

Maxstar® 210 DX

**TIG/Stick Welding
Power Source**



Quick Specs



Industrial Applications

Precision fabrication
Petro chemical
Aerospace
Food/beverage industry
Dairy
Shipboard

Processes

DC TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)

Input Power 120–480 V, 1- or 3-phase power

Amperage Range 1–210 A (DC)

Rated Output 210 A at 18 V, 60% duty cycle

Net Weight 17.2 kg (38 lb.)

Upgradeable and expandable. Front panel memory card data port provides the ability to easily upgrade software and expand product features.

Pro-Set™ eliminates the guesswork when setting weld parameters. Use Pro-Set when you want the speed, convenience and confidence of preset controls. Simply select the feature and adjust until Pro-Set appears on the display.

Sleep timer conserves electricity by powering down the machine if it sits idle for a specific time.

Auto-Line™ power management technology allows for any input voltage hookup (120–480 V) with no manual linking.

Blue Lightning™ high-frequency (HF) arc starter for non-contact arc initiation. Provides more consistent arc starts and greater reliability compared to traditional HF arc starters.

Meter calibration allows digital meters to be calibrated for certification.

Wind Tunnel Technology™ protects internal electrical components from airborne contaminants, extending the product life.



Fan-On-Demand™ power source cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through the machine.



Power source is warranted for three years, parts and labour.

WELD READY

See page 2 for package contents

DC TIG Features

Exceptionally smooth and precise arc for welding exotic materials.

Pulse. Pulsing can increase puddle agitation, arc stability and travel speeds while reducing heat input and distortion.

DC Stick Features

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.

Hot Start™ adaptive control provides positive arc starts without sticking.

Stick-Stuck detects if the electrode is stuck to the part and turns the welding output off to safely and easily remove the electrode. Menu selectable.

Specifications (Subject to change without notice.)



Welding Mode	Input Power	Welding Amperage Range	Rated Output at 60% Duty Cycle	IP Rating	Phase	Amps Input at Rated Load Output, 50/60 Hz								Max. Open-Circuit Voltage	Dimensions	Net Weight	
						120 V	208 V	240 V	400 V	480 V	KVA	KW					
TIG (GTAW)	208–480 V	1–210 A	210 A at 18.4 V	IP23	3-phase	—	14	12	7	6	5.2	4.9	80 VDC (11 VDC*)	H: 346 mm (13.6 in.) W: 219 mm (8.6 in.) D: 495 mm (19.5 in.)	17.2 kg (38 lb.)		
	120 V	1–210 A	125 A at 15 V		1-phase	22	—	—	—	—	2.6	2.6					
Stick (SMAW)	208–480 V	5–210 A	160 A at 26.4 V		3-phase	—	15	13	8	6	5.5	5.2					
					1-phase	—	26	22	13	11	5.3	5.3					
	120 V	5–100 A	90 A at 23.6 V		1-phase	23	—	—	—	—	2.8	2.8					

* Low OCV sense voltage for stick and Lift-Arc™ TIG.

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. All CE models conform to the applicable parts of the IEC 60974 series of standards.

ITW Welding



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Genuine Miller® Accessories



Small Runner™ Cart 301318

Designed for Maxstar 210/280, Dynasty 210/280, STH 270 and STi 270, with or without cooler. Cart features single cylinder rack, cable holder and foot pedal holder.



MH Running Gear 018035026

Designed for Maxstar 210/280, Dynasty 210/280, STH 270 and STi 270, with or without cooler. Easy-to-manuever two-wheel cart with single cylinder rack, cable holder and storage area.

Memory Cards

Memory Card Expansion

301151 14-Pin Automation Expansion

301152 14-Pin Modbus® Expansion

301328 Hot Wire Power Supply Expansion

Memory Card (Blank) 301080

Blank memory card for transferring data from computer to machine.

Remote Controls and Switches



Wireless Remote Foot Control 300429

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine.



RFCS-14 HD Foot Control 194744

Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Provides remote current and contactor control.



RCC-14 Remote Contactor and Current Control 151086

14-pin plug

Side-to-side rotary-motion fingertip control fastens to TIG torch using two hook-and-loop straps.



SHRC-14 Remote Control

058040019 5 m (16.4 ft.)

058040020 10 m (32.8 ft.)

058040021 20 m (65.6 ft.)

Single-hand control for current only.



Wireless Remote Hand Control 300430

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Maxstar® 210 DX	907684001	Includes 2.4 m (8 ft.) power cord and gas connection kit		
Maxstar® 210 DX, 4 m Air-Cooled Weld Ready Package	029083215	Includes 2.4 m (8 ft.) power cord, 5 m (16.4 ft.) work cable with clamp, 4 m (13.1 ft.) Miller® WP-17S4AXFD 150 A TIG torch, 3 m (10 ft.) gas hose, 5 m (16.4 ft.) electrode cable with holder, torch accessory kit, and USB with owner's manuals		
Maxstar® 210 DX, 8 m Air-Cooled Weld Ready Package	029083236	Includes 2.4 m (8 ft.) power cord, 5 m (16.4 ft.) work cable with clamp, 8 m (26.2 ft.) Miller® WP-17S4AXFD 150 A TIG torch, 3 m (10 ft.) gas hose, 5 m (16.4 ft.) electrode cable with holder, torch accessory kit, and USB with owner's manuals		
Accessories				
Small Runner™ Cart	301318			
MH Running Gear	018035026	MH two-wheeled cart with cylinder rack		
Memory Card Expansion	301151 301152 301328	14-pin automation expansion 14-pin Modbus® expansion Hot wire power supply expansion		
Memory Card (Blank)	301080			
Stick Welding Cable Kit	057014351	200 A, 35 mmq, 5 m (16.4 ft.)		
Work Cable with Clamp	057014331	200 A, 35 mmq, 5 m (16.4 ft.)		
Remote Controls				
Wireless Remote Foot Control	300429	Foot control with wireless 27.4 m (90 ft.) operating range		
RFCS-14 HD	194744	6 m (20 ft.), heavy-duty foot control		
RCC-14	151086	8 m (26.5 ft.), remote current/contactor side-to-side rotary control		
RCCS-14	043688	8 m (26.5 ft.), remote current/contactor up-and-down rotary control		
SRHC-14		See above for more information		
RHC-14	242211020	6 m (20 ft.), remote current/contactor hand control		
Wireless Remote Hand Control	300430	Hand control with wireless 91.4 m (300 ft.) operating range		
RMS-14	187208	8 m (26.5 ft.), momentary-contact switch for contactor control		

Date:

Total Quoted Price:

Miller recommends *elga* consumables

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