

Thunderbolt® XL AC

Stick Welding Power Source 

Quick Specs

Light Industrial Applications

Home and Farm Use
Garage/Job Shops
Plant Fabrication/Maintenance
Vocational Training

Process

AC Stick (SMAW)

Input Power 1-Phase Power

Max. Open-Circuit Voltage 80

Amperage Range

Low: 30–150 A
High: 40–235 A

Net Weight 85 lb. (39 kg)

Infinite current control allows the operator to adjust output by as little as one-amp increments. Users can always get the exact heat they need, unlike the step control design on competitive products.

Output selector switch allows you to quickly select low or high range without adjusting the output leads.

Accu-Set™ amperage indicator provides precise heat control with infinite amperage control.

High 100 percent duty cycle rating. 100 amps AC.



Comes complete with:

- 15-ft. (4.5 m) No. 4 electrode cable with heavy-duty electrode holder
- 10-ft. (3 m) work cable with clamp
- Power cord with 230 V plug

Note: Does not include wall receptacle.

Fully varnished magnetic coils. Varnish protects and lengthens the life of the coils inside.

Forced-draft cooling fan runs continuously and helps to extend the life of the power source.

Specifications (Subject to change without notice.)



Input Power	Welding Amperage Range	Rated Output at 20% Duty Cycle	Rated Output at 100% Duty Cycle	Amps Input at Rated Output 230 V	Max. Open-Circuit Voltage	Dimensions	Net Weight
230 VAC, 50/60 Hz	Low: 30–150 A High: 40–235 A	225 A at 25 VAC, 60 Hz (15% duty cycle at 50 Hz)	100 A	47.5	80	H: 18.75 in. (476 mm) W: 12.75 in. (323 mm) D: 17.5 in. (445 mm)	85 lb. (39 kg)

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



Power source is warranted for 3 years, parts and labor.
Original main power rectifiers are warranted for 5 years.



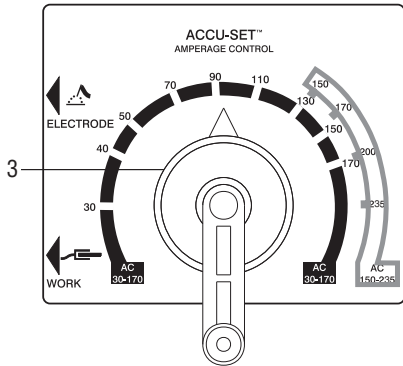
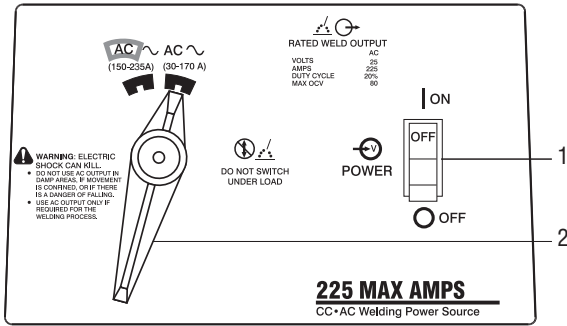
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An ITW Welding Company
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MillerWelds.com
   



Control Panel



1. Power Switch
2. Range Selector Switch
3. Amperage Adjustment Control

Electrode Charts

ELECTRODE POLARITY CHART

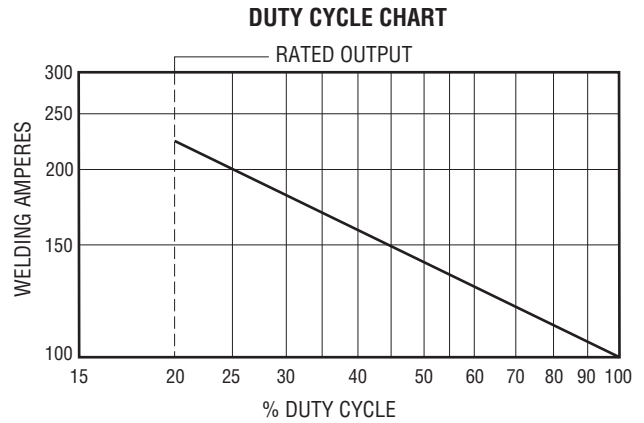
ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	
6013	EP, EN	✓	ALL	LOW	GENERAL
7014	EP, EN	✓	ALL	MED.	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	SMOOTH, EASY, FASTER
Ni-CI	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

*EP = ELECTRODE POSITIVE (REVERSE POLARITY)
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

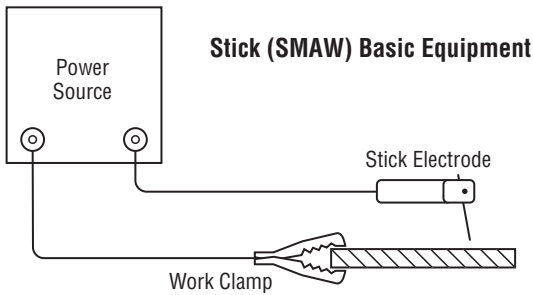
ELECTRODE/AMPERAGE CHART

ELECTRODE	DIAMETER		AMPERAGE RANGE					
	IN	MM	MIN	50A	100A	150A	200A	MAX.
6010 & 6011	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
6013	3/16	4.8						
	1/16	1.6						
	5/64	2.0						
6013	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
	3/16	4.8						
7014	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
7018	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
7024	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
	3/16	4.8						
Ni-CI	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
308L	3/32	2.4						
	1/8	3.2						
	5/32	4.0						

Performance Data



Typical Installation



Ordering Information

Power Source	Stock No.	Description	Qty.	Price
Thunderbolt® XL 225 AC	#903 641	230 V, 50/60 Hz. Includes 5-ft. (1.5 m) power cord with 230 V plug		
Accessories				
Thunderbolt XL Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and handle		
Stick Electrodes		See charts above		
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				

Date: Total Quoted Price:

Distributed by:

