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Millermatic® 212 Auto-Set™

MIG Power Source, Wire Feeder and Gun Package

Quick Specs

Industrial Applications
Metal fabrication
Maintenance and repair
Farm/home
Light industrial

Processes
MIG (GMAW)
Flux-cored (FCAW)

Input Power
200(208)/230 V, single-phase, 60 Hz

Amperage Range 30–210 A
Rated Output 160 A at 24.5 VDC, 60% duty cycle
Wire Feed Speed 50–700 ipm (1.3–17.8 m/min.)
Max. Open-Circuit Voltage 34.5 V
Net Weight 178 lb. (81 kg)

Auto-Set™ makes setup quick and easy and works with .030- and .035-inch wire. See page 2 for more information.

Infinite voltage control. When used in manual mode provides broader operating range with finer control than a tap machine.

Line voltage compensation keeps power constant even if power input varies by ±10 percent.

No more replacing mechanical output contactors. Our built-in solid-state contactor circuit makes wire electrically "cold" until trigger is pulled, and gives you life-long welding output and performance.

Gun-On-Demand.™ Simply pull the trigger for either gun and you're ready to weld. No wasted time installing modules and using gas valve kits.

Heavy-duty aluminum two-drive-roll system.

Fan-On-Demand™ cooling system only operates when needed, reducing noise, energy use and the amount of contaminants pulled though the machine.

Compatible with Bobcat™ welder/generators.

IMPROVED!
*Now with **NEW!** MDX Series MIG gun.*

Comes complete with:
- 15 ft. (4.6 m), 250-amp MDX™-250 MIG gun
- 10 ft. (3 m) work cable with clamp
- 7 ft. (2.1 m) power cord with plug
- Flow gauge regulator and gas hose for argon or AR/CO_2 mix
- Factory-installed lowered running gear/cylinder rack
- .030/.035 in. reversible dual-groove drive rolls
- Extra contact tips
- Material thickness gauge (229895) ➤

EZ-Access™ consumable compartment and parameter chart. Set weld parameters right the first time with convenient flip-down compartment that provides fast access to parameter chart and consumables. See page 3 for more information.

Aluminum MIG welding with optional Spoolmate™ 200 spool gun. Wire feed speed control on the gun saves time by reducing trips back to the machine. Also compatible with more industrial Spoolmatic® spool guns.

TRUE BLUE® 3 YR. WARRANTY

Welder is warranted for three years, parts and labor.
Original main power rectifier parts are warranted for five years.
Gun warranted for 90 days, parts and labor.

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MillerWelds.com

Certified System ISO 9001 Quality

Consumables

For MDX™-250 MIG Guns

Standard Miller® AccuLock™ MDX Consumables
Smaller consumables and components to access hard-to-reach weldments.

Contact Tips *(10 per package)*
T-M023 .023 in. (0.6 mm)
T-M030 .030 in. (0.8 mm)
T-M035 .035 in. (0.9 mm)
T-M045 .045 in. (1.2 mm)

Nozzles
N-M1200C Copper, 1/2 in. ID, flush, standard
N-M1218C Copper, 1/2 in. ID, 1/8 in. recess
N-M5800C Copper, 5/8 in. ID, flush
N-M5818C Copper, 5/8 in. ID, 1/8 in. recess
N-M58XTC Copper, 5/8 in. ID, 1/8 in. stickout

Diffuser D-M250

Monocoil Replacement Liners

10 ft. Liner
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)

12 ft. Liner
LM1A-12 .023/.025 in. (0.6 mm)
LM2A-12 .030/.035 in. (0.8/0.9 mm)
LM3A-12 .035/.045 in. (0.9/1.2 mm)

15 ft. Liner
LM1A-15 .023/.025 in. (0.6 mm)
LM2A-15 .030/.035 in. (0.8/0.9 mm)
LM3A-15 .035/.045 in. (0.9/1.2 mm)

Optional Bernard® AccuLock™ S Consumables
Consumables for increased durability and longer life when guns are used in industrial applications.

Contact Tips *(10 per package)*
T-A023CH .023 in. (0.6 mm)
T-A030CH .030 in. (0.8 mm)
T-A035CH .035 in. (0.9 mm)
T-A039CH .039 in. (1.0 mm)
T-A045CH .045 in. (1.2 mm)

Nozzles
N-A5800C Copper, 5/8 in. ID, flush, standard
N-A5818C Copper, 5/8 in. ID, 1/8 in. recess
N-A5814C Copper, 5/8 in. ID, 1/4 in. recess

Diffuser D-MA250

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

For Spoolmate™ 200 Spool Gun

Note: Spoolmate 200 spool gun ships with (2) .030 in. and (2) .035 in. contact tips and (1) nozzle.

For Standard Heavy-Duty Head Tube

Contact Tips *(5 per package)*
199387 .030 in. (0.8 mm)
199388 .035 in. (0.9 mm)

Nozzle 050622

For Optional Head Tubes
Note: The same consumables are used on 45-degree, 9-inch extension and 5-inch head tubes.

Contact Tips *(5 per package)*
199730 .024 in. (0.6 mm)
(requires V-knurled drive roll **136135**)
186419 .030 in. (0.8 mm)
186406 .035 in. (0.9 mm)

Nozzle 186405

For Spoolmatic® Spool Guns

For Aluminum Wire

FasTip™ Contact Tips *(25 per package)*
206186 Heavy-duty, .030 in. (0.8 mm)
206187 Heavy-duty, .035 in. (0.9 mm)
206188 Heavy-duty, .040 in. (1.0 mm)

209026 Tapered, .030 in. (0.8 mm)
209027 Tapered, .035 in. (0.9 mm)

Screw-On Nozzles
199610 Brass, 1/2 in. orifice, tapered
199613 Brass, 5/8 in. orifice, tapered
199614 Brass, 5/8 in. orifice, tapered HD
199611 Brass, 3/4 in. orifice, straight
199612 Brass, 3/4 in. orifice, straight HD

209035 Copper, 3/8 in. orifice, tapered
199615 Copper, 1/2 in. orifice, tapered
209036 Copper, 1/2 in. orifice, tapered HD
198855 Copper, 5/8 in. orifice, tapered
199618 Copper, 5/8 in. orifice, tapered HD
207313 Copper, 5/8 in. orifice, tapered 15/16 OD
199616 Copper, 3/4 in. orifice, straight
199617 Copper, 3/4 in. orifice, straight HD

Bernard® Centerfire™ "T" Series Contact Tips
T-035AL .035 in. (0.9 mm)

Bernard® Centerfire™ Small Nozzles
NST-3818B Brass, 3/8 in. ID, 1/8 in. tip recess
NS-1218B Brass, 1/2 in. ID, 1/8 in. tip recess
NS-1200B Brass, 1/2 in. ID, flush tip
NS-5818B Brass, 5/8 in. ID, 1/8 in. tip recess

NS-1218C Copper, 1/2 in. ID, 1/8 in. tip recess

For Millermatic® 212 Auto-Set™

Note: Machine drive roll kits include two drive rolls and an inlet guide.

V-Grooved Drive Roll Kits (solid wire)
204579 .030 and .035 in. (0.8 and 0.9 mm) combination (reversible)
087131 .024 in. (0.6 mm)
079594 .030 in. (0.8 mm)
079595 .035 in. (0.9 mm)

V-Knurled Drive Roll Kits
(flux-cored or difficult-to-feed wire)
079606 .035 in. (0.9 mm)
079607 .045 in. (1.2 mm)

Ordering Information

Steel Configuration

	Stock No.	Description	Qty.	Price
Millermatic® 212 Auto-Set™	**907405**	200(208)/230 V, 60 Hz		
Millermatic V-Grooved Drive Roll Kits (solid wire)	**087131** **079594** **079595** **204579**	.024 in. (0.6 mm) .030 in. (0.8 mm) .035 in. (0.9 mm) .030/.035 in. (0.8/0.9 mm)		
Millermatic V-Knurled Drive Roll Kits (flux-cored)	**079606** **079607**	.035 in. (0.9 mm) .045 in. (1.2 mm)		
Miller® AccuLock™ MDX™ Contact Tips (10 per package)	**T-M023** **T-M030** **T-M035** **T-M045**	.023 in. (0.6 mm) .030 in. (0.8 mm) .035 in. (0.9 mm) .045 in. (1.2 mm)		
Miller® AccuLock™ MDX™ Nozzles	**N-M1200C** **N-M1218C** **N-M5800C** **N-M5818C** **N-M58XTC**	Copper, 1/2 in. ID, flush, standard Copper, 1/2 in. ID, 1/8 in. recess Copper, 5/8 in. ID, flush Copper, 5/8 in. ID, 1/8 in. recess Copper, 5/8 in. ID, 1/8 in. stickout		

Aluminum Configuration

For MDX-250 gun consumables and Millermatic 212 Auto-Set drive rolls, see steel configuration chart above.

Millermatic® 212 Spool Gun Package (includes standard MDX™-250 MIG gun)	**951177**	200(208)/230 V, 60 Hz with Spoolmate™ 200, dual cylinder rack, elevated gun and cable rack, regulator and hose		
Spoolmate™ 200 Contact Tips (5 per package)	**199387** **199388**	.030 in. (0.8 mm) wire .035 in. (0.9 mm) wire		
Spoolmate™ 200 Nozzle	**050622**			
Optional Spoolmate™ 200 Head Tubes	**300591** **300592** **243385**	45-degree head tube 9 in. extension head tube 5 in. head tube		

Accessories

Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack	**300337**			
Elevated Gun and Cable Rack	**300335**	For use with single cylinder rack *(included with dual EZ-Change low cylinder rack)*		
Protective Cover	**195142**	Features side pocket		
Argon/Mixed Gas Regulator and Gas Hose	**195050**			
Full KVA Adapter Cord	**300517**			
Guns				
MDX™-250 MIG Gun with AccuLock™ MDX Consumables	**1770035** **1770036** **1770037**	10 ft. (3 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire 12 ft. (3.7 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire 15 ft. (4.6 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire		
MDX™-250 MIG Gun with Industrial AccuLock™ S Consumables	**1770041** **1770042** **1770043**	10 ft. (3 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire 12 ft. (3.7 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire 15 ft. (4.6 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire		
Spoolmate™ 200	**300497**	20 ft. (6 m), 160 A, .030–.035 in. (0.8–0.9 mm) for aluminum wire, .023–.035 in. (0.6–0.9 mm) for steel/stainless steel wires		
Spoolmatic® 15A	**195156**	15 ft. (4.6 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum wire		
Spoolmatic® 30A	**130831**	30 ft. (9 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum wire		

Date: **Total Quoted Price:**

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