

# Thunderbolt® XL AC/DC

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**Stick Welding  
Power Source** 

## Quick Specs

**Light Industrial Applications**  
Garage/Job Shops  
Plant Fabrication/Maintenance  
Vocational Training  
Light Production-line Work

**Processes**  
Stick (SMAW)  
**Input Power** 1-Phase Power

**Amperage Range**  
**225 AC/150 DC:** HIGH 40–235 A (AC),  
LOW 30–150 A (AC)  
30–160 (DC)  
**300 AC/200 DC:** HIGH 65–300 A (AC),  
LOW 40–200 A (AC)  
30–200 (DC)  
**Max. Open-Circuit Voltage** 80

## The Power of Blue.®

**Infinite current control** allows the operator to adjust output by as little as 1-amp increments. Users can always get the exact heat they need, unlike the step control design on competitive products.

**High 100% duty cycle rating:**  
100 amps AC/65 amps DC for the 225 AC/150 DC amp model.  
130 amps AC/90 amps DC for the 300 AC/200 DC amp model.

The exclusive **patented Accu-Set™** provides precise heat control with infinite amperage control.

**High DC weld output:** up to 150 amps for the 225 AC/150 DC model, and up to 200 amps for the 300 AC/200 DC model, available at 20% duty cycle. Thunderbolt XL 225 AC/150 DC model has 20% more DC output than competitive products.



**Comes Complete With:**  
Power source with 15 ft (4.5 m) electrode cable, electrode holder, 10 ft (3 m) work cable with clamp, and power cord (without plug).

*Note: Thunderbolt XL 225 AC/150 DC (#903 642) includes 230 V plug. Models do not include wall receptacle.*

**Output selector switch** allows you to quickly select AC, DCEP or DCEN without adjusting the output leads.

**Fully varnished magnetic coils:** varnish protects and lengthens the life of the coils inside.

**Forced-draft cooling fan** runs continuously and helps to extend the life of the power source.

## Specifications (Subject to change without notice.)



Model		Rated Output at 20% Duty Cycle	Welding Amperage Range		Max. Open-Circuit Voltage	Amps Input at Rated Output, 50 or 60 Hz		Dimensions	Net Weight
			High	Low		220 V	230 V		
Thunderbolt XL 225 AC/150 DC	AC	225 A at 25 VAC, 60 Hz (15% Duty Cycle at 50 Hz)	40–235	30–150	80	—	47.5	H: 18-3/4 in (476 mm) W: 12-3/4 in (323 mm) D: 17-1/2 in (445 mm)	104 lb (47 kg)
	DC	150 A at 25 VDC, 60 Hz (15% Duty Cycle at 50 Hz)	30–160						
Thunderbolt XL 300 AC/200 DC	AC	300 A at 30 VAC, 50/60 Hz	65–300	40–200	70	—	—		134 lb (61 kg)
	DC	200 A at 25 VDC, 50/60 Hz	30–200						



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

MADE IN **USA**



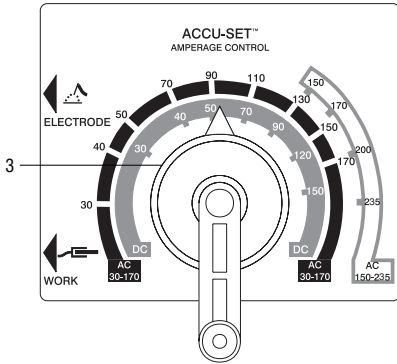
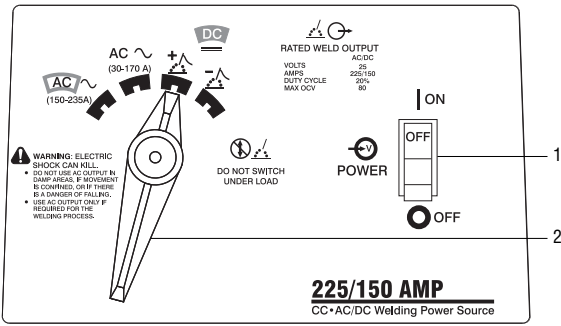
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1635 West Spencer Street  
Appleton, WI 54914 USA

**International Headquarters**  
Phone: 920-735-4505  
USA FAX: 920-735-4134  
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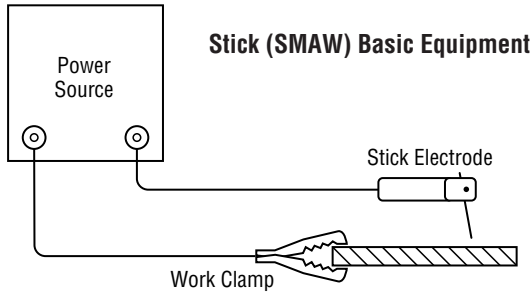
**Web Site**  
www.MillerWelds.com



# Control Panel



# Typical Installation



# Electrode Charts

**ELECTRODE POLARITY CHART**

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6013	EP, EN	✓	ALL	LOW	GENERAL
7014	EP, EN	✓	ALL	LOW	MED. SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	SMOOTH, EASY, FASTER
Ni-CI	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

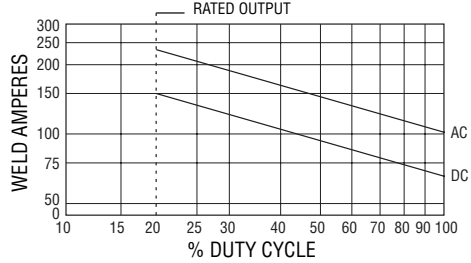
\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

**ELECTRODE/AMPERAGE CHART**

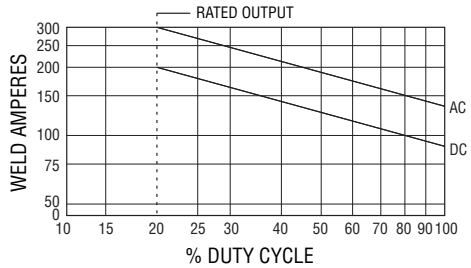
ELECTRODE	DIAMETER		AMPERAGE RANGE					
	IN	MM	MIN.	50A	100A	150A	200A	MAX.
6010 & 6011	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
6013	3/16	4.8						
	1/16	1.6						
	5/64	2.0						
7014	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
7018	3/16	4.8						
	3/32	2.4						
	1/8	3.2						
7024	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
Ni-CI	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
308L	3/16	4.8						
	3/32	2.4						
	1/8	3.2						

# Performance Data

**DUTY CYCLE – FOR 225 AC/150 DC MODELS**



**DUTY CYCLE – FOR 300 AC/200 DC MODELS**



# Ordering Information

Power Source	Stock No.	Description	Qty.	Price
Thunderbolt® XL 225 AC/150 DC	#903 642*	230 V, 50/60 Hz. Includes 5 ft (1.5 m) power cord w/230 V plug		
Thunderbolt® XL 300 AC/200 DC	#903 686	220 V, 50/60 Hz. Includes 7 ft (2.1 m) power cord		
Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and handle.		
<b>Miscellaneous</b>				
Stick Electrodes		See charts above		
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				

Date: Total Quoted Price:

\* Certified to both the Canadian and U.S. Standards for welding equipment.

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