**HF-251**

**Industrial/Light Industrial Applications**
- General manufacturing
- Tool and die
- Repair shops
- All-purpose maintenance

**Process**
- TIG (GTAW)

**Input Power**
- 1-phase power

**Rated Output**
- 250 A, 60% duty cycle

**Net Weight**
- HF-251D-1: 34 lb. (15 kg)
- HF-251-2: 36 lb. (16 kg)

The HF-251 is compatible with power sources made by other manufacturers. For use with power sources with 14-socket receptacle (5-socket adapter available).

Increase the flexibility and performance of most AC, DC or AC/DC constant-current welding machines with these portable high-frequency arc starters and stabilizers. The unit impresses high frequency on the welding circuit and provides the arc control needed for TIG welding.

With the addition of an HF unit, your constant-current power source can handle welds on aluminum, magnesium, thin stainless steel, brass, copper and a wide variety of both ferrous and non-ferrous alloys.

Two versions (115 V, 50/60/100 Hz and 230 V, 50/60 Hz) meet most single-phase power configurations, and all are rated at 60% duty cycle.

**Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Volts</th>
<th>Rated Output at 60% Duty Cycle</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HF-251D-1</td>
<td>115 V, 50/60/100 Hz</td>
<td>250 A</td>
<td>H: 13 in. (330 mm)</td>
<td>34 lb. (15 kg)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>W: 9.25 in. (235 mm)</td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>D: 16 in. (406 mm)</td>
<td>34 lb. (15 kg)</td>
</tr>
<tr>
<td>HF-251-2</td>
<td>230 V, 50/60 Hz</td>
<td></td>
<td></td>
<td>36 lb. (16 kg)</td>
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</tbody>
</table>

**14-pin receptacle** on front panel for remote controls

**Power on/off switch with pilot light**

**Start, off and continuous control**

**Gas solenoid valve**

**Built-in postflow eliminates contamination**

**High-frequency intensity control**

**Protected secondary terminal**

**Convenient, portable design** can be easily moved from location to location

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Genuine Miller Options and Accessories

Secondary Contactor Kit
For HF-251D-1 model
#041 969 Field only
For HF-251-2 model
#041 906 Field only
Mounts inside HF-251 cabinet. For use with a power source that does not have its own contactor.

Remote Controls and Switches
Controls listed below are for use with Miller constant-current power sources with solid-state output control. The controls are used when remote current control is desired. The HF-251 is equipped with a 14-pin plug for direct connection to new Miller CC power sources. An adapter cord will be required for older Miller equipment with 5-socket receptacles.

RMLS-14 Switch #129 337
Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control #151 086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

RHC-14 Hand Control #242 211 020
Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 83 mm). Includes 20-foot (6 m) cord and 14-pin plug.

RFCS-14 Foot Control #043 554
Foot current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.

Extension Cords
#242 208 025 25 ft. (7.6 m)
#242 208 050 50 ft. (15 m)
#242 208 080 80 ft. (23 m)
#242 208 100 100 ft. (23 m)
Extends HF-251 farther from power source or extends remote control farther from HF-251.

Coolant Systems
For more information, see the Coolmate Series literature sheet, Index No. AY/7.2.

Coolmate™ 3
#043 007 115 V
#043 008 230 V
For use with water-cooled torches rated up to 500 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ 4 #042 288 115 V
For use with water-cooled torches rated up to 600 amps. Tough molded-polyethylene case with carrying handle.

Ordering Information

<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>HF-251D-1</td>
<td>#042 388</td>
<td>115 V, 50/60/100 Hz</td>
<td></td>
<td></td>
</tr>
<tr>
<td>HF-251-2</td>
<td>#042 387</td>
<td>230 V, 50/60 Hz</td>
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<td></td>
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<tr>
<td>Secondary Contactor Kit</td>
<td>#041 969</td>
<td>For HF-251D-1 model. Field only</td>
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<td></td>
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<tr>
<td></td>
<td>#041 906</td>
<td>For HF-251-2 model. Field only</td>
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<td></td>
</tr>
</tbody>
</table>

Date: Total Quoted Price:

Distributed by: