

Maxstar® 200 Series

TIG/Stick Welding
Power Source 

Quick Specs



Industrial Applications

Precision Fabrication
Petro/Chemical
Aerospace
Food/Beverage Industry
Dairy
Shipboard

Processes

TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)
Air Carbon Arc (CAC-A)
5/32-inch maximum

Input Power 115–460 V, 3- or 1-Phase Power

Amperage Range 1–200 A

Rated Output 200 A at 28 V, 20% Duty Cycle

Weight 37 lb. (16.8 kg)



Allows for any input voltage hookup (115–460 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

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



Maxstar 200 SD



Maxstar 200 DX
Complete Package
with Wireless
Foot Control

DC TIG Features

Exceptionally smooth and precise arc for welding exotic materials.

Stick Features (DC)

Tailored arc control (DIG) allows the arc characteristic to be changed for specific applications and electrodes. Smooth running 7018 or stiffer, more penetrating 6010.

Hot Start™ adaptive control provides positive arc starts without sticking.

Lift-Arc™ starting provides x-ray clean welds without the use of high frequency.

Blue Lightning™ high-frequency arc starter for non-contact arc initiation. Provides more consistent arc starts and greater reliability compared to traditional HF arc starters. Easy to set and increases productivity.



Power source is warranted for 3 years, parts and labor.
Original main power rectifier parts are warranted for 5 years.
Coolant system is warranted for 1 year, parts and labor.



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MillerWelds.com
  



Specifications (Subject to change without notice.)



Welding Mode	Welding Amperage Range	Max. Open-Circuit Voltage	Input Power	Rated Output	Amps Input at Rated Load Output, 50/60 Hz,						Dimensions	Net Weight
					115 V	230 V	400 V	460 V	KVA	KW		
TIG (GTAW)	DC 1–150 A (115 VAC)	80 VDC 9–14 VDC**	3-Phase	175 A at 17 V, 60% Duty Cycle	—	10.5	6.0	5.2	4.2	4.0	H: 13.5 in. (343 mm) W: 7.5 in. (191 mm) D: 17.5 in. (445 mm)	37 lb. (16.8 kg) with Contractor Kit 69 lb. (31.3 kg)
			1-Phase	175 A at 17 V, 60% Duty Cycle	—	17.4	—	—	4.0	4.0		
	150 A at 16 V, 70% Duty Cycle			29.7	14.1	—	—	3.4	3.4			
	125 A at 15 V, 100% Duty Cycle			23.0	—	—	—	2.6	2.6			
Stick (SMAW)	DC 1–90 A (115 VAC)	80 VDC 9–14 VDC**	3-Phase	150 A at 26 V, 60% Duty Cycle	—	13.1	7.4	6.4	5.2	5.0	H: 46.25 in. (1175 mm) W: 23.5 in. (597 mm) D: 22.25 in. (565 mm)	with TIGRunner® 129 lb. (58.5 kg)
			1-Phase	150 A at 26 V, 60% Duty Cycle	—	21.7	—	—	5.0	5.0		
	125 A at 25 V, 50% Duty Cycle			34.1	—	—	—	4.0	3.8			
	90 A at 24 V, 100% Duty Cycle			25.0	—	—	—	4.0	3.8			

* Indicates idle draw. ** Sense voltage for Stick and Lift-Arc TIG.

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. All CE models conform to the applicable parts of the IEC 60974 series of standards.

Performance Data

DUTY CYCLE

110–120 V INPUT VOLTAGE

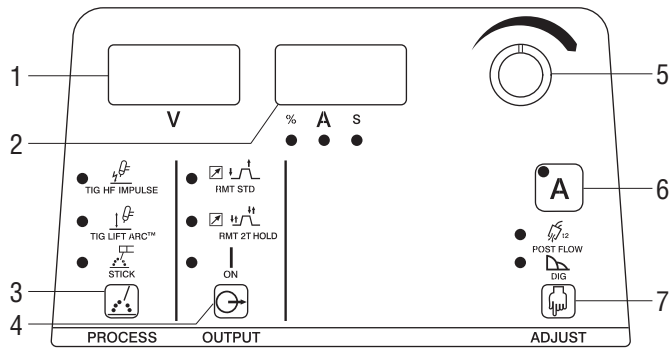
%	TIG	STICK
40%	150 A	125 A
70%	150 A	110 A
100%	125 A	90 A

200–460 V INPUT VOLTAGE

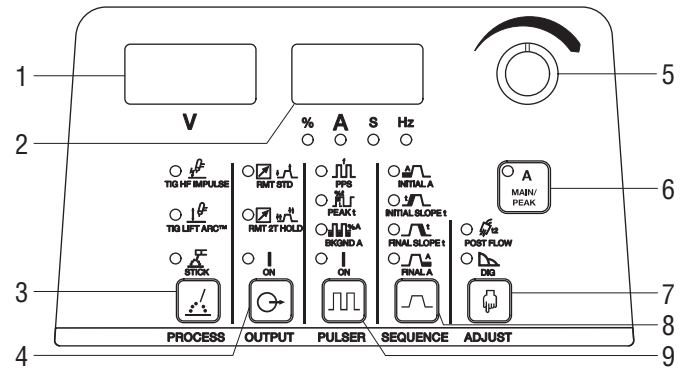
%	TIG	STICK
30%	200 A	200 A
40%	200 A	175 A
60%	175 A	150 A
100%	150 A	125 A

Control Panel

Maxstar 200 SD



Maxstar 200 DX/LX



Control Panel Parameter Values

- 1. Voltmeter Display**
- 2. Ammeter Display**
- 3. Process/
Arc Starting** TIG: HF Impulse, Lift Arc
STICK: Adaptive Hot Start
- 4. Output Control** Standard Remote,
2T Trigger Hold,
Output ON
- 5. Encoder Control**
- 6. Amperage Control**
- 7. Adjust Postflow** 0.0–50 seconds
DIG 0–100%

Advanced Features on the Maxstar LX and DX:

- 8. Sequencer Control**
 - Initial Amps 1–200 A
 - Initial Slope 0.0–25.0 seconds
 - Final Slope 0.0–25.0 seconds
 - Final Amps 1–200 A
- 9. Pulser Control**
 - Pulses per Second 0.1–500 PPS
 - Peak Time 5–95%
 - Background Amps 5–95%

Additional Setup Parameter Values

- Preprogrammed Starts**
 - .020–1/8 in. tungsten
- Programmable Starts**
 - Amperage 5–200 A
 - Time 1–200 milliseconds
 - Ramp Time 0–250 milliseconds
 - Minimum Amperage 1–20 A
- Additional Triggers** 3T, 4T, Mini Logic,
4T Momentary
- Spot/Timer** 0.1–25.0 seconds
- OCV** Low OCV, Normal OCV
- Stick Stuck Check** On/Off
- Lockouts** Four levels
- Arc Timer** 0.0–9999 hours
and 0–59 minutes
- Cycle Counter** 0–999,999 cycles

Available in Three Models:

SD— Provides the basic features that are required for most TIG or Stick welding applications.

DX— When the job demands greater control the DX provides pulse on/off, pulse frequency, peak % time, background amperage, initial amperage, initial slope time, final slope time and final amperage control.

LX— Automation made simple. With the **Automation Interface Connector**, the integrator can quickly interface to the output disable, weld start/stop, gas start/stop inputs; valid arc, pulse lock out, and end of weld sequence outputs.

LX Additional Features:

- Initial start time 0.0–25.0 seconds
- Weld cycle time 0.0–999 seconds
- Final current time 0.0–25.0 seconds

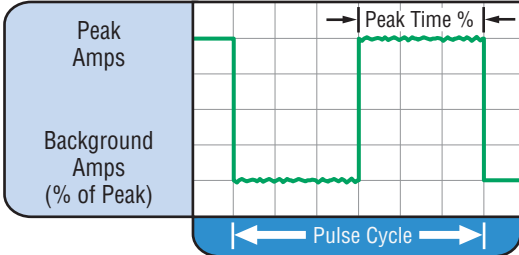
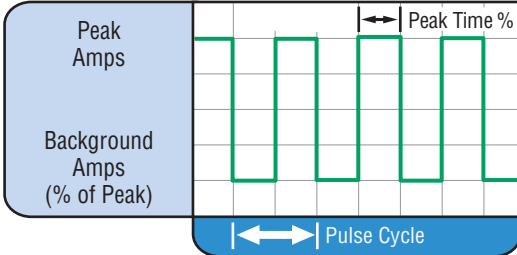
10-Pin Remote Connection Features:

- Weld cycle start/stop
- Gas start/stop
- Final slope output signal
- Pulse output signal
- Valid arc output signal

Pulse TIG Controls

High Speed DC TIG-Pulse Controls

- **PPS Pulses per second (Hz):** DC = 0.1 – 500 PPS
- **% ON – % Peak Time:** 5 - 95% (Controls the amount of time during each pulse cycle at the PEAK amperage.)
- **Background Amps:** 5 – 99% (Sets the low-pulse amperage value as a % of the Peak Amps.)

CONVENTIONAL PULSED TIG	HIGH SPEED PULSED TIG
 <p>The graph shows a single pulse cycle on a grid. The y-axis is labeled 'Peak Amps' and 'Background Amps (% of Peak)'. The pulse rises to a peak level and stays there for a duration labeled 'Peak Time %'. The background level is significantly lower than the peak. A double-headed arrow at the bottom indicates the 'Pulse Cycle'.</p> <p>Typically from 1 to 10 PPS. Provides a heating and cooling effect on the weld puddle and can reduce distortion by lowering the average amperage. This heating and cooling effect also produces a distinct ripple pattern in the weld bead. The relationship between pulse frequency and travel speed determines the distance between the ripples. Slow pulsing can also be coordinated with filler metal addition and can increase overall control of the weld puddle.</p>	 <p>The graph shows multiple pulse cycles on a grid. The y-axis is labeled 'Peak Amps' and 'Background Amps (% of Peak)'. The pulses are much narrower and more frequent than in the conventional graph. The background level is lower than the peak. A double-headed arrow at the bottom indicates the 'Pulse Cycle'.</p> <p>In excess of 40 PPS, Pulsed TIG becomes more audible than visible — causing increased puddle agitation for a better as-welded microstructure. Pulsing the weld current at high speeds — between a high Peak and a low Background amperage — can also constrict and focus the arc. This results in maximum arc stability, increased penetration and increased travel speeds (Common Range: 100 – 500 PPS).</p>

Packages



Maxstar® 200 Power Sources

- Maxstar 200 SD #903 701 (CSA)**
- Maxstar 200 DX #903 701-01-1 (CSA)**
- Maxstar 200 DX #907 354 (CE)**
- Maxstar 200 LX #903 701-01-2 (CSA)**

Includes:

- Adjustable shoulder strap
- 8-ft. (2.4 m) primary power cord

- Two Dinse 50 connectors
- DVD Setup Video (#251 116)
- One air-cooled TIG torch adapter (#195 378). *SD and DX models only*
- One 14-pin and 10-pin receptacle with mating plug. *LX model only*

Note: See page 6 for recommended Contractor Torch Kit.



Fingertip contractor kit shown.

Maxstar® 200 DX Contractor Kit Packages (Air Cooled)

- Maxstar 200 DX with Contractor Kit #951 172 (CSA) w/Foot Control**
- #951 173 (CSA) w/Fingertip Control**

Packages include:

- Maxstar 200 DX (#903 701-01-1)
- RFCS-14 HD foot control (#194 744) or RCCS-14 fingertip control (#043 688)
- Protective carrying case for accessories
- Weldcraft® 25-ft. (7.6 m) WP17 TIG torch with adapter

- Flow gauge regulator with gas hose
- AK2C accessory kit with short back cap, collets, collet bodies, aluminum nozzles, and 2% ceriated tungsten electrodes (.040, 1/16, and 3/32 in.)
- 200-amp Stick electrode holder with 15-ft. (4.6 m) #4 cable
- Work clamp with 15-ft. (4.6 m) #4 cable
- One air-cooled TIG torch adapter (#195 378)



TIGRunner® Package (Water Cooled)

- Maxstar 200 DX TIGRunner #903 701-02-2 (CSA)**

Completely assembled.

Package includes:

- Maxstar 200 DX (#903 701-01-1)
- Coolmate™ 1, 115 VAC (#300 360)
- One gallon of pre-mixed, low-conductivity coolant (#043 810)

- 2-Wheel Trolley Cart (#300 480) with the following features: easy-to-maneuver single-cylinder cart with cable and torch holders. Easy to release and remove welder from cart for even more portability. Convenient tray for consumable storage and filler rod holders.

Notes: TIG Torch Adapter must be ordered separately. See page 6 for recommended 250 A Water-Cooled Torch Kit (#300 185).

The Coolmate 1 requires a separate source for electricity. The Maxstar 200 does not contain auxiliary power.



Maxstar 200 DX Complete Package with Foot Control

Complete Packages (Water Cooled)

- Maxstar 200 DX Complete #951 396 (CSA) w/Wireless Foot Control**
- #951 137 (CSA) w/Foot Control**
- #951 138 (CSA) w/Fingertip Control**

Completely assembled.

Package includes:

- Maxstar 200 DX TIGRunner (#903 701-01-1)
- Coolmate™ 1, 115 VAC (#300 360)
- One gallon of pre-mixed, low-conductivity coolant (#043 810)
- Wireless Remote Foot Control (#300 429) or RFCS-14 HD foot control (#194 744) or RCCS-14 fingertip control (#043 688)

- 2-Wheel Trolley Cart (#300 480) with the following features: easy-to-maneuver single-cylinder cart with cable and torch holders. Easy to release and remove welder from cart for even more portability. Convenient tray for consumable storage and filler rod holders.
- 250 A Water-Cooled Torch Kit and Accessories (#300 185) See page 6 for more details.

Note: The Coolmate 1 requires a separate source for electricity. The Maxstar 200 does not contain auxiliary power.

Genuine Miller® Accessories



2-Wheel Trolley Cart #300 480

Easy-to-maneuver two-wheel cart features single-cylinder rack, chain for cylinder, straps (quick and easy to detach and carry machine), cable holders, torch holder, storage area, and filler

rod storage area. Works with Dynasty® or Maxstar® 200 and Coolmate™ 1.

Contact your local distributor for filler material holders.



Universal Carrying Cart and Cylinder Rack #042 934

Holds power source, and gas cylinder

up to 56 inches (142.2 cm) high measuring 6 to 9 inches (15.2 to 22.8 cm) in diameter.



Coolmate™ 1 #300 360

115 VAC, 60 Hz. One-gallon water cooler designed for 200 A portable welders. Features include fin-and-tube heat exchanger, back-lit power switch, external filter, polyethylene tank and coolant level sight gauge.



Low-Conductivity TIG Coolant #043 810

Sold in multiples of four in one-gallon recyclable plastic bottles.

Miller coolants

contains a base of ethylene glycol and deionized water to protect against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C).



250 A Water-Cooled Torch Kit #300 185

- 25-foot (7.6 m) Weldcraft® WP20 torch
- Torch cable cover
- AK4C torch accessory kit includes shielding cups, collets, collet bodies and 2% ceriated tungsten electrodes (1/16, 3/32 and 1/8 inch)
- Regulator/flowmeter HM2051A-580
- Gas hose (regulator to machine)
- Water-cooled Dinse torch adapter
- 15-foot (4.6 m) 1/0 weld lead with clamp (work or ground lead) and Dinse connector



Water-Cooled Dinse #195 377

Used to adapt WP20, WP18, and CS310 to dinse-style connector.



#195 054 kit shown.

Contractor Kits

#195 054 Foot Pedal Kit

#195 055 Fingertip Kit

Includes either RFCS-14HD foot or RCCS-14 fingertip control, 150-amp WP17 TIG torch with adapter and 25-foot (7.6 m) cable, 200-amp Stick electrode holder with 15-foot (4.6 m) #4 cable, work clamp with 15-foot (4.6 m) #4 cable, flow gauge regulator and gas hose, AK2C torch accessory kit (.040-, 1/16-, and 3/32-inch ceriated tungsten, collets and cups), and protective carrying case.



200 Amp Air-Cooled Torch

#WP2612RM (12 ft.)
#WP2625RM (25 ft.)

Torch body gas valve models are available.
Note: Adapter #195 379 required for WP26.



Air-Cooled Torch Adapters

#195 378 WP17, WP9, WP50, WP23
#195 379 WP26

Remote Controls and Switches



Wireless Remote Foot Control #300 429

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.



Wireless Remote Hand Control #300 430

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

RCCS-14 Remote Contactor and Current Control #043 688

North/south rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control #151 086

East/west rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 26.5-foot (8 m) cord and 14-pin plug.

RFCS-14 HD Foot Control #194 744

Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote 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 83 mm). Includes 20-foot (6 m) cord and 14-pin plug.



RMLS-14 Switch #129 337

Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.



RMS-14 On/Off Control #187 208

Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

Extension Cables for 14-Pin Remote Controls

#242 208 025 25 ft. (7.6 m)
#242 208 050 50 ft. (15.2 m)
#242 208 080 80 ft. (24.4 m)

Genuine Miller® Accessories (Continued)

Educational Materials

To order, please call Miller Literature at 866-931-9732 or visit MillerWelds.com/resources/tools.

Gas Tungsten Arc Welding (TIG) Publication #250 833

Ron Covell TIG Welding Basics DVD #196 567

DVD Setup Video #251 116

Video topics include tungsten selection, setup menus, DC pulse, sequencer, balance and frequency settings. (Included with machine.)

TIG Welding Gloves



Industrial TIG Welding Gloves #249 199

Large
#249 200 X-Large
Unlined pigskin leather palm with reinforced palm patch.



TIG Welding Gloves #249 178

Medium
#249 179 Large
#249 180 X-Large
Durable goatskin back and palm with flame-resistant cotton fleece back.



TIG Welding Gloves (Short Cuff)

#249 181 Medium
#249 182 Large
#249 183 X-Large
Durable pigskin back and goatskin palm with 3-inch cuff.

Tungsten

Tungsten	Amp Range	2% Ceriated (AC/DC)	2% Lanthanated (AC/DC)
.040 in. (1.2 mm)	10–80 A	WC040X7	WL2040X7
1/16 in. (1.6 mm)	70–150 A	WC116X7	WL2116X7
3/32 in. (2.4 mm)	140–250 A	WC332X7	WL2332X7
1/8 in. (3.2 mm)	225–400 A	WC018X7	WL2018X7
5/32 in. (4.0 mm)	300–500 A	WC532X7	WL2532X7

Multi-Operator Rack



4-Pack Rack (empty) #195 051

Appropriate fuses required.

- Rugged enclosure provides a simple means for protecting and transporting multiple welding power sources for construction, power plant turn-arounds, and shipbuilding applications.
- Light weight and small footprint for easy transportation. Low weight enables the use of elevators to move the rack.
- Top cover protects machines from falling debris.
- Lifting eye simplifies transportation using crane or overhead lifting device.
- Lift truck side and end fork pockets.
- One main disconnect box with fused circuit breaker switches for each machine.
- Common output ground connection (for same polarity use only).



4-Pack Rack Running Gear #195 114

Large 5-inch diameter wheels enable the rack to be moved over grating and driveway gravel.

Power Source	Rack Capacity	Input Power to Rack	Generator kW (Required)	Rack Fuse Size (3 per Power Source Required)*	Dimensions	Net Weight
Maxstar 200	4	230 V @ 74 A	20 kW	30 A (#199 795)	H: 59.375 in. (1508 mm)	Rack only 239 lb. (108 kg) With power sources 387 lb. (176 kg)
		460 V @ 36 A	20 kW	15 A (#220 514)	W: 43 in. (1092 mm) D: 34.375 in. (873 mm)	

*Rack comes with 25 A fuses. Order appropriate fuses for primary voltage.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Maxstar® 200 SD	#903 701	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Maxstar® 200 DX	#903 701-01-1	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Maxstar® 200 DX International	#907 354	Auto-Line™ 115–460 VAC, 50/60 Hz, CE . 8-ft. primary cord		
Maxstar® 200 LX	#903 701-01-2	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Air-Cooled Packages				
Maxstar® 200 DX Contractor Kit w/Foot Control	#951 172	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Maxstar® 200 DX Contractor Kit w/Fingertip Control	#951 173	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Water-Cooled Packages				
Maxstar® 200 DX TIGRunner®	#903 701-02-2	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord (Torch kit and accessories sold separately.)		
Maxstar® 200 DX Complete with Wireless Remote Foot Control	#951 396	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Maxstar® 200 DX Complete w/Foot Control	#951 137	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
Maxstar® 200 DX Complete w/Fingertip Control	#951 138	Auto-Line™ 115–460 VAC, 50/60 Hz, CSA . 8-ft. primary cord		
TIG Torch Kits				
Weldcraft® 250 A Water-Cooled Torch Kit	#300 185	See page 6		
Contractor Kit Foot Pedal (Air-Cooled)	#195 054	See page 6		
Contractor Kit Fingertip (Air-Cooled)	#195 055	See page 6		
Weldcraft® 200 A Air-Cooled Torch	#WP2625RM	Adapter #195 379 required		
Remote Controls				
Wireless Remote Foot Control	#300 429	Foot control with wireless 90-ft. (27.4 m) operating range		
Wireless Remote Hand Control	#300 430	Hand control with wireless 300-ft. (91.4 m) operating range		
RCCS-14	#043 688	North/south fingertip control		
RCC-14	#151 086	East/west fingertip control		
RFCS-14 HD	#194 744	Heavy-duty foot control		
RHC-14	#242 211 020	Hand control		
RMLS-14	#129 337	Momentary/maintained rocker switch		
RMS-14	#187 208	Momentary rubber dome switch		
Extension Cables	#242 208 025 #242 208 050 #242 208 080	25 ft. (7.6 m) 50 ft. (15.2 m) 80 ft. (24.4 m)		
Accessories				
4-Pack Rack (empty)	#195 051	<i>Order power source and fuses separately</i>		
4-Pack Rack Running Gear	#195 114	Four 5-in. diameter wheels and brackets		
Fuses	#199 795 #220 514	230 V, 30 A individual fuse. 12 required for 4-Pack 460 V, 15 A individual fuse. 12 required for 4-Pack		
2-Wheel Trolley Cart	#300 480	See page 6		
Universal Carrying Cart and Cylinder Rack	#042 934	See page 6		
Coolmate™ 1	#300 360	115 VAC, 60 Hz. <i>Requires coolant</i>		
TIG Coolant	#043 810	Sold in multiples of four in one-gallon plastic bottles		
Water-Cooled Dinse	#195 377	Used to connect water-cooled torch to Dinse terminal machine. For WP20, WP18 and SC310 (adapter included in Complete Package)		
Air-Cooled Dinse	#195 378 #195 379	Used to connect WP17, WP9 and WP23 torch to Dinse terminal machine Used to connect WP26 torch to Dinse terminal machine		
Dinse Connector 50 mm (1 male)	#042 418	Used to connect weld lead to Dinse terminal machine		
Dinse Connector 50 mm (1 male, 1 female)	#042 419	Used to extend weld cables		
Tweco® Terminal Adapter	#042 465	Male Dinse to female Tweco		
Cam-Lok Terminal Adapter	#042 466	Male Dinse to female Cam-Lok		
Gas Tungsten Arc Welding (TIG) Publication	#250 833			
Ron Covell TIG Welding Basics DVD	#196 567			
DVD Setup Video (included with machine)	#251 116			

To order, call Miller Literature at 866-931-9732
or visit MillerWelds.com/resources/tools

Date: _____ Total Quoted Price: _____

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