



TM-260850H

2018-10

**Processes**



Submerged Arc (SAW) Welding

**Description**



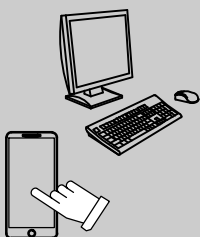
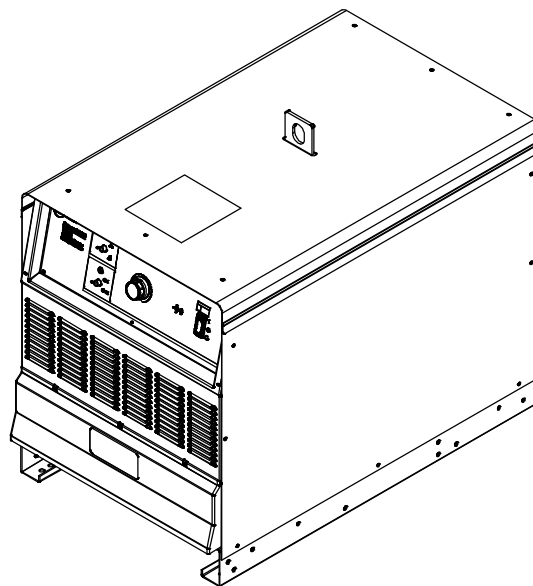
Arc Welding Power Source

# SubArc DC 650/800, 1000/1250 Digital Power Sources CE And Non-CE Models

## PARTS LIST

### Eff w/ME210002G And Following

For OM-265363 Revision A Thru M




For product information,  
Owner's Manual translations,  
and more, visit

[www.MillerWelds.com](http://www.MillerWelds.com)

# SECTION 13 - PARTS LIST EFF W/SERIAL NO. ME210002G AND FOLLOWING

## A. Part List For 650/800 Amp Models

 Hardware is common and not available unless listed.

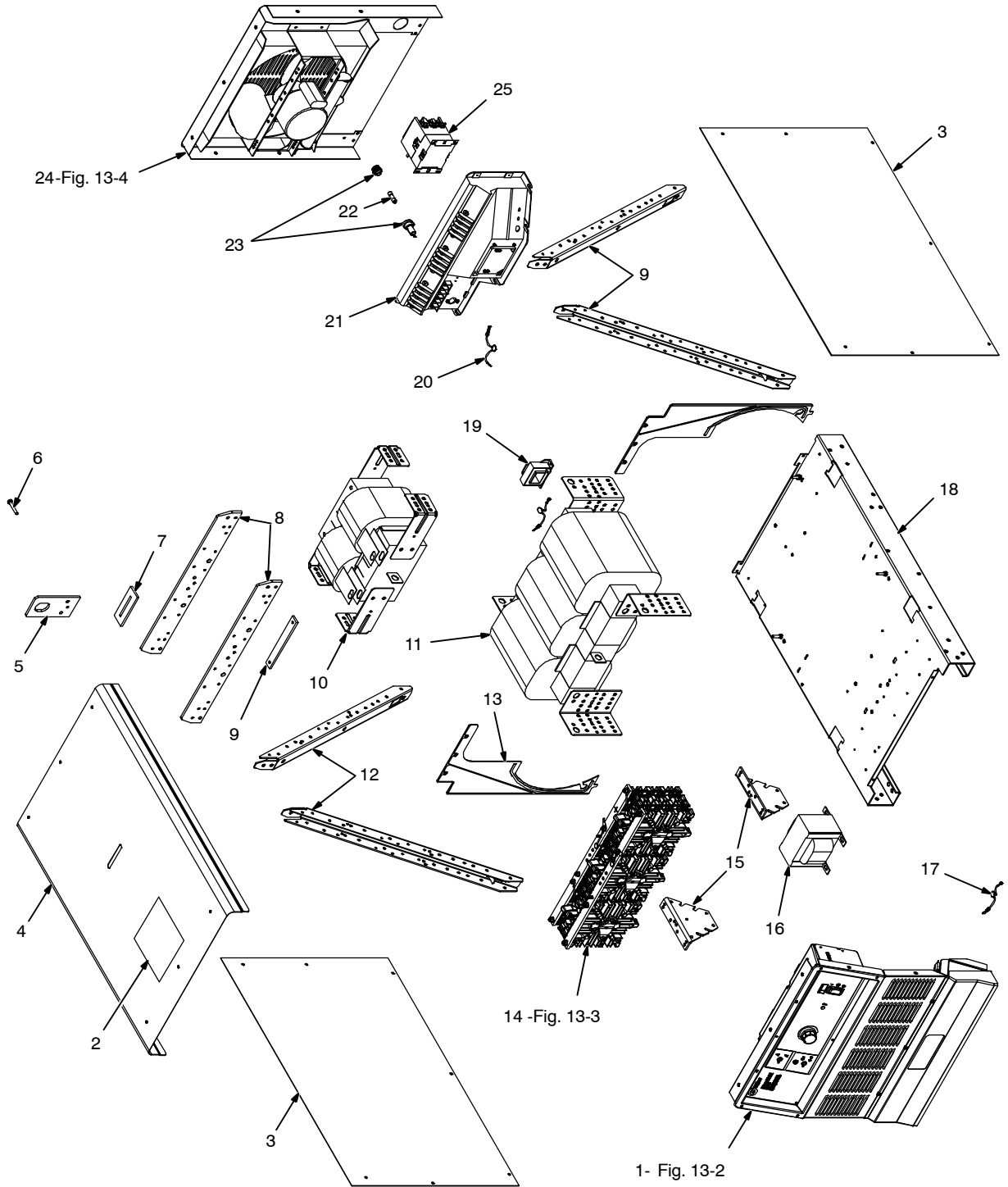


Figure 13-1. 650/800 Main Assembly (650 Model Illustrated)

270476-D


**Eff w/Serial No. ME210002G And Following**

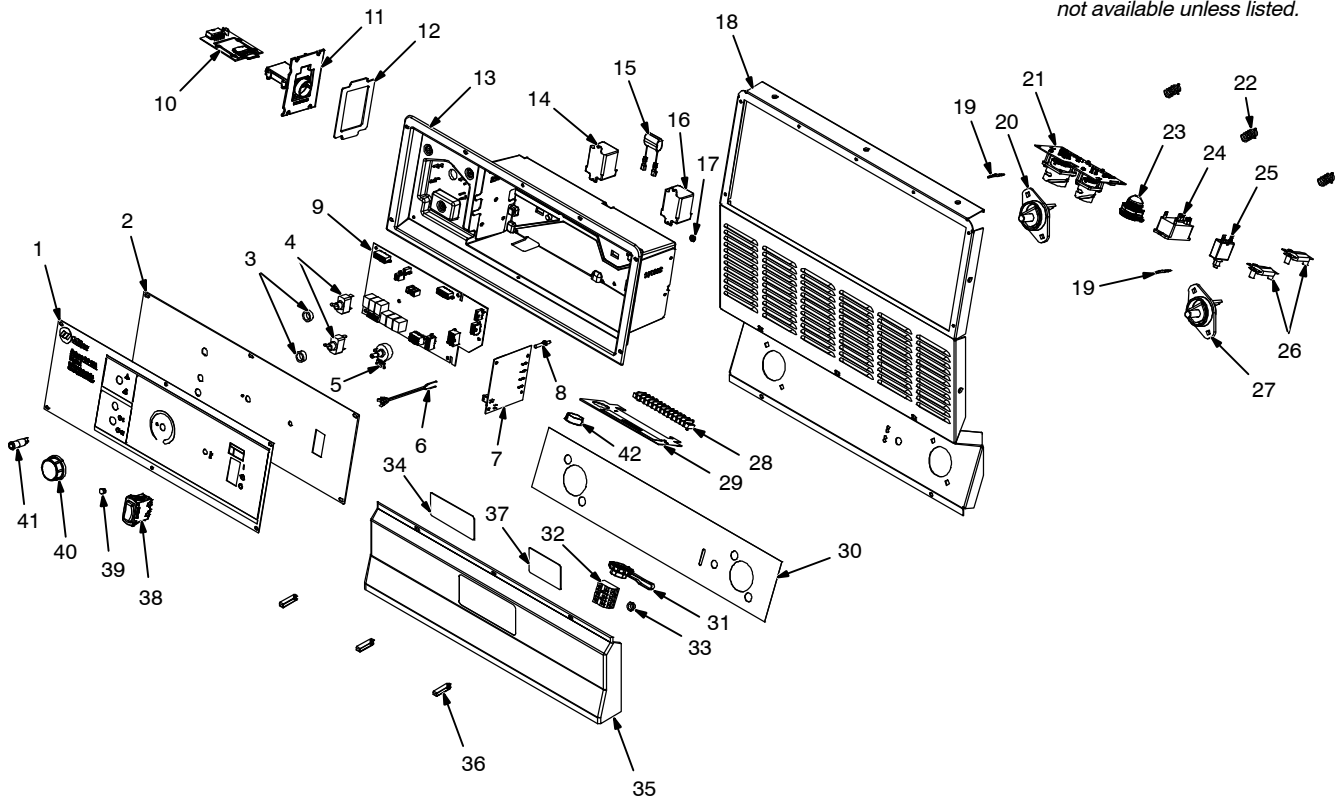
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 13-1. 650/800 Main Assembly (650 Model Illustrated)</b>				
.. 1		Fig 13-2	Panel, Front w/Components	1
.. 2		274964	Label, Warning General Precautionary (En/Fr/Sp)	1
.. 3		+179432	Panel, Side	2
.. 4		179431	Cover, Top	1
.. 5		162830	Lift, Eye	1
.. 6		604536	Screw, .312-18 x 1.75 hexhd-pln gr 5	2
.. 7		177279	Gasket, Lift Eye	1
.. 8		162820	Bar, Mtg Lift Eye	2
.. 9		164717	Bus Bar, Stabilizer	1
.. 10	Z1	180068	Stabilizer (Prior to MH390210G)	1
.. 10	Z1	280666	Stabilizer (Eff. w/MH390210G)	1
.. 11	T1	264820	XFMR, Power Main 230/460/575 (DC 650)	1
.. 11	T1	264956	XFMR, Power Main 380/400/440 (DC 800)	1
..	TP1,2	175405	Thermostat, NC (Included w/T1)	2
..	TP4,5	168891	Thermostat, NC (Included w/T1)	2
.. 12		162816	Channel, Upright	4
.. 13		164700	Baffle, Air	2
.. 14	SR1	267606	Rectifier, SCR Main Subarc DC 650/800	1
.. 15		161294	Bracket, Mtg Rectifier	2
.. 16	T2	260744	XFMR, Control 600VA 230/460/575V Pri 24V Sec 60hz (DC650)	1
.. 16	T2	260746	XFMR, Control 600VA 220/380/400/440V Pri 24V Sec 50 (DC800)	1
.. 17		128750	Capacitor, Cer Disc .1 UF 500 VDC w/Terms	2
.. 18		163359	Base	1
.. 19	HD1	244958	Transducer, Current 1000A Module Supply V +/- 15V	1
.. 20	C21-23	163906	Capacitor	3
.. 21	TE1	159244	Primary Box Layout (Includes)	1
..		601835	Nut, 10-32 Brs	24
..		038887	Stud, Pri Bd Brs 10-32 x 1.375	24
..		038618	Link, Jumper Term Bd Pri	8
..		010913	Washer, Flat .218ID Brs	24
.. 22	F1	*260395	Fuse, Crtg 3. Amp 600 V Time Delay	1
.. 23		159034	Holder, Fuse Mintr 10.3mm x 33.3 To 38.1mm Panel Mt	1
.. 24		Fig 13-4	Panel, Rear w/Components	1
.. 25	W	258661	Contact, Def Prp 75A 3P 24 VAC Coil w/Boxlug	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

\*Recommended Spare Parts.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

 Hardware is common and not available unless listed.



270478-C

**Figure 13-2. 650/800 Panel, Front w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 13-2. 650/800 Panel, Front w/Components**

.. 1			Nameplate, DC 650 Digital (Order By Model And Serial Number)	1
.. 2		262970	Panel, Front Upper Subarc DC Digital Units	1
.. 3		189404	Spacer, Nylon .718 Od x .526 Id x .281 Lg	2
.. 4		011609	Switch, Tgl Spdt 15A 125 VAC On-none-on Spd Term Chr	2
.. 5		198087	Pot, Cp Std Slot 1t 2. W 1k Linear w/Fricctabs	1
.. 6		159522	Led, Yellow 2.1V 20 Ma 45.0 Mcd Panel Mtg .250 Hole	1
.. 7	PC4	264088	Circuit Card Assy, Automation w/Prgrm	1
.. 8		038887	Stud, Primary Board Brs 10-32 x 1.375	1
.. 9	PC1	264012	Circuit Card Assy, Control w/Program	1
.. 10	PC3	244477	Circuit Card Assy, Sd Card	1
.. 11		234344	Program, Motor Control 8 X-treme 5 Sec Postflow	1
.. 12		264385	Gasket, Sd Card Bracket	1
.. 13		263759	Electronics Box, Modified	1
.. 14	CR3	052964	Relay, Encl 24 VDC Dpdt 10a/120 VAC 8pin Flange Mtg	1
.. 15	SN1	234081	Snubber Assy	1
.. 16	CR5	006393	Relay, Encl 24 VAC Dpdt 10A/120 VAC 8pin Flange Mtg	1
.. 17		601835	Nut, 10-32 Brs	2
.. 18		261068	Panel, Front	1
.. 19		010381	Connector, Rectifier	2
.. 20		181245	Terminal, Pwr Output Red	1
.. 21	PC2	261392	Circuit Card Assy, Subarc DC Filter	1
.. 22		161303	Spring, Cprsn .600 Od x .072 Wire x 1.500 Pld	3
.. 23		264897	Conn, Circ Cpc Ethernet Skt Sealed 34.000in Cable	1
.. 24	CR6	261010	Relay, Encl 24 VDC Dpst 30A/24 VAC 4pin Flange Mtg	1
.. 25	CB1	261011	Supplementary Pro, Man Reset 1p 25A 250 VAC Frict	1

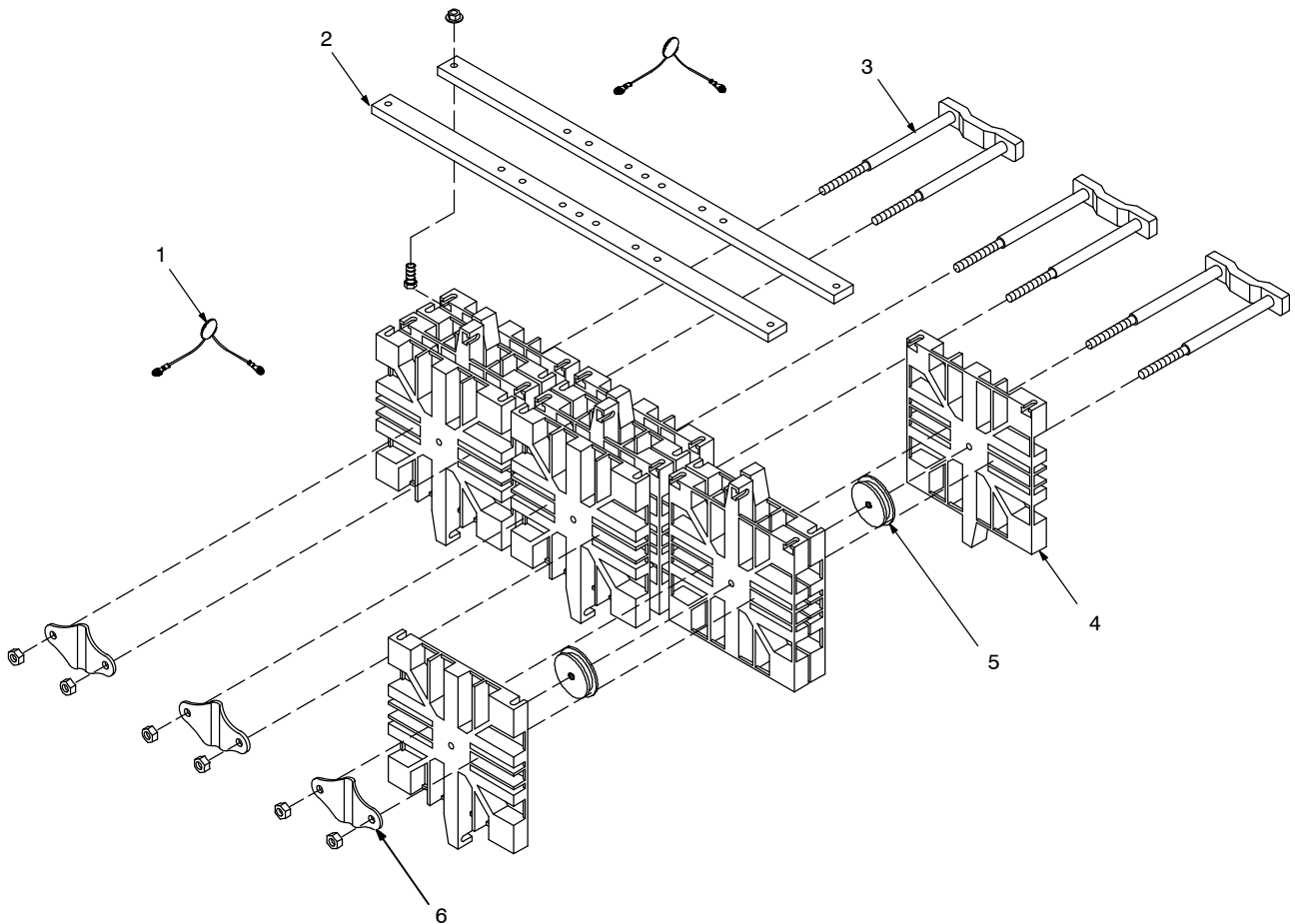
**Eff w/Serial No. ME210002G And Following**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 13-2. 650/800 Panel, Front w/Components (Continued)</b>				
.. 26 ...	R4, R5 ...	136076 ..	Resistor, WW Fxd 30 W 200 Ohm Faston Te .....	2
.. 27 .....		181246 ..	Terminal, Pwr Output Black .....	1
.. 28 .....	1T .....	159040 ..	Block, Term 20 Amp 12 Pole Screw Term .....	1
.. 29 .....		162828 ..	Panel, Mtg Rcpt/Terminal Strip .....	1
.. 30 .....			Nameplate, Lower (Order By Model And Serial Number) .....	1
.. 31 .....		244237 ..	Dust Cap .....	1
.. 32 .....		246951 ..	Block,Term 20 Amp 3 Pole Quick Conn .....	1
.. 33 .....		010546 ..	Bushing, Snap-in Nyl .375 Id x .500 Mtg Hole .....	1
.. 34 .....		217865 ..	Label, Warning Electric Shock And Reduced Air (Fr) .....	1
.. 35 .....	+172587		Cover, Output Stud Generic .....	1
.. 36 .....		160935 ..	Clip, Spring .....	3
.. 37 .....		227980 ..	Label, Notice Output Terminal Connection .....	1
.. 38 .....	S1 .....	261608 ..	Switch, Rocker Spdt 10A 24 VDC On-none-on Illum .....	1
.. 39 .....		159036 ..	Lens, LED Clear Panel Mtg .....	1
.. 40 .....		171007 ..	Knob, Pointer 1.670 Dia x .250 Id w/Set Screwsplstc .....	1
.. 41 .....		249340 ..	LED Assy, Blue w/Terminals .....	1
.. 42 .....		070371 ..	Blank, Snap-In Nyl 1.093/1.125 Mtg Hole Black .....	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Hardware is common and not available unless listed.



802351

Figure 13-3. Rectifier, Si Diode

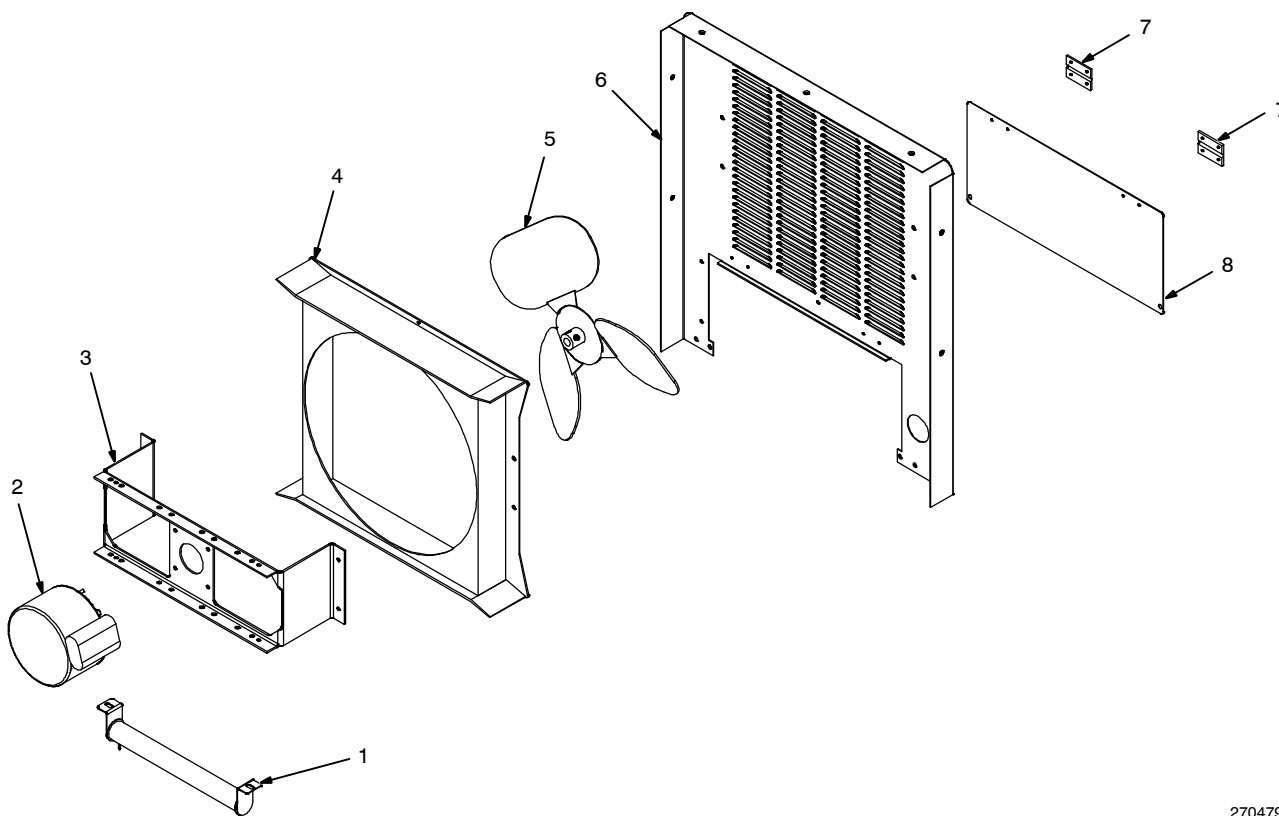
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 13-3. 650/800 Rectifier, Si Diode

.. 1	.... C7.12	.. 048420	.. Capacitor, Cer Disc .01uf 1000 VDC	6
.. 2	.....	.. 191989	.. Bar, Mtg Rectifier	2
.. 3	.....	.. 188691	.. Clamp, Thyristor Rectifier 5.500	3
.. 4	.....	.. 188839	.. Heatsink, Rectifier Snowflake .800	12
.. 5	... SCR1-6	.. 148091	.. Thyristor, SCR 865A 300V Hockey Puck	6
.. 6	.....	.. 166667	.. Clamp, Spring Thyristor Rectifier 5.500	3
.....	PLG1	.. 158720	.. Connector & Sockets	1
.....	TP3	.. 191992	.. Thermostat, NC Open 186f Close 166f No Flange Fasto	1
.....	TP6	.. 191991	.. Thermostat, Rectifier	1

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

☞ Hardware is common and not available unless listed.



270479-B


**Figure 13-4. Panel, Rear w/Components**

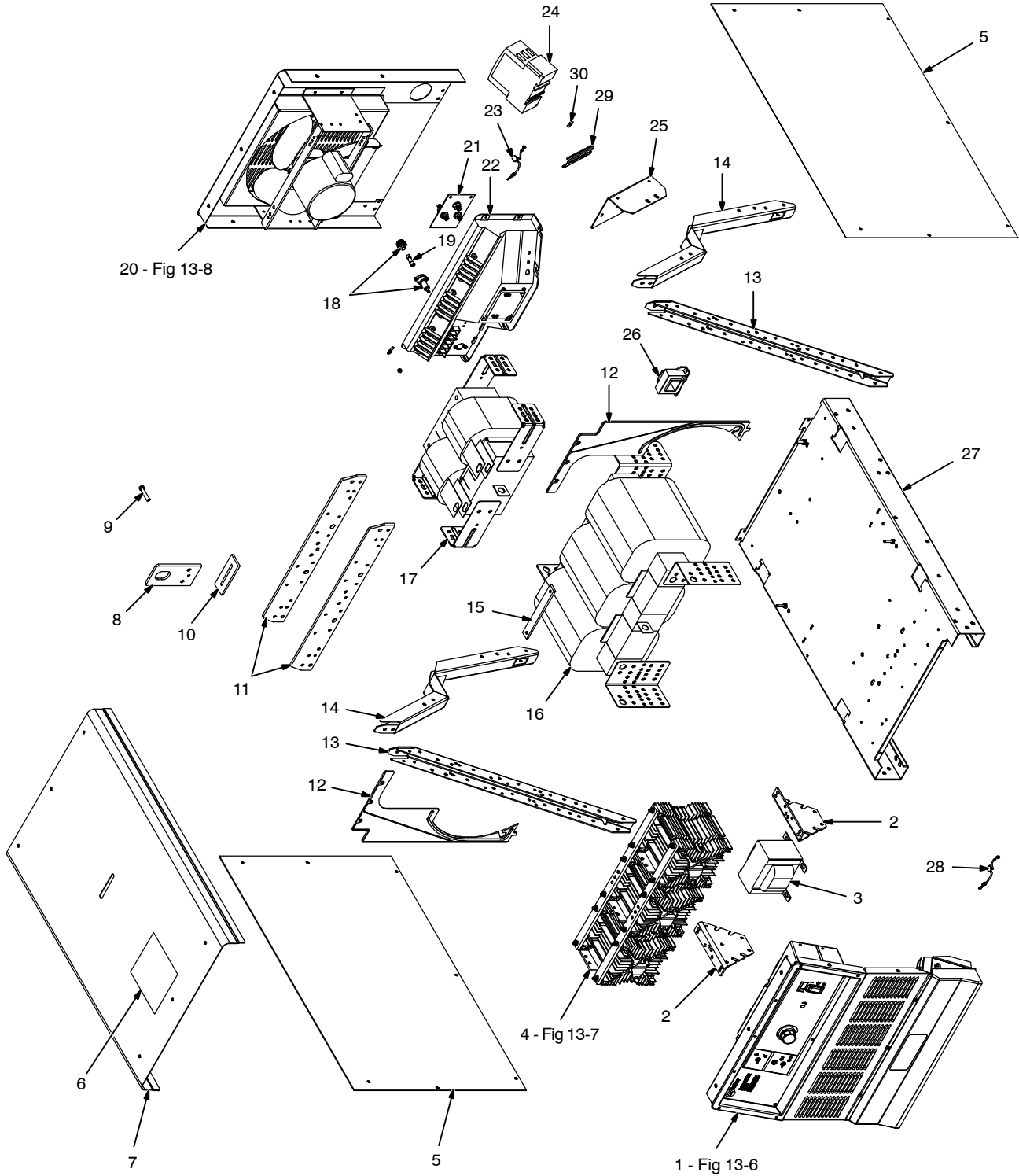
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 13-4. 650/800 Panel, Rear w/Components</b>				
.. 1	.. R3	.. 097459	.. Resistor, WW Fxd 375W 20 Ohm	.. 1
.. 2	.. FM	.. 237398	.. Motor, 1/12HP 230V 1550 RPM 50/60Hz .83A	.. 1
.. 3		.. 124274	.. Bracket, Mtg Fan Motor	.. 1
.. 4		.. 173283	.. Chamber, Plenum 14 In	.. 1
.. 5		.. 180165	.. Blade, Fan 14 In 3wg 23Deg .375 Bore CCW	.. 1
.. 6		.. 162807	.. Panel, Rear	.. 1
.. 7		.. 168343	.. Hinge, Door Primary	.. 2
.. 8		.. +162818	.. Door, Access Primary	.. 1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

**B. Part List For 1000/1250 Amp Models**

 Hardware is common and not available unless listed.



270477-D

**Figure 13-5. 1000/1250 Main Assembly**



**Eff w/Serial No. ME210002G And Following**

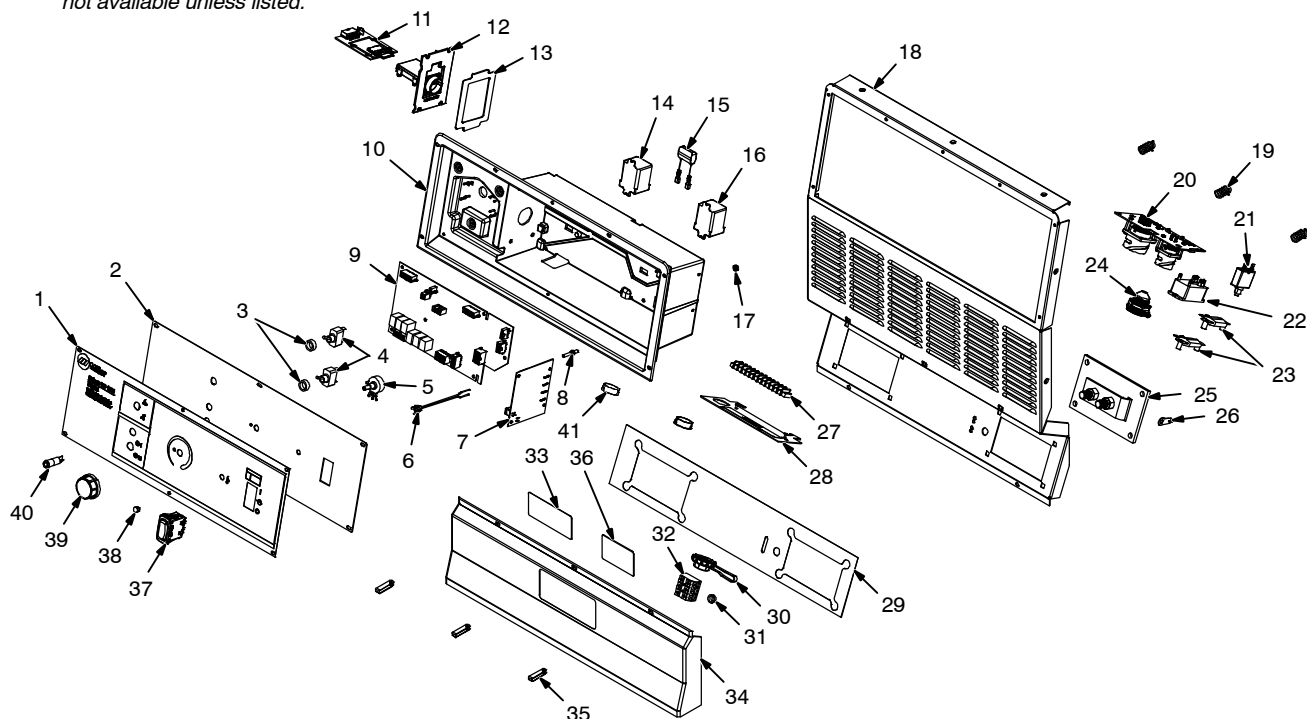
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 13-5. 1000/1250 Main Assembly</b>				
.. 1		Fig 13-6	Panel, Front w/Components	1
.. 2		161294	Bracket, Mtg Rectifier	1
.. 3	T2	260744	XFMR, Control 600VA 230/460/575V Pri 24V Sec 60hz (DC 1000)	1
.. 3	T2	260746	XFMR, Control 600VA 220/380/400/440V Pri 24V Sec 50 (DC 1250)	1
.. 4	SR1	267574	Rectifier, Scr Main Subarc DC 1000/1250 Digital (Fig 13-7)	1
.. 5		+179432	Panel, Side	2
.. 6		274964	Label, Warning General Precautionary (En/Fr/Sp)	1
.. 7		179431	Cover, Top	1
.. 8		162830	Lift Eye	1
.. 9		604536	Screw, .312-18 x 1.75 Hex Hd-Pln Gr 5	2
.. 10		177279	Gasket, Lift Eye	1
.. 11		162820	Bar, Mtg Lift Eye	2
.. 12		164700	Baffle, Air	2
.. 13		162816	Channel, Upright Front	2
.. 14		190959	Channel, Upright	2
.. 15		164717	Bus Bar, Stabilizer	1
.. 16	T1	264946	XFMR Assy, Power Main (DC 1000)	1
.. 16	T1	264958	XFMR Assy, Power Main (DC 1250)	1
..	TP1, 2	216600	Thermostat, NC Open 150C w/Insulator Leads & Terms (Included w/T1)	2
..	TP4, 5	168891	Thermostat, NC (Included w/T1) (Fan Control Circuit)	2
.. 17	Z1	190954	Stabilizer (Prior to MH370182G)	1
.. 17	Z1	280665	Stabilizer (Eff. w/MH370182G)	1
.. 18		159034	Holder, Fuse Mintr	1
.. 19	F1	260395	Fuse, Crtg 3. Amp 600V Time Delay	1
.. 20		Fig 13-8	Panel, Rear w/Components	1
.. 21		193676	Terminal Assy, Primary 3 phase	1
.. 22		193495	Primary Box, (Includes)	1
..		601835	Nut, 10-32 Brs	24
..		038887	Stud, Pri Bd Brs 10-32 x 1.375	24
..		038618	Link, Jumper Term Bd Pri	8
..		010913	Washer, Flat .218 Id Brs	24
..		601835	Nut, 10-32 Brs	24
.. 23	C21 - 23	099518	Capacitor (Prior To MF150244G)	3
.. 23	C21 - 23	269734	Capacitor, w/Lead (Eff w/ MF150244G)	3
.. 24	W	193473	Contact, Size 3-1/2 3P 24 VAC (Prior To MF150244G)	1
.. 24	W	252348	Contact, Size S3 3P AC 140 Amp 24V 50/60Hz (Eff w/MF150244G)	1
.. 25		193462	Bracket, Contactor Mount (Prior To MF150244G)	1
.. 25		264208	Bracket, Contactor Mount (Eff w/MF150244G)	1
.. 26	HD1	244958	Transducer, Current 1000A Module Supply V +/- 15V	1
.. 27		163359	Base	1
.. 28		128750	Capacitor, Cer Disc .1 Uf 500 VDC w/Terms	2
.. 29		252349	Rail (Eff w/MF150244G)	1
.. 30		252264	Spacer, Nylon (Eff w/MF150244G)	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

\*Recommended Spare Parts.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

☞ Hardware is common and not available unless listed.



270481-C

Figure 13-6. 1000/1250 Panel, Front w/Components

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 13-6. 1000/1250 Panel Front w/Components

.. 1			Nameplate (Order By Model And Serial Number)	1
.. 2		262970	Panel, Front Upper	1
.. 3		189404	Spacer, Nylon .718 Od x .526 Id x .281 LG	2
.. 4		011609	Switch, Tgl Spdt 15A 125 VAC On-none-on Spd Term Chr	2
.. 5		198087	Pot, Cp Std Slot 1t 2. W 1k Linear w/Fricctabs	1
.. 6		159522	LED, Yellow 2.1a 20 MA 45.0 Mcd Panel Mtg .250 Hole	1
.. 7	PC4	264088	Circuit Card Assy, Automation w/Prgm	1
.. 8		038887	Stud, Primary Board Brs 10-32 x 1.375	1
.. 9	PC1	264012	Circuit Card Assy, Control w/Program	1
.. 10		263759	Electronics Box, Modified	1
.. 11	PC3	244477	Circuit Card Assy, SD Card	1
.. 12		234344	Bracket, SD Card Reader	1
.. 13		264385	Gasket, SD Card Bracket	1
.. 14		052964	Relay, Encl 24 VDC Dpdt 10A/120 VAC 8pin Flange Mtg	1
.. 15	SN1	234081	Snubber Assy	1
.. 16		006393	Relay, Encl 24 VAC Dpdt 10A/120 VAC 8pin Flange Mtg	1
.. 17		601835	Nut, 10-32 Brs	2
.. 18		261067	Panel, Front	1
.. 19		161303	Spring, Cprsn .600 Od x .072 Wire x 1.500 Pld	3
.. 20	PC2	261392	Circuit Card Assy, Subarc DC Filter	1
.. 21	CB1	261011	Supplementary Pro, Man Reset 1p 25A 250 VAC Frict	1
.. 22		261010	Relay, Encl 24 VDC Dpst 30A/24 VAC 4pin Flange Mtg	1
.. 23		136076	Resistor, WW Fxd 30 W 200 Ohm Faston Te	2
.. 24		264897	Conn, Circ Cpc Ethernet Skt Sealed 34.000in. Cable	1
.. 25		263753	Terminal Assy, Power Output	2
.. 26		010381	Connector, Rectifier	2
.. 27		159040	Block, Term 20 Amp 12 Pole Screw Term	1
.. 28		162828	Panel, Mtg Rcpt/Terminal Strip	1

**Eff w/Serial No. ME210002G And Following**

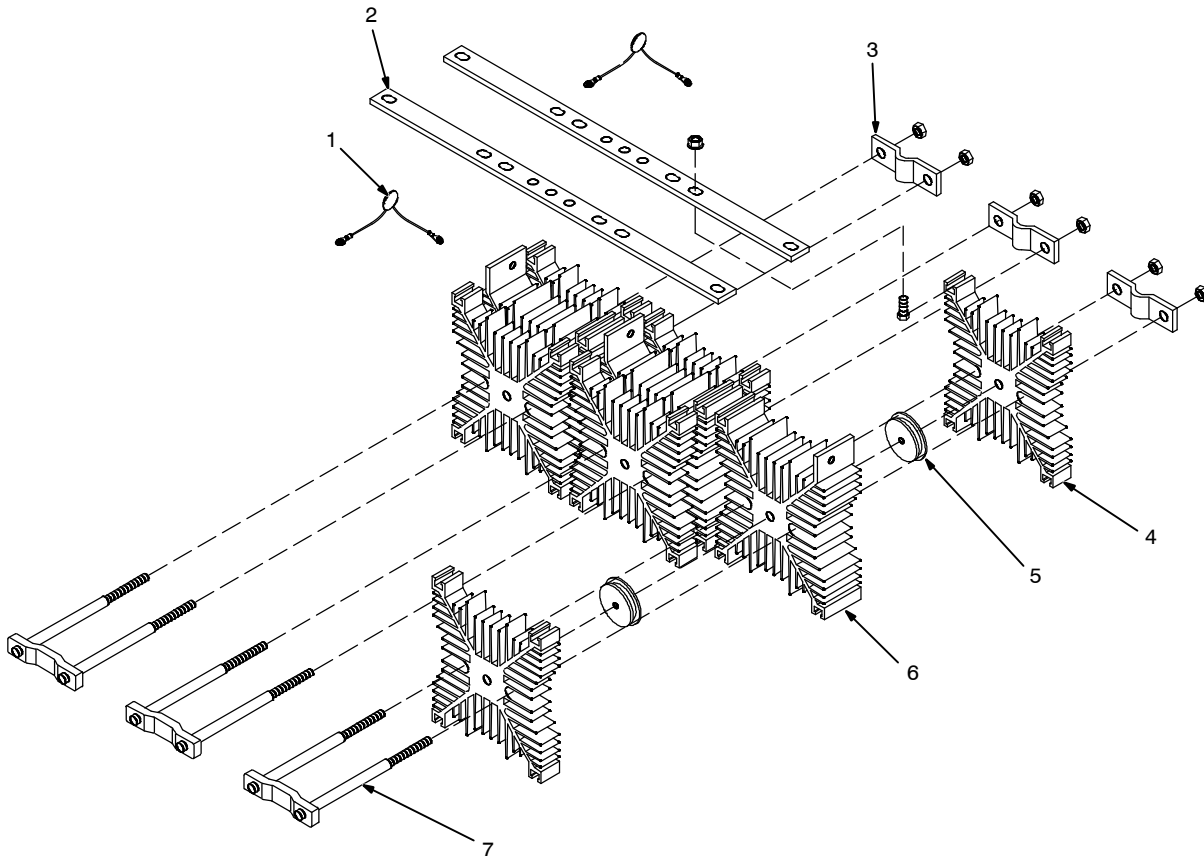
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 13-6. 1000/1250 Panel Front w/Components (Continued)</b>				
.. 29			Nameplate, Lower (Order By Model And Serial Number)	1
.. 30		244237	Dust, Cap	1
.. 31		010546	Bushing, Snap-In Nyl .375 Id x .500 Mtg Hole	1
.. 32		246951	Block, Term 20 Amp 3 Pole Quick Conn 20-12 Awg Wire	1
.. 33		217865	Label, Warning Electric Shock And Reduced Air (Fr)	1
.. 34		+172587	Cover, Output Stud Generic	1
.. 35		160935	Clip, Spring	3
.. 36		227980	Label, Notice Output Terminal Connection	1
.. 37	S1	261608	Switch, Rocker Spdt 10A 24 VDC On-None-On Illum	1
.. 38		159036	Lens, LED Clear Panel Mtg	1
.. 39		171007	Knob, Pointer 1.670 Dia x .250 Id w/Set Screwsplstc	1
.. 40		249340	LED Assy, Blue w/Terminals	1
.. 41		070371	Blank, Snap-In Nyl 1.093/1.125 Mtg Hole Black	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Eff w/Serial No. ME210002G And Following

☞ Hardware is common and not available unless listed.



800696-A

Figure 13-7. Rectifier, SCR Main

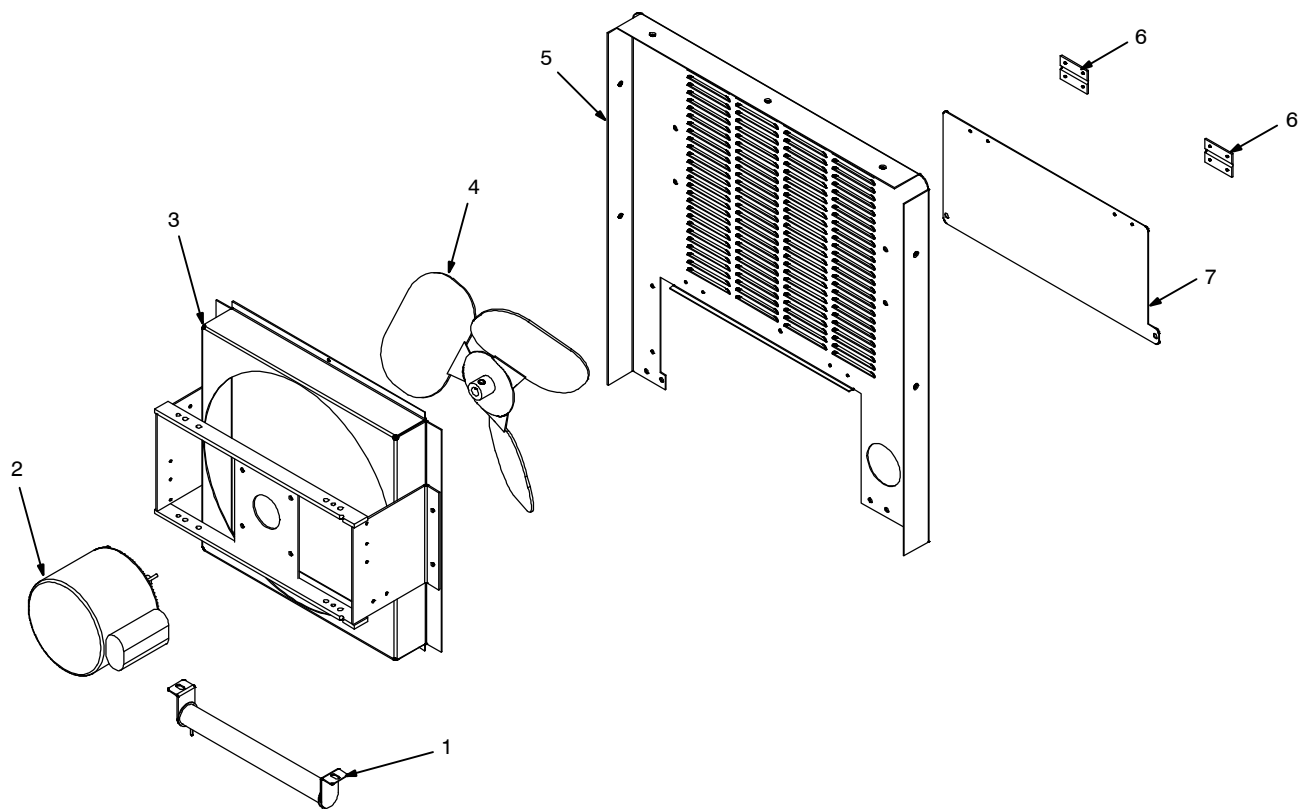
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 13-7. 1000/1250 Rectifier, SCR Main

.. 1	.... C7-12	.. 048420	.. Capacitor, Cer Disc .01uf 1000 VDC	6
.. 2	.....	.. 176168	.. Bar, Mtg Rectifier	2
.. 3	.....	.. 166667	.. Clamp, Spring Thyristor Rectifier	3
.. 4	.....	.. 191248	.. Heatsink, Rectifier Snowflake 1.500	6
.. 5	... SCR1-6	.. 148091	.. Thyristor, Scr 865A 300V Hockey Puck	6
.. 6	.....	.. 191247	.. Heatsink, Rectifier Snowflake 3.000	3
.. 7	.....	.. 191246	.. Clamp, Thyristor Rectifier 8.187	3
.....	PLG1	.. 158720	.. Connector & Sockets	1
.....	TP3	.. 192731	.. Thermostat, Rectifier	1
.....	TP6	.. 168894	.. Thermostat, Rectifier (Fan Control Circuit)	1

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

☞ Hardware is common and not available unless listed.



270480-B

**Figure 13-8. 1000/1250 Panel, Rear w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 13-8. 1000/12500 Panel, Rear w/Components**

.. 1	.. R3	.. 097459	.. Resistor, WW fxd 375W 20 ohm	.. 1
.. 2	.. FM	.. 032605	.. Motor, Cap Perm Sp 1/4Hp 230 VAC 1670Rpm	.. 1
.. 3		.. 132101	.. Chamber, Plenum 14 In	.. 1
.. 4		.. 605799	.. Blade, Fan 14.000 5wg 30deg .500 Bore Cw Al	.. 1
.. 5		.. 191552	.. Panel, Rear	.. 1
.. 6		.. 168343	.. Hinge, Door Primary	.. 2
.. 7		.. +191553	.. Door, Access Primary	.. 1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**



# Notes

## DECIMAL EQUIVALENTS

	$\frac{1}{64}$	.015625
	$\frac{1}{32}$	.03125
	$\frac{3}{64}$	.046875
$\frac{1}{16}$	$\frac{5}{64}$	.0625
	$\frac{7}{64}$	.078125
	$\frac{3}{32}$	.09375
	$\frac{9}{64}$	.109375
$\frac{1}{8}$	$\frac{11}{64}$	.125
	$\frac{13}{64}$	.140625
	$\frac{5}{32}$	.15625
	$\frac{15}{64}$	.171875
$\frac{3}{16}$	$\frac{17}{64}$	.1875
	$\frac{19}{64}$	.1875
	$\frac{7}{32}$	.203125
	$\frac{21}{64}$	.21875
	$\frac{23}{64}$	.234375
$\frac{1}{4}$	$\frac{25}{64}$	.25
	$\frac{27}{64}$	.25
	$\frac{9}{32}$	.265625
	$\frac{29}{64}$	.28125
$\frac{5}{16}$	$\frac{31}{64}$	.296875
	$\frac{33}{64}$	.3125
	$\frac{11}{32}$	.328125
	$\frac{35}{64}$	.34375
$\frac{3}{8}$	$\frac{37}{64}$	.359375
	$\frac{39}{64}$	.375
	$\frac{13}{32}$	.390625
	$\frac{41}{64}$	.40625
$\frac{7}{16}$	$\frac{43}{64}$	.421875
	$\frac{45}{64}$	.4375
	$\frac{15}{32}$	.453125
	$\frac{47}{64}$	.46875
	$\frac{17}{32}$	.484375
$\frac{1}{2}$	$\frac{49}{64}$	.5
	$\frac{51}{64}$	.515625
	$\frac{53}{64}$	.53125
$\frac{9}{16}$	$\frac{55}{64}$	.546875
	$\frac{57}{64}$	.5625
	$\frac{19}{32}$	.578125
	$\frac{59}{64}$	.59375
$\frac{5}{8}$	$\frac{61}{64}$	.609375
	$\frac{63}{64}$	.625
	$\frac{21}{32}$	.640625
	$\frac{65}{64}$	.65625
$\frac{11}{16}$	$\frac{67}{64}$	.671875
	$\frac{69}{64}$	.6875
	$\frac{23}{32}$	.703125
	$\frac{71}{64}$	.71875
$\frac{3}{4}$	$\frac{73}{64}$	.734375
	$\frac{75}{64}$	.75
	$\frac{49}{64}$	.765625
	$\frac{25}{32}$	.78125
	$\frac{51}{64}$	.796875
$\frac{13}{16}$	$\frac{53}{64}$	.8125
	$\frac{55}{64}$	.828125
	$\frac{27}{32}$	.84375
	$\frac{57}{64}$	.859375
$\frac{7}{8}$	$\frac{59}{64}$	.875
	$\frac{61}{64}$	.890625
	$\frac{29}{32}$	.90625
	$\frac{63}{64}$	.921875
$\frac{15}{16}$	$\frac{65}{64}$	.9375
	$\frac{67}{64}$	.953125
	$\frac{31}{32}$	.96875
	$\frac{69}{64}$	.984375
$1$		1.

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