

# Millermatic® 211

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

## Quick Specs

### Light Industrial Applications

Light fabrication  
Maintenance and repair  
Auto body  
Farm/home

### Processes

MIG (GMAW)  
Flux-cored (FCAW)

### Weld Thickness

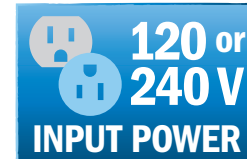
**120 V:** 24 ga.–3/16 in. steel  
18 ga.–1/8 in. aluminum  
**240 V:** 24 ga.–3/8 in. steel  
18 ga.–3/8 in. aluminum

### Input Power

**120 V:** 24.3 A, 50/60 Hz, single-phase  
**240 V:** 16.6 A, 50/60 Hz, single-phase

### Rated Output

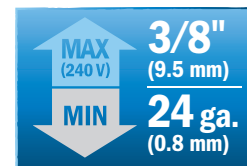
**120 V:** 115 A at 19.8 VDC, 20% duty cycle  
**240 V:** 150 A at 21.5 VDC, 40% duty cycle



Uses 120- or 240-volt power



Portable



Weld capacity



Quick and easy setup

**Advanced Auto-Set™** now includes five different wire/gas combinations and .024-inch (0.6 mm) wire capability. The easiest welder to use just became more versatile.

- Wire/gas combinations include Flux Cored, Mild Steel with 100% CO<sub>2</sub>, Mild Steel with C25, Stainless Steel, and Aluminum with spool gun
- Select the wire type and gas being used
- Set the wire diameter, and select from .024, .030 and .035 diameters. A blue LED indicates that Auto-Set is activated
- Dial in the thickness of what you're welding
- Start welding with the exact parameters you need!

**Inverter technology** combines best-in-class arc characteristics with the portability of a 38-pound machine. The arc is extremely forgiving to variations in arc length and travel speeds.

### Multi-voltage plug (MVP)

allows connection to common 120- and 240-volt power receptacles without the use of any tools — simply choose the plug that fits the receptacle and connect to the power cord.



**Angled cast-aluminum drive system** with calibrated tension knob creates consistent feeding and easy setup for up to 15-foot MIG guns.

**Quick Select™ drive roll** makes setup quicker by offering three grooves — two for different size solid wire and a third for flux-cored wire.

**Auto Spool Gun Detect™** automatically detects when a MIG gun or spool gun is connected eliminating the need for a switch.

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

**Smooth-Start™** provides a smooth, spatter-free start. It's the best-starting machine in the small MIG machine category.

**Thermal overload protection** shuts down unit and activates the **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when unit cools.



Welder is warranted for three years, parts and labor.  
Gun warranted for 90 days, parts and labor.

Uses 4- or 8-inch (102 or 203 mm) spools and can be set up to weld with .024–.035 inch (0.6–0.9 mm) solid wire and .030–.045 inch (0.8–1.2 mm) flux-cored wire.

### Comes complete with:

- Power source
- 6.5 ft. (2 m) power cord with MVP plugs for 120 V and 240 V
- 10 ft. (3 m) M-100 MIG gun and cable assembly
- 10 ft. (3 m) work cable with clamp
- Flow gauge regulator and gas hose for argon and AR/CO<sub>2</sub> mix
- Hobart® spool of .030 in. (0.8 mm) solid wire
- Two contact tips for .030 in. (0.8 mm) wire
- Quick Select™ drive rolls for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire
- Material thickness gauge ▶ 229895
- Hook-and-loop cord wraps

Note: Shielding gas and safety equipment not included.



**Miller Electric Mfg. Co.**  
An ITW Welding Company  
1635 West Spencer Street  
P.O. Box 1079  
Appleton, WI 54912-1079 USA

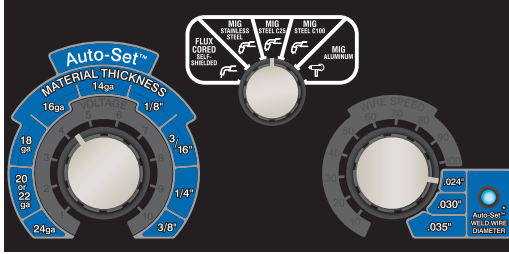
**Equipment Sales US and Canada**  
Phone: 866-931-9730  
FAX: 800-637-2315  
International Phone: 920-735-4554  
International FAX: 920-735-4125

**MillerWelds.com**



# Operation Modes

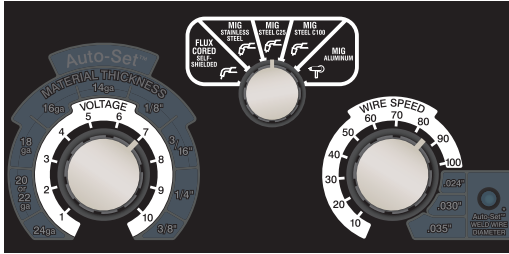
## Auto-Set™ mode



Auto-Set eliminates guesswork and saves you time on setup. Turn wire selector knob to select the wire and gas combination being used. Turn wire speed control fully clockwise to select Auto-Set mode and set the wire diameter to either .024, .030 or .035 inch. The Auto-Set light indicates mode is activated. Then select material thickness using the Auto-Set control.

Use Auto-Set when you want the speed, convenience and confidence of pre-set controls. Auto-Set automatically sets your welder to the proper parameters. It's available for welding with .024-, .030- and .035-inch steel and stainless steel wires, .030- and .035-inch flux-cored wires, and .030- and .035-inch 4043 aluminum wires with the Spoolmate 100 spool gun. Shielding gas is dependent on the wire being used.

## Manual mode



When welding outside of Auto-Set capabilities, or if you prefer custom parameters, use manual mode. The parameter chart on the inside of the access door is an easy-to-use guide for determining your voltage and wire feed speed settings. To optimize arc starts, turn wire selector knob to select the wire and gas combination being used. Reference the white areas on the controls when welding in manual mode.



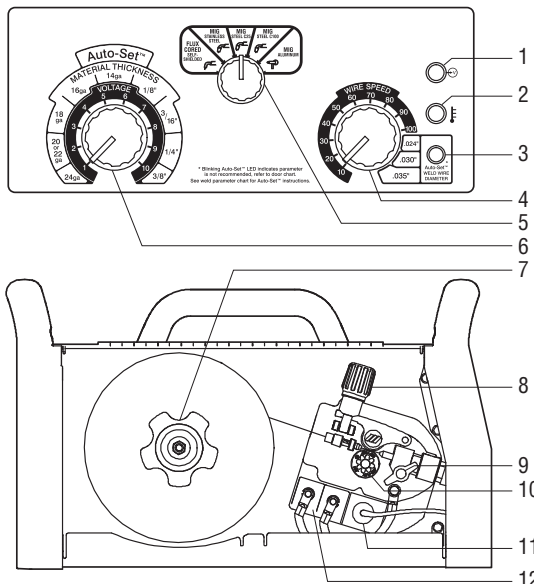
## Specifications (Subject to change without notice.)



Input Power	Amperage Range	Rated Output	Amps Input at Rated Output, 50/60 Hz				Wire Feed Speed	Wire Type and Diameter	Max. Open-Circuit Voltage	Dimensions	Net Weight
			120 V	240 V	KVA	KW					
120 V	30–130 A	115 A at 19.8 VDC, 20% duty cycle	24.3	—	2.9	2.9	60–600 ipm (1.5–15.2 m/min.)	Solid/stainless: .024–.035 in. (0.6–0.9 mm) Flux-cored: .030–.045 in. (0.8–1.2 mm)	54	H: 12.5 in. (318 mm) W: 11.25 in. (286 mm) D: 20.5 in. (521 mm)	38 lb. (17.2 kg) 42 lb. (19.1 kg) with gun
240 V	30–230 A	150 A at 21.5 VDC, 40% duty cycle	—	16.6	4.0	4.0					

