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MIG Guns

Product Guide

Product Guide	Page	Class	MIG	Pulsed MIG	Flux-cored*	Wire Types				Wire Diameter Capacity	Available Cable Lengths	Typical Applications	
						Solid	Flux-cored		Alum.				
							Gas-shld	Self-shld					
MIGmatic™ M-100 MIG Gun	23	●	●		●	●	●	● CV*	●	.023-.045 in. (0.6-1.2 mm)	10 ft.	Light industrial steel fabrication	Steel
MIGmatic™ M-150 MIG Guns	23	●	●		●	●	●	● CV*	●	.023-.045 in. (0.6-1.2 mm)	15 ft.	Light industrial steel fabrication	
MDX™-100 MIG Gun	24	●	●		●	●	●	● CV*	●	.023-.045 in. (0.6-1.2 mm)	10 ft.	Light industrial steel fabrication	
MDX™-250 MIG Guns	24	●	●	●	●	●	●	● CV*	●	.023-.045 in. (0.6-1.2 mm)	10, 12 or 15 ft.	Industrial steel fabrication	
MDX™-250 EZ-Select™ MIG Guns	24	●	●	●	●	●	●	● CV*	●	.023-.045 in. (0.6-1.2 mm)	15 ft.	Industrial steel fabrication	
Bernard® BTB MIG Guns	25	●	●	●	●	●	●	● CV*	●	.023-1/8 in. (0.6-3.2 mm)	10, 15, 20, or 25 ft.	Heavy industrial steel fabrication	
Bernard® Clean Air™ Fume Extraction Guns with Straight Handle	26	●	●	●	●	●	●	● CV*	●	.023-1/8 in. (0.6-3.2 mm)	8, 10, 12, 15, 20, or 25 ft.	Heavy industrial steel fabrication	
Bernard® Clean Air™ Fume Extraction Guns with Curved Handle	26	●	●	●	●	●	●	● CV*	●	.023-5/64 in. (0.6-2.0 mm)	8, 10, 12, 15, 20, or 25 ft.	Heavy industrial steel fabrication	
Bernard® Dura-Flux™ Guns with Fixed Liner	26	●			●			● CV*		1/16-3/32 in. (1.6-2.4 mm)	8, 10, 12, 15, 20, or 25 ft.	Heavy industrial steel fabrication	Aluminum
Bernard® Dura-Flux™ Guns with Replaceable Liner	26	●			●			● CV*		.045-5/64 in. (1.2-2.0 mm)	8, 10, 12, 15, 20, or 25 ft.	Heavy industrial steel fabrication	
Spoolmate™ Spool Guns	27	●	●			●			●	100/200/3035 models: .023-.035 in. (0.6-0.9 mm) 150 model: .030-.035 in. (0.8-0.9 mm)	100 model: 12 ft. 150/200/3035 models: 20 ft.	Light industrial aluminum fabrication	
Spoolmatic® Spool Guns	28	●	●	●	●	●		● CV*	●	.030-1/16 in. (0.8-1.6 mm)	15 or 30 ft.	Industrial aluminum fabrication	
XR-Aluma-Pro™ Lite Push-Pull Gun	29	●	●	●		●			●	.030-.047 in. (0.8-1.2 mm)	25 ft.	Industrial aluminum fabrication	
XR-Aluma-Pro™ Push-Pull Guns	29	●	●	●		●			●	.030-1/16 in. (0.8-1.6 mm)	15, 25 or 35 ft.	Heavy industrial aluminum fabrication	
XR™ Pistol Push-Pull Guns	29	●	●	●		●			●	.030-1/16 in. (0.8-1.6 mm)	XR-Pistol: 15 or 30 ft. XR-Pistol-Pro: 15, 25 or 35 ft.	Heavy industrial aluminum fabrication	

Product Key

Class: ● Light industrial ● Industrial ● Heavy industrial Capability: ● Designed for this process ● Capable of this process

*Certain self-shielded wires require CV output. Miller recommends a CV power source whenever possible.

MIGmatic™ M-Series MIG Guns

See literature AY/15.0

Upgrade your M-100 and M-150 MIG guns to AccuLock™ MDX™ consumables with a conversion diffuser.



Conversion diffuser



Conversion kit

AccuLock™ MDX™ Conversion Kit 1880269

Kit features a conversion diffuser to consolidate MIG nozzles and contact tips to AccuLock MDX. Includes diffuser (1070115), 1/2-inch flush nozzle (NS-M1200C), five .030-inch contact tips (T-M030), five .035-inch contact tips (T-M035) and a consumables storage box.

Light industrial ●

Processes

■ MIG (GMAW) ■ Flux-cored (FCAW)

Suggested power sources

- Millermatic® 141/211 (M-100/M-150) (pg 7)
- Multimatic® 200 (M-150) (pg 37)
- Multimatic® 215 (M-100/M-150) (pg 37)
- Multimatic® 220 (M-100/M-150) (pg 38)

Most popular accessories

- MIGmatic M-Series Consumable Kits (pg 121)
 - 234607 .023 in. (0.6 mm)
 - 234608 .030 in. (0.8 mm)
 - 234609 .035 in. (0.9 mm)
- AccuLock™ MDX™ Conversion Kit 1880269

Allows MIGmatic M-100 and M-150 MIG guns to upgrade to AccuLock™ MDX™ nozzles and tips (see pg 24)

Visit MillerWelds.com or your distributor for other Miller® options and accessories.

Model	Stock Number	Cable Length	Rated Output	Rated Duty Cycle	Wire Diameter Capacity	Gun Only Net Weight
M-100	(248282)	10 ft. (3 m)	100 A	100% with CO ₂ gas, 60% with mixed gas	.023-.045 in. (0.6-1.2 mm)	3.2 lb. (1.5 kg)
M-150	(249041)	15 ft. (4.6 m)	150 A	100% with CO ₂ gas, 60% with mixed gas	.023-.045 in. (0.6-1.2 mm)	6.0 lb. (2.7 kg)

MDX™ Series MIG Guns

See literature AY/15.5

An ideal match for Miller® all-in-one MIG machines or other Miller® wire feeders.



Durable, ergonomic handle features rubber overmolding for improved grip and rear swivel to reduce welder fatigue.

AccuLock™ consumables provide long life and superior wire feeding. See below for more information.

Pulse welding capable due to increased copper in the gun cable which ensures reliable performance with CV and pulse waveforms (MDX-250/MDX-250 EZ-Select only).

EZ-Select™ function allows you to conveniently select from up to four weld programs by tapping the MIG gun trigger rather than walking back to the machine. Lights on handle indicate weld program selected (MDX-250 EZ-Select only).



Model	Stock Number	Cable Length	Rated Output	Rated Duty Cycle	Standard Wire Size	Standard Consumables
MDX-100	(1770028)	10 ft. (3 m)	100 A	100% with CO ₂ gas, 60% with mixed gas	.030-.035 in. (0.8-0.9 mm)	AccuLock MDX
MDX-250	(1770035)	10 ft. (3 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.030-.035 in. (0.8-0.9 mm)	AccuLock MDX
	(1770036)	12 ft. (3.7 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.030-.035 in. (0.8-0.9 mm)	AccuLock MDX
	(1770037)	15 ft. (4.6 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.030-.035 in. (0.8-0.9 mm)	AccuLock MDX
	(1770038)	15 ft. (4.6 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.035-.045 in. (0.9-1.2 mm)	AccuLock MDX
	(1770041)	10 ft. (3 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.035-.045 in. (0.9-1.2 mm)	AccuLock S
	(1770042)	12 ft. (3.7 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.035-.045 in. (0.9-1.2 mm)	AccuLock S
	(1770043)	15 ft. (4.6 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.035-.045 in. (0.9-1.2 mm)	AccuLock S
MDX-250 EZ-Select	(1770046)	15 ft. (4.6 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.035-.045 in. (0.9-1.2 mm)	AccuLock S
	(1770047)	15 ft. (4.6 m)	250 A	100% with CO ₂ gas, 60% with mixed gas	.030-.035 in. (0.8-0.9 mm)	AccuLock MDX

AccuLock™ MDX™ Consumables

See literature AY/15.5

Flawless wire feeding path. Front-loading liner is locked and concentrically aligned with both the contact tip and power pin.

Error-proof liner trimming ensures accurate replacement every time — no measuring required!

Maximize electrical conductivity and tip life. Tapered mating surface between the contact tip and gas diffuser locks tips in place for optimal performance.

Upgrade to AccuLock S consumables for increased durability and longer life when guns are used in pulsed welding or more industrial applications. See page 25 for more information.



MDX Series MIG Guns Consumable Kits



For MDX-100 with AccuLock MDX

- 1880272** .023 in (0.6 mm)
- 1880273** .030 in (0.8 mm)
- 1880274** .035 in (0.9 mm)

For MDX-250 with AccuLock MDX

- 1880275** .030 in (0.8 mm)
- 1880276** .035 in (0.9 mm)
- 1880277** .045 in (1.2 mm)

For MDX-250 with AccuLock S

- 1880278** .035 in (0.9 mm)
- 1880279** .045 in (1.2 mm)

Kits include ten contact tips, one nozzle, one diffuser, and a consumable storage box. Both kits for MDX-250 gun also include one neck insulator.

Light industrial ● MDX-100
Industrial ● MDX-250/250 EZ-Select

Processes

- MIG (GMAW) ■ Flux-cored (FCAW)
- Pulsed MIG (GMAW-P) with MDX-250/250 EZ-Select

Suggested power sources

For MDX-100

- Millermatic® 141/211 (pg 7)
- Multimatic® 215 (pg 37)
- Multimatic® 220 AC/DC (pg 38)

For MDX-250

- Millermatic® 252 (pg 8)
- Millermatic® 255 (pg 9)
- Multimatic® 200 (pg 37)
- Multimatic® 235 (pg 39)
- Multimatic® 255 (pg 40)

For MDX-250 EZ-Select

- Millermatic® 255 (pg 9)
- Millermatic® 355 (pg 10)
- Multimatic® 255 (pg 40)

Most popular consumables

AccuLock Consumables

Liners (inches)

- LM1A-10** .023-.025, 10 ft. length
- LM2A-10** .030-.035, 10 ft. length
- LM3A-10** .035-.045, 10 ft. length
- LM1A-12** .023-.025, 12 ft. length
- LM2A-12** .030-.035, 12 ft. length
- LM3A-12** .035-.045, 12 ft. length
- LM1A-15** .023-.025, 15 ft. length
- LM2A-15** .030-.035, 15 ft. length
- LM3A-15** .035-.045, 15 ft. length

Diffusers

- D-M100** MDX-100
- D-M250** MDX-250
- D-MA250M** MDX-250 AccuLock S conversion

MDX-100 Nozzles (inches)

- NS-M1200B** 1/2 ID, flush, brass
- NS-M1200C** 1/2 ID, flush, copper
- NS-MFLX** Gasless nozzle

MDX-250 Nozzles (inches)

AccuLock MDX

- N-M1200C** 1/2 ID, flush, copper
- N-M1218C** 1/2 ID, 1/8 rec., copper
- N-M5800C** 5/8 ID, flush, copper
- N-M5818C** 5/8 ID, 1/8 rec., copper
- N-M58XTC** 5/8 ID, 1/8 ext., copper

AccuLock S

- N-A5800CM** 5/8 ID, flush, copper
- N-A5818CM** 5/8 ID, 1/8 rec., copper
- N-A5814CM** 5/8 ID, 1/4 rec., copper

Contact Tips (inches)

AccuLock MDX

- T-M023** .023
- T-M030** .030
- T-M035** .035
- T-M045** .045
- T-M047** 3/64

AccuLock S

- T-A023CHM** .023
- T-A030CHM** .030
- T-A035CHM** .035
- T-A039CHM** .039
- T-A045CHM** .045

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