

Trailblazer® 325 Diesel

Diesel Engine-Driven Welder 

Quick Specs

Industrial Applications

Fabrication
Maintenance
Repair
Structural steel work
Sheet metal
Pipe

Processes

Stick (SMAW)
MIG (GMAW)*
Flux-cored (FCAW)*
RMD®**
Pulsed MIG (GMAW-P)**
DC TIG (GTAW)
Air carbon arc (CAC-A) cutting and gouging
Rated: 3/16-inch carbons
Capable: 1/4-inch carbons
Air plasma cutting and gouging
with optional Spectrum® models

Output Range DC stick 20–325 A
MIG/flux-cored 15–40 V
DC TIG 20–325 A

Auxiliary Power Output Rated at 104°F (40°C)
12,000 watts peak, 10,500 watts continuous

Excel™ Power (option)
2,400 watts (120 V, 20 A) 60 Hz pure sine power***

*With wire feeder.

**With ArcReach Smart Feeder.

***Engine speed rpm may vary while welding.

Trailblazer engine-driven welders deliver unbeatable arc performance providing the smoothest, most stable arc in the industry.

The Trailblazer exclusive technologies — Auto-Speed™ and optional Excel™ power — deliver superior runtimes, increase fuel efficiency, and improve engine-driven welder performance.

No other compact machine in the 300-amp class delivers more welding power or more auxiliary power with better fuel efficiency and less noise — for productive, profitable, quieter jobsites.



Optimized arc control for stick welding applications. See page 2.



WIRELESS
INTERFACE CONTROL



Full control of your machine in the palm of your hand. See page 2.

ArcReach®

Parameter control at the wire feeder or pendant without needing a control cord. See page 2.

Trailblazer 325 Diesel with ArcReach and optional wireless interface control and Excel power shown.



Engine-driven welder is warrantied for three years, parts and labor.
Engine is warrantied separately by the engine manufacturer.



Miller Electric Mfg. LLC
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

MillerWelds.com



Dynamic DIG™ technology



Ultra-adaptive arc control. Unlike conventional DIG that provides a preset amount of short-clearing current, Miller-exclusive Dynamic DIG technology works on a time-based algorithm that automatically

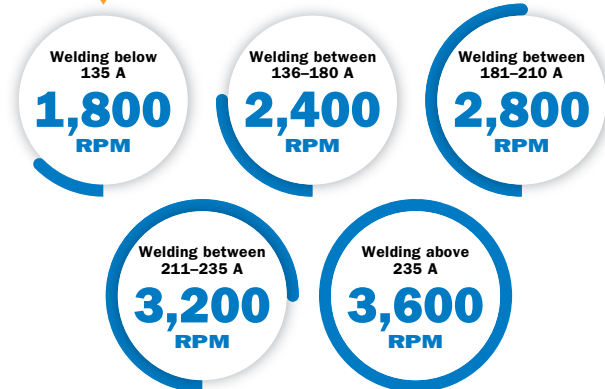
adjusts the amount of current required to clear a short. Delivers a smoother more consistent arc that can be tailored to match application, material, fit-up and welder technique.

Auto-Speed™ technology

Matches engine speed to load — a Miller exclusive. Get the welding power you need — plus reduced fuel consumption and lower noise levels for a more profitable jobsite.

Auto-Speed technology responds to weld requirements by automatically adjusting engine speed to one of five rpm levels so the engine never works harder than necessary. Weld up to 135 amps while the engine remains at idle (1,800 rpm), saving up to 15 percent in fuel over competitive units, and drastically reducing jobsite noise.

Welding at idle speed



Auto-Speed in XX18 and TIG modes.

ArcReach® technology

ArcReach® Parameter control at the wire feeder or pendant without needing a control cord.

An ArcReach system allows you to change weld settings from your ArcReach feeder or stick/TIG remote, saving a trip to the power supply.

ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or stick/TIG remote and the power source. This technology eliminates the need for control cords, and their associated problems and costs.

Wireless interface control (option)

WIRELESS Get full control of your machine in the palm of your hand so you can work hassle free.
INTERFACE CONTROL

With wireless interface control, you can change welding processes, adjust parameters, select and save preset programs, turn the machine on/off, get service reminders and more from wherever you are on the jobsite. Extend time between fill ups and maintenance intervals while eliminating the need to go back to your machine to make adjustments.

Wireless interface control is a factory-installed option available on the Trailblazer 325 Diesel.

VIEW STATUS

View engine status, fuel level, and battery charge level of remote.

SELECT PROCESSES

View and select between all available processes.

CONTACTOR ON/OFF

Turn contactor on/off manually in remote welding mode.

ENGINE ON/OFF

Turn engine on/off with remote.



CUSTOM PROGRAMS

Save custom presets in up to four programs and easily switch between pre-programmed settings.

FINE-TUNE ARC

Quickly adjust and save arc control settings including DIG, DIG range inductance and Auto-Stop.

AMP/VOLT ADJUST

Adjust amperage or voltage, by increments or percentage, while welding.

Excel™ power (option)

Power at idle — a Miller exclusive. Unlike competitive machines that provide auxiliary power only at 3,600 rpm (max), Excel power delivers a full 2,400 watts (20 A) of 120-volt inverter-based, pure sine-wave power at 2,400 rpm. With Excel power you can operate jobsite tools like grinders at quiet, fuel-saving speeds.

Refueling time and operating costs are reduced with Excel power, which means more productivity and profitability. Plus everyone on the jobsite gets a better working environment because noise levels and exhaust emissions are lowered. Excel power — available only from Miller.



UP TO **68%**
MORE FUEL EFFICIENT
WITH EXCEL POWER

Based on auxiliary-power-only use for total runtime.

Trailblazer® Benefits

Fewer refueling trips

No other diesel engine-driven welder in the 300-amp class lets your crews spend more time working and less time refueling — because only Trailblazer engine-driven welders provide Auto-Speed™ technology, plus the Excel™ power option, to deliver maximum runtime.

With optional wireless interface control, you can instantly turn your machine off when needed to save you even more fuel.

Maximum cost savings

Less money spent on fuel means more profit for you. Every Trailblazer engine-driven welder has fuel-saving Auto-Speed technology; add optional Excel power to save even more on fuel costs and enjoy a combination of advanced, profit-enhancing features that are only available on a Trailblazer engine-driven welder.

Maximize your savings with optional wireless interface control which allows you to turn your machine off remotely, saving you more money on fuel.

Quieter jobsites

Quieter jobsites are more productive because work crews can communicate easier, and work can start earlier and end later — even in noise-sensitive areas. Miller-exclusive Auto-Speed technology makes this engine-driven welder the quietest Trailblazer diesel yet — rated at 70 db at idle (1,800 rpm). If your jobsite needs an engine-driven welder, it needs a Trailblazer engine-driven welder — because no other diesel-fueled choice in this category is as quiet.

Optional wireless interface control makes it easy to shut off the machine remotely when it's not in use, so you can lower noise levels and hear what's going on around you.



IT WOULD TAKE
8 TRAILBLAZERS
TO EQUAL THE
SOUND OUTPUT OF
1 COMPETITOR
MACHINE.

More mobility, uses less truck and jobsite space

Trailblazer engine-driven welders use up to 24 percent less cubic space and weigh up to 10 percent less than other engine-driven welders in their class — which means moving them is faster and easier, for maximum productivity. And because they take up less space, Trailblazer engine-driven welders let work trucks carry more equipment and gear — so your work crews can be ready for anything.



UP TO
24%
LESS CUBIC SPACE

Unbeatable arc performance

Wide amperage output with better welding deposition rates means you can get jobs done faster, saving time and money. The Trailblazer also has precise arc control, which allows you to fine-tune the arc to match your

personal preferences and quickly dial in the perfect parameters to optimize weld quality and maximize productivity across a variety of applications and welding processes.

Specifications (Subject to change without notice.)



Welding Mode	Process	Amp/Volt Ranges	Rated Weld Output at 104°F (40°C)*	Single-Phase Auxiliary Power	Sound Levels at 7 m (23 ft.)	Dimensions	Net Weight**
CC/DC	Stick/TIG	20–325 A	325 A at 33 V, 100% duty cycle	Peak 12,000 watts Continuous 10,500 watts	Weld 135 A load: 70 dB (94 Lwa) 325 A load: 81.5 dB (106.5 Lwa) Auxiliary power Excel power (optional): 75 dB (100 Lwa) 12 kW standard power: 81.5 dB (106.5 Lwa)	H: 28 in. (711 mm) H: 34.375 in. (873 mm) <i>(to top of exhaust)</i> W: 20 in. (508 mm) D: 45.375 in. (1,153 mm)	620 lb. (281 kg)
CV/DC	MIG/FCAW	15–40 V	325 A at 33 V, 100% duty cycle	Excel™ power (optional) 2,400 watts, 20 A at 120 V, 60 Hz pure auxiliary power at 2,400 rpm and while welding			

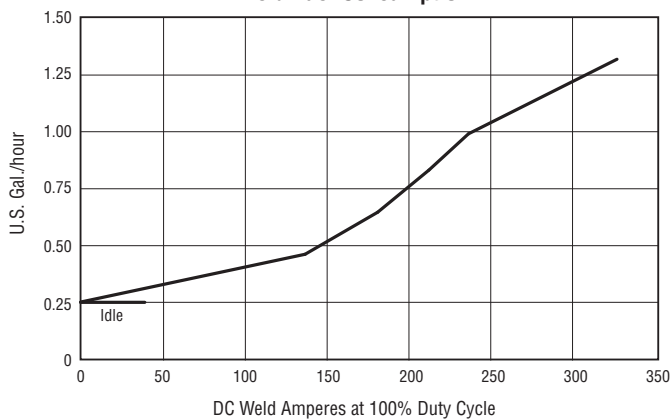
*Rated at sea level. **Net weight without fuel. Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Engine Specifications (Engines warranted separately by the engine manufacturer.)

Engine Brand and Warranty	Horsepower (HP)	Type	Weld Speed	Idle Speed	Fuel Capacity	Oil Capacity	Standard Shutdowns
Kubota D902, 2-year limited North American warranty	24.8 hp at 3,600 rpm	Three-cylinder, industrial liquid-cooled diesel	Auto-Speed™ 1,800, 2,400, 2,800, 3,200 or 3,600 rpm	1,800 rpm or 2,400 rpm	12 gal. (45 L)	3.9 qt. (3.7 L)	High coolant temperature/ Low oil pressure/low fuel

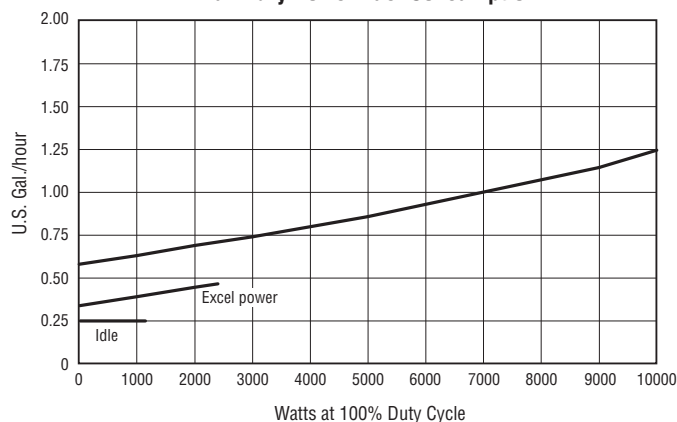
Performance Data

Weld Fuel Consumption*

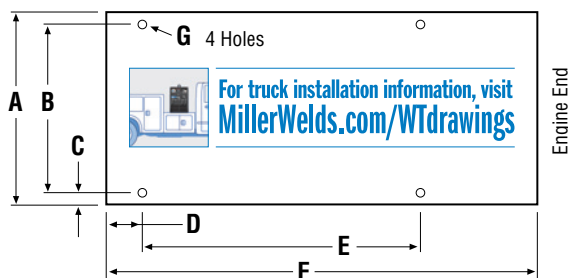


*Fuel curve was generated using NEMA recommended voltage/amperage levels.

Auxiliary Power Fuel Consumption

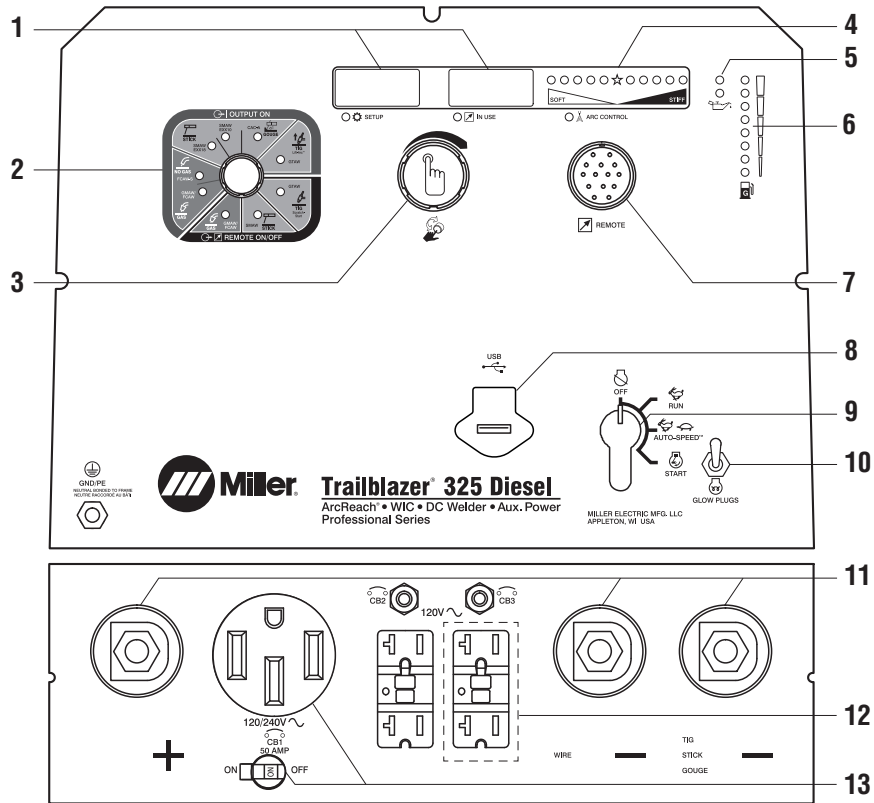


Mounting Specifications



- A. 20 in. (508 mm)
- B. 16.5 in. (419 mm)
- C. 1.75 in. (44 mm)
- D. 6.062 in. (154 mm)
- E. 32.75 in. (832 mm)
- F. 45.375 in. (1,153 mm)
- G. .406 in. (10.3 mm) diameter

Function and Benefit Guide



1. Self-calibrating digital meters with SunVision™

- Preset and actual amperage/voltage
- Process settings
- Maintenance functions: hour meter, oil change interval, rpm

2. Weld process selection switch

3. **Pushbutton main control knob** used for adjusting amperage/voltage, adjusting arc control, and accessing the service menu.

4. **Adjustable arc control** adjusts DIG when process control is in stick modes and adjusts inductance when process control is in FCAW or MIG modes. The amount of DIG determines how much amperage (heat) varies with stick arc length. Inductance determines the “wetness” of the weld puddle.

5. **Maintenance interval reminder.** Yellow and red indicator lights let an operator know when the machine is approaching, and finally in need of routine maintenance.

6. **Front-panel fuel-gauge LEDs** indicate fuel level. Low fuel shutdown automatically detects and shuts engine off prior to running out of fuel.

7. **Standard 14-pin receptacle** for simple connection of remote controls and wire feeders. Includes **Auto Remote Sense™** which automatically switches from panel to remote amperage/voltage (A/V) control with remote connected. Eliminates confusion of a panel/remote switch.

8. **USB port** allows software updates from a USB drive. A summary file of recorded data from the unit will be saved to a USB drive that is inserted.

9. **Engine control.** Run/idle position adjusts engine to run at lower speeds depending on total power needed for welding.

10. **Glow plugs** assist in cold weather starting.

11. Weld output terminals

12. **Optional Excel™ power (factory option, see page 8)** provides pure auxiliary power at 2,400 rpm and while welding.

Note: If Trailblazer is ordered without Excel power option, unit is shipped with two 20 A, 120 V duplex receptacles with circuit breakers and ground fault.

13. 50 A, 120/240 V receptacle with circuit breaker

Note: For matching plug, order 119172.

Genuine Miller® Options *Available as factory option. See ordering information on back page.

GFCI Receptacles* 300975 Field
Kit contains two GFCI 120 V duplex receptacles. (240 V GFCI receptacle not required.)

Cold Weather Kit 301115 Field
Includes block heater for improved starting, and a fuel heater for optimal filtration in cold temperatures.

Spark Arrestor 043579 Field
Mandatory when operating on California grasslands, brush or forest-covered land, and all national forests. For other areas, check your state and local laws.



Wireless Interface Control Replacement Kit 288137 Field
Replacement kit for wireless interface control machines. NOT compatible with machines that are not equipped with wireless interface control. Includes replacement remote, magnetic lanyard, USB charger, 110-volt adapter, and two screen protectors.

Wireless Interface Control Protective Covers 287594
Five-pack of screen protectors for wireless interface control remote.



Full KVA Adapter Cord 300517 Field
NEMA 14-50P to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.



Full KVA Plug Kit 119172 Field
120/240 V, 50 A plug (NEMA 14-50P) to fit full KVA receptacle.

Diesel Engine Filter Kit 259935 Field
Includes air filter, oil filter, fuel pre-filter and primary fuel filter.

Genuine Miller® Accessories



Never Flat™ Tires
Available on Bobcat and Trailblazer running gear.

- Reduce costly jobsite downtime

- Maintain constant tire pressure and will not develop flats
- Protect against punctures
- Preserve maneuverability, even when weighed down with heavy welding cable



Protective Cover 301099
Heavy-duty, water-resistant and mildew-resistant cover protects and maintains the finish of the welder.



ArcReach® Smart Feeder 951733
For use with ArcReach models only (see page 2 for more information). Includes drive rolls and Bernard® PipeWorx 300-15 MIG gun. For MIG, FCAW, and advanced RMD® and pulse processes. See literature M/6.55.



All-Purpose Running Gear 300477
Includes two heavy-duty 15-inch Never Flat™ tires, two 8-inch rubber swivel casters and a heavy-duty handle. Recommended for all surfaces and applications, and is easy to move around the jobsite.

MIG/Flux-cored Welding



ArcReach® SuitCase® 8
951726001 With Bernard® BTB Gun 300 A
951727 With Bernard® S-Gun™
951728 With Bernard® Dura-Flux™ gun

ArcReach® SuitCase® 12
951729001 With Bernard® BTB Gun 300 A
951730 With Bernard® S-Gun™
951731 With Bernard® Dura-Flux™ gun

ArcReach® SuitCase® 12 Heavy Duty 301604 Feeder only — for 3/32-inch cored wire
Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature M/6.55.



SuitCase® 12RC Wire Feeder 951580001
Lightweight and flexible enough to run wires up to .062-inch diameter. Includes remote voltage control, drive roll kit and Bernard® BTB Gun 300 A. See literature M/6.5.



Protective Cage with Cable Holders 195331
Rugged cage with cable holders protects your investment. Can be used with running gear, gas cylinder mounting assembly, or with trailer.
Note: Not for use with protective cover.



Spoolmatic® 30A Spool Gun 130831
Air-cooled, 200-amp, one-pound spool gun for aluminum MIG. See literature M/1.73. Requires WC-24 Control 137549.

XR™ Wire Feeders and Guns
Push-pull system designed to handle difficult-to-feed soft alloy wires such as aluminum. See literature M/1.7 through M/1.74.

Genuine Miller® Accessories (Continued)

Stick (SMAW) Welding



Weld Leads

2/0 Stick Cable Set, 50 ft. (15 m) 173851

Consists of 50-foot (15 m) 2/0 electrode cable with holder, and 50-foot (15 m) work cable with clamp. 350 A, 100% duty cycle.

2/0 Stick Cable Set, 100/50 ft. (30.5/15 m) 043952

Consists of 100-foot (30.5 m) 2/0 electrode cable with holder, and 50-foot (15 m) work cable with clamp. 300 A, 100% duty cycle.

TIG (GTAW) Welding



Dynasty® 210 Series
For portable AC/DC TIG.
See literature AD/4.81.

Plasma Cutting



Spectrum 375 X-TREME and 625 X-TREME shown.

Spectrum® 375 X-TREME™ 907529

See literature PC/9.2.

Spectrum® 625 X-TREME™ 907579

See literature PC/9.6.

Spectrum® 875 907583

See literature PC/9.8.

The Spectrum 375 X-TREME and 625 X-TREME come complete with protective X-CASE™ (not shown).

Remote Solutions



ArcReach® Stick/TIG Remote 301325

When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time

and money. See literature AY/14.5.



Wireless Remote Hand Control 301582

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



RHC-14 Hand Control 242211020

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.



PRHC-14 Hand Control 195511

Complete current or voltage control brings 120 volts GFCI power to work area in a single cord. Housed in a durable, light aluminum case and includes 125-foot (38 m) cord with plugs.

Extension Cables for 14-Pin Remote Controls

242208025 25 ft. (7.6 m)

242208050 50 ft. (15.2 m)

242208080 80 ft. (24.4 m)

Remote Output Panel Kit 951850

If your engine-driven welder is mounted on a truck, easily locate the outputs at the point of use with the auxiliary power and weld output remote panel. See literature AY/20.5.

Trailers and Hitches (Note: Trailers are shipped unassembled.)



HWY-Mid Frame Trailer 301438

1,424-pound (646 kg) capacity highway trailer with welded steel tubing frame, heavy-duty axle with roller bearing hubs and leaf-spring suspension. Includes jack stand, fenders, lights, and dual hitch with 2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye.



Cable Tree 043826

Provides an area to conveniently wrap weld cables and extension cords.



2-In-1 Document/ Fire Extinguisher Holder 301236

Stores documents and holds a five-pound fire extinguisher.

Note: Holder shown mounted on trailer. Fire extinguisher not included.

Trailer Specifications (Subject to change without notice.)

Model	Gross Axle Weight Rating	Gross Vehicle Weight Rating	Net Payload	Height of Bed	Road Clearance	Track (Center to center of tires)	Standard Tires (Standard rating or P-size rating)	Dimensions	Net Weight
HWY-Mid Frame	1,605 lb. (728 kg)	1,424 lb. (646 kg)	1,424 lb. (646 kg)	19.5 in. (495 mm)	8 in. (203 mm)	46 in. (1,168 mm)	ST175/80D-13 Load Range C	Length: 101 in. (2,565 mm) Width: 55 in. (1,397 mm)*	181 lb. (82 kg)

*Width at outside of fenders.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Trailblazer® 325 Diesel (Kubota engine)	907799	Base model		
	907799001	With GFCI receptacles		
	907799002	With Excel™ power and GFCI receptacles		
	907799003	With Excel™ power, GFCI receptacles and wireless interface control		
Field Options				
GFCI Receptacles	300975			
Cold Weather Kit	301115			
Spark Arrestor	043579			
Wireless Interface Control Replacement Kit	288137	See page 6 for items included		
Wireless Interface Control Protective Covers	287594	Five-pack of screen protectors for wireless interface control remote		
Full KVA Adapter Cord	300517			
Full KVA Plug	119172			
Diesel Engine Filter Kit	259935			
Accessories				
All-Purpose Running Gear	300477	With Never Flat™ tires		
Protective Cage with Cable Holders	195331	<i>Not for use with protective cover</i>		
Protective Cover	301099			
MIG/Flux-cored Welding				
ArcReach® SuitCase® 8	951726001	With Bernard® BTB Gun 300 A		
	951727	With Bernard® S-Gun™		
	951728	With Bernard® Dura-Flux™ gun		
ArcReach® SuitCase® 12	951729001	With Bernard® BTB Gun 300 A		
	951730	With Bernard® S-Gun™		
	951731	With Bernard® Dura-Flux™ gun		
ArcReach® SuitCase® 12 Heavy Duty	301604	Feeder only — for 3/32-inch cored wire		
ArcReach® Smart Feeder	951733	For use with ArcReach models only. MIG/FCAW/RMD®/pulse feeder with Bernard® PipeWorx 300-15 MIG gun. Tweco®-style connectors		
SuitCase® 12RC	951580001	With Bernard® BTB Gun 300 A. See literature M/6.5		
Spoolmatic® 30A Spool Gun	130831	Requires WC-24 control. See literature M/1.73		
WC-24 Control	137549	See literature M/1.73		
XR™ Wire Feeder Control and Guns		See literature M/1.7 through M/1.74		
Stick Welding		See page 7		
TIG Welding		See page 7		
Plasma Cutting		See page 7		
Remote Solutions and Extension Cables				
ArcReach® Stick/TIG Remote	301325	For use with ArcReach models only		
Wireless Remote Hand Control	301582			
RHC-14 Hand Control	242211020			
PRHC-14 Hand Control	195511			
Extension Cables		See page 7		
Remote Output Panel Kit	951850	For truck-mounted engine-driven welders. Includes auxiliary power and weld output remote panel		
Trailers and Hitches				
HWY-Mid Frame Trailer	301438	Trailer with lights, fenders and dual hitch. For highway use		
Cable Tree	043826	Trailer-mounted cable holder		
2-In-1 Document/Fire Extinguisher Holder	301236	Stores documents and holds a five-pound fire extinguisher		

Date:

Total Quoted Price:

Distributed by:

