

# Millermatic® Pulser

Issued January 2003 • Index No. DC/12.55

**MIG Arc Welding  
Power Source** 

## Quick Specs

### Industrial Applications

Light Fabrication  
Garages/Body Shops  
Maintenance and Repair  
(Boat, Aircraft, etc)  
Farm/Ranch  
Sign Shops

### Processes

MIG (GMAW)  
Pulsed MIG (GMAW-P)  
Flux Cored (FCAW)

**Rated Output** 160 Amps at 26 VDC, 60% Duty Cycle  
200 Amps at 24 VDC, 30% Duty Cycle

**Amperage Range** 30–200 Amps

**Max. Open-Circuit Voltage** 36

**Weight** 225 lb (102 kg)

## The Power of Blue.®

**Industrial quick-change drive system — no tools required!** Dual gear-driven drive rolls are easy to change and powered by the largest drive motor in its class. The industrial, cast aluminum wire drive assembly also features an easy-to-set tension adjustment knob with scale for consistent settings.

**User-friendly unit adds only one control dial for pulsing** requiring less operator experience and skill than other pulse welders.

**Patented pulsed MIG power supply** reduces burn through and minimizes distortion while providing good fusion on thin-gauge aluminum.

**Two regulators and gas hoses** for reduced process switch-over time.

**Spoolmate™ 3035 spool gun** provides reach and accessibility with smooth feeding of aluminum wire.

**Built-in dual gun/cable holder** for your MIG gun, spool gun and cables.



### Comes Complete With:

- Power source
- Power cord
- 12 ft (3.7 m), 150 amp M-15 MIG gun for .030/.035 in wire
- Spoolmate 3035 spool gun
- Work cable and clamp
- Two Argon mix regulator/flow gauges and hoses
- Factory-installed dual gas solenoids with hoses
- Extra contact tips
- Factory-installed running gear with dual cylinder rack

Capable of welding 19 gauge to 3/8 in (1.0–9.5 mm) aluminum, 22 gauge to 3/8 in (0.8–9.5 mm) steel, and 20 gauge to 3/8 in (1.0–9.5 mm) stainless steel in a single pass

**Durable 12 ft, M-15 MIG gun** is molded from a virtually unbreakable, lightweight resin. The rugged uncable outer jacket stands up to the toughest environments, and the trigger switch is rated for 1 million cycles. Steel spring coils on both cable ends protect the cable from fatigue.



**TRUE BLUE**  
3YR. 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**  
APPLETON, WI 



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

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International FAX: 920-735-4125

**Web Site**  
www.MillerWelds.com



# Specifications (Subject to change without notice.)

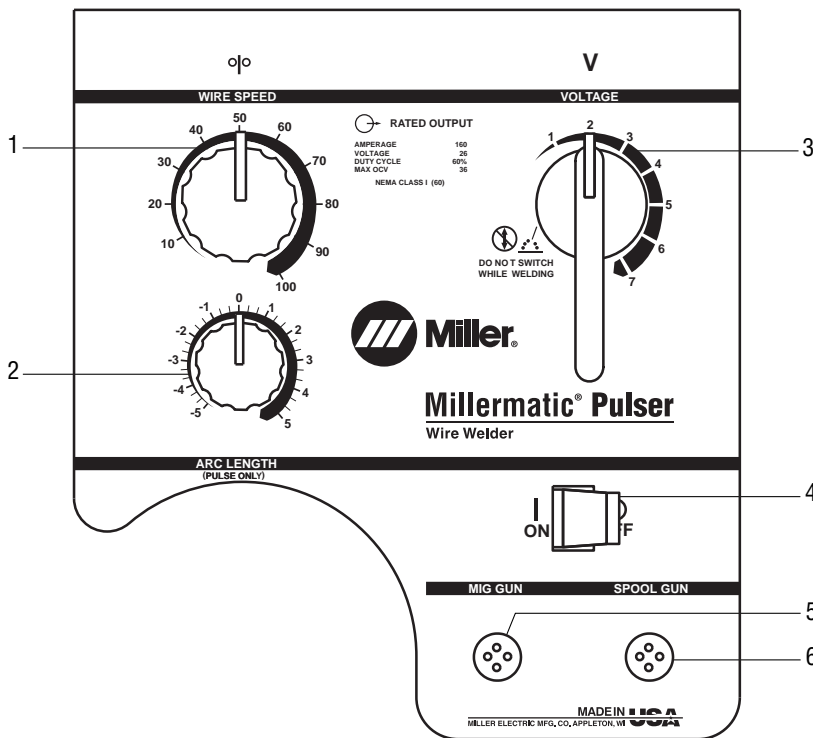
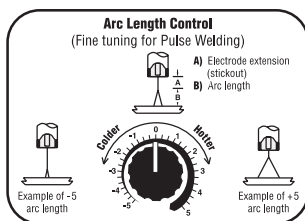


Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz					Wire Feed Speed	Dimensions	Net Weight
			200 V	230 V	240 V	KVA	KW			
160 A at 26 VDC, 60% Duty Cycle 200 A at 24 VDC, 30% Duty Cycle	30-200	36	32	28	27	6.4	5.5	<b>Spoolmate 3035:</b> 115-715 IPM <b>M-15:</b> 25-700 IPM	H: 32 in (813 mm) W: 26 in (660 mm) D: 46 in (1168 mm)	225 lb (102 kg)

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

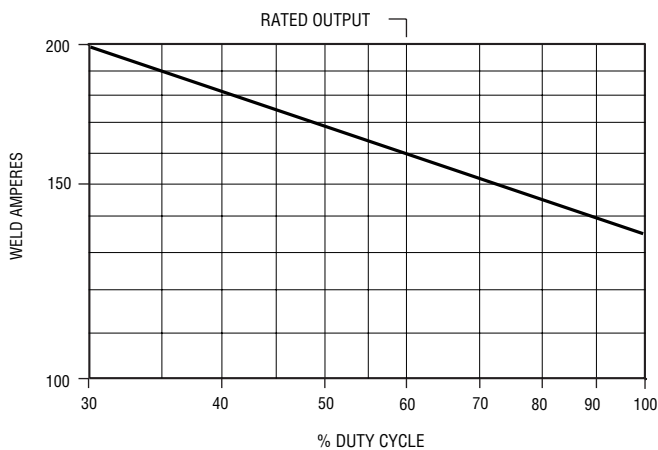
## Control Panel

1. Wire Speed Control
2. Arc Length Control
3. Voltage Control
4. Power Switch
5. MIG Gun Receptacle
6. Spool Gun Receptacle

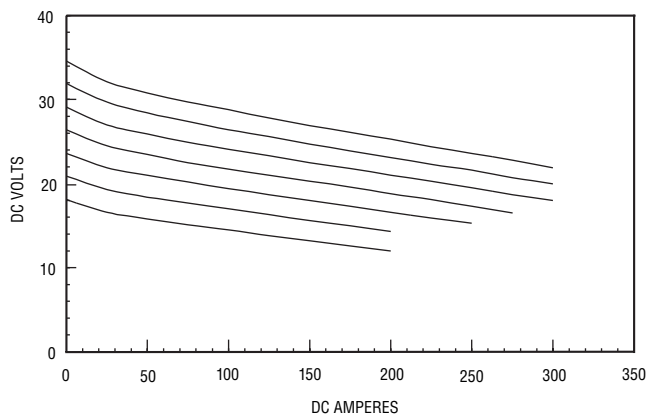


## Performance Data

DUTY CYCLE CHART



VOLT/AMP CURVES



## Genuine Miller Accessories

### M-15 Replacement Gun

#169 589 10 ft (3 m)

#169 591 12 ft (3.7 m) Standard

Guns shipped to run .030–.035 in (0.8–0.9 mm) wire.

### Spoolmate 25 ft Extension Cable Kit

#194 996



Miller<sup>®</sup> Protective Cover with  
Helmet Bag #195 142

### CO<sub>2</sub> Regulator/Flow Gauge #212 492

Required if using 100% CO<sub>2</sub> gas.

## Consumables (Order from Miller Service Parts.)

### For M-15 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 (1.1 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 nozzle models include (from left to right): outside corner, inside corner and flat.

#### 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)

2 – Shock washers (#169 717)

3 – O-rings (#170 471)

1 – 1/2 in (13 mm) diameter orifice nozzle (#169 715)

### Drive Rolls

Note: Drive roll kits include two drive rolls and an inlet guide.

#### V-Grooved Drive Roll Kits

#087 131 .023/.025 in (0.6 mm)

#079 594 .030 in (0.8 mm)

#079 595 .035 in (0.9 mm)

#079 596 .045 in (1.2 mm)

#### V-Knurled Drive Roll Kits

#079 606 .035 in (0.9 mm)

#079 607 .045 in (1.2 mm)

For more information on gun consumables, see literature sheet Index No. M/10.0.

### 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.

#186 406 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. Standard.



#### Push Roll (1)

#199 732 For .023 in (0.6 mm) wire.

#186 414 For .030/.035 in (0.8/0.9 mm) wire. Standard.

For more information on the Spoolmate 3035, see literature sheet Index No. M/1.5.

# Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>Millermatic® Pulser</b>	<b>#903 857</b> <b>#907 074</b>	200(208)/230/240 V, 60 Hz with Spoolmate 3035 460/575 V		
<b>Guns</b>				
M-15 Gun	<b>#169 589</b> <b>#169 591</b>	10 ft (3 m), .030–.035 in (0.8–0.9 mm) 12 ft (3.7 m), .030–.035 in (0.8–0.9 mm)		
Spoolmate™ 3035	<b>#195 016</b>	Spool gun for aluminum		
Spoolmate™ 25 ft Extension Cable Kit	<b>#194 996</b>			
<b>Accessories</b>				
Protective Cover with Helmet Bag	<b>#195 142</b>			
CO <sub>2</sub> Regulator/Flow Gauge	<b>#212 492</b>	Required if using 100% CO <sub>2</sub> gas		
Electrode Wire				
Shielding Gas Cylinder				
Helmet/Gloves/Scratch Brush				
<b>Consumables (Order from Miller Service Parts.)</b>				
Contact Tips				
Contact Tip Adapter				
Replacement Liners				
Nozzles				
Spot Nozzles				
Gun Convenience Kit	<b>#193 973</b>			
Drive Rolls				

Date:

Total Quoted Price:



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