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

## Control Panel

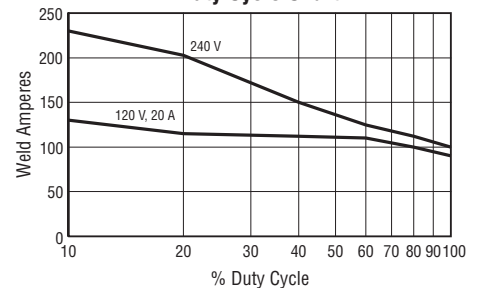


1. Power On Light
2. Over Temperature Light
3. Auto-Set Light
4. Wire Speed/Wire Diameter Control
5. Wire Selector Knob
6. Voltage/Material Thickness Control
7. Plastic Hub with Retaining Ring for 8-inch Spools (shaft also accepts 4-inch spools)
8. Calibrated Tension Knob
9. T-Knob (secures torch)
10. Drive Roll
11. Trigger Control Connector
12. Polarity Changeover Terminals

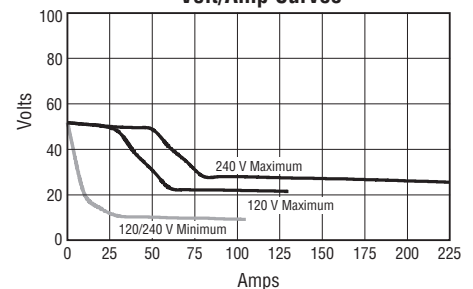
Note: Power switch and gas solenoid are on machine back panel.

## Performance Data

Duty Cycle Chart



Volt/Amp Curves



## Genuine Miller® Accessories

### Replacement/Optional MIG Gun

**M-100 (Standard)**  
248282 10 ft. (3 m)

**M-150 (Optional)**  
249040 12 ft. (3.7 m)  
249041 15 ft. (4.5 m)

All ship with liner 194011.



**Spoolmate™ 100 Spool Gun 300371**  
Direct-connect spool gun for all Millermatic 140, 141, 180, 190, 211 and Multimatic 200 models. Handles

.030–.035 inch (0.8–0.9 mm) aluminum (4043 only) and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 135 amps, 30-percent duty cycle. Includes 12-foot (3.7 m) cable assembly and custom carrying case.



**Spoolmate™ 150 Spool Gun 301272**  
Direct-connect spool gun for all Millermatic 211 and Multimatic 200 models. Handles

.030–.035 inch (0.8–0.9 mm) 4000/5000 series aluminum and .023–.035 inch (0.6–0.9 mm) steel/stainless steel wires. Rated at 150 amps, 60-percent duty cycle. Includes 20-foot (6.1 m) cable assembly.



**Millermatic Protective Cover 301262**



**Running Gear/Cylinder Rack 301239**  
Heavy-duty construction with 8-inch rubber rear wheels. Convenient front handles, cable holders and plastic consumable box.

For gas cylinders no greater than 7 inches (178 mm) in diameter or 65 pounds (29.5 kg) in weight.

**Purchase the Millermatic 211 package (951603) and receive the Millermatic 211 and running gear/cylinder rack (301239) packaged together!**

## Consumables (Order from Miller Service Parts.)

### For M-100/M-150 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)



**Contact Tip Adapter 169716**



#### Replacement Liners

194010 .024 in.  
194011 .030–.035 in. (standard)  
194012 .035–.045 in.  
15-foot length — trim to size needed.



**Nozzle 169715**  
1/2-inch (13 mm) diameter orifice.  
Nozzle flush with contact tip (standard).



**Gasless Flux-Cored Nozzle 226190**

*For M-100 gun only.*  
For use with self-shielding flux-cored wires. Improves visibility, eases access in tight corners, protects tip adapter/gas diffuser from spatter and from shorting to the workpiece.



#### Drive Rolls

**Quick Select™ 261157**  
For .024-inch (0.6 mm) or .030/.035-inch (0.8/0.9 mm) solid wire, and .030/.035-inch (0.8/0.9 mm) flux-cored wire.

**Dual Groove, V-Knurled 202926**  
For .030/.035-inch (0.8/0.9 mm) or .045-inch (1.2 mm) flux-cored wire.



#### M-Series Gun Consumable Kits

234607 .024 in. (0.6 mm)  
234608 .030 in. (0.8 mm)  
234609 .035 in. (0.9 mm)  
Each kit contains ten contact tips, one nozzle, and one contact tip adapter.

### For Spoolmate™ 100 Spool Gun



**Contact Tips (5 per package)**  
199730 .024 in. (0.6 mm)  
186419 .030 in. (0.8 mm)  
186406 .035 in. (0.9 mm)



**Nozzle 186405**

### For Spoolmate™ 150 Spool Gun



**Contact Tips (5 per package)**  
199387 .030 in. (0.8 mm)  
199388 .035 in. (0.9 mm)



**Nozzle 050622**

### For Both Spool Guns



**Drive Roll (1) 186413**  
For .030/.035-inch (0.8/0.9 mm) wire.

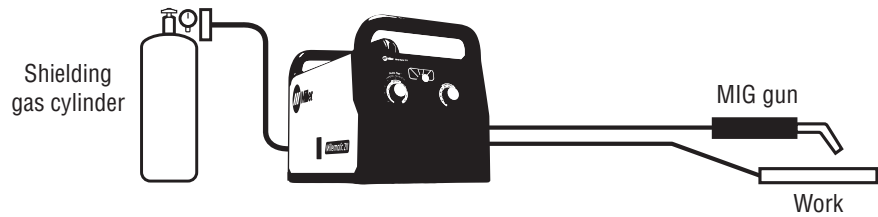


**Push Roll (1) 186414**  
For .030/.035-inch (0.8/0.9 mm) wire.

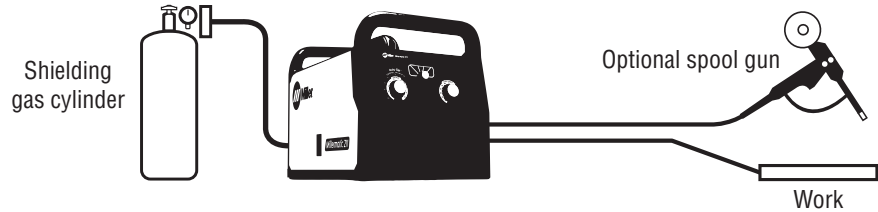
## Typical Installations



**MIG (GMAW) or Flux-Cored (FC)  
Basic Equipment**



**Aluminum MIG (GMAW)  
Basic Equipment**



## Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
<b>Millermatic® 211</b>	<b>907614</b>	120/240 V, 50/60 Hz		
<b>Millermatic® 211 with Running Gear/Cyl Rack</b>	<b>951603</b>	Power source packaged with 301239 running gear/cylinder rack		
<b>Guns</b>				
M-100 Gun (Standard)	<b>248282</b>	10 ft. (3 m), .030–.035 in. (0.8–0.9 mm)		
M-150 Gun (Optional)	<b>249040</b> <b>249041</b>	12 ft. (3.7 m), .030–.035 in. (0.8–0.9 mm) 15 ft. (4.5 m), .030–.035 in. (0.8–0.9 mm)		
Spoolmate™ 100 Spool Gun	<b>300371</b>	12 ft. (3.7 m). Includes custom carrying case		
Spoolmate™ 150 Spool Gun	<b>301272</b>	20 ft. (6.1 m)		
<b>Accessories</b>				
Protective Cover	<b>301262</b>			
Running Gear/Cylinder Rack	<b>301239</b>			
Material Thickness Gauge	<b>229895</b>			
Flux-Cored Wire				
Solid Wire				
Shielding Gas Cylinder				
Helmet/Gloves/Scratch Brush				
<b>Available Through Miller Service Parts</b>				
Flow Gauge Regulator for Argon or AR/CO <sub>2</sub> Mix	<b>268546</b>	Replacement standard regulator		
Flow Gauge Regulator for CO <sub>2</sub>	<b>212492</b>	Required if using 100-percent CO <sub>2</sub> gas		
Contact Tips		See page 3		
Contact Tip Adapter	<b>169716</b>	For M-100 and M-150 guns		
Replacement Liners		See page 3		
Nozzles		See page 3		
Gasless Flux-Cored Nozzle	<b>226190</b>	For M-100 gun		
Drive Rolls		See page 3		
M-Series Gun Consumable Kits	<b>234607</b> <b>234608</b> <b>234609</b>	.024 in. (0.6 mm) .030 in. (0.8 mm) .035 in. (0.9 mm)		

Date:

Total Quoted Price:

Distributed by:

