

Maxstar® 200 Series

Quick Specs



Heavy Industrial Applications

Petro/Chem Fabrication
Aerospace
Food/Beverage Industry
Mechanical Contractors
Shipboard Installation/Repair
Dairy Industry

Processes

TIG (GTAW)
Pulsed TIG (GTAW-P)
with DX and LX Models
Stick (SMAW)

Input Power Requires 1- or 3-Phase Power

Amperage Range 1–200 A

Max. Open-Circuit Voltage 80

Weight 37 lb (16.8 kg)

The Power of Blue.®

Auto-Line™ provides state-of-the-art flexibility to the end user. The Auto-Line circuitry automatically connects to 120–460 VAC, single- or three-phase power without removing the covers to relink the power source. No longer is there a concern if you have the correct machine for shop or the job site.

Inverter-based, DC power source has **state-of-the-art operator interface** allowing the user extra set-up capabilities in a compact machine. Features more precise control of output parameters than traditional knobs and switches.

Programmable HF start parameters allows the independently set HF starting conditions based upon process or application.

NEW! Low OCV Stick is a simple design that reduces the open-circuit voltage to 13 volts when the welding power source is not in use. This built-in circuit design eliminates the need for add-on voltage reducers.

HF arc starting provides non-contact arc starting that eliminates tungsten or material contamination.

Lift-Arc™ start provides TIG arc starting without the use of high frequency.



Maxstar 200 DX

Maxstar 200 LX

Maxstar 200 SD

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.

Superior TIG/Stick arc performance on all input voltages. Even on the difficult to run electrodes like E6010.

Portable in the shop or at the job site — at 37 lb the Maxstar 200 is easily moved from location to location.



Power source is warranted for 3 years, parts and labor.
Original main power rectified parts are warranted for 5 years.

MADE IN **USA**
APPLETON, WI



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An Illinois Tool Works Company
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International FAX: 920-735-4125

Web Site
www.MillerWelds.com



Specifications (Subject to change without notice.)



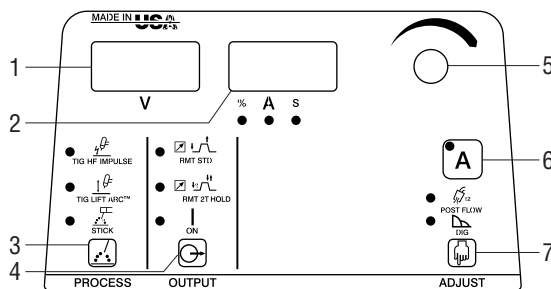
| Welding Mode | Input Power | Rated Output | Welding Amperage Range | Max. Open-Circuit Voltage | Amps Input at Rated Load Output, 50/60 Hz, | | | | | | | | Dimensions | Net Weight | | | | | |
|--------------|-------------|--------------------------------|--|---------------------------|--|-------|-------|-------|-------|-------|-------|-------|--|-----------------|---|---|---|-------|-------|
| | | | | | 115 V | 200 V | 230 V | 400 V | 440 V | 460 V | KVA | KW | | | | | | | |
| TIG (GTAW) | 3-Phase | 175 A at 17 V, 60% Duty Cycle | 115 VAC, 1–140 A 200–460 VAC, 1–200 A | 75 VDC 9–14 VDC** | — | 12.1 | 10.5 | 6.0 | 5.3 | 5.2 | 4.2 | 4.0 | H: 13-1/2 in (343 mm) W: 7-1/2 in (191 mm) D: 17-1/2 in (445 mm) | 37 lb (16.8 kg) | | | | | |
| | 1-Phase | 175 A at 17 V, 60% Duty Cycle | | | — | 0.16* | 0.16* | 0.24* | 0.24* | 0.25* | 0.06* | 0.03* | | | | | | | |
| | | 150 A at 16 V, 70% Duty Cycle | | | — | 0.25* | 0.23* | — | — | — | 0.05* | 0.02* | | | | | | | |
| | | 125 A at 15 V, 100% Duty Cycle | | | 29.7 | — | — | — | — | 3.4 | 3.4 | 0.42* | | | — | — | — | 0.05* | 0.03* |
| Stick (SMAW) | 3-Phase | 150 A at 26 V, 60% Duty Cycle | 115 VAC, 1–90 A 200–460 VAC, 1–200 A | 75 VDC | — | 14.7 | 13.1 | 7.4 | 6.6 | 6.4 | 5.2 | 5.0 | | | | | | | |
| | 1-Phase | 150 A at 26 V, 60% Duty Cycle | | | — | 0.16* | 0.16* | 0.24* | 0.24* | 0.25* | 0.06* | 0.03* | | | | | | | |
| | | 125 A at 25 V, 50% Duty Cycle | | | — | 0.25* | 0.23* | — | — | — | 0.05* | 0.02* | | | | | | | |
| | | 90 A at 24 V, 100% Duty Cycle | | | 34.1 | — | — | — | — | 4.0 | 3.8 | 0.42* | | | — | — | — | 0.05* | 0.03* |
| | | | | | 25.0 | — | — | — | — | — | 4.0 | 3.8 | 0.42* | — | — | — | — | 0.05* | 0.03* |

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

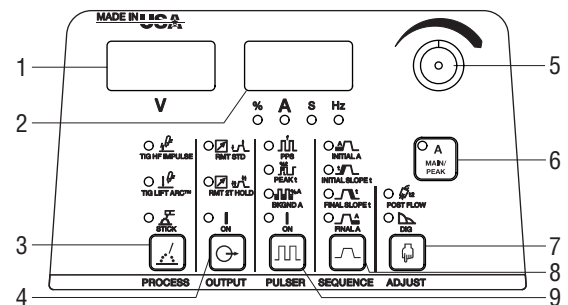
CSA approval. Models with CE specifications are available and manufactured according to the Standards IEC-974-1 and EN-60974-1.

Control Panel

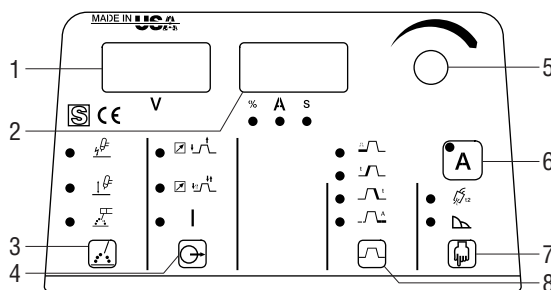
Maxstar 200 SD



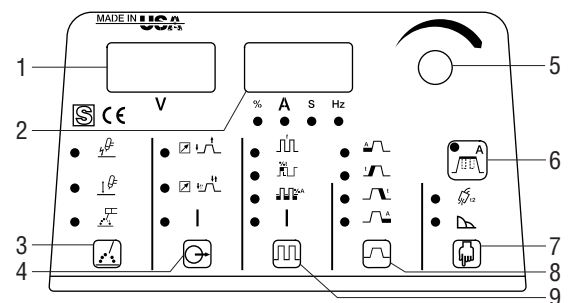
Maxstar 200 DX/LX



Maxstar 200 SD (CE)



Maxstar 200 DX (CE)



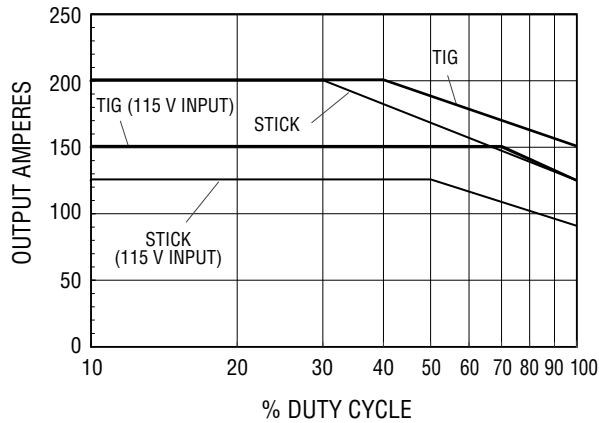
1. Voltmeter
2. Ammeter
3. Process Control
4. Output Control
5. Encoder Control
6. Amperage Control
7. Adjust Control
8. Sequencer Controls
9. Pulser Controls

Control Panel Parameter Values

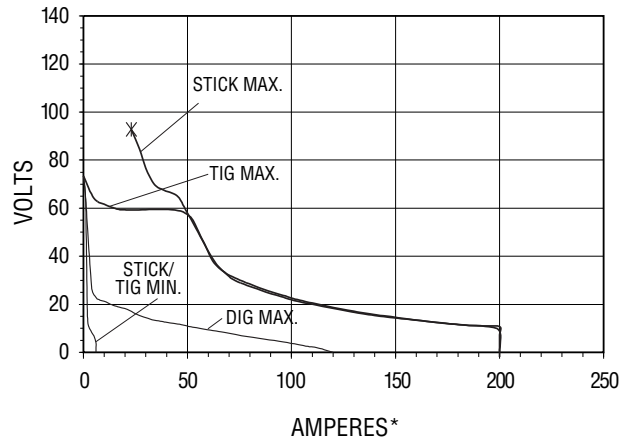
| | | | | | |
|----------------------------------|------------------|-----------------------------------|---------|-----------------------------|------------------|
| A. Preflow (s) | 0.0–25 | F. Pulse Frequency (Hz) | 0.1–500 | K. Final Time (s) | 0.0–25 (LX only) |
| B. Initial Time (s) | 0.0–25 (LX only) | G. Background Amperage (%) | 0–100 | L. Postflow Time (s) | 0–50.0 |
| C. Initial Amperage (A) | 1–200 | H. Peak Percent Time (%) | 5–95 | M. Dig (%) | 0–100 |
| D. Initial Slope Time (s) | 0.0–25 | I. Final Slope Time (s) | 0.0–25 | | |
| E. Weld Amperage (A) | 1–200 | J. Final Amperage (A) | 1–200 | | |

Performance Data

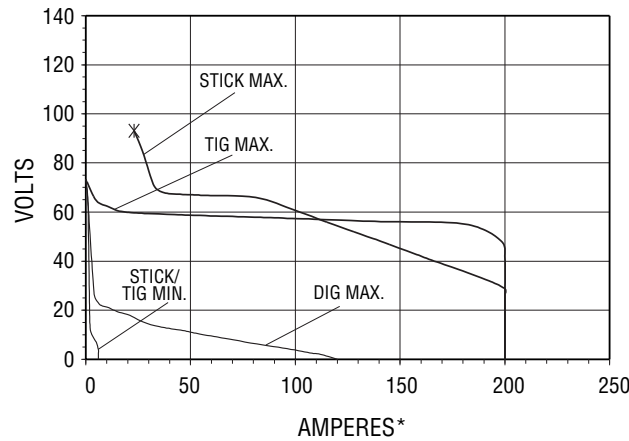
DUTY CYCLE CHART



115 VAC INPUT



OTHER INPUT VOLTAGES



*Amperage setting must be reduced to obtain currents less than highlighted data point.

Included Accessories

Non-CE SD/DX Models Include:

- (2) International-style connectors 35/50
- (1) DA-917F torch adapter to international-style connector (#194 720)

Non-CE LX Model Includes:

- (2) International-style connectors 35/50
- (1) 14-pin amphenol with clamp
- (1) 10-pin amphenol with clamp
- (1) 5/8 in - 18 gas fitting

CE SD/DX Models Include:

- (2) International-style connectors 35/50
- (1) 14-pin amphenol with clamp
- (1) 5/8 in - 18 gas fitting
- (1) 3/8 in BSPP gas fitting

Ordering Information

| Power Source and Options | Stock No. | Description | Qty. | Price |
|---------------------------------------|---|--|------|-------|
| Maxstar® 200 SD | #903 701 | Basic controls for TIG/Stick, 120–460 VAC | | |
| | #903 768 | Basic controls for TIG/Stick, 120–460 VAC with CE | | |
| Maxstar® 200 DX | #903 701-01-1 | Full-feature controls for TIG/Stick, 120–460 VAC | | |
| | #903 768-01-1 | Full-feature controls for TIG/Stick, 120–460 VAC with CE | | |
| Maxstar® 200 LX | #903 701-01-2 | Full-feature controls with the required automation connections, 120–460 VAC | | |
| TIG Accessories | | | | |
| TIG Torch Adapters | #194 720 #190 219 #194 724 | DA-917F DA-1820L DA-26R | | |
| Contractor Kits | #195 055 #195 054 | 150 A TIG/Stick with RCCS-14 fingertip control 150 A TIG/Stick with RFCS-14 HD foot control | | |
| Diamondback™ TIG Torches | | See Diamondback TIG Torch Selector Guide | | |
| Consumables/Tungsten | | See Parts Guide | | |
| Gas Cylinder/Hose and Fittings | | | | |
| Remote Controls | | | | |
| RFCS-14 HD | #194 744 | Heavy-duty foot control | | |
| RCCS-14 | #043 688 | North/south fingertip control | | |
| RCC-14 | #151 086 | Side-to-side fingertip control | | |
| RMLS-14 | #129 337 | Momentary/maintained rocker control | | |
| RMS-14 | #187 208 | Momentary rubber dome switch | | |
| Extension Cords | | | | |
| Coolant Systems | | | | |
| Coolmate™ 3 | #043 007 | 115 VAC | | |
| | #043 007-01-2 | 115 VAC with CE | | |
| | #043 008 | 230 VAC | | |
| | #043 008-01-2 | 230 VAC with CE | | |
| Coolmate™ V3 | #043 009 | 115 VAC | | |
| | #043 009-01-2 | 115 VAC, 50/60 Hz with CE | | |
| Coolmate™ 4 | #042 288 | 115 VAC | | |
| | #042 288-01-5 | 115 VAC with CE | | |
| Low-Conductivity Coolant | #043 810 | | | |
| International-Style Connectors | | | | |
| International-Style Connector Kit | #042 418 | Dinse, (1) male plug - 50 mm | | |
| Extension Kit for International-Style | #042 419 | Dinse, (1) plug and (1) receptacle - 50 mm | | |
| International/Tweco® Adapter | #042 465 | A one-piece adapter with International-style male plug | | |
| International/Cam-Lok Adapter | #042 466 | A one-piece adapter with International-style male plug | | |

Date:

Total Quoted Price:



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