

# Millermatic® 180 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** 230 V, 21.7 A, 60 Hz, Single-Phase  
**Rated Output** 135 A at 22.5 VDC, 30% Duty Cycle  
**Amperage Range** 30–180 A  
**Max. Open-Circuit Voltage** 31

## 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.

### Welds thickest material in its class!

The Millermatic® 180 Auto-Set™ has the highest output in its class. It can weld from 24 ga–5/16 in (0.8–7.9 mm) mild steel in a single pass.

### Spool gun compatible!

Finally a reliable and economic way to weld aluminum. Hooked up to a Millermatic® 180 Auto-Set™, the Spoolmate 100 Series spool gun allows you to weld from 18 ga–1/4 in aluminum.

**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.



### 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/CO<sub>2</sub> 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.

**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.

**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–.035 in (0.6–0.9 mm) mild/stainless steel and .030–.045 in (0.8–1.2 mm) flux cored.



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



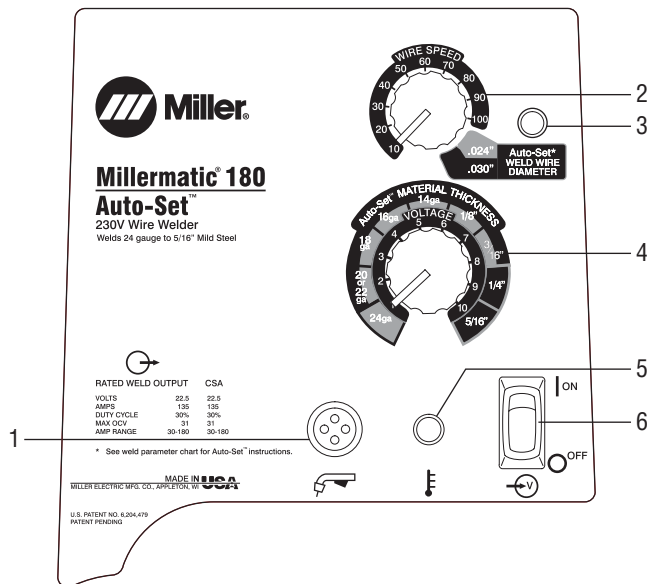
# Specifications (Subject to change without notice.)



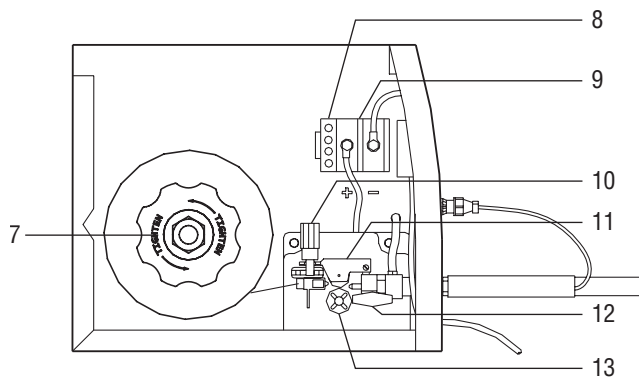
Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz			Wire Feed Speed	Dimensions	Net Weight	Ship Weight
			230 V	KVA	KW				
135 A, 22.5 VDC at 30% Duty Cycle	30-180 A	31	21.7	5.0	4.1	40-460 IPM (1.0-11.7 m/min)	H: 17-1/2 in (444 mm) W: 10-5/8 in (273 mm) D: 15-3/4 in (400 mm)	72 lb (32.7 kg)	81 lb (36.4 kg)

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

## Control Panel



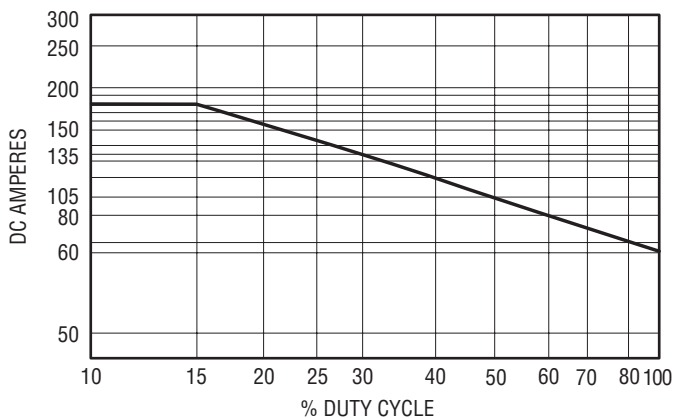
1. Trigger Lead Switch Connection
2. Wire Feed/Wire Diameter Speed Control
3. Auto-Set Light
4. Voltage/Material Thickness Control
5. Over Temperature Light
6. Power Switch



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

DUTY CYCLE CHART



VOLT/AMP CURVES

