

XMT[®] 425 Series

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**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,
208–460 VAC, 50/60 Hz CE

Rated Output 10–38 V, 5–425 A

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

The Power of Blue.[®]

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 (208–460 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

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%. XMT 425 models further expand line voltage compensation on 460 VAC to an amazing +37%, -59%.

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%!

350 A of welding output at 60% 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% 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.

115 VAC auxiliary power provides 10 amps of circuit-breaker-protected power for water circulators. Available on CE model.

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.



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.

MADE IN **USA**
APPLETON, WI **USA**



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An Illinois Tool Works Company
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Appleton, WI 54914 USA

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Canadian FAX: 920-735-4169
International FAX: 920-735-4125

Web Site
www.MillerWelds.com



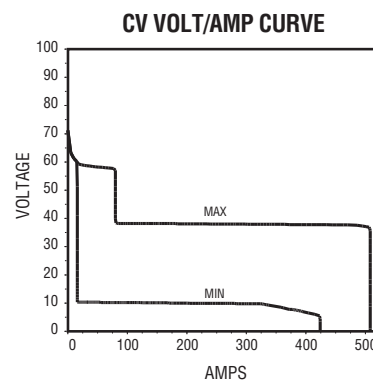
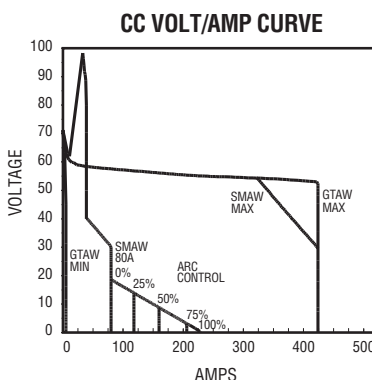
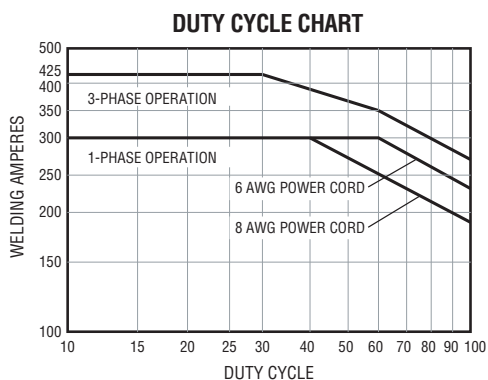
XMT® 425 Specifications (Subject to change without notice.)



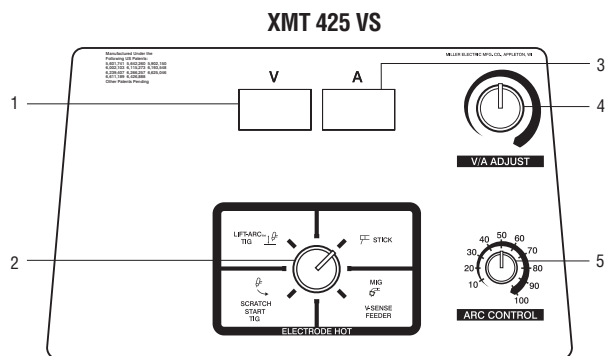
Input Power	Rated Output at 60% Duty Cycle	Voltage Range in CV Mode	Amperage Range in CC Mode	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 60 Hz, 208 V 230 V 400 V 460 V 575 V KVA KW	Dimensions	Weight
Three-Phase	350 A at 34 VDC	10–38 V	5–425 A	75 VDC	40.4 36.1 20.6 17.8 14.1 14.2 13.6	H: 17 in (432 mm) W: 12-1/2 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 to both the Canadian and U.S. Standards for welding equipment.

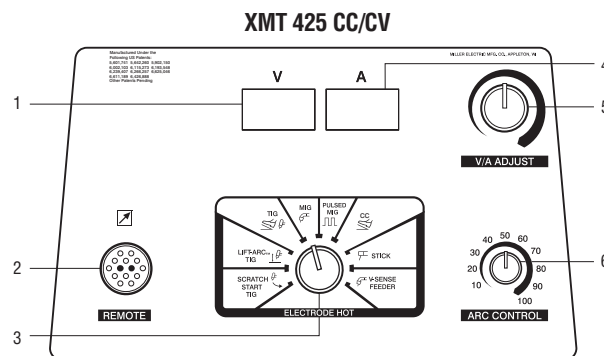
XMT® 425 Performance Data



Control Panels



1. Voltmeter
2. Process Selector Switch (Rotary Switch)
3. Ammeter
4. Voltage/Amperage Adjustment Control
5. Arc Control



1. Voltmeter
2. Remote Control Receptacle
3. Process Selector Switch (Rotary Switch)
4. Ammeter
5. Voltage/Amperage Adjustment Control
6. Arc Control

Genuine Miller Accessories



Optima™ #043 389

A multipurpose, microprocessor-based 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 ft (7.6 m) cord with 14-pin plug. (Not for use with XMT 425 VS model.)

Extension Cords for Optima

- #043 725 25 ft (7.6 m)
- #043 726 50 ft (15.2 m)
- #043 727 75 ft (22.9 m)

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 ft (3 m) 14-pin cord.



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 ft (3 m) wall-type plug and power cord.

Genuine Miller Accessories



HF-251D-1
High-Frequency Arc
Starter and Stabilizer
#042 388

Portable 250 amp, 60% 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 ft (6 m) cord and 14-pin plug.



RHC-14 Hand Control
#129 340

Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3-1/4 in (102 x 102 x 82 mm). Includes 20 ft (6 m) cord and 14-pin plug.



RMLS-14 #129 337

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



RCC-14 Remote Contactor and Current Control
#151 086

14-pin plug. Rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 28 ft (8.5 m) control cord.



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 ft (8.5 m) control cord.

Extension Cords for Remote Controls and 24 VAC Wire Feeders

#122 973 25 ft (7.6 m)

#122 974 50 ft (15.2 m)

#122 975 75 ft (22.8 m)

14-pin plug to 14-pin socket.

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

Protective Cover



Protective Cover
#195 478

Mildew and water resistant, odor-free cover protects your machine's finish. For 300/350 A inverters: XMT, Maxstar and Dynasty.

Running Gear



XMT Cylinder Cart
#042 537

Carries two 160 lb (72.6 kg) gas cylinders, or one gas cylinder and one coolant system for TIG (GTAW) welding. Feeder mounts to tray above power source.

Wire Feeders/Guns

SuitCase™ 8VS #194 890

SuitCase™ X-TREME™ 12VS #195 500

Lightweight, portable wire feeder for a variety of wires up to .062 in. Holds up to an 8 in (8VS) or 12 in (12VS) spool of wire. Operates on open-circuit voltage eliminating the need for a control/power cord. See Lit. Index No. M/6.4 and M/6.41.

SuitCase™ 8RC/12RC #194 938/#194 940

Lightweight, portable wire feeder for a variety of wires up to .062 in. Holds up to an 8 in (8RC) or 12 in (12RC) spool of wire. Operates using 14-pin control receptacle. 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 #195 057

S-74D #195 058

S-74DX #195 059

Wire feeder features Posifeed™ wire drive assembly and handles a variety of wires up to 1/8 in. Comes with FREE Bernard® Q™-Gun. See Lit. Index No. M/3.0.



Spoolmatic® 30A
#130 831

A 1-lb, air-cooled spool gun that extends the weld process range by adding a handy

portable system for small wire MIG. Rated 200 A at 100% duty cycle. Includes 30 ft (9.1 m) cable assembly. (WC-24 #137 549 for 14 pin.)

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)

Water 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 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ V3

#043 009 115 VAC

For use with water-cooled torches rated up to 500 amps. Vertical design conveniently mounts to Miller cylinder rack in place of one cylinder.

Coolmate™ 4

#042 288 115 VAC

For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Coolant

#043 810 Sold in cases of four 1-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37°F (-38°C) or boiling to 227°F (108°C). Also contains a compound that resists algae growth.

International-Style Connectors

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



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

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

International-Style Connector Kit

#042 418 50 mm

Accepts #4 or #1/0 AWG cable size. Required if male plugs shipped with power source must be replaced, or if additional plugs are needed.

#042 533 70 mm

Accepts #1/0 or #2/0 AWG cable size. Required if #1/0 or #2/0 AWG size cable is to be used.

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

Extension Kit for International-Style Cable Connectors

#042 419 50 mm

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

#042 534 70 mm

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

Used to adapt or extend weld and/or work cables. Kit includes one male International-style plug and one in-line female International-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™		
	#907 386-01-1	230 – 460 VAC with Auto-Line™ and Auxiliary Power and CE		
XMT® 425 VS	#907 387	208 – 575 VAC with Auto-Line™		
Accessories				
Optima™ MIG Pulse Control	#043 389	For CC/CV models only. Not for use with XMT 425 VS		
Optima™ Extension Cords		See page 4		
Gas Solenoid Kit	#195 286			
Process Selector Control	#042 872			
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		
HF-251D-1 HF Starter/Stabilizer	#042 388	See Lit. Index No. AY/5.1		
RFCS-14	#043 554	Foot control		
RHC-14	#129 340	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 4. Not to be used with Optima, 60M or XR-M		
Protective Cover	#195 478			
Running Gear				
XMT Cylinder Cart	#042 537			
Wire Feeders/Guns				
SuitCase™ 8VS/X-TREME™ 12VS	#194 890 / #195 500	See Lit. Index No. M/6.4 and M/6.41		
SuitCase™ 8RC/12RC	#194 938 / #194 940	See Lit. Index No. M/6.5		
XR™-Control	#181 538	See Lit. Index No. M/1.7		
70 Series	#195 057	S-74S. See Lit. Index No. M/3.0		
	#195 058	S-74D. See Lit. Index No. M/3.0		
	#195 059	S-74DX. See Lit. Index No. M/3.0		
Spoolmatic® 30A Spool Gun	#130 831	Includes 30 ft (9.1 m) cable assembly		
Ironmate™ Flux Cored Guns		See Lit. Index No. AY/16.0		
Water Coolant Systems		See page 6. See Lit. Index No. AY/7.2		
International-Style Connectors		See page 6		

Date:

Total Quoted Price:



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