

Maxstar® 200 Series

Issued October 2003 • Index No. DC/32.0

TIG/Stick Welding
Power Source 

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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Specifications (Subject to change without notice.)



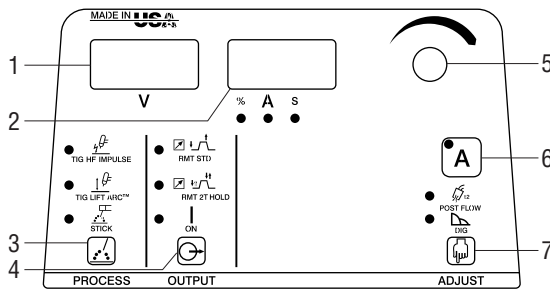
Welding Mode	Input Power	Rated Output	Welding Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 50/60 Hz,								Dimensions	Net Weight		
					115 V	200 V	230 V	400 V	440 V	460 V	KVA	KW				
TIG (GTAW)	3-Phase	175 A at 17 V, 60% Duty Cycle	115 VAC, 1–140 A 200–460 VAC, 1–200 A	75 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			—	19.9	17.4	—	—	—	4.0	4.0			0.05*	0.02*
		150 A at 16 V, 70% Duty Cycle			29.7	—	—	—	—	—	3.4	3.4			0.05*	0.03*
		125 A at 15 V, 100% Duty Cycle			23.0	—	—	—	—	—	2.6	2.6			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			—	24.9	21.7	—	—	—	5.0	5.0			0.05*	0.02*
		125 A at 25 V, 50% Duty Cycle			34.1	—	—	—	—	—	4.0	3.8			0.05*	0.03*
		90 A at 24 V, 100% Duty Cycle			25.0	—	—	—	—	—	4.0	3.8			0.05*	0.03*

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

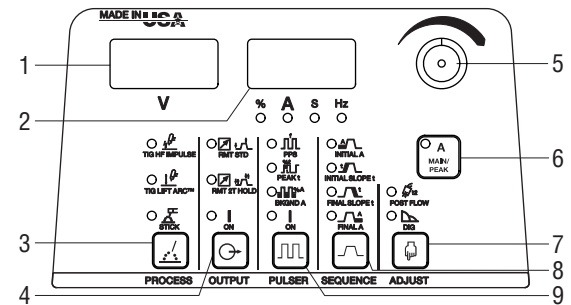
CSA approval. Models with CE specifications are available and manufactured according to the Standards IEC-974-1 and EN-60974-1.

Control Panel

Maxstar 200 SD

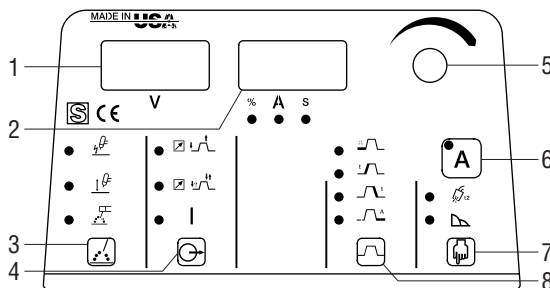


Maxstar 200 DX/LX

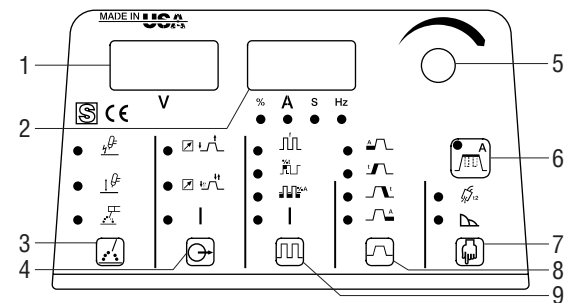


1. Voltmeter
2. Ammeter
3. Process Control
4. Output Control
5. Encoder Control
6. Amperage Control
7. Adjust Control
8. Sequencer Controls
9. Pulser Controls

Maxstar 200 SD (CE)



Maxstar 200 DX (CE)

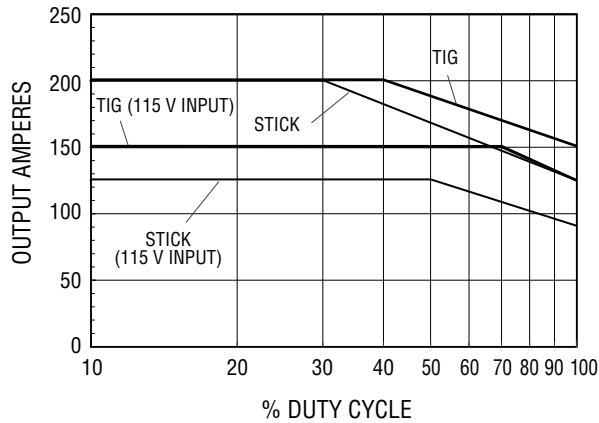


Control Panel Parameter Values

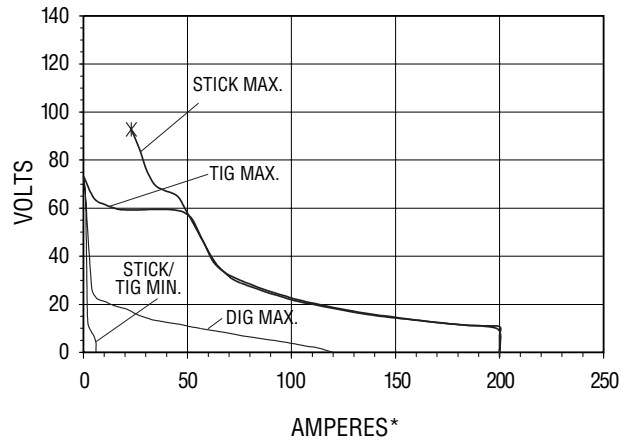
A. Preflow (s)	0.0–25	F. Pulse Frequency (Hz)	0.1–500	K. Final Time (s)	0.0–25 (LX only)
B. Initial Time (s)	0.0–25 (LX only)	G. Background Amperage (%)	0–100	L. Postflow Time (s)	0–0.50
C. Initial Amperage (A)	1–200	H. Peak Percent Time (%)	5–95	M. Dig (%)	0–100
D. Initial Slope Time (s)	0.0–25	I. Final Slope Time (s)	0.0–25		
E. Weld Amperage (A)	1–200	J. Final Amperage (A)	1–200		

Performance Data

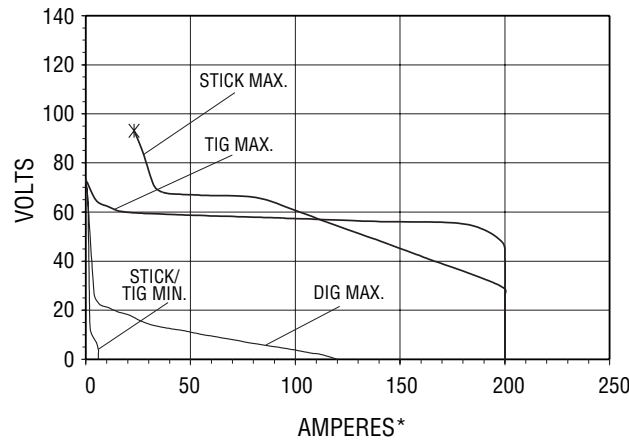
DUTY CYCLE CHART



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	DA-917F		
	#190 219	DA-1820L		
	#194 724	DA-26R		
Contractor Kits	#195 055	150 A TIG/Stick with RCCS-14 fingertip control		
	#195 054	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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