

Maxstar[®] 200 STR

Issued February 2002 • Index No. DC/29.5

Stick/TIG Welding
Power Source



Quick Specs



Industrial Applications

Petro/Chem Fabrication
Mechanical Contractors
Shipboard Installation
Mining
Process Piping
MRO

Processes

Stick (SMAW) Lift Stick
TIG (GTAW) Lift-Arc

Input Power Requires 1- or 3-Phase Power

Amperage Range 5–200 A

Max. Open-Circuit Voltage 80

Weight 32 lb (14.5 kg)

The Power of Blue.[®]

Easy installation — Auto-Line™ provides state-of-the-art flexibility to the end user. The Auto-Line circuitry automatically connects to 120–460 VAC, single- or three-phase power without removing the covers to relink the power source. No longer is there a concern if you have the correct machine for shop or the job site.

NEW! Low OCV Stick is a simple design that reduces the open-circuit voltage to 13 volts when the welding power source is not in use. This circuit design is now built into the Maxstar 200 STR eliminating the need for add-on voltage reducers.

Adaptive Hot Start™ for Stick arc starts automatically increases the output amperage at the start of a weld should the start require it. Prevents the electrode from sticking and creating an inclusion.

Optional 4-pack racks are available for multiple operator applications. These are commonly used in construction and shipyard applications.



New!

Includes two International-style connectors 35/50.

Superior Stick arc performance on all input voltages. Even on the difficult-to-run electrodes like E6010.

Lift-Arc™ start provides TIG arc starting without the use of high frequency.

Portable in the shop or at the job site — at 32 lb the Maxstar 200 STR easily moves from location to location.

Inverter-based, DC power source has a **simple-to-use operator interface** providing only the necessary controls in a compact machine.

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.

Remote amperage control provided through 14-pin receptacle on front of the machine. This permits use of standard remote amperage control devices.

TRUE BLUE[®]
3YR. WARRANTY

Power source is warranted for 3 years, parts and labor.
Original main power rectified parts are warranted for 5 years.

MADE IN **USA**
APPLETON, WI **USA**



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An Illinois Tool Works Company
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Web Site
www.MillerWelds.com



Specifications (Subject to change without notice.)

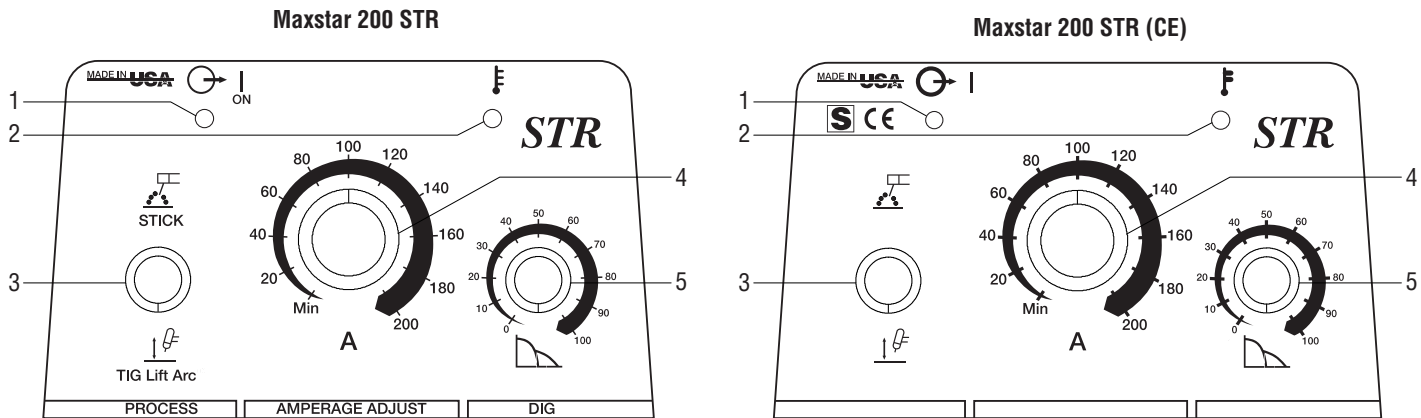


Welding Mode	Input Power	Rated Output	Welding Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 50/60 Hz,								Dimensions	Net Weight
					120 V	200 V	230 V	400 V	440 V	460 V	KVA	KW		
Stick (SMAW)	3-Phase	150 A at 26 V, 60% Duty Cycle	120 VAC, 1-90 A 200-460 VAC, 1-200 A	80 VDC	—	14.7	13.1	7.4	6.6	6.4	5.2	5.0	H: 13-1/2 in (343 mm) W: 7-1/2 in (191 mm) D: 17-1/2 in (445 mm)	32 lb (14.5 kg)
		—			0.16*	0.16*	0.24*	0.24*	0.25*	0.06*	0.03*			
	1-Phase	150 A at 26 V, 60% Duty Cycle			—	24.9	21.7	—	—	—	5.0	5.0		
		125 A at 25 V, 50% Duty Cycle			—	0.25*	0.23*	—	—	—	0.05*	0.02*		
1-Phase	90 A at 24 V, 100% Duty Cycle	—	34.1	19.6	17.2	—	—	—	4.0	3.8				
	—	—	0.42*	0.25*	0.23*	—	—	—	0.05*	0.03*				
TIG (GTAW)	3-Phase	175 A at 17 V, 60% Duty Cycle	120 VAC, 1-110 A 200-460 VAC, 1-200 A	80 VDC	—	12.1	10.5	6.0	5.3	5.2	4.2	4.0		
		—			0.16*	0.16*	0.24*	0.24*	0.25*	0.06*	0.03*			
	1-Phase	175 A at 17 V, 60% Duty Cycle			—	19.9	17.4	—	—	—	4.0	4.0		
		150 A at 16 V, 70% Duty Cycle			—	0.25*	0.23*	—	—	—	0.05*	0.02*		
1-Phase	110 A at 15 V, 100% Duty Cycle	—	29.7	17.1	14.1	—	—	—	3.4	3.4				
	—	—	0.42*	0.25*	0.23*	—	—	—	0.05*	0.03*				
1-Phase	110 A at 15 V, 100% Duty Cycle	—	20.0	—	—	—	—	—	2.0	2.0				
	—	—	0.42*	—	—	—	—	—	0.05*	0.03*				

* Indicates idle draw.

CSA applied for. Models with CE specifications are available and manufactured according to the Standards IEC-974-1 and EN-60974-1.

Control Panel



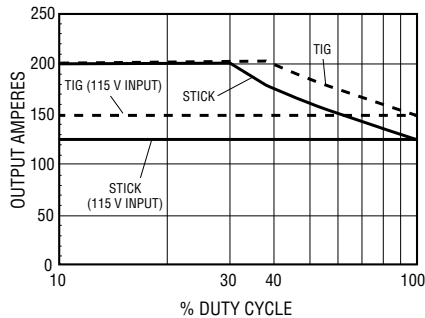
- 1. Output Light
- 2. Overtemp Light
- 3. Weld Process Selector Switch
- 4. Amperage Adjustment Control
- 5. Dig Adjustment Control

Control Panel Parameter Values

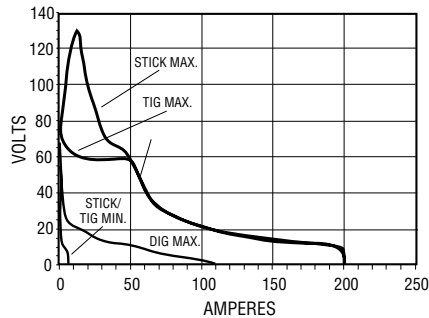
A. Amperage (A) 5-200 B. Dig Control (%) 1-100

Performance Data

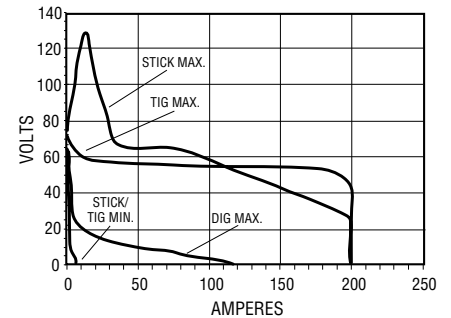
DUTY CYCLE CHART



115 VAC INPUT



OTHER INPUT VOLTAGES



Genuine Miller Accessories



TIG (GTAW) Torches

Diamondback™ TIG Torches

The NEW Diamondback line of ergonomically designed TIG torches from Miller Electric complements the most popular TIG power source line available today. The Diamondback torch line includes both air-cooled and water-cooled models. The air-cooled models range in size from 125 to 200 A. The water-cooled models include 250 and 350 A torches. All models are standard with a rigid head. See Diamondback TIG Torch Selector Guide.

TIG (GTAW) Torch Adapters

DA-917F #194 720

Used to adapt a 1-piece 125 or 150 amp air-cooled torch to an International-style connector.

DA-26R #194 724

Used to adapt a 1-piece 200 amp air-cooled torch to an International-style connector.

DA-1820L #190 219

Used to adapt a 250 or 350 amp water-cooled torch to an International-style connector.

Remote Controls



RCC-14 Remote Contactor and Current Control #151 086

14-pin plug

Side-to-side rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 28 ft (8.5 m) control cord. Great for production or contractors that need quick ramp-up.



RCCS-14 Remote Contactor and Current Control #043 688

Up-and-down rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Includes 28 ft (8.5 m) control cord. Great for applications that require a finer amperage control.



RFCS-14 HD Foot Control #194 744

New design with larger, more stable base and heavier cord that can exit front, back or sides of pedal. Provides remote current and contactor control and includes 20 ft (6 m) cord and 14-pin plug.



RHC-14 Hand Control #129 340

Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3-1/4 in (102 x 102 x 82 mm). Includes 20 ft (6 m) cord and 14-pin plug.

International-Style Connectors (Will accept Dinse™ or other international connectors.)

Note: All Maxstar power sources are equipped with International-style connectors for secondary connections. (Power source is shipped with two 50-mm male International-style plugs for use with #1 or #2 AWG size cable.)

International-Style Connector Kit

#042 418 50 mm

Accepts #1 or #2 AWG cable size. Required if male plugs shipped with power source must be replaced or if additional plugs are needed. Kit includes one International-style male plug which attaches to the work and/or weld cables and plugs into the International-style receptacles on the power source.

Extension Kit for International-Style

Cable Connectors #042 419 50 mm

Accepts #1 or #2 AWG size cable. Used to adapt or extend weld and/or work cables. Kit includes one male International-style plug and one in-line female International-style receptacle.



International/Tweco® Adapter #042 465

A one-piece adapter which has an International-style male plug (to power source) on one end and a female Tweco receptacle (for weld cable connection) on other end.



International/Cam-Lok Adapter #042 466

A one-piece adapter which has an International-style male plug (to power source) on one end and a Cam-Lok receptacle (for weld cable connection) on other end.

CST™ (Maxstar®) Rack



- Rugged enclosure provides a simple means for protecting and transporting multiple welding power sources for construction, power plant turn-arounds, and shipbuilding applications.
- Light weight and small footprint for easy transportation. Low weight enables the use of elevators to move the rack.
- Top cover protects machines from falling debris.
- Lifting eye simplifies transportation using crane or overhead lifting device.
- Lift truck side and end fork pockets.
- One main disconnect box with fused circuit breaker switches for each machine.
- Common output ground connection (for same polarity use only).

CST Rack Specifications (Subject to change without notice.)

Power Source Used	Input Power to Rack	Rack Capacity	Dimensions	Net Weight
Maxstar 200 STR	230–460 V, 60 Hz, Three-Phase	4	H: 59-3/8 in (1508 mm) W: 43 in (1092 mm) D: 34-3/8 in (873 mm)	298 lb (135 kg)

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
Maxstar® 200 STR	#907 036	120–460 VAC, 50/60 Hz		
	#907 037	120–460 VAC, 50/60 Hz, CE		
CST™ (Maxstar) Rack	#195 051	Empty Rack		
	#907 079	With four Maxstar 200 STRs for 230–460 V		
TIG Accessories				
Diamondback™ TIG Torches		See Diamondback TIG Torch Selector Guide		
TIG Torch Adapters	#194 720 #194 724 #190 219	DA-917F DA-26R DA-1820L		
Consumables/Tungsten		See Parts Guide		
Gas Cylinder/Hose and Fittings				
Remote Controls				
RCC-14	#151 086	Remote current side-to-side rotary control		
RCCS-14	#043 688	Remote current up and down rotary control		
RFCS-14 HD	#194 744	Remote current foot pedal control		
RHC-14	#129 340	Remote current hand control		
International-Style Connectors				
International-Style Connector Kit	#042 418	50 mm		
Extension Kit for International-Style	#042 419	50 mm		
International/Tweco® Adapter	#042 465	A one-piece adapter with International-style male plug		
International/Cam-Lok Adapter	#042 466	A one-piece adapter with International-style male plug		

Date:

Total Quoted Price:

Distributed by:

