Trailblazer® 325 Diesel

Welder/generator is warranted for three years, parts and labor. Engine is warranted separately by the engine manufacturer.

Trailblazer welder/generators deliver unbeatable arc performance providing the smoothest, most stable arc in the industry.

The Trailblazer exclusive technologies — Auto-Speed™ and optional Excel™ power — deliver superior runtimes, increased fuel efficiency, and improved welder/generator performance.

No other compact machine in the 300-amp class delivers more welding power or more auxiliary power with better fuel efficiency and less noise — for productive, profitable, quieter jobsites.

Quick Specs

<table>
<thead>
<tr>
<th>Processes</th>
<th>Output Range</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stick (SMAW)</td>
<td>DC stick 30–325 A</td>
</tr>
<tr>
<td>MIG (GMAW)</td>
<td>MIG/flux-cored 10–35 V</td>
</tr>
<tr>
<td>Flux-cored (FCAW)</td>
<td>DC TIG 10–325 A</td>
</tr>
<tr>
<td>RMD®*</td>
<td></td>
</tr>
<tr>
<td>Pulsed MIG (GMAW-P)*</td>
<td></td>
</tr>
<tr>
<td>DC TIG (GTAW)</td>
<td></td>
</tr>
<tr>
<td>Air carbon arc (CAC-A) cut and gouging Rated: 3/16-inch carbons, Capable: 1/4-inch carbons</td>
<td></td>
</tr>
<tr>
<td>Air plasma cutting and gouging with optional Spectrum® models Rated: 5/8-inch mild steel</td>
<td></td>
</tr>
</tbody>
</table>

Generator Power Output Rated at 104°F (40°C) 12,000 watts peak, 10,500 watts continuous

Excel™ Power (Recommended option) 2,400 watts (120 V, 20 A) 60 Hz pure sine power**

*Available only with ArcReach Smart Feeder.
**Engine speed rpm may vary while welding.

Trailblazer 325 Diesel with ArcReach and optional Excel power shown.

Remote control of the power source without a cord. See page 2.
Trailblazer® Technologies

**Dynamic DIG™ technology**

**Ultra-adaptive arc control.** Unlike conventional DIG that provides a preset amount of short-clearing current, Miller-exclusive Dynamic DIG technology works on a time-based algorithm that automatically adjusts the amount of current required to clear a short. Delivers a smoother more consistent arc that can be tailored to match application, material, fit-up and welder technique.

Auto-Speed™ technology

Matches engine speed to load — a Miller exclusive. Get the welding power you need — plus reduced fuel consumption and lower noise levels for a more profitable jobsite.

Miller-exclusive Auto-Speed technology responds to weld requirements by automatically adjusting engine speed to one of five rpm levels so the engine never works harder than necessary. Weld up to 135 amps while the engine remains at idle (1,800 rpm), saving up to 15 percent in fuel over competitive units, and drastically reducing jobsite noise.

**ArcReach® remote control technology**

Remote control of the power source without a control cord. An ArcReach system allows you to change weld settings from your ArcReach feeder or remote, saving a trip to the power supply. ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or remote and the power source. This technology eliminates the need for control cords, and their associated problems and costs.

Excel™ power (option)

**Power at idle — a Miller exclusive.** Unlike competitive machines that provide auxiliary power only at 3,600 rpm (max), Excel power delivers a full 2,400 watts (20 A) of 120-volt inverter-based, pure sine-wave power at 2,400 rpm. With Excel power you can operate jobsite tools like grinders at quiet, fuel-saving speeds.

Refueling time and operating costs are reduced with Excel power, which means more productivity and profitability. Plus everyone on the jobsite gets a better working environment because noise levels and exhaust emissions are lowered. Excel power — available only from Miller.
More productive jobsites

Quieter jobsites are more productive because work crews can communicate easier, and work can start earlier and end later — even in noise-sensitive areas. Miller-exclusive Auto-Speed technology makes this welder/generator the quietest Trailblazer diesel yet — rated at 70 db at idle (1,800 rpm). If your jobsite needs a welder/generator, it needs a Trailblazer welder/generator — because no other diesel-fueled choice in this category is as quiet.

ArcReach® remote control technology eliminates the need to trace or move heavy secondary weld leads bundled with control cords on the jobsite. Complete remote control of welding processes and parameters improves safety by limiting jobsite movement and reducing slip, trip and fall hazards.

More portable, uses less truck and jobsite space

Trailblazer welder/generators use up to 24 percent less cubic space and weigh up to 10 percent less than other welder/generators in their class — which means moving them is faster and easier, for maximum productivity. And because they take up less space, Trailblazer welder/generators let work trucks carry more equipment and gear — so your work crews can be ready for anything.

Unbeatable arc performance

Wide amperage output with better welding deposition rates means you can get jobs done faster, saving time and money. The Trailblazer also has precise arc control, which allows you to fine-tune the arc to match your personal preferences and quickly dial in the perfect parameters to optimize weld quality and maximize productivity across a variety of applications and welding processes.

Stronger generator power

Combined with a 24.8-horsepower engine, Trailblazer welder/generators offer 12,000 watts of clean, truly usable generator power that is Accu-Rated™, not inflated — tested to deliver uninterrupted peak output for a minimum of 30 seconds for big loads, so you can get more jobs done.

An independent welder and generator power system ensures no interaction between jobsite tools and the welding arc, while advanced generator technology virtually eliminates power spikes and other electrical imperfections — so welds are cleaner and jobsite tools can run without interruption, maximizing quality, productivity and profit.

Fewer refueling trips

No other diesel welder/generator in the 300-amp class lets your crews spend more time working and less time refueling — because only Trailblazer welder/generators provide Auto-Speed™ technology, plus the Excel™ power option, to deliver maximum runtime.

Maximum cost savings

Less money spent on fuel means more profit for you. Every Trailblazer welder/generator has fuel-saving Auto-Speed technology; add optional Excel power to save even more on fuel costs and enjoy a combination of advanced, profit-enhancing features that are only available on a Trailblazer welder/generator.

Trailblazer® Benefits

IT WOULD TAKE 8 TRAILBLAZERS TO EQUAL THE SOUND OUTPUT OF 1 COMPETITOR MACHINE.

UP TO 24% LESS CUBIC SPACE
Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Welding Mode</th>
<th>Process</th>
<th>Amp/Volt Ranges</th>
<th>Rated Weld Output at 104°F (40°C)*</th>
<th>Single-Phase Generator Power</th>
<th>Sound Levels at 7 m (23 ft.)</th>
<th>Dimensions</th>
<th>Net Weight**</th>
</tr>
</thead>
</table>
| CC/DC        | Stick/TIG | 10–325 A       | 325 A at 33 V, 100% duty cycle  | Peak: 12,000 watts  
Continuous: 10,500 watts | Weld: 135 A load: 70 dB (94 Lwa),  
325 A load: 81.5 dB (106.5 Lwa) | Weld: 28 in. (711 mm)  
(873 mm) (to top of exhaust) | H: 28 in. (711 mm) | 620 lb. (281 kg) |
| CV/DC        | MIG/FCAW | 10–35 V        | 325 A at 33 V, 100% duty cycle  | Excel** power (optional):  
2,400 watts,  
20 A at 120 V, 60 Hz pure generator power at 2,400 rpm and while welding | Generator power:  
Excel power (optional):  
75 dB (100 Lwa),  
12 kW standard power:  
81.5 dB (106.5 Lwa) | W: 20 in. (508 mm) | D: 45.375 in. (1,153 mm) |

*Rated at sea level. **Net weight without fuel. Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Engine Specifications (Engines warranted separately by the engine manufacturer.)

<table>
<thead>
<tr>
<th>Engine Brand and Warranty</th>
<th>Horsepower (HP)</th>
<th>Type</th>
<th>Weld Speed</th>
<th>Idle Speed</th>
<th>Fuel Capacity</th>
<th>Oil Capacity</th>
<th>Standard Shutdowns</th>
</tr>
</thead>
<tbody>
<tr>
<td>Kubota D902, 2-year limited North American warranty</td>
<td>24.8 hp at 3,600 rpm</td>
<td>Three-cylinder, industrial liquid-cooled diesel</td>
<td>Auto-Speed™ 1,800, 2,400, 2,800, 3,200 or 3,600 rpm</td>
<td>1,800 rpm or 2,400 rpm</td>
<td>12 gal. (45 L)</td>
<td>3.9 qt. (3.7 L)</td>
<td>High coolant temperature/ Low oil pressure/low fuel</td>
</tr>
</tbody>
</table>

Performance Data

Weld Fuel Consumption*

![Weld Fuel Consumption Graph](image)

*Fuel curve was generated using NEMA recommended voltage/ampere levels.

Auxiliary Power Fuel Consumption

![Auxiliary Power Fuel Consumption Graph](image)

Mounting Specifications

![Mounting Specifications Diagram](image)

A. 20 in. (508 mm)  
B. 16.5 in. (419 mm)  
C. 1.75 in. (44 mm)  
D. 6.062 in. (154 mm)  
E. 32.75 in. (832 mm)  
F. 45.375 in. (1,153 mm)  
G. .406 in. (10.3 mm) diameter
1. Self-calibrating digital meters with SunVision™
   - Preset and actual amperage/voltage
   - Process settings
   - Maintenance functions: hour meter, oil change interval, rpm

2. Weld process selection switch

3. Pushbutton main control knob used for adjusting amperage/voltage, adjusting arc control, and accessing the service menu.

4. Adjustable arc control adjusts DIG when process control is in stick modes and adjusts inductance when process control is in FCAW or MIG modes. The amount of DIG determines how much amperage (heat) varies with stick arc length. Inductance determines the "wetness" of the weld puddle.

5. Maintenance interval reminder. Yellow and red indicator lights let an operator know when the machine is approaching, and finally in need of routine maintenance.

6. Front-panel fuel-gauge LEDs indicate fuel level. Low fuel shutdown automatically detects and shuts engine off prior to running out of fuel.

7. Standard 14-pin receptacle for simple connection of remote controls and wire feeders. Includes Auto Remote Sense™ which automatically switches from panel to remote amperage/voltage (A/V) control with remote connected. Eliminates confusion of a panel/remote switch.

8. USB port allows software updates from a USB drive. A summary file of recoded data from the unit will be saved to a USB drive that is inserted.

9. Engine control. Run/idle position adjusts engine to run at lower speeds depending on total power needed for welding.

10. Glow plugs assist in cold weather starting.

11. Weld output terminals

12. Optional Excel™ power (factory option, see page 8) provides pure generator power at 2,400 rpm and while welding.

Note: If Trailblazer is ordered without Excel power option, unit is shipped with two 20 A, 120 V duplex receptacles with circuit breakers and ground fault.

13. 50 A, 120/240 V receptacle with circuit breaker

Note: For matching plug, order 119172.
Genuine Miller® Options  *Available as factory option. See ordering information on back page.*

GFCI Receptacles*  300975 Field
Kit contains two GFCI 120 V duplex receptacles. (240 V GFCI receptacle not required.)

Cold Weather Kit  301115 Field
Includes block heater for improved starting, and a fuel heater for optimal filtration in cold temperatures.

Spark Arrestor  043579 Field
Mandatory when operating on California grasslands, brush or forest-covered land, and all national forests. For other areas, check your state and local laws.

Spark Arrestor  043579 Field
Mandatory when operating on California grasslands, brush or forest-covered land, and all national forests. For other areas, check your state and local laws.

Full KVA Adapter Cord  300517 Field
NEMA 14-50P to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.

Full KVA Plug Kit  119172 Field
120/240 V, 50 A plug (NEMA 14-50P) to fit full KVA receptacle.

Diesel Engine Filter Kit  259935 Field
Includes air filter, oil filter, fuel pre-filter and primary fuel filter.

Genuine Miller® Accessories

Never Flat™ Tires
Available on Bobcat and Trailblazer running gear.
- Reduce costly jobsite downtime
- Maintain constant tire pressure and will not develop flats
- Protect against punctures
- Preserve maneuverability, even when weighed down with heavy welding cable

All-Purpose Running Gear  300477
Includes two heavy-duty 15-inch Never Flat™ tires, two 8-inch rubber swivel casters and a heavy-duty handle. Recommended for all surfaces and applications, and is easy to move around the jobsite.

Protective Cover  301099
Heavy-duty, water-resistant and mildew-resistant cover protects and maintains the finish of the welder.

MIG/Flux-cored Welding

ArcReach® SuitCase® 8
951726 With Bernard® BTB Gun 300 A
951727 With Bernard® S-Gun™
951728 With Bernard® Dura-Flux™ gun

ArcReach® SuitCase® 12
951729 With Bernard® BTB Gun 300 A
951730 With Bernard® S-Gun™
951731 With Bernard® Dura-Flux™ gun

Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature M/6.55.

SuitCase® 12RC Wire Feeder  951580
Lightweight and flexible enough to run wires up to .062-inch diameter. Includes remote voltage control, drive roll kit and Bernard® BTB Gun 300 A. See literature M/6.5.

Spoolmatic® 30A Spool Gun  130831
Air-cooled, 200-amp, one-pound spool gun for aluminum MIG. See literature M/1.73. Requires WC-24 Control (137549).

XR™ Wire Feeders and Guns
Push-pull system designed to handle difficult-to-feed soft alloy wires such as aluminum. See literature M/1.7 through M/1.74.

Note: Not for use with protective cover.
**Genuine Miller® Accessories (Continued)**

### Stick (SMAW) Welding

**Weld Leads**

- **2/0 Stick Cable Set, 50 ft. (15 m) 173851**
  Consists of 50-foot (15 m) 2/0 electrode cable with holder, and 50-foot (15 m) work cable with clamp. 350 A, 100% duty cycle.

- **2/0 Stick Cable Set, 100/50 ft. (30.5/15 m) 043952**
  Consists of 100-foot (30.5 m) 2/0 electrode cable with holder, and 50-foot (15 m) work cable with clamp. 300 A, 100% duty cycle.

### AC TIG (GTAW) Welding

**Dynasty® 210 Series**
For portable AC/DC TIG. See literature AD/4.81.

### Plasma Cutting

**Spectrum® 375 X-TREME and 625 X-TREME shown.**

- **Spectrum® 375 X-TREME™ 907529**
  See literature PC/9.2.
- **Spectrum® 625 X-TREME™ 907579**
  See literature PC/9.6.
- **Spectrum® 875 907583**
  See literature PC/9.8.

The Spectrum 375 X-TREME and 625 X-TREME come complete with protective X-CASE™ (not shown).

### Remote Controls

- **ArcReach® Stick/TIG Remote 301325**
  When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature AY/14.5.

- **Wireless Remote Hand Control 300430**
  For remote current, voltage and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller® machine. Up to 300-foot (91.4 m) operating range.

- **RHC-14 Hand Control 24221020**
  Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 82 mm).
  Includes 20-foot (6 m) cord and 14-pin plug.

### Extension Cables for 14-Pin Remote Controls

- **25 ft. (7.6 m) 242208025**
- **50 ft. (15.2 m) 242208050**
- **80 ft. (24.4 m) 242208080**

#### Trailers and Hitches (Note: Trailers are shipped unassembled.)

**HWY-Mid Frame Trailer 301438**
1,424-pound (646 kg) capacity highway trailer with welded steel tubing frame, heavy-duty axle with roller bearing hubs and leaf-spring suspension. Includes jack stand, fenders, lights, and dual hitch with 2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye.

**Cable Tree 043826**
Provides an area to conveniently wrap weld cables and extension cords.

**2-In-1 Document/ Fire Extinguisher Holder 301236**
Stores documents and holds a five-pound fire extinguisher. *Note: Holder shown mounted on trailer. Fire extinguisher not included.*

### Trailer Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Gross Axle Weight Rating</th>
<th>Gross Vehicle Weight Rating</th>
<th>Net Payload</th>
<th>Height of Bed</th>
<th>Road Clearance</th>
<th>Track (Center to center of tires)</th>
<th>Standard Tires (Standard rating or P-size rating)</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HWY-Mid Frame</td>
<td>1,605 lb. (728 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>19.5 in. (495 mm)</td>
<td>8 in. (203 mm)</td>
<td>46 in. (1,168 mm)</td>
<td>ST175/800-13 Load Range C</td>
<td>Length: 101 in. (2,565 mm) Width: 55 in. (1,397 mm) *</td>
<td>181 lb. (82 kg)</td>
</tr>
</tbody>
</table>

*Width at outside of fenders.*
## Ordering Information

### Equipment and Options

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>907799</td>
<td>Kubota engine, base model</td>
</tr>
<tr>
<td>907799001</td>
<td>Kubota engine with GFCI receptacles</td>
</tr>
<tr>
<td>907799002</td>
<td>Kubota engine with Excel™ power and GFCI receptacles</td>
</tr>
</tbody>
</table>

### Field Options

Options listed below can be added to the above packages. Installation is required.

<table>
<thead>
<tr>
<th>Description</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>GFCI Receptacles</td>
<td>300975</td>
</tr>
<tr>
<td>Cold Weather Kit</td>
<td>301115</td>
</tr>
<tr>
<td>Spark Arrestor</td>
<td>043579</td>
</tr>
<tr>
<td>Full KVA Adapter Cord</td>
<td>300517</td>
</tr>
<tr>
<td>Full KVA Plug</td>
<td>119172</td>
</tr>
<tr>
<td>Diesel Engine Filter Kit</td>
<td>259935</td>
</tr>
</tbody>
</table>

### Accessories

<table>
<thead>
<tr>
<th>Description</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>All-Purpose Running Gear</td>
<td>300477</td>
</tr>
<tr>
<td>With Never Flat™ tires</td>
<td></td>
</tr>
<tr>
<td>Protective Cage with Cable Holders</td>
<td>195331</td>
</tr>
<tr>
<td>Not for use with protective cover</td>
<td></td>
</tr>
<tr>
<td>Protective Cover</td>
<td>301099</td>
</tr>
</tbody>
</table>

### MIG/Flux-cored Welding

With Bernard® BTB Gun 300 A

With Bernard® S-Gun™

With Bernard® Dura-Flux™ gun

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951726</td>
<td>ArcReach® SuitCase® 8</td>
</tr>
<tr>
<td>951727</td>
<td>ArcReach® SuitCase® 8</td>
</tr>
<tr>
<td>951728</td>
<td>ArcReach® Smart Feeder</td>
</tr>
<tr>
<td>951729</td>
<td>ArcReach® SuitCase® 12</td>
</tr>
<tr>
<td>951730</td>
<td>ArcReach® SuitCase® 12</td>
</tr>
<tr>
<td>951731</td>
<td>ArcReach® SuitCase® 12</td>
</tr>
<tr>
<td>951733</td>
<td>ArcReach® Smart Feeder</td>
</tr>
<tr>
<td>951580</td>
<td>SuitCase® 12RC</td>
</tr>
<tr>
<td>130831</td>
<td>Spoolmatic® 30A Spool Gun</td>
</tr>
<tr>
<td>137549</td>
<td>WC-24 Control</td>
</tr>
<tr>
<td></td>
<td>XR™ Wire Feeder Control and Guns</td>
</tr>
</tbody>
</table>

### Stick Welding

See page 7

### TIG Welding

See page 7

### Plasma Cutting

See page 7

### Remote Controls and Extension Cables

For use with ArcReach models only

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>301325</td>
<td>ArcReach® Stick/TIG Remote</td>
</tr>
<tr>
<td>300430</td>
<td>Wireless Remote Hand Control</td>
</tr>
<tr>
<td>242211020</td>
<td>RHC-14 Hand Control</td>
</tr>
</tbody>
</table>

### Trailers and Hitches

<table>
<thead>
<tr>
<th>Description</th>
<th>Stock No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>HWY-Mid Frame Trailer</td>
<td>301438</td>
</tr>
<tr>
<td>Trailer with lights, fenders and dual hitch. For highway use</td>
<td></td>
</tr>
<tr>
<td>Cable Tree</td>
<td>043826</td>
</tr>
<tr>
<td>Trailer-mounted cable holder</td>
<td></td>
</tr>
<tr>
<td>2-In-1 Document/Fire Extinguisher Holder</td>
<td>301236</td>
</tr>
<tr>
<td>Stores documents and holds a five-pound fire extinguisher</td>
<td></td>
</tr>
</tbody>
</table>

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The Power of Blue

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