

Millermatic® 140 Auto-Set™

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**MIG Arc Welding 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)

Input Power 115 V, 20 A, 60 Hz, Single-Phase

Rated Output 90 A at 18 VDC, 20% Duty Cycle
63 A at 21 VDC, 20% Duty Cycle, **CSA**

Amperage Range 30–140 A

Max. Open-Circuit Voltage 28

The Power of Blue.®

Auto-Set™: The right settings automatically —

- Set the wire diameter, a blue light shows that **Auto-Set™** is activated
- Dial in the thickness of what you're welding
- Start welding with the exact parameters you need!

Infinite voltage control gives you the flexibility to manually set the machine when welding aluminum, stainless steel, or anytime you want to set your own parameters on mild steel.

Smooth-Start™ patented technology provides a smooth, spatter-free start. It's the best-starting machine in the small MIG machine category. No pop gun starts and no spatter to clean up.

Durable cast aluminum drive system incorporates dual-groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob, all designed to make set up easier and faster.

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

Miller's exclusive "Tip Saver" short circuit protection shuts down output when tip is shorted to the work. Extends contact tip life and protects internal components from damage. **Trigger reset** permits quick reset at torch rather than unit.

Self-resetting motor protection circuit eliminates the need to find and replace fuses.



Comes Complete With:

- Power source
- 6 ft (1.8 m) power cord and plug
- 10 ft (3 m), M-10 MIG gun and cable assembly
- 10 ft (3 m) work cable and clamp
- Smith® Argon and AR/CO₂ mix regulator/flow gauge with hose
- Spool of Hobart® .030 in (0.8 mm) solid wire
- Two contact tips for .024 in (0.6 mm) wire and two contact tips for .030 in (0.8 mm) wire
- Dual groove quick-change drive roll for .024 in (0.6 mm) or .030/.035 in (0.8/0.9 mm) wire
- Factory-installed gas solenoid valve
- Set-up and operation CD
- Information/settings chart
- Material thickness gauge #229 895

Note: Shielding gas and safety equipment not included.



Easy access to output studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

Semiautomatic constant voltage wire welding package is capable of welding 24 gauge up to 3/16 in (0.8–4.8 mm) mild steel.

Standard built-in solid-state contactor circuit makes wire electrically "cold" until trigger is pulled, making the unit safer. It's also easier to position torch to work before starting weld.

Uses 4 or 8 in (102 or 203 mm) spools and can be set up to weld with wire sizes .024–.030 in (0.6–0.8 mm) mild/stainless steel and .030–.035 in (0.8–0.9 mm) flux cored.

TRUE BLUE®
3 YR. WARRANTY

Welder is warranted for 3 years, parts and labor. Original main power rectified parts are warranted for 5 years.
Gun warranted for 90 days, parts and labor.

MADE IN **USA**



Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters
Phone: 920-735-4505
USA FAX: 920-735-4134
Canadian FAX: 920-735-4169
International FAX: 920-735-4125

Web Site
www.MillerWelds.com



Auto-Set™ Feature

The Millermatic® 140 Auto-Set™ offers all the benefits of the standard Millermatic 140, but adds Auto-Set to eliminate the guesswork.

Use Auto-Set when you want the speed, convenience and confidence of pre-set controls. Simply set the wire diameter, set the material thickness, and go! The Auto-Set control automatically sets your welder to the proper parameters. It is available when welding mild steel with solid wire and only works with .024 and .030 solid wires and C25 shielding gas (75% Argon, 25% CO₂).

When not within the Auto-Set profiles, use the manual mode to set the weld parameters you desire. The parameter door chart lists voltage and wire feed speed settings options.

Auto-Set Mode



- Turn wire speed control fully clockwise to select Auto-Set mode. Set the wire diameter to either .024 or .030 in.
- Light indicates Auto-Set mode is activated.
- Set the material thickness within Auto-Set range for 24 gauge through 3/16 in mild steel. The welder automatically sets itself to proper parameters, and is ready to weld!

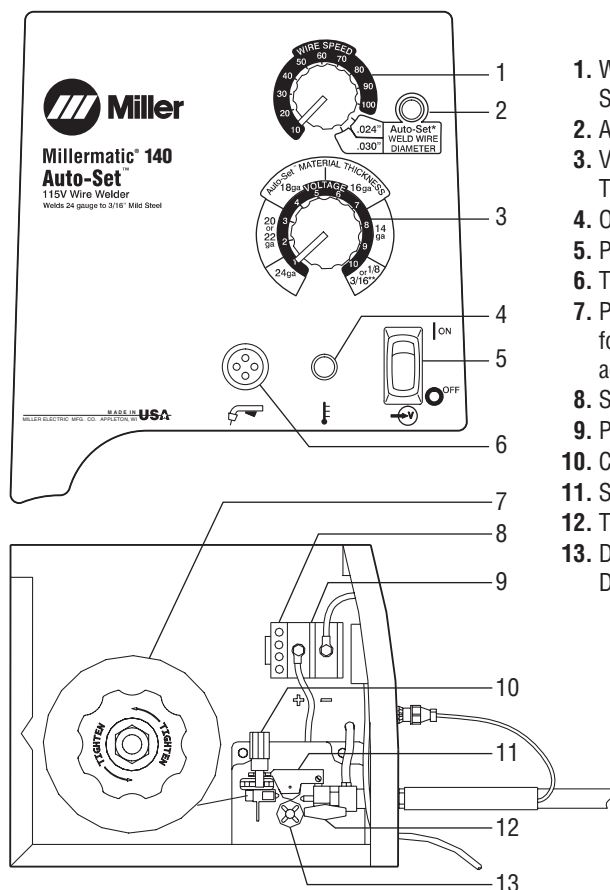
Specifications (Subject to change without notice.)



Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz			Wire Feed Speed	Dimensions	Net Weight	Ship Weight
			115 V	KVA	KW				
90 A, 18 VDC at 20% Duty Cycle	30–140 A	28	20	2.8	2.4	15–390 IPM (0.4–9.9 m/min); 35–420 IPM at no load (0.9–10.7 m/min)	H: 17-1/2 in (444 mm) W: 10-5/8 in (273 mm) D: 15-3/4 in (400 mm)	60 lb (27.3 kg)	67 lb (30.5 kg)
63 A, 21 VDC at 20% Duty Cycle, CSA			15	2.1	1.8				

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

Control Panel



1. Wire Feed/Wire Diameter Speed Control
2. Auto-Set Light
3. Voltage Control/Material Thickness
4. Over Temperature Light
5. Power Switch
6. Trigger Lead Switch Connection
7. Plastic Hub with Retaining Ring for 8 in Spools (shaft also accepts 4 in spools)
8. Storage Holes for Spare Tips
9. Polarity Changeover Terminals
10. Calibrated Tension Knob
11. Springloaded Tension Arm
12. T-Knob (secures torch)
13. Dual Groove Quick-Change Drive Roll

Performance Data

