 in. steel
  18 ga.–3/8 in. aluminum
- **AC/DC TIG:** 24 ga.–1/4 in. steel and aluminum
- **DC stick:** 16 ga.–3/8 in. steel

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

With our innovative 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, AC/DC TIG, DC stick) with the ability to fine-tune your settings.
- **MDX™-100 MIG gun with AccuLock™ MDX consumable system** features a dual-locked, front-loading liner that optimizes wire feedability.
  - Install AccuLock contact tips with a single turn.
  - AccuLock liner locks at front and back of gun to align with contact tip and power pin for a flawless wire feed path.
  - Durable, ergonomic handle with overmolding improves grip and comfort.
  - Ball-and-socket handle with rear swivel for increased gun maneuverability while reducing welder fatigue.

**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.


**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.

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**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
- 10 ft. (3 m) MDX™-100 MIG gun
- 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
- 10 ft. (3 m) work cable with clamp and 25 mm Dinse-style connector
- 6.5 ft. (2 m) power cord with MVP™ plugs for 120 V and 240 V
- RFCS-14 HD foot control with 20 ft. (6 m) cord
- Two flow gauge regulators and gas hoses for argon or 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
- 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 — 2.8</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>— 46 VDC</td>
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<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 — 2.9</td>
<td>—</td>
<td>—</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>— 22.4</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 — 2.9</td>
<td>—</td>
<td>—</td>
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<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>

*Not recommended for 6010 electrodes.

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.

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)

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
**Genuine Miller® Accessories**

**MDX™-100 MIG Gun** 1770028
100-amp MIG gun with Miller® AccuLock™ MDX consumables for 0.030–0.035 in. (0.8–0.9 mm) wire. Includes 10 ft. (3 m) cable assembly.

**Spoolmate™ 100 Spool Gun** 300371
Direct-connect spool gun handles 0.030–0.035 inch (0.8–0.9 mm) aluminum (4043 only) and 0.023–0.035 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 0.030–0.035 inch (0.8–0.9 mm) 4000/5000 series aluminum and 0.023–0.035 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.

**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.

**Protective Cover** 301524

**MVP™ Plugs**

- **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

### For MDX™-100 MIG Gun

**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)
- T-M047 3/64 in. (1.2 mm)

**Nozzles**
- NS-M1200B Brass, 1/2 in. ID, flush
- NS-M1200C Copper, 1/2 in. ID, flush
- NS-MFLX Gasless nozzle

**Diffuser**
- D-M100

**Monocoil Replacement Liners (10 ft.)**
- 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)

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

### 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.

### For Multimatic® 220 AC/DC

**Quick Select™ Drive Roll**
- 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.

**V-Knurled Dual-Groove Drive Roll**
- 202926
  For .030/.035-inch (0.8/0.9 mm) or .045-inch (1.2 mm) flux-cored 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>
<td></td>
</tr>
</tbody>
</table>

**Guns**

| MDX™-100 Gun              | 1770028   | 10 ft. (3 m), .030–.035 in (0.8–0.9 mm) wire                                  |       |       |
| Spoolmate™ 100 Spool Gun  | 300371    | 12 ft. (3.7 m). Includes custom carrying case                                   |       |       |
| Spoolmate™ 150 Spool Gun  | 301272    | 20 ft. (6.1 m)                                                                 |       |       |

**Accessories**

| Weldcraft™ A-150 (WP-17) TIG Torch | WP1712RDI25 | 12.5 ft. (3.8 m) cable                                                      |       |       |
| TIG Torch Accessory Kits         | AK2C       | For use with Weldcraft™ A-150 (WP-17) Torch                                 |       |       |
|                                  | AK-150MFC  | For use with Weldcraft™ A-150 (WP-17) Torch                                 |       |       |
| Protective Cover                 | 301524     |                                                                               |       |       |
| Dual Cylinder Rack Cart          | 951770     | Includes running gear/cylinder rack 301239 and dual cylinder rack conversion kit 301454. Must be assembled together |       |       |
| MVP™ Plugs                       | 229895     |                                                                               |       |       |
| Material Thickness Gauge         | 190429     |                                                                               |       |       |
| Replacement Screen Cover         | 31-50-580-6| Replacement standard regulator                                               |       |       |
| Flow Gauge Regulator for Argon or AR/CO₂ Mix | 31-50-320 | Required if using 100 percent CO₂ gas                                       |       |       |

**Remote Controls**

| Wireless Remote Foot Control   | 300429     | Foot control with wireless 90 ft. (27.4 m) operating range                   |       |       |
| RFCS-14 HD                     | 190429     | Heavy-duty foot control (included with TIG kit and TIG package)              |       |       |
| RCC-14                         | 151086     | Fingertip control                                                            |       |       |
| RCCS-14                        | 043688     | Fingertip control                                                            |       |       |

**Consumables**

| Contact Tips                  | See page 7 |                                                                               |       |       |
| Nozzles                       | See page 7 |                                                                               |       |       |
| Diffuser                      | See page 7 |                                                                               |       |       |
| Monocoil Replacement Liners   | See page 7 |                                                                               |       |       |
| Drive Rolls                   | See page 7 |                                                                               |       |       |

**Date:**

**Total Quoted Price:**