

Miller[®] 212 Auto-Set™

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



Quick Specs

Industrial Applications

Metal fabrication
Maintenance and repair
Farm/home
Light industrial

Processes

MIG (GMAW)
Flux-cored (FCAW)

Input Power

200(208)/230 V, 1-phase, 60 Hz

Amperage Range 30–210 A

Rated Output 160 A at 24.5 VDC, 60% duty cycle

Wire Feed Speed 50–700 ipm (1.3–17.8 m/min.)

Max. Open-Circuit Voltage 34.5 V

Net Weight 178 lb. (81 kg)

Auto-Set™ makes setup quick and easy and works with .030- and .035-inch wire. See page 2 for more information.

Infinite voltage control. When used in manual mode provides broader operating range with finer control than a tap machine.

Line voltage compensation keeps power constant even if power input varies by ±10 percent.

No more replacing mechanical output contactors. Our built-in solid-state contactor circuit makes wire electrically “cold” until trigger is pulled, and gives you life-long welding output and performance.

Gun-On-Demand™ Simply pull the trigger for either gun and you’re ready to weld. No wasted time installing modules and using gas valve kits.

Heavy-duty aluminum, two-drive-roll system.

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

Compatible with Bobcat™ welder/generators.



Comes complete with:

- 15 ft. (4.6 m), 250-amp M-25 MIG gun
- 10 ft. (3 m) work cable with clamp
- 7 ft. (2.1 m) power cord with plug
- Flow gauge regulator and gas hose for argon or AR/CO₂ mix
- Factory-installed lowered running gear/cylinder rack
- .030/.035 in. reversible dual-groove drive rolls
- Extra contact tips
- Material thickness gauge (229895) ➤



EZ-Access™ consumable compartment and parameter chart.

Set weld parameters right the first time with convenient flip-down compartment that provides fast access to parameter chart and consumables. See page 3 for more information.

Aluminum MIG welding with optional Spoolmate™ 200 spool gun.

Wire feed speed control on the gun saves time by reducing trips back to the machine. Also compatible with more industrial Spoolmatic® spool guns.



Welder is warranted for three years, parts and labor.
Original main power rectified parts are warranted for five years.
Gun warranted for 90 days, parts and labor.



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Operation Modes

Auto-Set™ eliminates guesswork and saves you time on setup.

Use Auto-Set when you want the speed, convenience and confidence of preset controls. Simply set the wire diameter, set the material thickness, and go! Auto-Set automatically sets your welder to the proper parameters. It's available when welding mild steel with .030 or .035 solid wires and C25 shielding gas (75 percent argon, 25 percent CO₂).

You can also set the weld parameters manually. Simply refer to the flip-down parameter chart, and set the voltage and wire feed speed to the recommended settings for your application.

Auto-Set™ mode



- Turn wire speed control fully clockwise to select Auto-Set mode. Set the wire diameter to either .030 or .035 inch.

- Light indicates Auto-Set mode is activated.

- Set the material thickness within Auto-Set range for 22 gauge through 3/8-inch mild steel. The welder automatically sets itself to proper parameters, and is ready to weld!

Specifications (Subject to change without notice.)



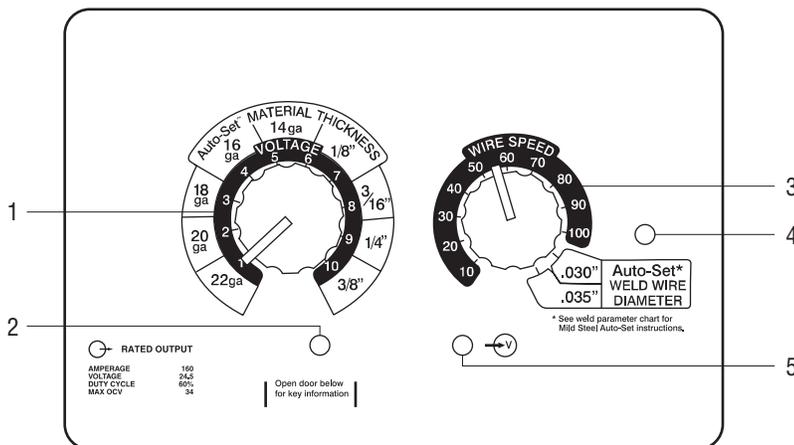
Amperage Range	Rated Output	Amps Input at Rated Output, 60 Hz				Wire Feed Speed	Wire Type and Diameter	Max. Spool Size	Max. Open-Circuit Voltage	Dimensions	Net Weight
		200(208) V	230 V	KVA	KW						
30–210 A	160 A at 24.5 VDC, 60% duty cycle 210 A at 22 VDC, 30% duty cycle	31.2 2.1*	27.1 1.8*	6.36 0.51*	5.45 0.26*	50–700 ipm (1.3–17.8 m/min.)	Solid/stainless steel: .023–.035 in. (0.6–0.9 mm) Flux-cored: .030–.045 in. (0.8–1.2 mm)	12 in. (305 mm)	34.5	H: 30 in. (762 mm) W: 19 in. (483 mm) D: 40 in. (1,016 mm)	178 lb. (81 kg)

*While idling.

Note: Operating temperature range: -4° to +104°F (-20° to +40°C). Storage temperature range: -22° to +122°F (-30° to +50°C).

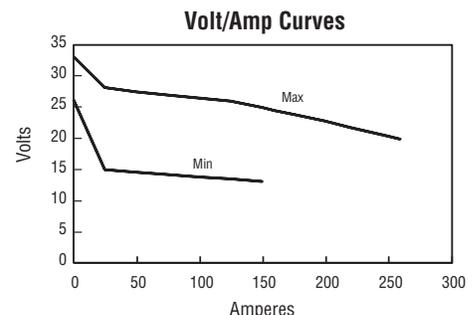
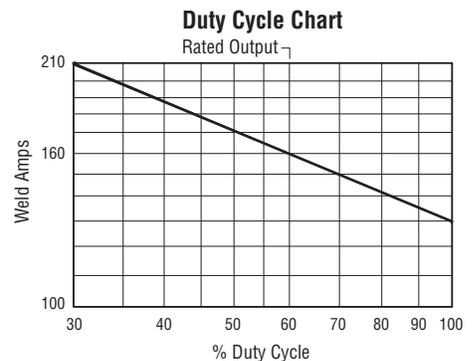
Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Control Panel



1. Infinite Voltage Control/Material Thickness
2. Diagnostic Indicator Light
3. Wire Feed Speed Control/Wire Diameter
4. Auto-Set Light
5. Power On Indicator Light

Performance Data



Standard Fully Loaded Features

EZ-Change™ low cylinder rack

- Operators no longer need to lift cylinders. Cylinders now easily roll on and off our EZ-Change™ low cylinder rack.



Angled wire drive

- Angled industrial aluminum dual-gear drive system significantly improves wire feeding and runs large spools of wire.
- Allows quick change of drive rolls without tools.
- Drive roll storage — no more lost drive rolls, extra drive rolls are conveniently stored next to drive motor.
- Operators no longer bump into and bend MIG gun and gun liner.



Dual front handles

- Split handle with rubber grips designed to move machine easily and allow work lead and MIG gun to be stored independently.
- Handles provide protection for front panel and MIG gun during transportation.



EZ-Access™ consumable compartment and parameter chart

- Convenient flip-down compartment holds parameter chart and storage for consumables.



Optional Fully Loaded Features

Elevated gun and cable rack

300335

- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.
- No more running over spool gun cables or cables dragging on the floor.
- Elevated gun and cable rack can be used with either a single or dual cylinder rack. (Elevated gun and cable rack is included with the dual EZ-Change™ low cylinder rack.)



Dual EZ-Change™ low cylinder rack with elevated gun and cable rack

300337

- Dual cylinder rack allows for easy storage of two cylinders.
- EZ-Change™ low cylinder rack eliminates the need to lift cylinders on and off cylinder rack.
- No more running over spool gun cables or cables dragging on the floor.
- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.



Genuine Miller® Accessories

M-25 Replacement Gun

169594 10 ft. (3 m)
169596 12 ft. (3.7 m)
169598 15 ft. (4.6 m) standard
 Gun shipped to run .030–.035 inch
 (0.8–0.9 mm) wire.



Spoolmate™ 200 Spool Gun 300497

Reliable and economical spool gun perfect for hobbyists and light fabricators who weld aluminum. Handles .030–.035 inch (0.8–0.9 mm) aluminum wires and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 160 amps, 60 percent duty cycle with 20-foot cable assembly. For detailed information, see Spoolmate literature M/1.47.



Spoolmatic® 15A Spool Gun 195156 Spoolmatic® 30A Spool Gun 130831

Ideal for aluminum welding jobs. Air-cooled, one-pound spool gun with 15-foot (4.6 m) or 30-foot (9.1 m) cable assembly. Rated at 200 amps at 100 percent duty cycle. For detailed information, see Spoolmatic literature M/1.73.



Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack 300337

Dual cylinder rack allows operators to easily roll cylinders on and off the rack with no lifting. Gun and cable rack keeps cables off the floor and tangle free.

Elevated Gun and Cable Rack 300335

For use with single cylinder rack. *(Included with dual EZ-Change low cylinder rack.)*



Protective Cover 195142

Features side pocket.
(Not for use with dual cylinder rack or elevated gun and cable rack.)

Argon/Mixed Gas Regulator and Gas Hose 195050

(Order from Miller Service Parts.)



Female Receptacle 

Full KVA Adapter Cord 300517 Field NEMA 14-50P to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.

Consumables (Order from Miller Service Parts.)

Millermatic® Drive Roll Kits

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

V-Grooved Drive Roll Kits (solid wire)

204579 .030 and .035 in.
(0.8 and 0.9 mm)
combination (reversible)

087131 .024 in. (0.6 mm)

079594 .030 in. (0.8 mm)

079595 .035 in. (0.9 mm)

V-Knurled Drive Roll Kits

(flux-cored or difficult-to-feed wire)

079606 .035 in. (0.9 mm)



M-Series Consumable Kits

234610 .030 in. (0.8 mm)

234611 .035 in. (0.9 mm)

234612 .045 in. (1.2 mm)

Contains ten contact tips, one nozzle, one contact tip adapter and one nozzle adapter.

For M-25 Gun



Contact Tips

087299 .024 in. (0.6 mm)

000067 .030 in. (0.8 mm)

000068 .035 in. (0.9 mm)

000069 .045 in. (1.2 mm)

187117 .035 in. (0.9 mm) heavy-duty tip

187118 .045 in. (1.2 mm) heavy-duty tip

Tapered Contact Tips

176797 .030 in. (0.8 mm)

176793 .035 in. (0.9 mm)

176794 .045 in. (1.2 mm)



Contact Tip Adapter 169728



Replacement Liners

194010 .024 in.

194011 .030–.035 in. (standard)

194012 .035–.045 in.

15-foot length — trim to size needed.

Nozzles

Note: Flush or stickout nozzles should be used for the short-circuit process. Recessed nozzles should be used for the spray arc process.

200258 (standard)

1/2-inch (13 mm) diameter orifice. Nozzle flush with contact tip.

169726

5/8-inch (16 mm) diameter orifice. Nozzle flush with contact tip.

169727

5/8-inch (16 mm) diameter orifice. Contact tip sticks out of nozzle 1/8 inch (3.2 mm).

169724

1/2-inch (13 mm) diameter orifice. Contact tip recessed 1/8 inch (3.2 mm) into nozzle.

169725

5/8-inch (16 mm) diameter orifice. Contact tip recessed 1/8 inch (3.2 mm) into nozzle.

Tapered Nozzles

Note: Tapered tips are recommended when using a tapered nozzle.

176243

3/8-inch (9.5 mm) diameter orifice.

178386

11/32-inch (8.7 mm) diameter orifice.

Nozzle Adapter 169729

Ordering Information

Steel Configuration	Stock No.	Description	Qty.	Price
Millermatic® 212 Auto-Set™	907405	200(208)/230 V, 60 Hz		
Millermatic V-Grooved Drive Roll Kits (solid wire)	087131	.024 in. (0.6 mm)		
	079594	.030 in. (0.8 mm)		
	079595	.035 in. (0.9 mm)		
	204579	.030/.035 in. (0.8/0.9 mm)		
Millermatic V-Knurled Drive Roll Kits (flux-cored)	079606	.035 in. (0.9 mm)		
	079607	.045 in. (1.2 mm)		
Contact Tips (10 per package)	087299	.024 in. (0.6 mm)		
	000067	.030 in. (0.8 mm)		
	000068	.035 in. (0.9 mm)		
	000069	.045 in. (1.2 mm)		
Nozzles	200258	1/2 in. (13 mm) diameter, flush <i>(included with standard configuration)</i>		
	169726	5/8 in. (16 mm) diameter, flush		
	169727	5/8 in. (16 mm) diameter, 1/8 in. (3.2 mm) exposed		
	169724	1/2 in. (13 mm) diameter, 1/8 in. (3.2 mm) recessed		
	169725	5/8 in. (16 mm) diameter, 1/8 in. (3.2 mm) recessed		
M-Series Gun Consumable Kits (for M-25)	234610	.030 in. (0.8 mm)		
	234611	.035 in. (0.9 mm)		
	234612	.045 in. (1.2 mm)		

Aluminum Configuration *For M-25 gun consumables and Millermatic 212 Auto-Set drive rolls, see steel configuration chart above.*

Millermatic® 212 Spool Gun Package (includes standard M-25 MIG gun)	951177	200(208)/230 V, 60 Hz with Spoolmate™ 200, dual cylinder rack, elevated gun and cable rack, regulator and hose		
Spoolmate 200 Contact Tips (5 per package)	199730	.023 in. (0.6 mm) wire <i>(requires V-knurled drive roll 136135)</i>		
	186419	.030 in. (0.8 mm) wire		
	186406	.035 in. (0.9 mm) wire		
Spoolmate 200 Nozzle	186405			
Optional Spoolmate 200 Barrel Assemblies	300591	45-degree barrel		
	300592	9 in. extension barrel		
	300593	Heavy-duty barrel		

Accessories

M-25 Gun	169594	10 ft. (3 m), .023–.035 in. (0.6–0.9 mm)		
	169596	12 ft. (3.7 m), .023–.035 in. (0.6–0.9 mm)		
	169598	15 ft. (4.6 m), .023–.035 in. (0.6–0.9 mm)		
Spoolmate 200	300497	20 ft. (6 m), 160 A, .030–.035 in. (0.8–0.9 mm) for aluminum, .023–.035 in. (0.6–0.9 mm) for steel/stainless steel wires		
Spoolmatic® 15A	195156	15 ft. (4.6 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum		
Spoolmatic® 30A	130831	30 ft. (9 m), 200 A, .023–1/16 in. (0.6–1.6 mm) for aluminum		
Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack	300337			
Elevated Gun and Cable Rack	300335	For use with single cylinder rack <i>(included with dual EZ-Change low cylinder rack)</i>		
Protective Cover	195142	Features side pocket		
Argon/Mixed Gas Regulator and Gas Hose	195050	<i>Order from Miller Service Parts</i>		
Full KVA Adapter Cord	300517			

Date:

Total Quoted Price:

Distributed by:

