

# Millermatic® 212 Auto-Set™

Issued Sept. 2009 • Index No. DC/12.46

**MIG Arc Welding  
Power Source**



## Quick Specs

### Industrial Applications

Metal Fabrication  
Maintenance and Repair  
Farm/Home  
Light Industrial

### Processes

MIG (GMAW)  
Flux Cored (FCAW)

### Input Power

208/230 V, 1-Phase, 60 Hz

**Rated Output** 160 A at 24.5 VDC, 60% Duty Cycle

**Max. Open-Circuit Voltage** 34.5 VDC

**Amperage Range** 30 – 210 A

**Wire Feed Speed** 50–700 IPM (1.3–17.8 m/min)

**Weight** 178 lb (81 kg)

## The Power of Blue.®

**Auto-Set™** is a breakthrough control that automatically sets your welder to the proper parameters.

Auto-Set makes set up very simple and gives you precise settings instantly. See page 2 for details.

**Manual Mode** allows you to manually set weld parameters for broader applications.

**Infinite voltage control** replaces “tap” settings which means that you now can “dial in” precise weld voltage and wirefeed speed when using the Manual Mode.

### **NEW! Compatible with Spoolmate™ 200 spool gun!**

The Spoolmate 200 with wirefeed speed control on the gun saves time for the operator by eliminating the need to go back to the machine to change the spool gun wirefeed speed.



**Line Voltage Compensation** keeps welding output constant even if power input varies by +/- 10%.

**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.

**Reduce Maintenance and Operating Costs** with our **Fan-On-Demand™** cooling system only operates when needed, reducing power consumption and contaminants drawn into the machine.

Compatible with Bobcat™ welder/generators.



### Comes Complete With:

- 7 ft (2.1 m) power cord and plug (208/230 V model only)
- 15 ft (4.6 m), 250 amp M-25 MIG gun for .030/.035 in wire
- 10 ft (3 m) work cable and clamp
- Argon mix regulator/flow gauge and hose
- Extra contact tips
- Factory-installed running gear with EZ-Change™ Low Cylinder Rack
- .030/.035 in reversible drive rolls
- Set-up and operation interactive CD
- Material thickness gauge (#229 895) ➤



**EZ-Access™ Consumable Compartment and Parameter Chart** — with convenient new flip-down compartment that provides fast access to parameter chart and consumables. [See page 3 for more information.](#)

**NEW! Compatible with the Millermatic® Reach Wire Feeder.** MIG Gun sold separately. (See page 5 for more information.)



**TRUE BLUE**  
3 YR. WARRANTY

Welder 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 **USA**



### Miller Electric Mfg. Co.

An Illinois Tool Works Company  
1635 West Spencer Street  
Appleton, WI 54914 USA

### Equipment Sales US and Canada

Phone: 866-931-9730  
FAX: 800-637-2315  
International Phone: 920-735-4554  
International FAX: 920-735-4125

### Web Site

www.MillerWelds.com



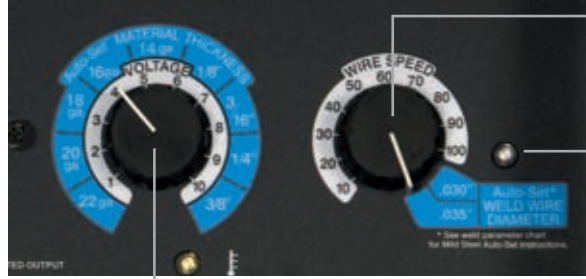
# Auto-Set™ Feature

The Millermatic® 212 Auto-Set™ eliminates the guess work when setting weld parameters.

Use Auto-Set when you want the speed, convenience and confidence of pre-set controls. Simply set the wire diameter, set the material thickness, and go! The Auto-Set control automatically sets your welder to the proper parameters. It is available when welding mild steel with solid wire and only works with .030 and .035 Argon, 25% CO<sub>2</sub>.

When not within the Auto-Set profiles, use the manual mode to set the weld parameters you desire. The parameter flip chart lists voltage and wire feed speed settings options.

## Auto-Set Mode



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

- Turn wire speed control fully clockwise to select Auto-Set mode. Set the wire diameter to either .030 or .035 in.
- Light indicates Auto-Set mode is activated.

## Specifications (Subject to change without notice.)



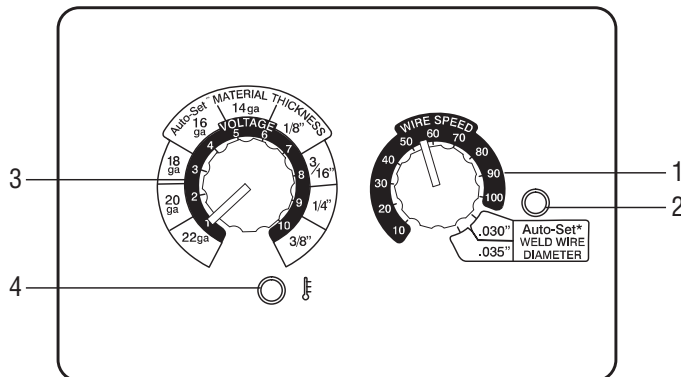
Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz				Wire Type and Diameter	Wire Feed Speed	Max. Spool Size	Dimensions	Net Weight
			200(208) V	230 V	KVA	KW					
160 A, 24.5 VDC at 60% Duty Cycle 210 A, 22 VDC at 30% Duty Cycle	30–210 A	34.5	31.2 2.1*	27.1 1.8*	6.36 0.51*	5.45 0.26*	<b>Solid/Stainless Steel:</b> .023–.035 in (0.6–0.9 mm) <b>Flux Cored:</b> .030–.045 in (0.8–1.2 mm)	50–700 IPM (1.3–17.8 m/min)	12 in (305 mm)	H: 30 in (762 mm) W: 19 in (483 mm) D: 40 in (1016 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)

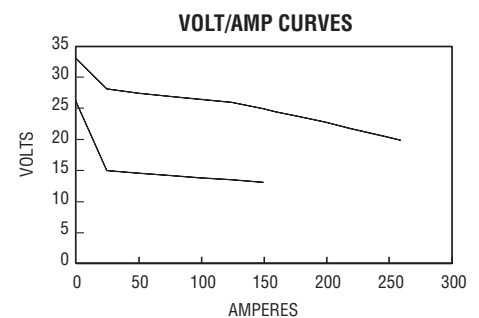
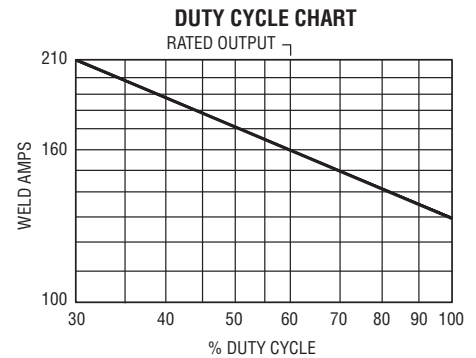
Certified to both the Canadian and U.S. Standards for welding equipment.

## Control Panel



1. Wire Feed Speed Control
2. Auto-Set Light
3. Infinite Voltage Control
4. Over Temperature Light

## Performance Data



# Standard Fully Loaded Features

## EZ-Change™ Low Cylinder Rack

- Patent-pending design — 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 wirefeeding 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

- Exclusive 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

#300 335

- 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

#300 337

- Dual cylinder rack allows for easy storage for 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

#169 594 10 ft (3 m)

#169 596 12 ft (3.7 m)

#169 598 15 ft (4.6 m) standard

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



### NEW! Spoolmate™ 200 Spool Gun #300 497

Reliable and economical spool gun perfect for hobbyists and light fabricators who weld aluminum. Handles .030–.035 in (0.8–0.9 mm) aluminum and .023–.035 in (0.6–0.9 mm) steel/stainless steel wires. Rated at 160 amps, 60% duty cycle with 20 ft cable assembly. For detailed information, see Spoolmate literature, Index No. M/1.47.



**Spoolmatic® 15A Spool Gun #195 156**

**Spoolmatic® 30A Spool Gun #130 831**

Ideal for aluminum welding jobs. 200 amp, 100% duty cycle, air-cooled, 1 lb spool gun with your choice of 15 ft or (4.6 m) 30 ft (9.1 m) cable assembly. For detailed information, see Spoolmatic literature, Index No. M/1.2.



### NEW! Millermatic Reach

#907 437 6 ft (1.8 m)

#907 438 25 ft (7.6 m)

Extend your Millermatic work envelope up to 40 feet! No more moving the machine and pulling primary power cables around the shop. Or use as a dual feeder option! No more downtime changing spools and drive rolls. For use with Millermatic 212 Auto-Set, 251, 252 and 350/350P. (MIG Gun sold separately.)



### Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack #300 337

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 #300 335

For use with single cylinder rack. (Included with Dual EZ-Change Low Cylinder Rack.)



### Protective Cover #195 142

Features side pocket.

(Not for use with Dual Cylinder Rack or Elevated Gun and Cable Rack.)

### Argon/Mixed Gas Regulator and Gas Hose #195 050

(Order from Miller Service Parts.)

### CO<sub>2</sub> Regulator/Flow Gauge #237 702

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

(Order from Miller Service Parts.)

## For M-25 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)
- #187 117 .035 in (0.9 mm) heavy-duty tip
- #187 118 .045 in (1.2 mm) heavy-duty tip

### Tapered Contact Tips

- #176 797 .030 in (0.8 mm)
- #176 793 .035 in (0.9 mm)
- #176 794 .045 in (1.2 mm)



Contact Tip Adapter #169 728



### Replacement Liners

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



### Nozzles

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

#### #200 258 Standard

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

#### #169 726

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

#### #169 727

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

#### #169 724

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

#### #169 725

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

### Spot Nozzles

- #176 238 Flat
- #176 240 Inside corner
- #176 242 Outside corner

### Tapered Nozzles

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

- #176 243 3/8 in (9.5 mm) diameter orifice
- #178 386 11/32 in (8.7 mm) diameter orifice



### Consumable Kits

- #234 610 .030 in (0.8 mm)
  - #234 611 .035 in (0.9 mm)
  - #234 612 .045 in (1.2 mm)
- Contains 10 contact tips, 1 nozzle, 1 contact tip adapter, and 1 nozzle adapter.

## Drive Rolls

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

### V-Grooved Drive Roll Kits (solid wire)

- #204 579 .030 & .035 in (0.8 & 0.9 mm) Combination (Reversible)

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

- #079 594 .030 in (0.8 mm)

- #079 595 .035 in (0.9 mm)

### V-Knurled Drive Roll Kits

(Flux Cored or difficult-to-feed wire)

- #079 606 .035 in (0.9 mm)



# Ordering Information

## Steel Configuration

	Stock No.	Description	Qty.	Price
<b>Millermatic® 212 Auto-Set™</b>	<b>#907 405</b>	200(208)/230 V, 60 Hz		
V-Groove Drive Roll Kits (solid wire)	<b>#087 131</b> <b>#079 594</b> <b>#079 595</b> <b>#204 579</b>	.023/.025 (0.6 mm) .030 (0.8 mm) .035 (0.9 mm) .030/.035 (0.8/0.9 mm)		
V-Knurl Drive Roll Kits (flux cored)	<b>#079 606</b> <b>#079 607</b>	.035 (0.9 mm) .045 (1.2 mm)		
Contact Tips (10 per package)	<b>#087 299</b> <b>#000 067</b> <b>#000 068</b> <b>#000 069</b>	.023/.025 (0.6 mm) .030 (0.8 mm) .035 (0.9 mm) .045 (1.2 mm)		
Nozzles	<b>#169 724</b> <b>#169 725</b> <b>#200 258</b> <b>#169 726</b> <b>#169 727</b>	1/2 in (13 mm) diameter, 1/8 in (3.2 mm) recessed 5/8 in (16 mm) diameter, 1/8 in (3.2 mm) recessed 1/2 in (13 mm) diameter, flush. <i>Included with standard configuration</i> 5/8 in (16 mm) diameter, flush 5/8 in (16 mm) diameter, 1/8 in (3.2 mm) exposed		

## Aluminum Configuration

<b>Millermatic® 212 Spool Gun Package</b> <i>(Also includes standard M-25 MIG gun)</i>	<b>#951 177</b>	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)	<b>#199 730</b> <b>#186 419</b> <b>#186 406</b>	.023 (0.6 mm) wire (requires V-Knurl drive roll #136 135) .030 (0.8 mm) wire .035 (0.9 mm) wire		
Spoolmate 200 Nozzle	<b>#186 405</b>			
Optional Spoolmate 200 Barrel Assemblies	<b>#300 591</b> <b>#300 592</b> <b>#300 593</b>	45-degree barrel 9 in extension barrel Heavy-duty barrel		

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

## Accessories

MIG Gun Consumable Kit for Steel	<b>#193 975</b>	<i>(Order from Miller Service Parts.)</i>		
M-25 Gun	<b>#169 594</b> <b>#169 596</b> <b>#169 598</b>	10 ft (3 m), .023–.035 in (0.6–0.9 mm) 12 ft (3.7 m), .023–.035 in (0.6–0.9 mm) 15 ft (4.6 m), .023–.035 in (0.6–0.9 mm)		
<b>NEW!</b> Spoolmate™ 200	<b>#300 497</b>	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	<b>#195 156</b>	15 ft (4.6 m), 200 A, .023–1/16 in (0.6–1.6 mm) for aluminum		
Spoolmatic® 30A	<b>#130 831</b>	30 ft (9 m), 200 A, .023–1/16 in (0.6–1.6 mm) for aluminum		
<b>NEW!</b> Millermatic Reach Wire Feeder <i>(MIG Gun sold separately.)</i>	<b>#907 437</b> <b>#907 438</b>	6 ft (1.8 m) cable assembly 25 ft (7.6 m) cable assembly		
Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack	<b>#300 337</b>			
Elevated Gun and Cable Rack	<b>#300 335</b>	For use with single cylinder rack. <i>(Included with Dual EZ-Change Low Cylinder Rack.)</i>		
Protective Cover	<b>#195 142</b>	Features side pocket		
Argon/Mixed Gas Regulator and Gas Hose	<b>#195 050</b>			
CO <sub>2</sub> Regulator/Flow Gauge	<b>#237 702</b>	Required if using 100% CO <sub>2</sub> gas. <i>(Order from Miller Service Parts.)</i>		

Date:

Total Quoted Price:

Distributed by:

