## Quick Specs

<table>
<thead>
<tr>
<th>Processes</th>
<th>Weld Thickness</th>
<th>Input Power</th>
<th>Rated Output</th>
</tr>
</thead>
<tbody>
<tr>
<td>MIG (GMAW)</td>
<td></td>
<td>120 V: 24.3 A, single-phase, 50/60 Hz</td>
<td>120 V: 115 A at 19.8 VDC, 20% duty cycle</td>
</tr>
<tr>
<td>Flux-cored (FCAW)</td>
<td>240 V: 16.6 A, single-phase, 50/60 Hz</td>
<td>240 V: 150 A at 21.5 VDC, 40% duty cycle</td>
<td></td>
</tr>
</tbody>
</table>

### Advanced Auto-Set™
- Includes five different wire/gas combinations and three wire size capabilities.
  - Wire/gas combinations include Flux Cored, Mild Steel with 100% CO₂, Mild Steel with C25, Stainless Steel, and Aluminum with spool gun
  - Select the wire type and gas being used
  - Set the wire diameter (.024, .030 or .035 in.). 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.

### Quick Select™ drive roll
Sets up 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™
Cooling system only operates when needed, reducing noise, energy use and 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.

### TrueBlue® SYR Warranty
Welder is warranted for three years, parts and labor. Gun warranted for 90 days, parts only.

### NEW! MDX™-100 MIG gun with AccuLock™
MDX consumable system featuring a dual-locked, front-loading liner that optimizes wire feedability.

### 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
- 10 ft. (3 m) MDX™-100 MIG gun
- 10 ft. (3 m) work cable with clamp
- 6.5 ft. (2 m) power cord with MVP™ plugs for 120 V and 240 V
- Flow gauge regulator and gas hose for argon or AR/CO₂ 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.
**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.)*

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Amperage Range</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output, 50/60 Hz</th>
<th>Wire Feed Speed</th>
<th>Wire Type and Diameter</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>120 V</td>
<td>30–130 A</td>
<td>115 A at 19.8 VDC, 20% duty cycle</td>
<td>24.3 – 2.9 2.9</td>
<td>60–600 ipm</td>
<td>Solid/stainless: .024–.035 in. (0.6–0.9 mm)</td>
<td>54</td>
<td>H: 12.5 in. (318 mm) W: 11.25 in. (286 mm) D: 20.5 in. (521 mm)</td>
<td>38 lb. (17.2 kg)</td>
</tr>
<tr>
<td>240 V</td>
<td>30–230 A</td>
<td>150 A at 21.5 VDC, 40% duty cycle</td>
<td>– 16.6 4.0 4.0</td>
<td>3.0–0.45 in. (0.8–1.2 mm)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**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**

**Note**
Genuine Miller® Accessories

MDX™-100 MIG Gun  1770028
100-amp MIG gun with Miller® AccuLock™ MDX consumables for .030–.035 in. (0.8–0.9 mm) wire. Includes 10 ft. (3 m) cable assembly.

- Install AccuLock contact tips with a single turn.
- AccuLock liner locks at front and back of gun to align with contact tip and power pin for a flawless wire feed path.
- Durable, ergonomic handle with overmolding improves grip and comfort.
- Ball-and-socket handle with rear swivel for increased gun maneuverability while reducing welder fatigue.

Spoolmate™ 100 Spool Gun  300371
Direct-connect spool gun 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 handles .030–.035 inch (0.8–0.9 mm) 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.

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.

Dual Cylinder Rack Conversion Kit and Tool Holder  301454
Converts running gear/cylinder rack (301239) from a single cylinder cart to a dual cylinder cart. Top bracket holds a variety of tools including a welper, adjustable wrench, screwdrivers, chipping hammer, wire brush and filler rod.

Protective Cover  301262

Consumables

For MDX™-100 MIG Gun

Miller® AccuLock™ MDX Consumables
Smaller consumables and components to access hard-to-reach weldments.

Contact Tips (10 per package)
- T-M023 .023 in. (0.6 mm)
- T-M030 .030 in. (0.8 mm)
- T-M035 .035 in. (0.9 mm)
- T-M045 .045 in. (1.2 mm)
- T-M047 3/64 in. (1.2 mm)

Nozzles
- NS-M1200B Brass, 1/2 in. ID, flush
- NS-M1200C Copper, 1/2 in. ID, flush
- NS-MFLX Gasless nozzle

Diffuser D-M100

Monocoil Replacement Liners (10 ft.)
- LM1A-10 .023/.025 in. (0.6 mm)
- LM2A-10 .030/.035 in. (0.8/0.9 mm)
- LM3A-10 .035/.045 in. (0.9/1.2 mm)

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)

For Spoolmate™ 150 Spool Gun

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

Nozzle 186405

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.

For Millermatic 211

Quick Select™ Drive Roll  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.

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

Note: Miller® FasTip™, M-Series and Bernard Centerfire™ diffusers and consumables are NOT compatible with MDX Series guns.
### Power Source and Options

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>907614</td>
<td>120/240 V, 50/60 Hz</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951603</td>
<td>Power source packaged with 301239 running gear/cylinder rack</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Guns

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>120/240 V, 50/60 Hz</td>
<td>301239 running gear/cylinder rack</td>
</tr>
<tr>
<td>1770028</td>
<td>10 ft. (3 m), .030–.035 in (0.8–0.9 mm) wire</td>
</tr>
<tr>
<td>300371</td>
<td>12 ft. (3.7 m). Includes custom carrying case</td>
</tr>
<tr>
<td>301272</td>
<td>20 ft. (6.1 m)</td>
</tr>
</tbody>
</table>

### Accessories

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>301239</td>
<td>Running Gear/Cylinder Rack</td>
</tr>
<tr>
<td>301454</td>
<td>Dual Cylinder Rack Conversion Kit and Tool Holder</td>
</tr>
<tr>
<td>951770</td>
<td>Includes running gear/cylinder rack 301239 and dual cylinder rack conversion kit 301454. Must be assembled together</td>
</tr>
<tr>
<td>301262</td>
<td>Protective Cover</td>
</tr>
<tr>
<td>229895</td>
<td>Material Thickness Gauge</td>
</tr>
<tr>
<td>31-50-580-6</td>
<td>Replacement standard regulator</td>
</tr>
<tr>
<td>31-50-320</td>
<td>Required if using 100 percent CO₂ gas</td>
</tr>
</tbody>
</table>

### Consumables

- Contact Tips: See page 3
- Nozzles: See page 3
- Diffuser: See page 3
- Monocoil Replacement Liners: See page 3
- Drive Rolls: See page 3

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