Millermatic® 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 though 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/CO_2 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.

TRUE BLUE® 3YR. WARRANTY

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.

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 CO_2).

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!

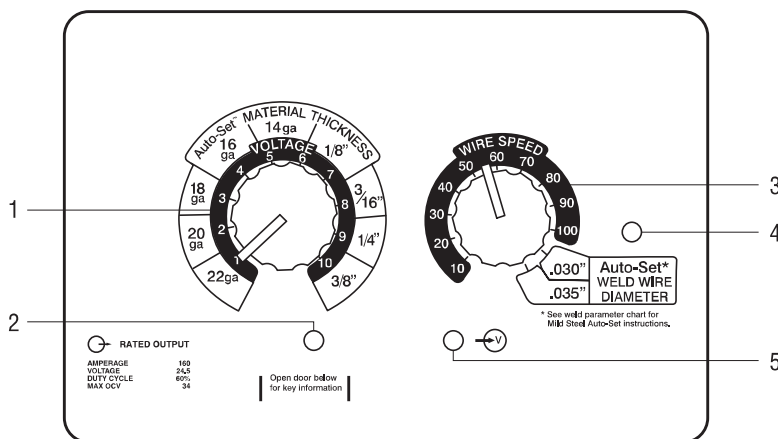# Specifications (Subject to change without notice.)

CV **DC** **1 Phase**

Amperage Range	Rated Output	Amps Input at Rated Output, 60 Hz 200(208) V	230 V	KVA	KW	Wire Feed Speed	Wire Type and Diameter	Max. Spool Size	Max. Open-Circuit Voltage	Dimensions	Net Weight
30–210 A	160 A at 24.5 VDC, 60% duty cycle 210 A at 22 VDC, 30% duty dyce	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).

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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

Duty Cycle Chart

Volt/Amp Curves

Miller.