

# 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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### International Sales

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MillerWelds.com



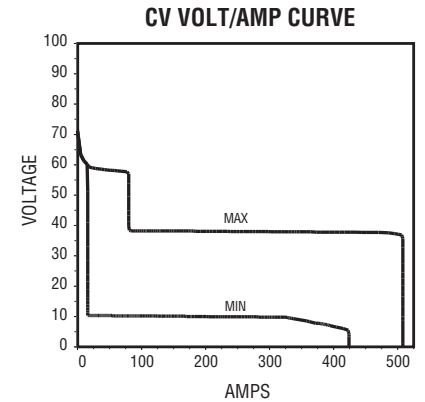
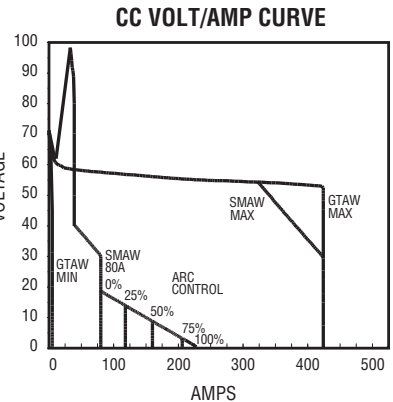
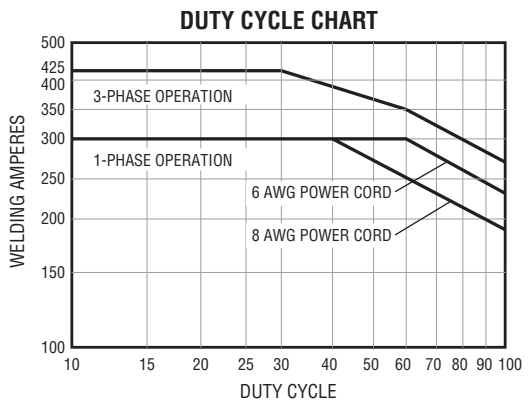
# Specifications (Subject to change without notice.)



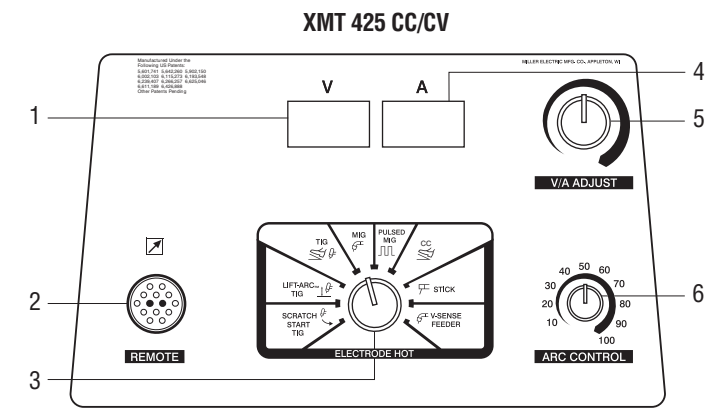
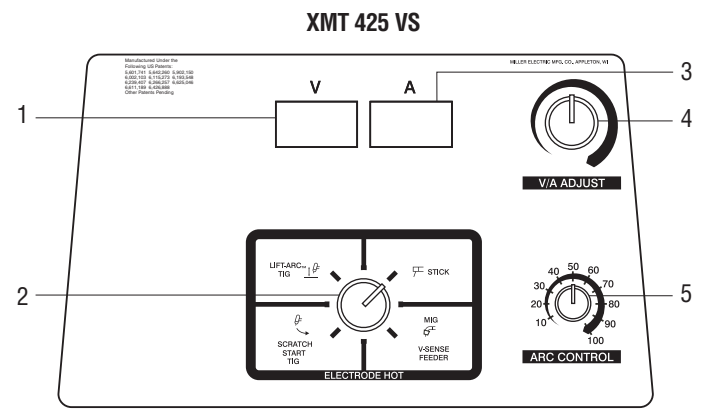
Input Power	Rated Output at 60% Duty Cycle	Voltage Range in CV Mode	Amperage Range in CC Mode	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 60 Hz,								Dimensions	Weight
					208 V	230 V	400 V	460 V	575 V	KVA	KW			
Three-Phase	350 A at 34 VDC	10–38 V	5–425 A	75 VDC	40.4	36.1	20.6	17.8	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™		
<b>Accessories</b>				
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		
<b>Wire Feeders/Guns</b>				
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 <b>with</b> 14-pin		
WC-115A	#137 546-01-1	For use with Spoolmatic® 30A and power sources <b>without</b> 14-pin		
Ironmate™ Flux Cored Guns		See Lit. Index No. AY/16.0		
<b>Coolant Systems</b>				
		See page 3. See Lit. Index No. AY/7.2		
<b>Cable Connectors and Adapters</b>				
		See above		

Date:

Total Quoted Price:

Distributed by:

