

Multimatic® 255

MIG/Multiprocess Power Source,
Wire Feeder and Gun Package



QUICK SPECS

Industrial Applications

Contract welding services
Plant maintenance shops
General fabricators

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
Flux-cored (FCAW)
DC stick (SMAW)
DC Lift-Arc™ TIG (GTAW)
Pulsed TIG (GTAW-P)

Input Power Auto-Line™ 208–575 V, single-phase

Rated Output **MIG:** 230 A at 25.5 V, 60% duty cycle

Stick: 200 A at 28 V, 60% duty cycle

TIG: 275 A at 21 V, 60% duty cycle

Amperage Range 5–350 A

Net Weight **Machine only:** 84 lb. (38 kg)

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

Easy to Use. Versatility. Portability.

Built for professionals in the MRO and manufacturing/fabrication segments who want a smaller, versatile welder with intuitive setup to increase efficiencies and productivity. This 250-amp inverter multiprocess welder is easy to use, will deliver versatility for faster uptime and performance, while allowing for portability.



Machine only

Machine with
running gear

Heavy-duty aluminum
two-drive-roll system



Quick and easy setup



Multiple processes
with only one machine



Easier to get to the work

TRUE BLUE®
3YR. WARRANTY

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



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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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International Phone: 920-735-4554

MillerWelds.com

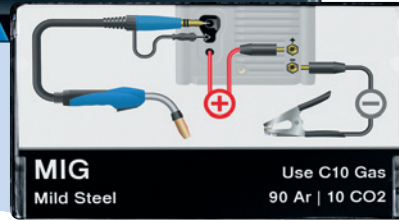


Multimatic® 255 Features and Benefits

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 process and weld mode backlit buttons across the top 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, pulsed MIG, stick and DC TIG processes with the ability to fine-tune your settings.
- Set weld parameters by selecting:
MIG (shown) — wire and gas type, wire diameter and material thickness
Stick — electrode type, electrode diameter and material thickness
DC Lift-Arc™ TIG — remote on/off, tungsten diameter and material thickness



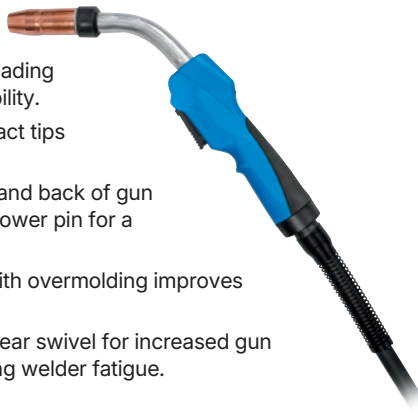
Program mode allows easy save and recall of favorite weld settings.

- Save up to four programs for each process.
- Deliver more productivity by eliminating need to manually set parameters.
- Deliver consistent quality by welders of all skill levels with prequalified settings.
- Minimize supervisor intervention.



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

- Coarse threads on MDX contact tips speed up tip replacement.
- Front load 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.



Multimatic® 255 Features and Benefits

Versatility



Multiprocess capabilities include MIG, flux cored, DC stick (6010) and DC Lift-Arc™ TIG welding. The Multimatic 255 also has pulsing capability that allows it to do pulsed MIG and TIG 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 from changing wire spools.

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



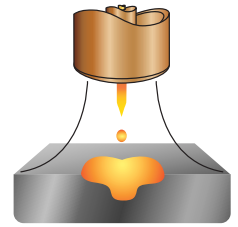
For portability and reliability Auto-Line™ allows for any single-phase input voltage hookup (208–575 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.



Generator compatible. The Multimatic 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



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



Weighing only 84 pounds, the weight of the Multimatic 255 has been 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.



Specifications (Subject to change without notice.)

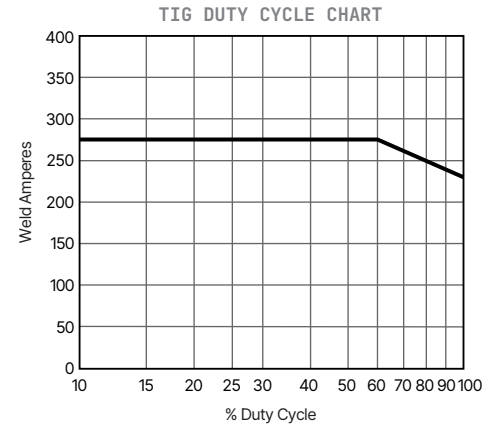
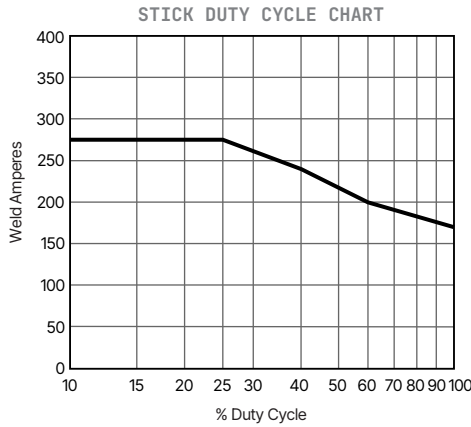
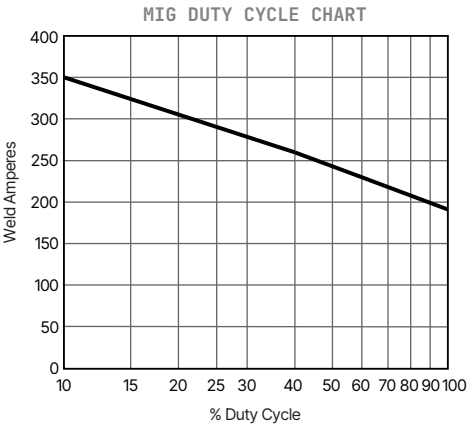


WELDING MODE/PROCESS	WELDING AMPERAGE RANGE	RATED OUTPUT	AMPS INPUT AT RATED OUTPUT, 50/60 HZ 208 V 240 V 460 V 575 V KVA KW					WIRE FEED SPEED	MAX. OPEN-CIRCUIT VOLTAGE	DIMENSIONS	NET WEIGHT	
CV: MIG/flux-cored	20–350 A	230 A at 25.5 V, 60% duty cycle	34.7	29.7	17.1	14.3	8.2	8.2	50–800 ipm (1.3–20 m/min.)	81 VDC	Machine only: H: 19.25 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)
CC: Stick*	30–275 A	200 A at 28 V, 60% duty cycle	33.5	29	16.4	13.6	7.8	7.8	—			
CC: DC TIG	5–275 A	275 A at 21 V, 60% duty cycle	34.1	29.9	17	14.1	8.1	8.1	—			

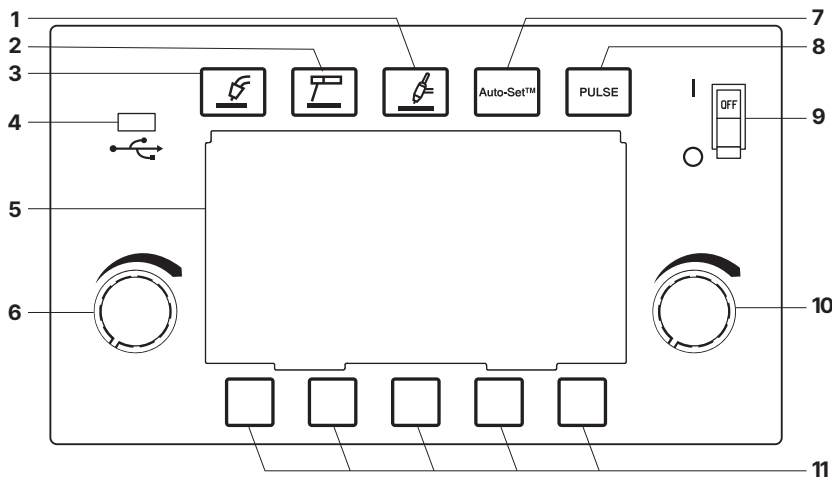
*Superior stick arc performance even on the difficult-to-run electrodes like E6010.

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

Performance Data



Control Panel



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

Multimatic® 255 Packages



907728

Machine only comes complete with:

- Power source with 10 ft. (3 m) industrial power cord
- 15 ft. (4.6 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) cable with electrode holder and 50 mm Dinse-style connector
- 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



951767

Machine with running gear package comes complete with

- Power source with 10 ft. (3 m) industrial power cord
- 15 ft. (4.6 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) cable with electrode holder and 50 mm Dinse-style connector
- 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



951768

Machine with dual cylinder/TIG kit package comes complete with

- Power source with 10 ft. (3 m) industrial power cord
- 15 ft. (4.6 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) cable with electrode holder and 50 mm Dinse-style connector
- 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™ dual cylinder running gear with elevated gun and cable rack
- Two chains to secure gas cylinders
- Multimatic 235/255 TIG kit

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 dual cylinder rack which allows operator to easily store two gas cylinders. Includes elevated gun and cable rack (shown at right) 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)
Industrial 250-amp MIG gun with 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)
Industrial 250-amp MIG gun with consumables for .030/.035 in. (0.8/0.9 mm) wire.



Spoolmatic® Spool Guns

195156 15 ft. (4.6 m)
130831 30 ft. (9.1 m)

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



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 Multimatic® U-grooved drive rolls, nylon wire guides and contact tips.

TIG Accessories



Multimatic® 235/255 TIG Kit 301518

Kits comes complete with everything needed to TIG weld with the Multimatic 255. Includes 25-foot (7.6 m) Weldcraft™ A-150 TIG torch, RFCS-14 HD foot control, 10-pin to 14-pin adapter cord, flow gauge regulator with 5-foot (1.5 m) gas hose, and AK3C torch accessory kit.



Wireless Remote Foot Control 301580

For remote current and contactor control. Receiver plugs

directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

Note: Multimatic 255 is not compatible with wireless hand control.



RFCS-14 HD Foot Control 301589

Heavy-duty foot pedal current and contactor control provides increased stability and durability from larger base

and heavier cord. Includes 20-foot (6 m) cord with plug.



RCC-14 Remote Contactor and Current Control 151086

East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord with 14-pin plug.



RCCS-14 Remote Contactor and Current Control 043688

North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord with 14-pin plug.



10-Pin to 14-Pin Adapter Cord 301545

Allows standard 14-pin TIG remote controls to be used with the Multimatic 255.

Consumables

For MDX™-250 MIG Guns

MDX™ Heavy Duty Consumables

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

Contact Tips (10 per package)

T-A023CHM	.023 in. (0.6 mm)
T-A030CHM	.030 in. (0.8 mm)
T-A035CHM	.035 in. (0.9 mm)
T-A039CHM	.039 in. (1.0 mm)
T-A045CHM	.045 in. (1.2 mm)

Nozzles

N-M5800CM	Copper, 5/8 in. ID, flush, standard
N-M5818CM	Copper, 5/8 in. ID, 1/8 in. recess
N-A5814CM	Copper, 5/8 in. ID, 1/8 in. stickout

Diffuser D-MA250M

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)

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)

MDX™ 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

N-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
199613	Brass, 5/8 in. orifice, tapered
199614	Brass, 5/8 in. orifice, tapered HD
199611	Brass, 3/4 in. orifice, straight
199612	Brass, 3/4 in. orifice, straight 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

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

For Spoolmate™ 200 Spool Gun

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 Multimatic® 255

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
Multimatic® 255	907728	Auto-Line™ 208–575 V, 50/60 Hz		
Multimatic® 255 with Running Gear	951767	Includes Multimatic® 255 (907728) and single cylinder running gear (301449)		
Multimatic® 255 with Dual Cylinder/TIG Kit	951768	Includes Multimatic® 255 (907728) and dual cylinder running gear (951769) and TIG kit (301518)		
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			
MIG 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		
Spoolmatic® Spool Guns	195156	15 ft. (4.6 m), 200 A, .030–.047 in. (0.8–1.2 mm) for aluminum wire		
	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)		See page 6		
XR™-Pistol-Pro Guns (air-cooled)		See page 6		
TIG Accessories				
Multimatic 235/255 TIG Kit	301518	See page 6 for contents		
Wireless Remote Foot Control	301580	Foot control with wireless 90 ft. (27.4 m) operating range		
RFCS-14 HD	301589	Heavy-duty foot control (included with TIG kit and TIG package)		
RCC-14	151086	Fingertip control		
RCCS-14	043688	Fingertip control		
10-Pin to 14-Pin Adapter Cord	301545	Allows standard 14-pin TIG remote controls to be used with the Multimatic 255		
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:

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