

XMT® 425 Series

Multiprocess Welding Power Source 

Quick Specs



Heavy Industrial Applications

Construction
Shipbuilding
Railroad
Truck/Trailer Manufacturing
Fabrication
Repair Shops
Rental Fleets
Power Generation Plants

Processes

MIG (GMAW)/Pulsed MIG (GMAW-P)*
Stick (SMAW)
TIG (GTAW)
Flux Cored (FCAW)
Air Carbon Arc Cutting and Gouging (CAC-A)

**XMT 425 CC/CV requires optional control; not available with XMT 425 VS model.*

Input Power Requires 3- or 1-Phase Power, 208–575 VAC, 50/60 Hz

Rated Output 10–38 V, 5–425 A

Weight Net: 80 lb. (36.3 kg)
Ship: 89.1 lb. (40.4 kg)

Wind Tunnel Technology™ protects electrical components and PC boards from contamination.

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

Lift-Arc™ allows TIG starting without the use of high-frequency. Starts the arc without contaminating the weld with tungsten.

Adaptive Hot Start™ increases the output amperage at the start of a weld if necessary, eliminating electrode sticking.

Lightweight, aerospace-grade aluminum case offers protection with the benefit of reduced weight.

Auto-Line™ Power Management Technology allows for any input voltage hook-up (208–575 V) with no manual linking required, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

Inverter arc control technology provides greater puddle control for superior 6010 Stick electrode performance, and outstanding MIG weld performance.

Process selector switch reduces the number of control setup combinations without reducing any features.



XMT 425 CC/CV

XMT 425 VS

350 A of welding output at 60 percent duty cycle with superior low-end performance.

Power factor of .95 enables smaller fuses/breakers and primary wiring. Primary amperage draw at rated output is 25 percent less than the competition.

Ultra-tough, polycarbonate-blended cover for control panel protects front controls from damage.

Low OCV Stick — A built-in, selectable feature, that reduces the Stick mode open-circuit voltage (OCV) to nearly 15 volts when the welding power source is not in use. Eliminates the need for add-on voltage reducers.

Dinse international-style weld disconnects provide high-quality weld cable connections.

Additional Features for XMT 425 CC/CV

Auto Remote Sense™ enables unit to automatically use remote control if connected to remote control receptacle.

Pulsed MIG (GMAW-P) capabilities with optional Optima™ control reduces spatter and distortion, allows better out-of-position puddle control, and provides potential reduction of fume particle emission.

The XMT 425 Series is packed with features to meet the most demanding welding needs.

Line voltage compensation keeps welding output constant even if input power varies by +/-10 percent. XMT 425 models further expand line voltage compensation on 460 VAC to an amazing +37 percent, -59 percent.

Large, dual digital meters are easy to view and are presettable to ease setting weld output.

Exceptional electrical efficiency. At 400 A, efficiency is 87.24 percent!



Power source is warranted for 3 years, parts and labor.
Original main power rectified parts are warranted for 5 years.
Gun warranted for 90 days, parts and labor.



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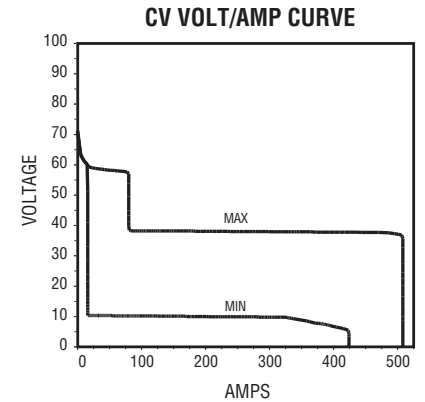
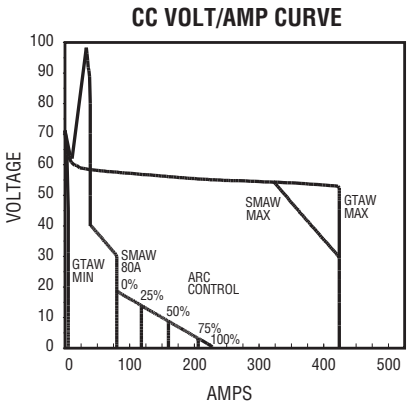
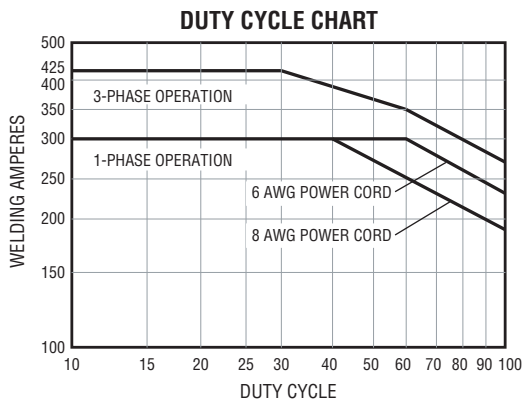
Specifications (Subject to change without notice.)



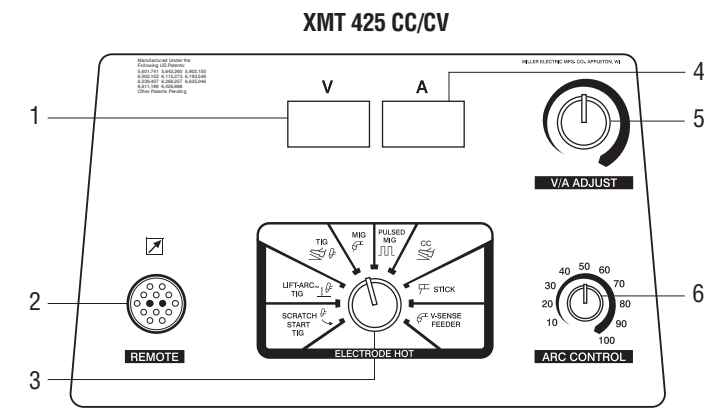
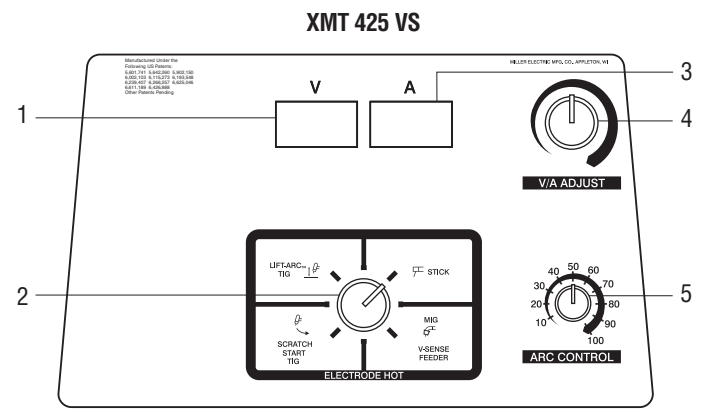
Input Power	Rated Output at 60% Duty Cycle	Voltage Range in CV Mode	Amperage Range in CC Mode	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 60 Hz,							Dimensions	Weight
					208 V	230 V	400 V	460 V	575 V	KVA	KW		
Three-Phase	350 A at 34 VDC	10–38 V	5–425 A	75 VDC	40.4	36.1	20.6	17.8	14.1	14.2	13.6	H: 17 in. (432 mm) W: 12.5 in. (318 mm) D: 24 in. (610 mm)	80 lb. (36.3 kg)
Single-Phase	300 A at 32 VDC	10–38 V	5–425 A	75 VDC	60.8	54.6	29.7	24.5	19.9	11.7	11.2		

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

Performance Data



Control Panels



Genuine Miller® Accessories



XMT Cylinder Cart #042 537
Carries two 160-pound (72.6 kg) gas cylinders, or one gas cylinder and one coolant system for TIG (GTAW) welding. Feeder mounts to tray above power source.

Gas Solenoid Kit #195 286
Easy to install, optional gas solenoid kit for TIG welding applications.

Process Selector Control #042 872
Designed for use with dual wire feeders, applications where electrical isolation and/or polarity reversing of weld current is required, and for welding process changes. Includes 115 VAC/2-amp receptacle, two 14-pin receptacles and a 10-foot (3 m) 14-pin cord.



HF-251D-1 High-Frequency Arc Starter and Stabilizer #042 388
Portable 250-amp, 60-percent duty cycle unit adds high frequency to the

welding circuit to help start the arc when using the DC TIG (GTAW) process. Operates on 115 VAC, 50/50 Hz. See Lit. Index No. AY/5.1.



RFCS-14 Foot Control #043 554
Heavy-duty foot current and contactor control. Includes 20-foot (6 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 82 mm). Includes 20-foot (6 m) cord and 14-pin plug.



RMLS-14 #129 337
Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and back for momentary contact. Includes 20-foot (6 m) cord and 14-pin plug.



RCC-14 Remote Contactor and Current Control #151 086
Rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 28-foot (8.5 m) control cord and 14-pin plug.



RCCS-14 Remote Contactor and Current Control #043 688
Up-and-down rotary-motion fingertip control. Great for applications that require a finer amperage control. Includes 28-foot (8.5 m) control cord and 14-pin plug.

Extension Cords for Remote Controls and 24 VAC Wire Feeders
#242 208 025 25 ft. (7.6 m)
#242 208 050 50 ft. (15 m)
#242 208 080 80 ft. (24.3 m)
14-pin plug to 14-pin socket.

Note: Not for use with Optima or 60M Series.



Optima™ #043 389
A microprocessor-based, multipurpose pulse control for both synergic MIG (wire welding or GMAW) or manual MIG pulsing. Use this control with the XMT 425 CC/CV power source and any Miller wire feeder, including automatic feeders and spool guns. Includes a 25-foot (7.6 m) cord with 14-pin plug. (Not for use with XMT 425 VS model.)

Extension Cords for Optima
#242 205 025 25 ft. (7.6 m)
#242 205 050 50 ft. (15 m)
#242 205 080 80 ft. (24.3 m)

Wire Feeders/Guns

SuitCase® X-TREME™ 8VS #951 582
SuitCase® X-TREME™ 12VS #951 543
Lightweight, voltage-sensing wire feeder for a variety of wires up to .062 inch. Holds up to an 8-inch (8VS) or 12-inch (12VS) spool of wire. Operates on open-circuit voltage eliminating the need for a control/power cord. Includes secondary contactor, gas valve and drive roll kit. See Lit. Index No. M/6.42.

SuitCase® 12RC #951 188
Lightweight, modular design and flexible enough to run a variety of wires up to 5/64-inch diameter. Holds up to an 8-inch (8RC) or 12-inch (12RC) spool of wire. Operates using 14-pin control receptacle. Includes remote voltage control and drive roll kit. See Lit. Index No. M/6.5.

XR™-Control #181 538
Push-pull wire feed system offers unparalleled performance for aluminum MIG welding. See Lit. Index No. M/1.7.

70 Series
S-74S #951 196
S-74D #951 198
S-74DX #951 200
Wire feeder features Posifeed™ wire drive assembly and handles a variety of wires up to 1/8 inch. Includes Bernard® Q™-Gun. See Lit. Index No. M/3.0.



Spoolmatic® 30A #130 831
One-pound, air-cooled spool gun that extends the weld process range by adding a handy portable system for small wire MIG. Rated at 200 amps at 100 percent duty cycle. Includes 30-foot (9.1 m) cable assembly. **WC-24 Control (#137 549)** required with 14-pin receptacles.



WC-24 Weld Control #137 549
Designed for use with Miller CV power sources supplying 24 VAC and 14-pin receptacles. For use with Spoolmatic 30A spool gun.



WC-115A Weld Control #137 546-01-1
Operates on 115 VAC and is designed for power sources without a 14-pin receptacle. For use with Spoolmatic 30A spool gun. Includes 10-foot (3 m) wall-type plug and power cord.

Ironmate™ Flux Cored Guns
See Lit. Index No. AY/16.0.

FC-1260
#195 732 10 ft. (3 m)
#195 729 15 ft. (4.6 m)

FC-1260LM
#194 912 10 ft. (3 m)
#194 911 15 ft. (4.6 m)

FC-1150
#194 864 10 ft. (3 m)
#194 863 15 ft. (4.6 m)

Coolant Systems

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

Coolmate™ 3
#043 007 115 VAC
#043 008 230 VAC
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 VAC
For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Low-Conductivity TIG Coolant #043 810
Sold in cases of four one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C).

Genuine Miller® Accessories (Continued)

Note: XMT 425 power sources are equipped with Dinse-style connectors for secondary connections. (Power source is shipped with two 50-mm male Dinse-style plugs for use with #1 or #2 AWG size cable.)



Dinse/Tweco® Adapter
#042 465
Dinse/Cam-Lok Adapter
#042 466

One-piece adapter with Dinse-style male plug (to power source) on one end and female receptacle (Tweco or Cam-Lok for weld cable connection) on other end.

Dinse-Style Connectors

#042 418

Accepts #4 to #1/0 AWG size cable.

#042 533

Accepts #1/0 to #2/0 AWG size cable.

Kit includes one Dinse-style male plug which attaches to the work and/or weld cables and plugs into the Dinse-style receptacles on the power source.

Extension Kits for Dinse-Style Cable Connectors

#042 419

Accepts #4 to #1/0 AWG size cable.

#042 534

Accepts #1/0 to #2/0 AWG size cable.

Used to adapt or extend weld and/or work cables. Kit includes one male Dinse-style plug and one in-line female Dinse-style receptacle.

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
XMT® 425 CC/CV	#907 386	208–575 VAC with Auto-Line™		
XMT® 425 VS	#907 387	208–575 VAC with Auto-Line™		
Accessories				
XMT Cylinder Cart	#042 537			
Gas Solenoid Kit	#195 286			
Process Selector Control	#042 872			
HF-251D-1 HF Starter/Stabilizer	#042 388	See Lit. Index No. AY/5.1		
RFCS-14	#043 554	Foot control		
RHC-14	#242 211 020	Hand control		
RMLS-14	#129 337	Rocker switch		
RCC-14	#151 086	Fingertip control		
RCCS-14	#043 688	Fingertip control		
Extension Cords (For 24 VAC wire feeders and remote controls)		See page 3. Not to be used with Optima, 60M or XR-M		
Optima™ MIG Pulse Control	#043 389	For CC/CV models only. Not for use with XMT 425 VS		
Optima™ Extension Cords		See page 3		
Wire Feeders/Guns				
SuitCase® 8VS/X-TREME™ 12VS	#951 181 / #951 543	See Lit. Index No. M/6.42		
SuitCase® 8RC/12RC	#951 186 / #951 188	See Lit. Index No. M/6.5		
XR™-Control	#181 538	See Lit. Index No. M/1.7		
70 Series	#951 196 #951 198 #951 200	S-74S. See Lit. Index No. M/3.0 S-74D. See Lit. Index No. M/3.0 S-74DX. See Lit. Index No. M/3.0		
Spoolmatic® 30A Spool Gun	#130 831	Includes 30-ft. (9.1 m) cable assembly		
WC-24	#137 549	For use with Spoolmatic® 30A and power sources with 14-pin		
WC-115A	#137 546-01-1	For use with Spoolmatic® 30A and power sources without 14-pin		
Ironmate™ Flux Cored Guns		See Lit. Index No. AY/16.0		
Coolant Systems				
		See page 3. See Lit. Index No. AY/7.2		
Cable Connectors and Adapters				
		See above		

Date:

Total Quoted Price:

Distributed by:

