

# Millermatic® 135

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**MIG Arc Welding Power Source,  
Wire Feeder and Gun Package**



## Quick Specs

### Light Industrial Applications

Light Fabrication  
Maintenance and Repair  
Auto Body  
Farm/Home

### Processes

Flux Cored (FCAW)  
MIG (GMAW)

**Input Power** 115 V, 20 A, 60 Hz, Single-Phase

**Rated Output** 90 A at 18 VDC, 20% Duty Cycle  
63 A at 21 VDC, 20% Duty Cycle, **CSA**

**Amperage Range** 30–135 A

**Max. Open-Circuit Voltage** 28

## The Power of Blue.®



### Infinite Voltage Control with Wire Feed

**Speed Tracking** provides a broader operating range with finer control by automatically increasing or decreasing wire feed speed when voltage is adjusted.

### Durable cast aluminum feedhead

incorporates dual groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob all designed to make set up easier and faster.

### Miller's exclusive "Tip Saver"

**short circuit protection** shuts down output when tip is shorted to the work. Extends contact tip life and protects internal components from damage. **Trigger reset** permits quick reset at torch rather than unit.

Easy access to output

studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

### Self-resetting motor

**protection circuit** rather than fuses to find and replace.

**Thermal overload protection** shuts down unit and activates **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when fault is corrected and unit cools.

**Semiautomatic constant voltage wire welding package** is capable of welding 24 gauge–3/16 in (0.8–4.8 mm) mild steel.



### Comes Complete With:

- Power source
- Power cord and plug
- 10 ft (3 m), M-10 MIG gun and cable assembly
- 10 ft (3 m) work cable and clamp
- Argon and AR/CO<sub>2</sub> mix regulator/flow gauge with hose
- Sample spool of .024 in (0.6 mm) solid wire
- Two contact tips for .024 in (0.6 mm) wire and two contact tips for .030 in (0.8 mm) wire
- Dual groove quick-change drive roll for .024 in (0.6 mm) or .030/.035 in (0.8/0.9 mm) wire
- Factory-installed contactor and gas solenoid valve
- Information/settings chart

*Note: Shielding gas and safety equipment not included.*

### Standard built-in solid state

**contactor circuit** makes wire electrically "cold" until trigger is pulled. Makes the unit safer, and is easier to position torch to work before starting weld.

### Uses 4 or 8 in (102 or 203 mm)

**spools** and can be set up to weld with wire sizes .024–.030 in (0.6–0.8 mm) mild/stainless steel and .030–.035 in (0.8–0.9 mm) flux cored.

Add the Spoolmate™ 3035 spool gun and SGA spool gun adapter for welding with .030 in (0.8 mm) aluminum wire on 14 gauge to 1/8 in material.



**TRUE BLUE**  
3 YR. WARRANTY

Welder/generator 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.

MADE IN **USA**



**Miller Electric Mfg. Co.**  
An Illinois Tool Works Company  
1635 West Spencer Street  
Appleton, WI 54914 USA

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USA FAX: 920-735-4134  
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International FAX: 920-735-4125

**Web Site**  
www.MillerWelds.com



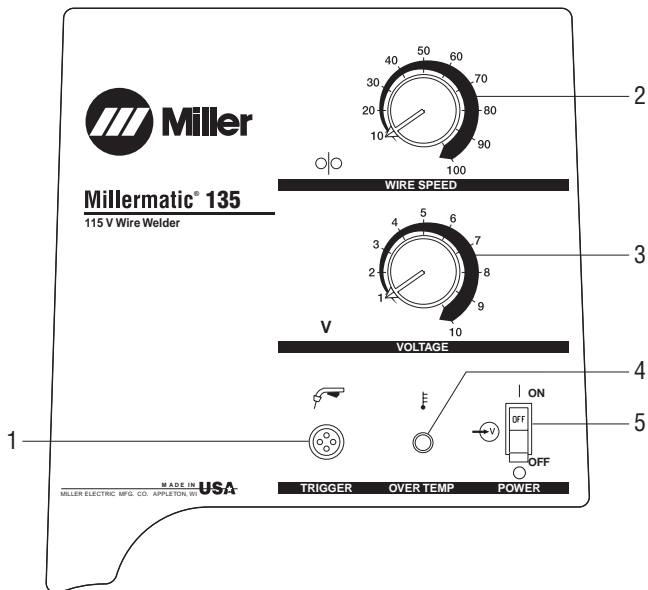
# Specifications (Subject to change without notice.)

**CV** **DC** **1** Phase

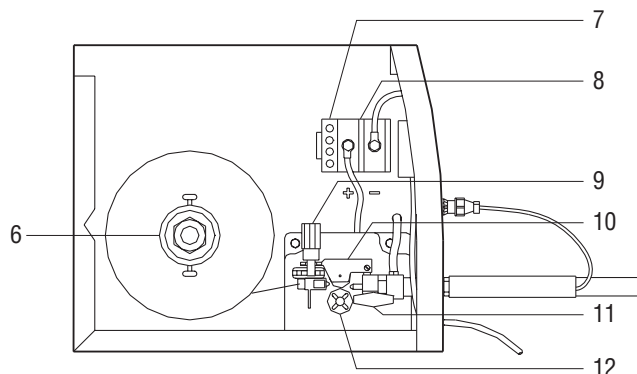
Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz			Wire Feed Speed	Dimensions	Net Weight	Ship Weight
			115 V	KVA	KW				
90 A, 18 VDC at 20% Duty Cycle	30–135 A	28	20	2.9	2.4	20–600 IPM (0.5–15.2 m/min);	H: 17-1/2 in (444 mm) W: 10-5/8 in (273 mm) D: 15-3/4 in (400 mm)	60 lb (27.3 kg)	67 lb (30.5 kg)
63 A, 21 VDC at 20% Duty Cycle, <b>CSA</b>			15	2.2	1.8	40–620 IPM at no load (1.0–15.8 m/min)			

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

## Control Panel



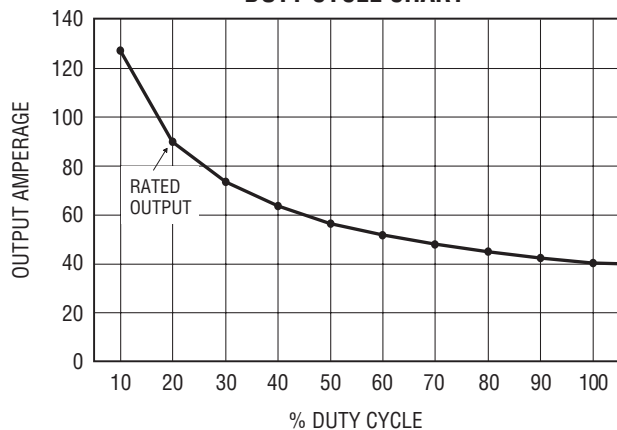
1. Trigger Lead Switch Connection
2. Wire Feed Speed Control
3. Infinite Voltage Control (with Wire Feed Speed Tracking)
4. Over Temperature Light
5. Power Switch



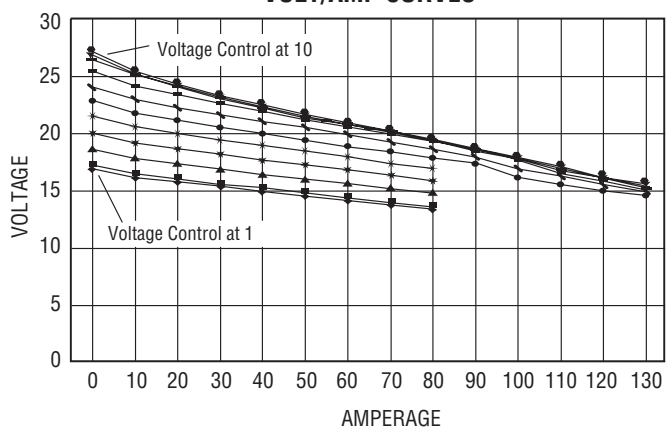
6. Plastic Hub with Retaining Ring for 8 in Spools (shaft also accepts 4 in spools)
7. Storage Holes for Spare Tips
8. Polarity Changeover Terminals
9. Calibrated Tension Knob
10. Springloaded Tension Arm
11. T-Knob (secures torch)
12. Dual Groove Quick-Change Drive Roll

## Performance Data

**DUTY CYCLE CHART**



**VOLT/AMP CURVES**



## Genuine Miller Accessories

**M-10 Replacement Gun #195 605**  
10 ft (3 m). Shipped with liner #194 011.



**Spoolmate™  
3035 Spool Gun  
#195 016**

Spool gun for aluminum and other wires.  
4 in spools;

.030 – .035 in (0.8 – 0.9 mm) aluminum, steel and stainless steel. Rated at 150 amps, 60% duty cycle with 20 ft (6 m) cable assembly.



**SGA 100  
#043 856**  
Miller's exclusive spool gun adapter

is dedicated to the Spoolmate 3035 spool gun and is rated at 150 A at 60% duty cycle. Comes with 10 ft (3 m), 115 VAC power cable and plug, 6 ft (1.8 m) inter-connecting cable and 5 ft (1.5 m) gas hose.



**Spoolmate™ Curved Barrel Assembly  
#198 371**



**Spoolmate™ 9 in Straight Barrel Assembly  
#198 372**



**Running Gear/ Cylinder Rack #770 187**  
Heavy-duty construction. For gas cylinders no larger than 7 in (178 mm) diameter, maximum weight 100 lb (45 kg).



**Small Running Gear/Cylinder Rack  
#194 776**

Durable construction. For gas cylinders no larger than 7 in (178 mm) diameter, maximum weight 75 lb (34 kg).

**Purchase the Millermatic 135 package (#907 048) and receive Millermatic 135 and Small Running Gear/Cylinder Rack (#194 776) packaged together!**

## Consumables (Order from Miller Service Parts.)

### For M-10 Gun



#### Contact Tips

**#087 299** .023/.025 in (0.6 mm)  
**#000 067** .030 in (0.8 mm)  
**#000 068** .035 in (0.9 mm)  
**#000 069** .045 in (1.2 mm)



**Contact Tip Adapter #169 716**



#### Replacement Liners

**#194 010** .023/.025 in  
**#194 011** .030–.035 in (standard)  
**#194 012** .035–.045 in



**Nozzle #169 715**

1/2 in (13 mm) diameter orifice. Nozzle flush with contact tip (standard).

#### Spot Nozzles

**#176 237** Flat  
**#176 239** Inside corner  
**#176 241** Outside corner

#### Gun Convenience Kit #193 973

Contains:

3 – .025 in (0.6 mm) contact tips (#087 299)  
5 – .030 in (0.8 mm) contact tips (#000 067)  
5 – .035 in (0.9 mm) contact tips (#000 068)  
2 – Tip adapters (#169 716)  
3 – O-rings (#170 471)  
2 – Shock washers (#169 717)  
1 – 1/2 in (13 mm) diameter orifice nozzle (#169 715)



#### Drive Rolls — Quick Change Dual Groove, V-Smooth #202 925

For .023/.025, .030 and .035 in (0.6, 0.8 and 0.9 mm) wire.

#### Dual Groove, V-Knurl #202 926

For .030/.035 in (0.8/0.9 mm) or .045 in (1.2 mm) flux cored wire.

### For Spoolmate™ 3035 Gun



#### Contact Tips (5 per package)

**#199 730** For .023 in (0.6 mm) wire.  
**#186 419** For .030 in (0.8 mm) wire.  
**#186 409** For .035 in (0.9 mm) wire.



**Nozzle #186 405**



#### Drive Roll (1)

**#199 731**  
For .023 in (0.6 mm) wire  
**#186 413**  
For .030/.035 in (0.8/0.9 mm) wire.



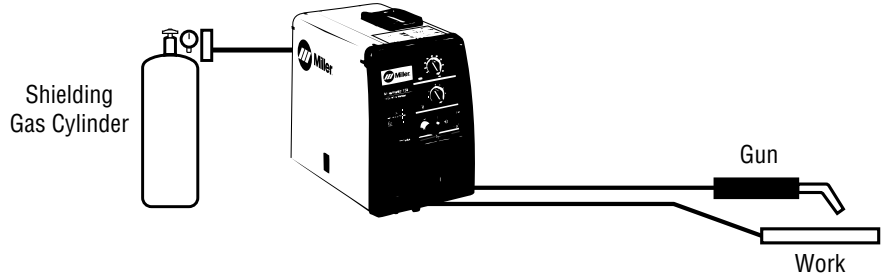
#### Push Roll (1)

**#199 732**  
For .023 in (0.6 mm) wire  
**#186 414**  
For .030/.035 in (0.8/0.9 mm) wire.

# Typical Installations



**MIG (GMAW) or Flux Cored (FCAW)  
Basic Equipment**



## Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>Millermatic® 135</b>	<b>#907 019</b>	115 V, 60 Hz		
<b>Millermatic® 135 with #194 776 Running Gear</b>	<b>#907 048</b>	Both items packaged together		
<b>Guns</b>				
M-10 Gun	<b>#195 605</b>	10 ft (3 m), .030–.035 in (0.8–0.9 mm)		
Spoolmate™ 3035	<b>#195 016</b>	Spool gun for aluminum		
SGA 100	<b>#043 856</b>	Spool gun adapter for Spoolmate 3035		
Spoolmate™ Curved Barrel Assembly	<b>#198 371</b>			
Spoolmate™ 9 in Straight Barrel Assembly	<b>#198 372</b>			
<b>Consumables</b> (Order from Miller Service Parts.)				
Contact Tips				
Contact Tip Adapter				
Replacement Liners				
Nozzles				
Spot Nozzles				
Gun Convenience Kit	<b>#193 973</b>			
Drive Rolls				
Push Roll				
<b>Accessories</b>				
Running Gear/Cylinder Rack	<b>#770 187</b>			
Small Running Gear/Cylinder Rack	<b>#194 776</b>			
Flux Cored Wire				
Solid Wire				
Shielding Gas Cylinder				
Helmet/Gloves/Scratch Brush				

Date:

Total Quoted Price:

Distributed by:

