

Millermatic® 255/255 Auto-Line™

MIG Power Source,
Wire Feeder and
Gun Package



QUICK SPECS

Industrial Applications

General fabricators
Contract welding services
Plant maintenance shops

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
Flux-cored (FCAW)

Input Power

208–240 V, single-phase
Auto-Line™ 208–575 V, single-phase

Rated Output

230 A at 25.5 V, 60% duty cycle

Amperage Range 20–350 A

Net Weight

Machine only: 84 lb. (38 kg)
Machine with running gear: 148 lb. (67 kg)

Easy to Use. Versatility. Portability.

**THINK
SIMPLY. WELD
SMARTER.**

Built for professionals in the light manufacturing or fabrication segment who want a smaller, versatile welder with intuitive setup to increase efficiencies and productivity. This 250-amp inverter welder is **easy to use** for faster uptime and performance. The **versatility** of this welder to be integrated on running gear, makes it very easy to move around a work cell or it can be quickly disconnected from the running gear enabling **portability**, making it easier to integrate into a work cell or work in confined spaces.

Machine only



Machine with
running gear

Heavy-duty aluminum
two-drive-roll system

Easy to use



Quick and easy setup

Versatility



MIG, pulsed MIG, push-pull
and spool gun capabilities

Portability



Easily integrates
into a work cell

TRUE BLUE®
3YR. WARRANTY

Welder is warrantied for three years, parts and labor.
Gun warrantied for 90 days, parts only.



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

Equipment Sales US and Canada
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MillerWelds.com

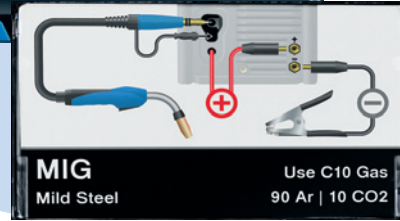


Millermatic® 255/255 Auto-Line™ Features and Benefits

Easy to use



Pulsed MIG setup screen



Connection screen for MIG process using C10 gas

Easy-to-understand interface with 7-inch color LCD display ensures proper machine setup and parameter selection, reducing setup time and increasing weld time.

- Quick-access backlit Auto-Set and Pulse buttons above the LCD display illuminate when active.
- Soft-key buttons below the display change function depending on which screen is displayed. Makes setup or change quick, easy and intuitive.
- Large text for easier readability.
- Intuitive connection setup images.
- Full troubleshooting descriptions versus help errors and look up codes.

Auto-Set™ offers predefined weld settings to increase ease of use and ensure that the job is done right for operators of all skill levels.

- Available for MIG and pulsed MIG processes with the ability to fine-tune your settings.
- Set weld parameters by selecting wire and gas type, wire diameter and material thickness.



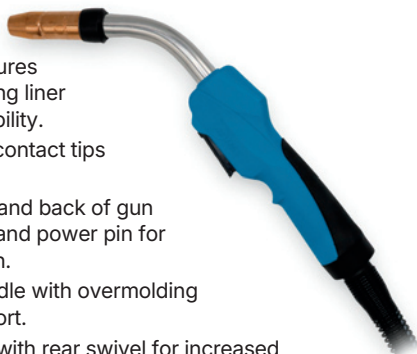
Program mode allows easy save and recall of favorite weld settings.

- Delivers greater productivity by eliminating the need to manually set or change parameters.
- Delivers consistent quality by welders of all skill levels by using prequalified weld settings.



MDX™-250 MIG gun with MDX™ heavy duty consumable system features a dual-locked, front-loading liner that optimizes wire feedability.

- Install MDX heavy duty contact tips with a single turn.
- MDX liner locks at front and back of gun to align with contact tip and power pin for a flawless wire feed path.
- Durable, ergonomic handle with overmolding improves grip and comfort.
- Ball-and-socket handle with rear swivel for increased gun maneuverability while reducing welder fatigue.



Millermatic® 255/255 Auto-Line™ Features and Benefits

Versatility



Capabilities include MIG, pulsed MIG and flux-cored welding.

Compatible with push-pull MIG guns. Increases productivity by allowing the use of 12-inch wire spools versus a spool gun's 4-inch spools. Reduces downtime changing wire spools.

Auto-Gun Detect™ automatically adjusts voltage, wire speed and timers for faster switching between MIG, push-pull and spool guns.



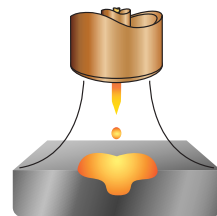
For portability and reliability Auto-Line™ allows for any single-phase input voltage hookup (208–575 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power (*Millermatic 255 Auto-Line model only*).



Generator compatible. The Millermatic 255 will be able to operate and provide full output when powered by generators with 12,000-watt (12 kW) output or higher. Limited output will occur when used with smaller generators.

Pulsed MIG welding delivers higher quality welds for ALL welders.

- Lower heat input for less distortion on thin materials and better puddle control on out-of-position welds.
- Less spatter minimizes post weld grinding and rework allowing more welding time.
- Perform welding applications that couldn't be done in the past.
- Ideal for MIG welding aluminum and stainless steel.



BEST FOR	STANDARD SPRAY	PULSED MIG	SHORT CIRCUIT
Gap filling	D	B	A
Low heat input	D	B	A
Out-of-position welds		A	B
Low spatter	A	A	C
Thick metals	A	A	D
Thin metals		B	A
Increased travel speed	A	A	B
Aluminum MIG welding	C	A	C

HOT **COLD**

Ratings A, B, C, and D are relative values. An "A" rating indicates a best fit between your performance needs and process. A "blank" rating indicates that the process is not recommended for that application.

Portability



Weight is reduced by more than 50 percent compared to the Millermatic 252.

Optional EZ-Latch™ Running Gear

EZ-Latch running gears are available in single cylinder and dual cylinder models (included with package or can be ordered separately). Operators no longer need to lift machine AND running gear into the truck. Latches secure machine to running gear. Simply loosen the latch retaining knob and rotate latches to disengage machine from running gear for easy portability. Cylinder racks feature bottle forward technology for increased stability when moving along an incline and running gears have built-in storage for accessories. Dual cylinder model includes an elevated gun and cable rack to keep cables off the floor and tangle free.



Storage solution

Single cylinder running gear



Latches shown in open position without machine and in closed position securing the machine

Bottle forward technology



Dual cylinder running gear

Dual cylinder model includes elevated gun and cable rack



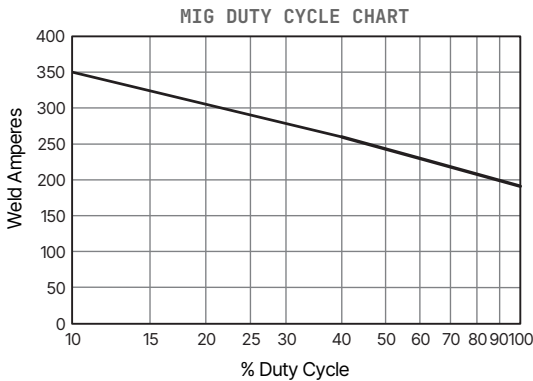
Specifications (Subject to change without notice.)



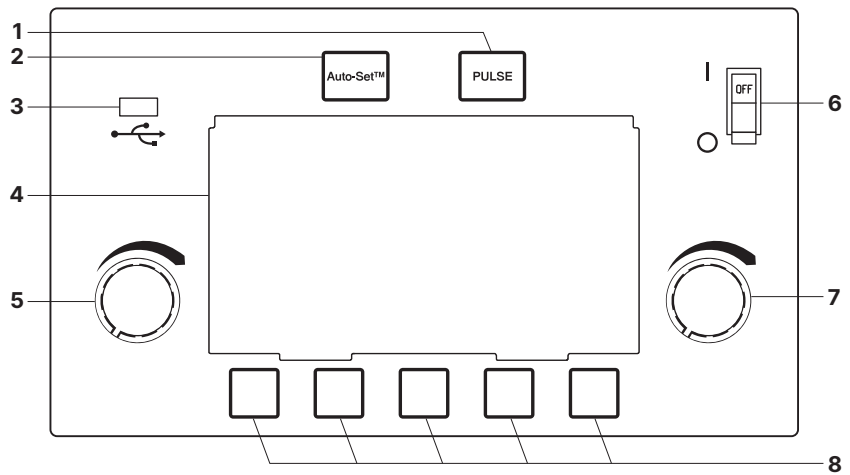
MODEL	AMPERAGE RANGE	RATED OUTPUT	AMPS INPUT AT RATED OUTPUT, 50/60 HZ						WIRE FEED SPEED	WIRE TYPE AND DIAMETER	MAX. OPEN-CIRCUIT VOLTAGE	DIMENSIONS	NET WEIGHT
			208 V	240 V	460 V	575 V	KVA	KW					
Millermatic 255	20–350 A	230 A at 25.5 V, 60% duty cycle	44.0	39.5	—	—	9.5	7.2	50–800 ipm (1.3–20.3 m/min.)	Solid/stainless: .023–.045 in. (0.6–1.2 mm) Flux-cored: .030–.045 in. (0.8–1.2 mm) Aluminum: .035–.047 in. (0.9–1.2 mm)	87 VDC	Machine only: H: 19.24 in. (489 mm) W: 13.75 in. (349 mm) D: 24.25 in. (616 mm) Machine with running gear: H: 32 in. (813 mm) W: 13.75 in. (349 mm) D: 45 in. (1,143 mm)	Machine only: 84 lb. (38 kg) Machine with running gear: 148 lb. (67 kg)
Millermatic 255 Auto-Line™	20–350 A	230 A at 25.5 V, 60% duty cycle	34.7	29.7	17.1	14.3	8.2	8.3			81 VDC		

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

Performance Data



Control Panel



1. Pulse Button
2. Auto-Set Button
3. USB Software Port
4. Color LCD Display
5. Left Adjustment Knob
(adjusts voltage, arc length or parameter values depending on mode)
6. Power On/Off Switch
7. Right Adjustment Knob
(adjusts wire feed speed or parameter values depending on mode)
8. Soft Keys (multiple functions depending on screen displayed)

Millermatic® 255/255 Auto-Line™ Packages

Machine only

907734 Millermatic 255 (208–240 V)

907964 Millermatic 255 Auto-Line (208–575 V)

Comes complete with

- Power source with 10 ft. (3 m) industrial power cord
- 15 ft. (4.5 m) 250-amp MDX™-250 MIG gun with MDX™ heavy duty consumables for .035/.045 in. (0.9/1.2 mm) wire
- 10 ft. (3 m) work cable with clamp and 50 mm Dinse-style connector
- Flow gauge regulator and gas hose for argon or AR/CO2 mix
- .035/.045 in. (0.9/1.2 mm) reversible drive rolls
- Extra contact tips
- Material thickness gauge



907734
machine
only shown

Machine with running gear package

951766 Millermatic 255 (208–240 V)

951000271 Millermatic 255 Auto-Line (208–575 V)

Comes complete with

- Power source with 10 ft. (3 m) industrial power cord
- 15 ft. (4.5 m) 250-amp MDX™-250 MIG gun with MDX™ heavy duty consumables for .035/.045 in. (0.9/1.2 mm) wire
- 10 ft. (3 m) work cable with clamp and 50 mm Dinse-style connector
- Flow gauge regulator and gas hose for argon or AR/CO2 mix
- .035/.045 in. (0.9/1.2 mm) reversible drive rolls
- Extra contact tips
- Material thickness gauge
- EZ-Latch™ single cylinder running gear
- Chain to secure gas cylinder



951766
machine with
running gear
package
shown

Genuine Miller® Accessories



EZ-Latch™ Single Cylinder Running Gear 301449

Running gear with a single cylinder rack and storage compartment. Latches secure machine to cart. Simply rotate latches to disengage machine from cart for easy portability.

EZ-Latch™ Dual Cylinder Running Gear 951769

Similar to above, but with a dual cylinder rack which allows operator to easily store two gas cylinders. Includes elevated gun and cable rack (shown below) to keep cables off the floor and tangle free.



EZ-Latch™ Dual Cylinder Rack with Elevated Gun and Cable Rack 301481

Converts an EZ-Latch single cylinder running gear into a dual cylinder rack to easily store two gas cylinders. Gun and cable rack keeps cables off the floor and tangle free. (Included with EZ-Latch dual cylinder running gear.)



Protective Cover 301521

Features side pocket.

Argon/Mixed Gas Regulator and Gas Hose 195050

MIG Guns

MDX™-250 MIG Gun with MDX™ Heavy Duty Consumables 1770043

15 ft. (4.6 m)
Standard industrial 250-amp MIG gun that comes with the Millermatic® 255 models, with heavy duty consumables for .035/.045 in. (0.9/1.2 mm) wire.

MDX™-250 MIG Gun with MDX™ Standard Duty Consumables 1770035

10 ft. (3 m)
1770037 15 ft. (4.6 m)
1770038 15 ft. (4.6 m)
Industrial 250-amp MIG gun with standard duty consumables for .030/.035 in. (0.8/0.9 mm) wire, except 1770038 which comes with .035/.045 in. (0.9/1.2 mm) standard duty consumables.

Spool Guns



Spoolmatic® 15A Spool Gun 195156

Spoolmatic® 30A Spool Gun 130831

Ideal for aluminum welding jobs. Air-cooled, one-pound spool gun with 15-foot (4.6 m) or 30-foot (9.1 m) cable assembly. Rated at 200 amps at 100 percent duty cycle. For detailed information, see Spoolmatic literature M/1.73.



Spoolmate™ 200 Spool Gun 300497

Reliable and economical spool gun perfect for hobbyists and light fabricators who weld aluminum. Handles .030–.035 inch (0.8–0.9 mm) aluminum wires and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 160 amps, 60 percent duty cycle with 20-foot cable assembly. For detailed information, see Spoolmate literature M/1.47.

Optional Spoolmate™ 200 Head Tubes

300591 45-degree head tube

300592 9-inch extension head tube

243385 5-inch head tube

Push-Pull Guns



XR-Aluma-Pro™ Push-Pull Guns

301568 15 ft. (4.6 m)

301569 25 ft. (7.6 m)

Air-cooled gooseneck-style gun for .030–.047 inch (0.8–1.2 mm) aluminum. Rated at 300 amps at 100 percent duty cycle.



XR-Aluma-Pro™ Lite Push-Pull Gun

300948 25 ft. (7.6 m)

Air-cooled gooseneck-style gun for .030–.047 inch (0.8–1.2 mm) aluminum. Rated at 175 amps at 60 percent duty cycle.



XR™-Pistol-Pro Push-Pull Guns

300782 15 ft. (4.6 m)

300783 25 ft. (7.6 m)

Air-cooled pistol-grip gun for .030–.047 inch (0.8–1.2 mm) aluminum. Rated at 200 amps at 100 percent duty cycle.

U-Grooved Aluminum Drive Roll and Accessory Kits for XR-Aluma-Pro Push-Pull Guns

195311 .035 in. (0.9 mm)

195313 .047 in. (1.2 mm)

Kits include Millermatic U-grooved drive rolls, nylon wire guides and contact tips.

Consumables

For MDX™-250 MIG Gun

Note: Millermatic 255/255 Auto-Line™ power sources come with MDX-250 MIG gun with MDX heavy duty consumables.

Miller® MDX MIG Gun

Heavy Duty Consumables

Consumables for increased durability and longer life when guns are used in industrial applications.

Contact Tips (10 per package)

T-A023CH	.023 in. (0.6 mm)
T-A030CH	.030 in. (0.8 mm)
T-A035CH	.035 in. (0.9 mm)
T-A039CH	.039 in. (1.0 mm)
T-A045CH	.045 in. (1.2 mm)

Nozzles

N-A5800C	Copper, 5/8 in. ID, flush, standard
N-A5818C	Copper, 5/8 in. ID, 1/8 in. recess
N-A5814C	Copper, 5/8 in. ID, 1/4 in. recess

Diffuser D-MA250

Monocoil Replacement Liners

10 ft. Liner

LM1A-10	.023/.025 in. (0.6 mm)
LMD2A-10	.030/.035 in. (0.8/0.9 mm)
LMD3A-10	.035/.045 in. (0.9/1.2 mm)

12 ft. Liner

LM1A-12	.023/.025 in. (0.6 mm)
LMD2A-12	.030/.035 in. (0.8/0.9 mm)
LMD3A-12	.035/.045 in. (0.9/1.2 mm)

15 ft. Liner

LM1A-15	.023/.025 in. (0.6 mm)
LMD2A-15	.030/.035 in. (0.8/0.9 mm)
LMD3A-15	.035/.045 in. (0.9/1.2 mm)

Optional Miller® MDX MIG Gun

Standard Duty Consumables

Smaller consumables and components to access hard-to-reach weldments.

Contact Tips (10 per package)

T-M023	.023 in. (0.6 mm)
T-M030	.030 in. (0.8 mm)
T-M035	.035 in. (0.9 mm)
T-M045	.045 in. (1.2 mm)
T-M047	3/64 in. (1.2 mm)

Nozzles

NS-M1200C	Copper, 1/2 in. ID, flush, standard
N-M1218C	Copper, 1/2 in. ID, 1/8 in. recess
N-M5800C	Copper, 5/8 in. ID, flush
N-M5818C	Copper, 5/8 in. ID, 1/8 in. recess
N-M58XTC	Copper, 5/8 in. ID, 1/8 in. stickout

Diffuser D-M250

Note: Miller® FasTip™, M-Series and Bernard® Centerfire™ diffusers and consumables are NOT compatible with MDX Series guns.

For Spoolmatic® Spool Guns and XR™ Push-Pull Guns

For Aluminum Wire

FasTip™ Contact Tips (25 per package)

206186	Heavy-duty, .030 in. (0.8 mm)
206187	Heavy-duty, .035 in. (0.9 mm)
206188	Heavy-duty, .040 in. (1.0 mm)
206189	Heavy-duty, 3/64 in. (1.2 mm)
206191	Heavy-duty, 1/16 in. (1.6 mm)
209026	Tapered, .030 in. (0.8 mm)
209027	Tapered, .035 in. (0.9 mm)
209029	Tapered, 3/64 in. (1.2 mm)
209030	Tapered, 1/16 in. (1.6 mm)

Screw-On Nozzles

199610	Brass, 1/2 in. orifice, tapered
199611	Brass, 3/4 in. orifice, straight
199612	Brass, 3/4 in. orifice, straight HD
199613	Brass, 5/8 in. orifice, tapered
199614	Brass, 5/8 in. orifice, tapered HD
209035	Copper, 3/8 in. orifice, tapered
199615	Copper, 1/2 in. orifice, tapered
209036	Copper, 1/2 in. orifice, tapered HD
198855	Copper, 5/8 in. orifice, tapered
199618	Copper, 5/8 in. orifice, tapered HD
207313	Copper, 5/8 in. orifice, tapered 15/16 OD
199616	Copper, 3/4 in. orifice, straight
199617	Copper, 3/4 in. orifice, straight HD

Bernard® Centerfire™ "T" Series Contact Tips

T-035AL	.035 in. (0.9 mm)
T-047AL	.047 in. (1.2 mm)
T-062AL	1/16 in. (1.6 mm)

Bernard® Centerfire™ Small Nozzles

NST-3818B	Brass, 3/8 in. ID, 1/8 in. tip recess
NS-1218B	Brass, 1/2 in. ID, 1/8 in. tip recess
NS-1200B	Brass, 1/2 in. ID, flush tip
NS-5818B	Brass, 5/8 in. ID, 1/8 in. tip recess
NS-1218C	Copper, 1/2 in. ID, 1/8 in. tip recess

For Spoolmate™ 200 Spool Gun

Note: Spoolmate 200 spool gun ships with (2) .030 in. and (2) .035 in. contact tips and (1) nozzle.

For Standard Heavy-Duty Head Tube

Contact Tips (5 per package)

199387	.030 in. (0.8 mm)
199388	.035 in. (0.9 mm)

Nozzle 050622

For Optional Head Tubes

Note: The same consumables are used on 45-degree, 5-inch, and 9-inch extension head tubes.

Contact Tips (5 per package)

199730	.024 in. (0.6 mm) (requires V-knurled drive roll 136135)
186419	.030 in. (0.8 mm)
186406	.035 in. (0.9 mm)

Nozzle 186405

For Millermatic® 255/255 Auto-Line™

Note: Machine drive roll kits include two drive rolls and an inlet guide.

V-Grooved Drive Roll Kits (solid wire)

204579	.030 and .035 in. (0.8 and 0.9 mm) combination (reversible)
087131	.024 in. (0.6 mm)
079594	.030 in. (0.8 mm)
079595	.035 in. (0.9 mm)
079596	.045 in. (1.2 mm)

V-Knurled Drive Roll Kits (flux-cored or difficult-to-feed wire)

079606	.035 in. (0.9 mm)
079607	.045 in. (1.2 mm)
079608	.052 in. (1.3 mm)

U-Grooved Drive Roll Kits (aluminum wire)

044749	.035 in. (0.9 mm)
079599	.047 in. (1.2 mm)

Ordering Information

EQUIPMENT AND OPTIONS	STOCK NO.	DESCRIPTION	QTY.	PRICE
Millermatic® 255	907734	208–240 V, 50/60 Hz		
Millermatic® 255 with Running Gear	951766	208–240 V, 50/60 Hz. Includes single cylinder running gear (301449)		
Millermatic® 255 Auto-Line™	907964	Auto-Line™ 208–575 V, 50/60 Hz		
Millermatic® 255 Auto-Line™ with Running Gear	951000271	Auto-Line™ 208–575 V, 50/60 Hz. Includes single cylinder running gear (301449)		
Accessories				
EZ-Latch™ Single Cylinder Running Gear	301449	Running gear with single cylinder rack		
EZ-Latch™ Dual Cylinder Running Gear	951769	Running gear with dual cylinder rack and elevated gun and cable rack		
EZ-Latch™ Dual Cylinder Rack with Elevated Gun and Cable Rack	301481	Upgrade single cylinder rack to dual (included with EZ-Latch dual cylinder running gear)		
Protective Cover	301521	Features side pocket		
Argon/Mixed Gas Regulator and Gas Hose	195050			
Guns				
MDX™-250 MIG Gun with MDX™ Heavy Duty Consumables	1770043	15 ft. (4.6 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire		
MDX™-250 MIG Gun with MDX™ Standard Duty Consumables	1770035	10 ft. (3 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire		
	1770037	15 ft. (4.6 m), 250 A, .030/.035 in. (0.8/0.9 mm) wire		
	1770038	15 ft. (4.6 m), 250 A, .035/.045 in. (0.9/1.2 mm) wire		
Spoolmatic® 15A Spool Gun	195156	15 ft. (4.6 m), 200 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
Spoolmatic® 30A Spool Gun	130831	30 ft. (9 m), 200 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
Spoolmate™ 200 Spool Gun	300497	20 ft. (6 m), 160 A, .030–.035 in. (0.8–0.9 mm) for aluminum wire, .023–.035 in. (0.6–0.9 mm) for steel/stainless steel wire		
Optional Spoolmate™ 200 Head Tubes		See page 6		
XR-Aluma-Pro™ Guns (air-cooled)	301568	15 ft. (4.6 m), 300 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
	301569	25 ft. (7.6 m), 300 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
XR-Aluma-Pro™ Lite Gun (air-cooled)	300948	25 ft. (7.6 m), 175 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
XR™-Pistol-Pro Guns (air-cooled)	300782	15 ft. (4.6 m), 200 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
	300783	25 ft. (7.6 m), 200 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
Consumables				
Contact Tips		See page 7		
Nozzles		See page 7		
Diffuser		See page 7		
Monocoil Replacement Liners		See page 7		
Drive Rolls		See page 6 for gun drive rolls and page 7 for machine drive rolls		

DATE : TOTAL QUOTED PRICE:

Distributed by:

