

Dialarc® 250 AC/DC

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**Stick Welding
Power Source** 

Quick Specs

Light Industrial Applications

Production Line Work
Plant Maintenance
Garage/Job Shops
Fabrication
Vocational School Training

Process

Stick (SMAW)

Input Power 1-Phase Power

Rated Output AC: 225 A at 29 V, 30% Duty Cycle
DC: 175 A at 27 V, 50% Duty Cycle

Max. Open-Circuit Voltage AC: 70
DC: 79

The Power of Blue.®

Single-dial current control simplifies weld adjustment.

Infinite current control allows precise weld output adjustment; you always get the exact heat you need to produce a better weld.

Two weld ranges for both AC and DC welding allow greater control of weld performance for changes in welding conditions.

Fully varnished magnetic amplifier technology provides lower maintenance, and outstanding product reliability with fewer moving parts.

Forced-draft cooling fan ensures a cooler running product, extending the life of the power source.



Superior 6010 and 7018 Stick welding performance offers a wide range of electrode versatility; welds difficult-to-weld metals.

High output and duty cycle allows unit to handle nearly all of your Stick welding needs.

Industrial, weld output terminal cover.

Power factor correction is available for lower primary power demand.

Optional remote weld output control provides current control without going back to the power source—saves time and effort.

TRUE BLUE®
3YR. WARRANTY

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 **USA**



Miller Electric Mfg. Co.
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.)



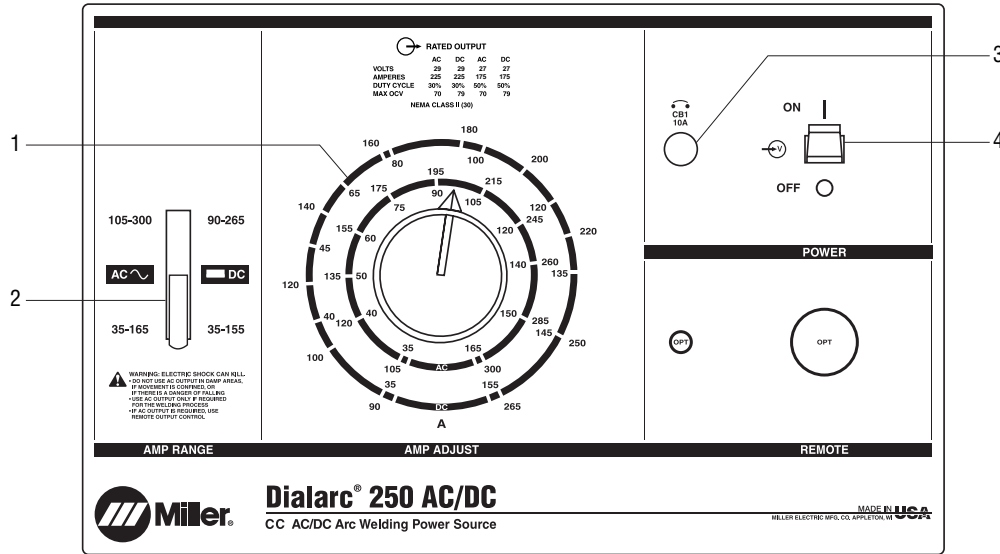
Power Factor Correction	Welding Amperage Ranges	Max. Open-Circuit Voltage	Rated Output*	Amps Input at Rated Output, 50 or 60 Hz, Single-Phase								Dimensions	Weight		
				200 V	208 V	220 V	230 V	380 V	440 V	460 V	575 V			KVA	KW
60 Hz, Without	AC Low: 35–165 High: 105–300	70	225 A at 29 V, 175 A at 27 V	84	—	—	73	—	—	36	29	16.8	9.8	H: 24-1/4 in (616 mm) W: 19 in (483 mm) D: 28 in (711 mm)	Net: 360 lb (163 kg) Ship: 370 lb (168 kg)
	DC Low: 35–155 High: 90–265	79	225 A at 29 V, 175 A at 27 V	92	—	—	80	—	—	40	32	18.6	11.8		
60 Hz, With	AC Low: 35–165 High: 105–300	70	225 A at 29 V, 175 A at 27 V	—	60	—	55	—	—	27	22	12.5	9.9		Net: 365 lb (166 kg) Ship: 375 lb (171 kg)
	DC Low: 35–155 High: 90–265	79	225 A at 29 V, 175 A at 27 V	—	66	—	60	—	—	30	24	13.7	10.8		
50 Hz, With	AC Low: 35–165 High: 105–300	70	225 A at 29 V, 175 A at 27 V	—	—	62	—	36	31	—	—	13.7	10.2		Net: 365 lb (166 kg) Ship: 375 lb (171 kg)
	DC Low: 35–155 High: 90–265	79	225 A at 29 V, 175 A at 27 V	—	—	73	—	42	36	—	—	16	12.2		
				—	—	52	—	30	26	—	—	11.4	8.3		

*Rated output at low welding amperage ranges is **30% duty cycle**. Rated output at high welding amperage ranges is **50% duty cycle**.

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

Control Panel

1. Amperage Adjustment Control
2. Range Selector Switch
3. Circuit Breaker CB1
4. Power Switch

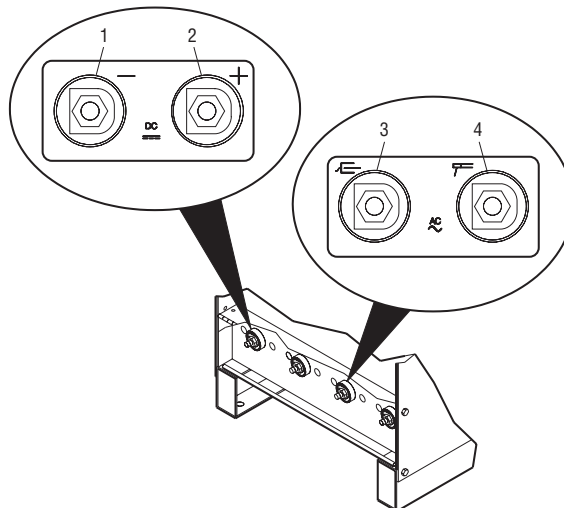


For DC Weld Output

1. Negative (-) Weld Output Terminal
2. Positive (+) Weld Output Terminal

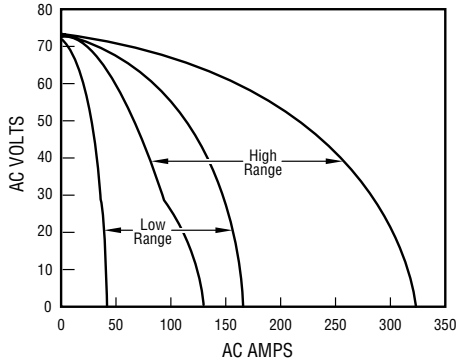
For AC Weld Output

3. Work Weld Output Terminal
4. Electrode Weld Output Terminal

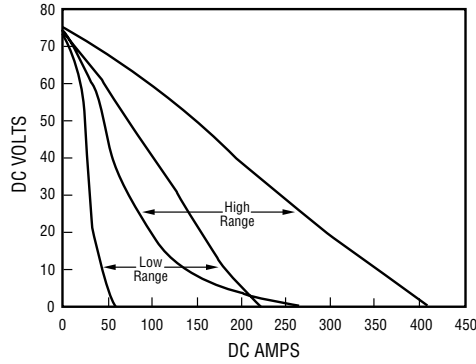


Performance Data

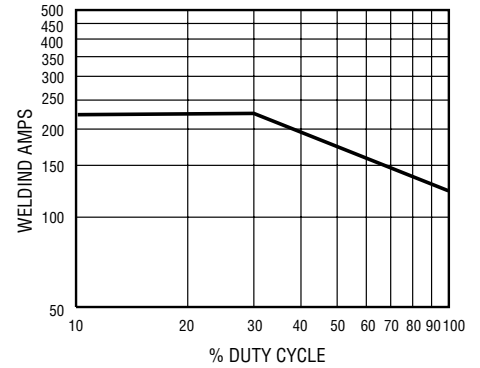
VOLT AMP CURVES



VOLT/AMP CURVES



DUTY CYCLE CHART



Genuine Miller Accessories



No. 2 Stick Cable Set, 15 ft #195 196
 Consists of 15 ft (4.6 m) No. 2 electrode cable and holder, and 15 ft (4.6 m) work cable and clamp. 200 A, 100% duty cycle.

No. 2 Stick Cable Set, 50 ft #195 195
 Consists of 50 ft (15.2 m) No. 2 electrode cable and holder, and 50 ft (15.2 m) work cable and clamp. 200 A, 100% duty cycle.

RF-10 Remote Current Control Facilities #041 111 Field
 Includes receptacle, remote-standard switch and wiring.



RHC-3 Remote Hand Amperage Control #040 056
 Requires RF-10 Remote Current Control Facilities. Includes 20 ft (6 m) cord and plug.

RFC-23A #040 071
 Requires RF-10 Remote Current Control Facilities. Remote foot amperage control with 20 ft (6 m) cord and plug.

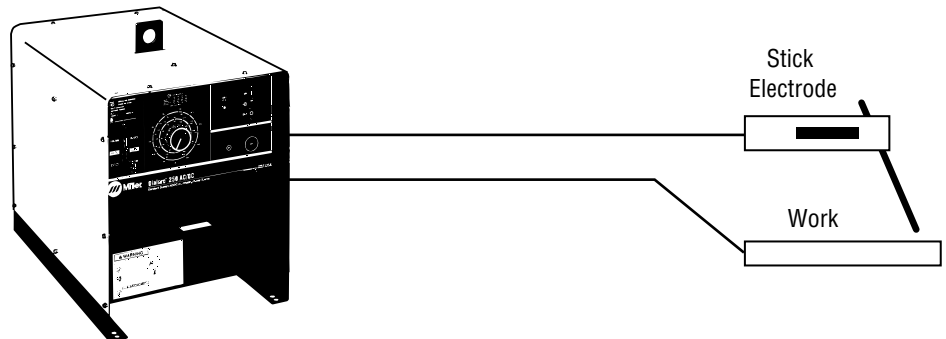


No. 19 Running Gear #041 580
 Four 8 in (203 mm) poly/rubber blend wheels with 30 in (762 mm) towing handle. All running gear shipped unassembled.

Typical Installations



Stick (SMAW) Basic Equipment



Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Dialarc® 250 AC/DC	#907 017	200/230/460, 60 Hz		
	#907 016	230/460/575, 60 Hz		
Dialarc® 250P AC/DC	#907 047	220/380/440, 50 Hz		
Dialarc® 250P AC/DC	#907 015	200/230/460/575, 60 Hz		
No. 19 Running Gear	#041 580			
Accessories				
No. 2 Stick Cable Set	#195 196	Includes 15 ft (4.6 m) No. 2 electrode cable and holder, 15 ft (4.6 m) work cable and clamp		
	#195 195	Includes 50 ft (15.2 m) No. 2 electrode cable and holder, 50 ft (15.2 m) work cable and clamp		
RF-10	#041 111	Remote current control facilities, field only		
RHC-3	#040 056	Remote hand amperage control		
RFC-23A	#040 071	Remote foot amperage control		
Miscellaneous				
Stick Electrodes				
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Other				

Date: _____ **Total Quoted Price:** _____



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