

Maxstar® 210 DX

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TIG/Stick Welding
Power Source



Quick Specs



Industrial Applications

Precision fabrication
Petro chemical
Aerospace
Food/beverage industry
Dairy
Shipboard

Processes

DC TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)

Input Power 120-480 V, 1-phase or 3-phase power

Amperage Range 1-210 A (DC)

Rated Output 210 A at 18 V, 60% duty cycle

Net Weight 17.2 kg

Upgradeable and expandable. Front panel memory card data port provides the ability to easily upgrade software and expand product features.

Pro-Set™ eliminates the guesswork when setting weld parameters. Use Pro-Set when you want the speed, convenience and confidence of preset controls. Simply select the feature and adjust until Pro-Set appears on the display.

Sleep timer conserves electricity. This programmable feature will power down the machine if it sits idle for a specific time.

Auto-Line™ power management technology allows for any input voltage hookup (120-480 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

Blue Lightning™ high-frequency (HF) arc starter for non-contact arc initiation. Provides more consistent arc starts and greater reliability compared to traditional HF arc starters.

Wind Tunnel Technology™ protects internal electrical components from airborne contaminants, extending the product life.

Meter calibration allows digital meters to be calibrated for certification.

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



DC TIG Features

Exceptionally smooth and precise arc for welding exotic materials.

Pulse. Pulsing can increase puddle agitation, arc stability and travel speeds while reducing heat input and distortion.

DC Stick Features

DIG control allows the arc characteristics to be changed for specific applications and

electrodes. Lower the DIG setting for smooth running electrodes like E7018 and increase the DIG setting for stiffer, more penetrating electrodes like E6010.

Hot Start™ adaptive control provides positive arc starts without sticking.

Stick-Stuck detects if the electrode is stuck to the part and turns the welding output off to safely and easily remove the electrode. Menu selectable.



Power source is warranted for three years, parts and labor.



International Headquarters Miller Electric Mfg. LLC

An ITW Welding Company
1635 W. Spencer Street
Appleton, WI 54914 USA

MillerWelds.com/europe

Miller Europe

Orbitalum Tools GmbH
Josef Schuettler Str. 17
78224 Singen, Germany
Tel.: +49 7731 792 400
sales.MILLER@ITWwelding.com

ITW WELDING Sales Office UK

77 New Court Way
Ormskirk, Lancashire L39 2YT
United Kingdom
Tel.: +44 1695 585 910
sales.UK@ITWwelding.com

Specifications (Subject to change without notice.)



Maxstar® 210 DX

Welding Mode	Input Power	Welding Amperage Range	Rated Output at 60% Duty Cycle	IP Rating	Phase	Amps Input at Rated Load Output, 50/60 Hz						Max. Open-Circuit Voltage	Dimensions	Net Weight	
						120 V	208 V	240 V	400 V	480 V	KVA				KW
TIG (GTAW)	208-480 V	1-210 A	210 A at 18.4 V	IP23	3-phase	-	14	12	7	6	5.2	4.9	80 VDC (11 VDC*)	H: 346 mm W: 219 mm D: 495 mm	17.2 kg
	120 V	1-210 A	125 A at 15 V		1-phase	-	24	20	12	10	4.9	4.9			
Stick (SMAW)	208-480 V	5-210 A	160 A at 26.4 V		1-phase	22	-	-	-	-	2.6	2.6			
					3-phase	-	15	13	8	6	5.5	5.2			
	120 V	5-210 A	90 A at 23.6 V		1-phase	-	26	22	13	11	5.3	5.3			
					1-phase	23	-	-	-	-	2.8	2.8			

*Low OCV sense voltage for stick and Lift-Arc™ TIG.

CE All CE models conform to the applicable parts of the IEC 60974 series of standards.

Genuine Miller® Accessories



Small Runner™ Cart 058035010

Designed for Maxstar 210/280, Dynasty 210/280, STH 270 and STi 270, with or without cooler. Cart features single cylinder rack, cable holder and foot pedal holder.



2 Wheel Trolley Running Gear 058035012

Designed for Maxstar 210/280, Dynasty 210/280, STH 270 and STi 270, with or without cooler. Easy-to-maneuver two-wheel cart with single cylinder rack, cable holder and storage area.

Memory Cards

Memory Card Expansion

- 301151** 14-Pin Automation Expansion
- 301152** 14-Pin Modbus® Expansion
- 301328** Hot Wire Power Supply Expansion

Memory Card (Blank) 301080

Blank memory card for transferring data from computer to machine.

Remote Controls and Switches



Wireless Remote Foot Control 301580

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller® machine. 27.4 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 6 m cord and 14-pin plug.



RCC-14 Remote Contactor and Current Control 151086

14-pin plug Side-to-side rotary-motion fingertip control fastens to TIG torch using two hook-and-loop straps.



SHRC-14 Remote Control

- 058040019** 5 m
 - 058040020** 10 m
 - 058040021** 20 m
- Single-hand control for current only.



Wireless Remote Hand Control 301582

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller® machine. 91.4 m operating range.



RHC-14 Hand Control 242211020

Miniature hand control for remote current and contactor control. Dimensions: 102 x 102 x 83 mm Includes 6 m cord and 14-pin plug.

TIG Torch Kits and Connectors

The Miller® TIG torches have been designed to perfectly match and to ensure that the welder can fully benefit from the superior arc quality of the Miller® TIG equipment. The material has been carefully selected to prevent ageing and leakage in the hoses and cables. Miller® uses more copper in the power cable to minimize the heat losses and maximize the output.

The TIG torches can be configured with a standard torch head or a flexible alternative. The ergonomic handle can also be fitted with a remote control for adjustment of the weld current at the point of welding.

Miller® recommends Miller®|Weldcraft® 2% lanthanated tungsten electrode.

The blue electrode ensures a stable arc in both AC and DC processes, with greater longevity than conventional tungsten electrodes, the ability to use a smaller-diameter electrode for the same job, use of a higher current for a similar-sized electrode, and less tungsten spitting.



**Remote current control from the thumb wheel, available as an option on all models*

Torch	Stock No.	Technical description	DC current	AC current
EuroTorch A-125, 4 meter	058022031	50 mm ² Dinse, 5/8" gas, 14 pin control	125A @ 60%	100A @ 60%
EuroTorch A-150, 4 meter	058022021	50 mm ² Dinse, 5/8" gas, 14 pin control	150A @ 60%	115A @ 60%
EuroTorch A-200F, 4 meter	058022014	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%
EuroTorch A-200, 8 meter	058022015	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%
EuroTorch A-200F, 8 meter	058022016	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%
EuroTorch A-200R, 4 meter	058022017	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%
EuroTorch A-200FR, 4 meter	058022018	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%
EuroTorch A-200R, 8 meter	058022019	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%
EuroTorch A-200FR, 8 meter	058022020	50 mm ² Dinse, 5/8" gas, 14 pin control	200A @ 60%	150A @ 60%

R - Remote control
F - Flex neck
A - Air cooled

Tungsten

Tungsten	Amp Range	2% Ceriated (AC/DC)	2% Lanthanated (AC/DC)
1.6 mm	70-150 A	WC116X7	WL2116X7
2.4 mm	140-250 A	WC332X7	WL2332X7
3.2 mm	225-400 A	WC018X7	WL2018X7
4.0 mm	300-500 A	WC532X7	WL2532X7

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Maxstar® 210 DX	907684001	Includes 2.4 m power cord and gas connection kit		
Torches		See page 3		
Accessories				
4-wheel Small Running Gear	058035010	Four-wheeled cart with cylinder rack		
2-wheel Trolley	058035012	Two-wheeled cart with cylinder rack		
Memory Card Expansion	301151 301152 301328	14-pin automation expansion 14-pin Modbus® expansion Hot wire power supply expansion		
Memory Card (Blank)	301080			
Stick Welding Cable Kit	057014351	Electrode holder kit 200 A, 35 mm ² , 5 m		
Work Cable with Clamp	057014331	Return cable kit 200 A, 35 mm ² , 5 m		
Remote Controls				
Wireless remote foot pedal	301580	Wireless foot pedal (range: 27 m)		
Wireless Remote Hand Control	301582	Wireless hand control (range: 90 m)		
RFCS-14 Heavy duty remote foot pedal	194744	Wired foot pedal (range: 6 m)		
RHC-14	242211020	Wired hand control (range: 6 m)		
SRHC-14	058040019 058040020 058040021	Single-hand remote control for current only, 5 m Single-hand remote control for current only, 10 m Single-hand remote control for current only, 20 m		
RMS-14	187208	Momentary-contact switch for contactor control, 8 m		
RCC-14	151086	Remote current/contactor side-to-side rotary control, 8 m		
RCCS-14	043688	Remote current/contactor up-and-down rotary control, 8 m		

Date:

Total Quoted Price:

Miller recommends *Elega* consumables

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