

XMT® 350/450 Series

Issued July 2012 • Index No. DC/18.83

Multiprocess Welding
Power Source 

Quick Specs

Heavy Industrial Applications

Construction
Shipbuilding
Railroad
Truck/Trailer Manufacturing
Fabrication
Repair Shops
Rental Fleets
Power Generation Plants

Processes

MIG (GMAW)/Pulsed MIG (GMAW-P)*
Stick (SMAW)
TIG (GTAW)
Flux-Cored (FCAW)
Air Carbon Arc Cutting and Gouging (CAC-A)
**XMT 350 CC/CV and 450 CC/CV with required optional control; not available with XMT 350 VS model.*

Input Power 350: Requires 3- or 1-Phase Power,
450: Requires 3-Phase Power

Rated Output 350: 10–38 V, 15–425 A
450: 10–38 V, 15–600 A

Net Weight 350: 80 lb. (36.3 kg)
450: 122 lb. (55.3 kg)

The Power of Blue.®



XMT 350 CC/CV

XMT 350 VS

XMT 450 CC/CV

Wind Tunnel Technology™ protects electrical components and PC boards from contamination.

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

Lift-Arc™ allows TIG starting without the use of high-frequency. Starts the arc without contaminating the weld with tungsten.

Adaptive Hot Start™ increases the output amperage at the start of a weld if necessary, eliminating electrode sticking.

Lightweight, aerospace-grade aluminum case offers protection with the benefit of reduced weight.

XMT 350 Model Only

Auto-Line™ Power Management Technology allows for any input voltage hook-up (208–575 V) with no manual linking required, providing convenience in any job setting. Ideal solution for dirty or unreliable input power. (450 model is manual link.)

Dinse- or Tweco-style weld disconnects provide high-quality weld cable connections. (450 model utilizes studs.)

Inverter arc control technology provides greater puddle control for superior 6010 Stick electrode performance, and outstanding MIG weld performance.

Line voltage compensation keeps welding output constant even if input power varies by +/-10 percent. Line voltage compensation further expands to an amazing +37/-59 percent when operating on 460 VAC.

Process selector switch reduces the number of control setup combinations without reducing any features.

Large, dual digital meters are easy to view and are presettable to ease setting weld output.



Power source is warranted for 3 years, parts and labor.
Original main power rectified parts are warranted for 5 years.
Gun warranted for 90 days, parts and labor.



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XMT[®] 350/450 Specifications (Subject to change without notice.)



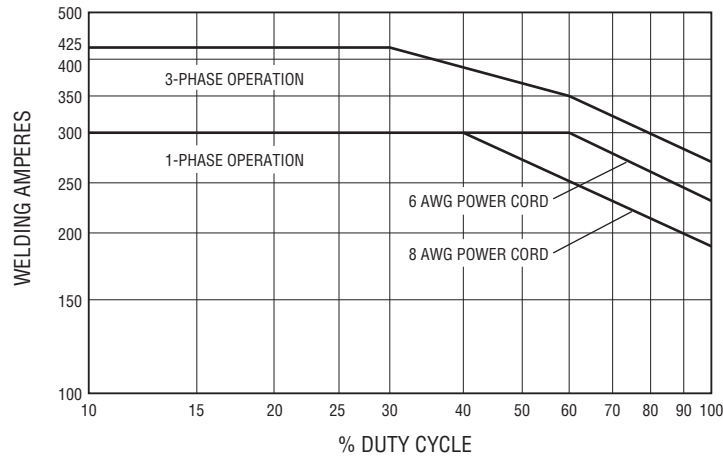
(XMT 450 CC/CV is 3-Phase only.)

Model	Input Power	Rated Output	Voltage Range in CV Mode	Amperage Range in CC Mode	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 60 Hz						Dimensions	Weight	
						208 V	230 V	400 V	460 V	575 V	KVA			KW
XMT 350 CC/CV and VS	Three-Phase	350 A at 34 VDC, 60% Duty Cycle	10–38 V	5–425 A	75 VDC	40.4	36.1	20.6	17.8	14.1	14.2	13.6	H: 17 in. (432 mm) W: 12.5 in. (318 mm) D: 24 in. (610 mm)	80 lb. (36.3 kg)
	Single-Phase	300 A at 32 VDC, 60% Duty Cycle	10–38 V	5–425 A	75 VDC	60.8	54.6	29.7	24.5	19.9	11.7	11.2		
XMT 450 CC/CV	Three-Phase	450 A at 38 VDC, 100% Duty Cycle	10–38 V	15–600 A	90 VDC	—	51	32.1	27.6	24.4	22	18.9	H: 17.25 in. (438 mm) W: 14.5 in. (368 mm) D: 27.125 in. (689 mm)	122 lb. (55.3 kg)

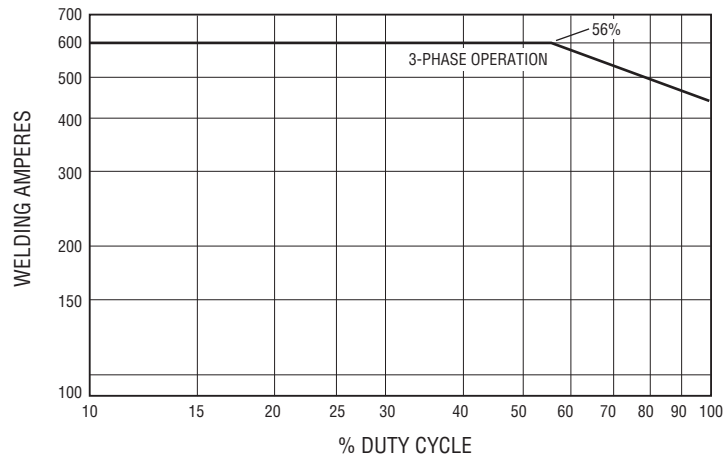
Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

XMT[®] 350/450 Performance Data

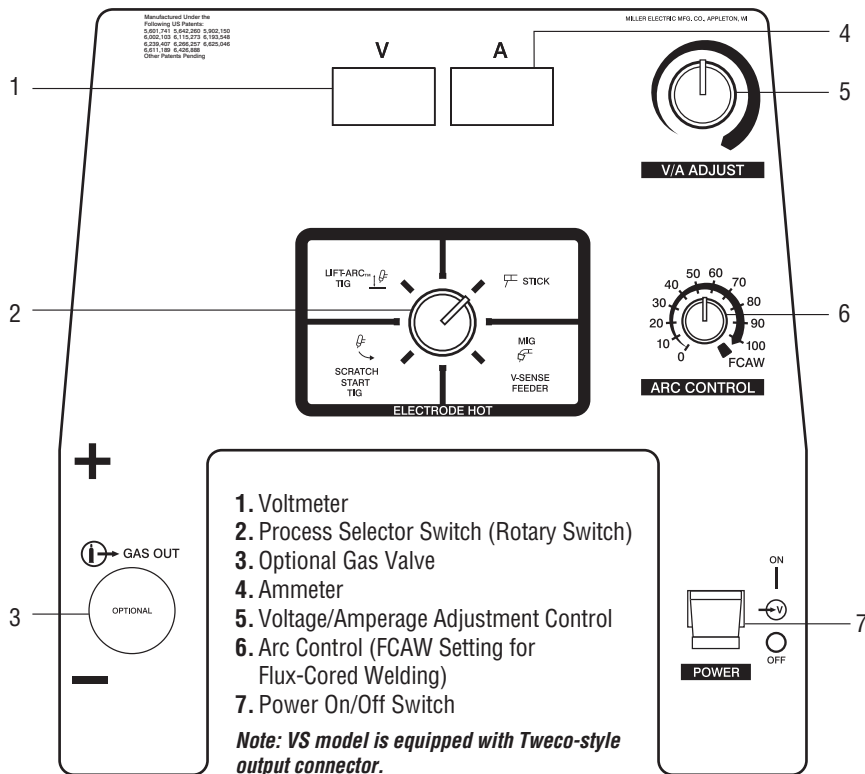
XMT 350 CC/CV and VS DUTY CYCLE CHART



XMT 450 CC/CV DUTY CYCLE CHART



XMT® 350 VS Control Panel



Additional Features

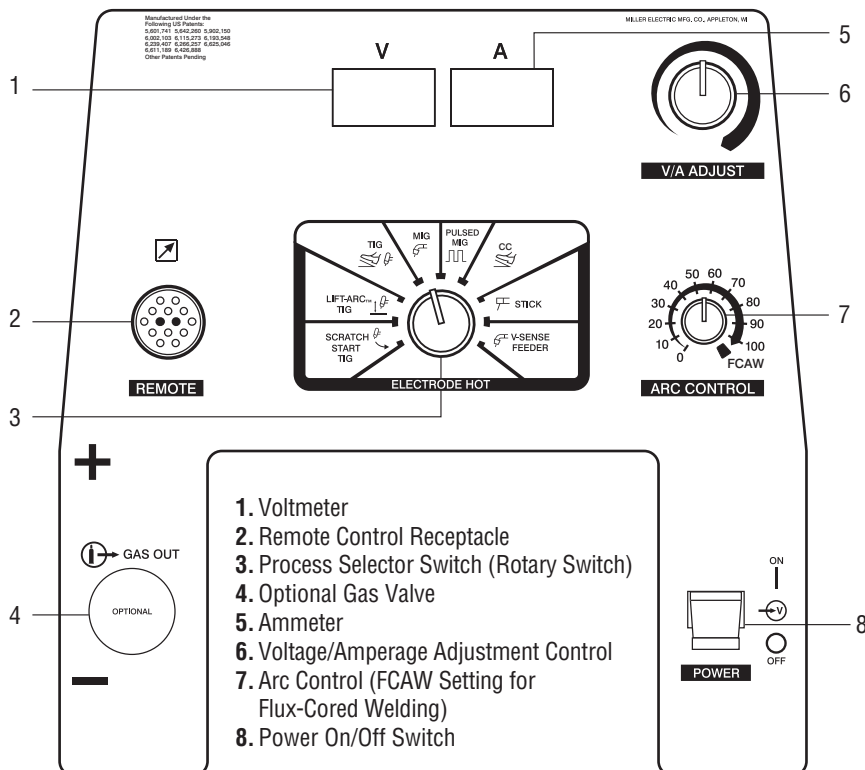
Low OCV Stick. A built-in, selectable feature, that reduces the Stick mode open-circuit voltage (OCV) to nearly 15 volts when the welding power source is not in use. Eliminates the need for add-on voltage reducers.

Note: VS model is available only with Tweco-style weld cable disconnects. Tweco cable connectors are not supplied with the unit and must be ordered separately.

Optional 115 VAC auxiliary power is not available on VS model.

Pulsed MIG (GMAW-P) capability is not available on VS model.

XMT® 350 CC/CV Control Panel



Additional Features

Auto Remote Sense™ enables unit to automatically use remote control if connected to remote control receptacle.

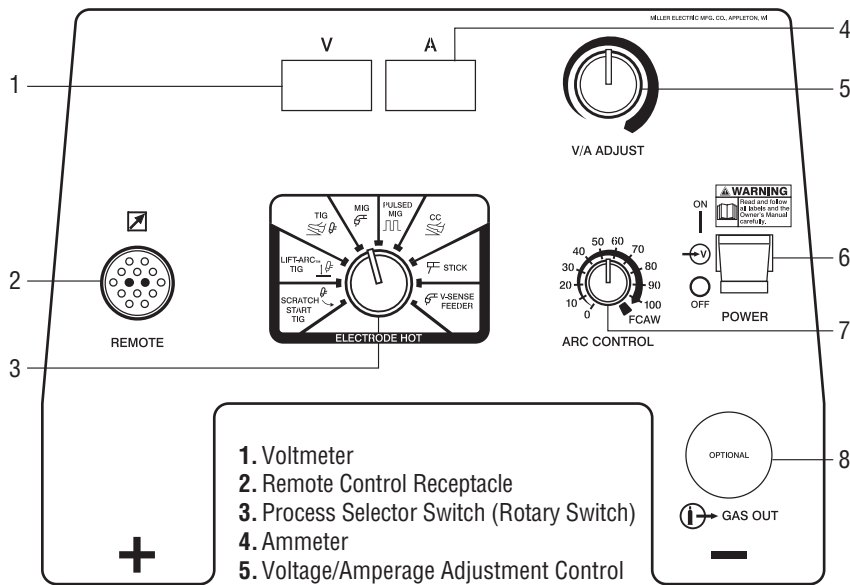
Low OCV Stick. A built-in, selectable feature, that reduces the Stick mode open-circuit voltage (OCV) to nearly 15 volts when the welding power source is not in use. Eliminates the need for add-on voltage reducers.

Disne- or Tweco-style weld disconnects provide high-quality weld cable connections.

Optional 115-VAC auxiliary power provides 10 amps of circuit-breaker-protected power for water circulators, etc.

Pulsed MIG (GMAW-P) capabilities with optional Optima™ control reduces spatter and distortion, allows better out-of-position puddle control, and provides potential reduction of fume particle emission.

XMT® 450 CC/CV Control Panel



Note : 450 model is equipped with studs for ring-lug output connections.

Additional Features

Primary voltage display shows what primary voltage the power source is linked for without removing the side panels. Saves time and assures you that the power source has been correctly linked for available input voltage.

Unique case design helps protect internal components from dirt and dust. To connect input power cord and/or set unit up for correct input power, remove the easy-to-handle panel (1/3 case). The remaining two-thirds of the case never needs to be removed!

XMT® 350 Wire Feeder Packages



SuitCase® X-TREME™ 8VS with XMT® 350 VS and Bernard® Q300 gun #951 306

Pulse MIG	Stick MIG TIG	Remote Control Cable	Feeder Remote Control	Weight w/steel wire
No	Yes	No	No	32 lb.



SuitCase® X-TREME™ 12VS with XMT® 350 CC/CV and Bernard® Q300 gun #951 305

Pulse MIG	Stick MIG TIG	Remote Control Cable	Feeder Remote Control	Weight w/steel wire
No	Yes	No	No	66 lb.



XMT® 350 CC/CV, 22A, MIGRunner™ #951 327
XMT® 350 CC/CV S-74D MIGRunner™ #951 314 (not shown)

Comes complete with:

- XMT 350 CC/CV power source
- 22A or S-74D wire feeder
- Bernard® Q™-Gun
- Consumables
- .035/.045-in. drive roll kit
- Regulator/flow gauge with gas hose
- MIGRunner Cart with cylinder rack
- Bottom tray will hold optional Coolmate™ 3 (sold separately)



Optima™ #043 389
A multipurpose, microprocessor-based pulse control for both synergic MIG (wire welding or GMAW) or manual MIG pulsing. Use this control with the XMT CC/CV power

sources and any Miller wire feeder, including automatic feeders and spool guns. Includes a 25-foot (7.6 m) cord with 14-pin plug. (Not for use with XMT VS model.)

Extension Cords for Optima

- #242 205 025 25 ft. (7.6 m)
- #242 205 050 50 ft. (15 m)
- #242 205 080 80 ft. (24.3 m)



WC-24 Weld Control #137 549

Designed for use with Miller CV power sources supplying 24 VAC and 14-pin receptacles. For use with Spoolmatic 30A spool gun.



HF-251D-1 High-Frequency Arc Starter and Stabilizer #042 388

Portable 250-amp, 60-percent duty cycle unit adds high frequency to the welding circuit to help start the arc when using the DC TIG (GTAW) process. Operates on 115 VAC, 50/60 Hz. See Lit. Index No. AY/5.1.



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.



RFCS-14 Foot Control #043 554

Foot current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.



RHC-14 Hand Control* #242 211 020

20-foot (6 m) cord
#242 211 100
100-foot (30.5 m) cord

Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 82 mm). Includes cord and 14-pin plug.

**Custom lengths available in 5-foot increments up to 50 feet and 10-foot increments up to 100 feet.*



RMLS-14 #129 337 14-pin plug
Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and back for momentary contact. Includes 20-foot (6 m) cord.



RCC-14 Remote Contactor and Current Control #151 086 14-pin plug
Rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 26.5 foot (8 m) control cord.



RCCS-14 Remote Contactor and Current Control #043 688 14-pin plug
Up-and-down rotary-motion fingertip control. Great for applications that require a finer amperage control. Includes 26.5-foot (8 m) control cord.

Extension Cables for Remote Controls and 24 VAC Wire Feeders*

- #242 208 025 25 ft. (7.6 m)
 - #242 208 050 50 ft. (15 m)
 - #242 208 080 80 ft. (24.3 m)
- 14-pin plug to 14-pin socket. Not for use with Optima or XR-AlumaFeed feeder.

**Custom lengths available in 5-foot increments up to 50 feet and 10-foot increments up to 100 feet.*

Running Gear



MIGRunner™ Cart #195 445

Running Gear Cylinder Rack #300 408

For dual feeders
Small footprint and easily maneuverable, with cylinder rack low enough that you do not have to lift bottles.



XMT Cylinder Cart #042 537

Carries two 160-pound (72.6 kg) gas cylinders, or one gas cylinder and one coolant system for TIG

(GTAW) welding. Feeder mounts to tray above power source.



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.

Protective Cover



#195 478
Mildew and water resistant, odor-free cover protects your machine's finish. For 300/350 A inverters: XMT, Maxstar and Dynasty.

Inverter Racks



Four or Six-Arc Welding System

The Inverter Rack conveniently houses multiple XMT power sources for multiple welders. Both 4-pack and 6-pack models are available.

Features include:

- Provision to parallel power sources or common work connections
- Two lifting eyes for transportation
- Rugged skids for dragging or pushing
- Customer can install up to a maximum of four XMT 450 CC/CV power sources

For detailed information on customized Inverter Rack systems see Lit. Index No. DC/18.81.

Wire Feeders/Guns



SuitCase® X-TREME™ 8VS #951 181
SuitCase® X-TREME™ 12VS #951 184

Lightweight, portable wire feeder for a variety of wires up to .062 inch. Holds up to an 8-inch (8VS) or 12-inch (12VS) spool of wire. Operates on open-circuit voltage eliminating the need for a control/power cord. See Lit. Index No. M/6.41.



SuitCase® 8RC #951 186
SuitCase® 12RC #951 188

Lightweight, portable wire feeder for a variety of wires up to .062 inch. Holds up to an 8-inch (8RC) or 12-inch (12RC) spool of wire. Operates using 14-pin control receptacle. See Lit. Index No. M/6.5.



XR™-S Control #300 601
XR™-D Control #300 678

The updated XR Controls offer unsurpassed performance and reliability for feeding aluminum and other difficult-to-feed wire types. Models include .035-inch and factory-installed 3/64-inch drive rolls. See Lit. Index No. M/1.7.



XR-AlumaFeed™ #300 509

Advanced push-pull wire feeder designed for high-volume, high-production aluminum MIG welding where quality and consistency is a high priority. See Lit. Index No. DC/34.



70 Series

S-74S #951 196
S-74D #951 198
S-74DX #951 200

Features Posifeed™ wire drive assembly and handles a variety of wires up to 1/8 inch. Comes with FREE Bernard® Q™-Gun. Dual-wire models also available. See Lit. Index No. M/3.0.

Extension Cables*

#247 831 025 25 ft. (7.6 m)

#247 831 050 50 ft. (15.2 m)

#247 831 080 80 ft. (24.4 m)

Eleven conductors to support contactor control and remote voltage control on all Miller electronic CV 14-pin power sources.

*Custom lengths available in 5-foot increments up to 50 feet and 10-foot increments up to 100 feet.



Spoolmatic® 30A #130 831

A one-pound, air-cooled spool gun that extends the weld process range by adding a handy portable system for small wire MIG. Rated 200 amps at 100% duty cycle. Includes 30-foot (9.1 m) cable assembly. WC-24 (#137 549) required for use with 14-pin receptacles, order separately.

Ironmate™ Flux Cored Guns

See Lit. Index No. AY/16.0.

FC-1260

#195 732 10 ft. (3 m)

#195 729 15 ft. (4.6 m)

FC-1260LM

#194 912 10 ft. (3 m)

#194 911 15 ft. (4.6 m)

FC-1150

#194 864 10 ft. (3 m)

#194 863 15 ft. (4.6 m)

Coolant Systems

For more information, see the Miller Coolant Systems literature sheet, Index No. AY/7.2.



Coolmate™ 3

#043 007 115 VAC

#043 008 230 VAC

For use with water-cooled torches rated up to 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ V3 #043 009 115 VAC

For use with water-cooled torches rated up to 500 amps. Vertical design conveniently mounts to Miller cylinder rack in place of one cylinder.

Coolmate™ 4 #042 288 115 VAC

For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Coolant #043 810

Sold in cases of four one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37 degrees Fahrenheit (-38° C) or boiling to 227 degrees Fahrenheit (108° C). Also contains a compound that resists algae growth.

Cable Connectors and Adapters

Note: XMT 350 power sources are equipped with Dinse- or Tweco-style connectors for secondary connections.

Dinse-Style Connectors

#042 418

Accepts #4 AWG to #1/0 cable size.

#042 533

Accepts #1/0 to #2/0 AWG cable size.

Kit includes one Dinse-style male plug which attaches to the work and/or weld cables and plugs into the Dinse-style receptacles on the power source.

Extension Kit for Dinse-Style Cable Connectors

#042 419

Accepts #4 AWG to #1/0 cable size.

#042 534

Accepts #1/0 to #2/0 AWG cable size.

Used to adapt or extend weld and/or work cables. Kit includes one male Dinse-style plug and one in-line female Dinse-style receptacle.



Dinse/Tweco® Adapter

#042 465

Dinse/Cam-Lok Adapter

#042 466

One-piece adapter with Dinse-style male plug (to power source) on one end and female receptacle (Tweco or Cam-Lok for weld cable connection) on other end.

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
XMT® 350 CC/CV	#907 161	208–575 VAC with Auto-Line™		
	#907 161-01-1	208–575 VAC with Auto-Line™ and Auxiliary Power		
	#907 161-01-2	230–460 VAC with Auto-Line™ and Auxiliary Power and CE		
	#907 161-01-4	208–575 VAC with Auto-Line™ and Tweco connectors		
XMT® 350 VS	#907 224	208–575 VAC with Auto-Line™ (without 14-pin, Tweco connectors)		
XMT® 350 Wire Feeder Packages		See page 4		
XMT® 450 CC/CV	#907 481	230–460 VAC		
	#907 482	575 VAC		
	#907 525	400 VAC with Auxiliary Power and CE		
Inverter Racks (full or empty)		See Lit. Index No. DC/18.81		
Gas Valve Kit	#195 286	For XMT 350		
	#300 928	For XMT 450		
Accessories				
Optima™ MIG Pulse Control	#043 389	For CC/CV models only. Not for use with XMT 350 VS		
Optima™ Extension Cords		See page 5		
WC-24 Weld Control	#137 549	For use with Spoolmatic® 30A and power sources with 14-pin		
HF-251D-1 HF Starter/Stabilizer	#042 388	See Lit. Index No. AY/5.1		
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		
RFCs-14	#043 554	Foot control		
RHC-14	#242 211 020	Hand control with 20-foot (6 m) cord		
	#242 211 100	Hand control with 100-foot (30.5 m) cord		
RMLS-14	#129 337	Rocker switch		
RCC-14	#151 086	Fingertip control		
RCCS-14	#043 688	Fingertip control		
Extension Cables		See page 5		
Running Gear				
MIGRunner™ Cart	#195 445			
Running Gear Cylinder Rack	#300 408	For dual feeders		
XMT Cylinder Cart	#042 537			
Universal Carrying Cart and Cylinder Rack	#042 934			
Protective Cover	#195 478			
Wire Feeders/Guns				
SuitCase® X-TREME 8VS/X-TREME™ 12VS	#951 181 / #951 184	See Lit. Index No. M/6.4 and M/6.41		
SuitCase® 8RC/12RC	#951 186 / #951 188	See Lit. Index No. M/6.5		
XR™-S Control	#300 601	Standard model with wire feed speed digital display, jog/purge, run-in control, and trigger hold. See Lit. Index No. M/1.7		
XR™-D Control	#300 687	Enhanced model has same features as XR-S model plus advanced digital and programming capabilities. See Lit. Index No. M/1.7		
XR-AlumaFeed™	#300 509	Advanced model adds Profile Pulse™, synergic control, trigger schedule select, lock capabilities and flow meter		
70 Series	#951 196	S-74S. See Lit. Index No. M/3.0		
	#951 198	S-74D. See Lit. Index No. M/3.0		
	#951 200	S-74DX. See Lit. Index No. M/3.0		
Spoolmatic® 30A Spool Gun	#130 831	Requires WC-24 for use with 14-pin receptacles		
Ironmate™ Flux-Cored Guns		See Lit. Index No. AY/16.0		
Coolant Systems		See page 7. See Lit. Index No. AY/7.2		
Cable Connectors and Adapters		See page 7		

Date:

Total Quoted Price:

Distributed by:

