

XMT® 425

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)
Stick (SMAW)
TIG (GTAW)
Flux-cored (FCAW)
Air carbon arc cutting and gouging (CAC-A)
Rated: 1/4-inch carbons
Capable: 5/16-inch carbons

Input Power

Auto-Line™, 208–575 V,
requires 3- or 1-phase power

Output Range

10–38 V, 15–425 A

Net Weight

80 lb. (36.3 kg)

Portability and excellent arc performance make the XMT family the most popular in the industry.

With multiprocess capabilities and features like Auto-Line, the XMT 425 is portable and versatile for applications from jobsites to the factory floor.



Input power management for portability



Lightweight and portable



Best multiprocess capabilities



Power source is warrantied for three years, parts and labor.
Original main power rectifier parts are warrantied for five years.



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XMT® 425 CC/CV Features

Versatility



For portability and reliability, Auto-Line allows for any input voltage hookup (208–575 V, single- or three-phase) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

14-pin receptacle has the flexibility to be used with spool guns, feeders, and remote controls.

Insight Core™

Optional Welding Intelligence™ system. XMT 425 CC/CV is Insight-capable to monitor weld voltage, amperage, and arc-time and percentage.

Multiprocess weld quality

High-quality performance in all welding processes.

Adaptive Hot Start™ makes starting stick electrodes easy without creating an inclusion.

Infinite arc control available in the stick and wire modes for easier fine tuning of tough-to-weld materials and out-of-position applications.

Lift-Arc™ provides arc starting that minimizes contamination of the electrode and without the use of high-frequency.



Welder friendly control panel

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.

Ultra-tough, polycarbonate-blended cover protects front controls from damage.

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.

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

Portability

Jobsite mobility is made easy with a small, compact design and Auto-Line technology.

Reliability

Wind Tunnel Technology™ Internal air flow that protects electrical components and PC boards from dirt, dust and debris... greatly improving reliability.

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

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

Dinse-style weld disconnects provide high-quality weld cable connections.

Note: Two Dinse-style connectors are supplied with each Dinse machine.

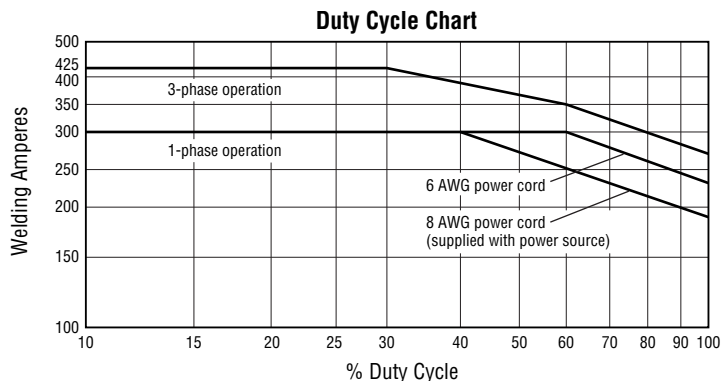
Specifications (Subject to change without notice.)



Input Power	Voltage Range in CV Mode	Amperage Range in CC Mode	Rated Output at 60% Duty Cycle	Amps Input at Rated Load Output, 60 Hz							Max. Open-Circuit Voltage	Dimensions	Net Weight
				208 V	230 V	400 V	460 V	575 V	KVA	KW			
Three-phase	10–38 V	5–425 A	350 A at 34 VDC	40.4	36.1	20.6	17.8	14.1	14.2	13.6	75 VDC	H: 17 in. (432 mm) W: 12.5 in. (318 mm) D: 24 in. (610 mm)	80 lb. (36.3 kg)
Single-phase	10–38 V	5–425 A	300 A at 32 VDC	60.8	54.6	29.7	24.5	19.9	11.7	11.2			

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

Performance Data



Genuine Miller® Accessories



MIGRunner™ Cart 195445
For single feeders. Small footprint and easily maneuverable, with dual-cylinder rack low enough that you do not have to lift bottles. Durable ergonomic handles are designed for comfort.

Note: Not compatible with dual wire feeders.



Running Gear Cylinder Rack 300408
For single or dual feeders. Holds two large gas cylinders and has gun cable hangers and a consumable drawer in front. A convenient handle allows the cart to be pulled

easily through doorways. Power source and single or dual feeders can be mounted to cart and secured.



MIG kit 300405 shown.

Industrial MIG 4/0 Kit with Dinse Connectors 300405 For single feeders
300956 For dual feeders
Consists of flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable, and 15-foot (4.6 m) work cable with 600-amp C-clamp. Dual kit comes with two flowmeter regulators and gas hoses.

Remote Controls



Wireless Remote Foot Control 300429
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 300430
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 HD Foot Control 194744
Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.



RHC-14 Hand Control 24221020
20-foot (6 m) cord
24221100
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.



RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.



RCCS-14 Remote Contactor and Current Control 043688
North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

Extension Cables for Remote Controls and 24 VAC Wire Feeders

242208025 25 ft. (7.6 m)
242208050 50 ft. (15 m)
242208080 80 ft. (24.3 m)
14-pin plug to 14-pin socket. Not for use with 70 Series MPa Plus feeders.

Wire Feeders/Guns



ArcReach® SuitCase® 8 301457
ArcReach® SuitCase® 12 301456
Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money.



SuitCase® 12RC 301121
Lightweight, portable wire feeder for a variety of wires up to .062 inch. Holds up to a 12-inch spool of wire.



70 Series S-74S 300616
S-74D 300617
Features Posifeed™ wire drive assembly and handles a variety of wires up to 1/8 inch.



70 Series MPa Plus S-74 MPa Plus 300577
D-74 MPa Plus 300578
Same features as traditional 70 Series plus more. Handles a variety of wires up to 5/64 inch.

Extension Cables

247831025 25 ft. (7.6 m)
247831050 50 ft. (15.2 m)
247831080 80 ft. (24.4 m)
Eleven conductors to support contactor control and remote voltage control on all Miller® electronic CV 14-pin power sources. Additional functions supported when using MPa power sources include synergic pulsed MIG, remote process select and side select capabilities.



Spoolmatic® 30A 130831
A one-pound, air-cooled spool gun that extends 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. *Requires WC-24 (137549), order separately. For use with Miller CV power sources with 14-pin receptacles and supplying 24 VAC.*

Welding Intelligence™



Insight Core™ 14-pin Module 301072
Easy-to-install module brings Insight Core capabilities to your existing fleet. This simplified, Internet-based weld data solution collects, transmits and presents actionable information to any Web-connected device. Insight Core can help you increase productivity, improve weld quality and manage costs.

Genuine Miller® Accessories (Continued)

Cable Connectors and Adapters

Note: XMT 425 CC/CV power source is equipped with Dinse-style connectors for secondary connections.

Dinse-Style Connectors

042418 Accepts #4 to #1/0 AWG cable

042533 Accepts #1/0 to #2/0 AWG cable

Kits include 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

042419 Accepts #4 to #1/0 AWG cable.

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.

Extensions for Dinse-Style Cable Connectors

134460 Male Dinse-style plug

136600 Female Dinse-style receptacle

Used to adapt or extend weld and/or work cables. Accepts #1/0 to #2/0 AWG cable.

Dinse/Tweco® Adapter 042465

Dinse/Cam-Lok Adapter 042466

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

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
XMT® 425 CC/CV	907386	208–575 V with Auto-Line™		
Gas Valve Kit	195286	For XMT 425 CC/CV		
Accessories				
MIGRunner™ Cart	195445	For single feeders		
Running Gear Cylinder Rack	300408	For dual feeders		
Industrial MIG 4/0 Kit with Dinse Connectors	300405 300956	For single feeders For dual feeders		
Remote Controls				
Wireless Remote Foot Control	300429	Foot control with wireless 90 ft. (27.4 m) operating range		
Wireless Remote Hand Control	300430	Hand control with wireless 300 ft. (91.4 m) operating range		
RFCS-14 HD	194744	Foot control with 20 ft. (6 m) cord and 14-pin plug		
RHC-14	242211020 242211100	Hand control with 20 ft. (6 m) cord Hand control with 100 ft. (30.5 m) cord		
RCC-14	151086	Fingertip control		
RCCS-14	043688	Fingertip control		
Extension Cables (8-conductor)		See page 7		
Wire Feeders/Guns				
ArcReach® SuitCase® 8	301457			
ArcReach® SuitCase® 12	301456			
SuitCase® 12RC	301121			
70 Series	300616 300617	S-74S S-74D		
70 Series MPa Plus	300577 300578	S-74 MPa Plus (single-wire) D-74 MPa Plus (dual-wire)		
Extension Cables (11-conductor)		See page 7		
Spoolmatic® 30A Spool Gun	130831	Requires WC-24 for use with 14-pin receptacles		
WC-24 Weld Control	137549	Required for use with Spoolmatic® 30A and power sources with 14-pin		
Bernard® MIG Guns		See Bernard literature SP-BTB		
Welding Intelligence				
		See page 7		
Cable Connectors and Adapters				
		See above		

Date:

Total Quoted Price:

Distributed by:

