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Maxstar® 400

TIG/Stick Welding Power Source

QUICK SPECS

Industrial Applications
Precision fabrication
Tube mills
Pipe and tube fabrication
Tool and die
Exotic material fabrication
Pressure vessel fabrication

Processes
TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)
Air carbon arc (CAC-A)
1/4 in. maximum

Input Power 208–600 V, 3-phase or 1-phase power

Amperage Range 3–400 A

Rated Output 300 A at 32 V, 60% duty cycle

Net Weight 26 lb. (57 kg)

Reimagined for Your Pursuit of Perfection.

Unlock your full potential with the new Maxstar 400 advanced DC TIG welder. Now equipped with an intuitive LCD interface that puts precision welding capabilities at your fingertips. Demand more from your machine and achieve results that you never thought were possible.

Easy-to-understand interface with 7-inch LCD display.
- Ensures proper machine setup and parameter selection
- Informative on-screen explanations and dynamic images enhance the parameter selection process

Maxstar 400 machine only

WIRELESS REMOTE COMPATIBLE

Maxstar 400 Wireless Complete

QUIETPULSE™

Activate QuietPulse by selecting sine or triangular waveshape to reduce audible noise.

Blue Lightning™ provides more consistent high-frequency (HF) arc starts and greater reliability compared to traditional arc starters.

Lift-Arc™ provides AC or DC arc initiation without the use of high frequency.

AUTO-LINE™ TECHNOLOGY

Allows for any input voltage hookup (208–600 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

Program memory allows easy naming, saving and recalling of favorite weld settings.
- Deliver more productivity by eliminating the need to manually set the parameters
- Deliver consistent quality by welders of all skills

Pro-Set™ eliminates the guesswork when setting weld parameters.

Locks and limits. Provides control of weld parameter ranges minimizing deviation from the welding procedure specification (WPS).

USB. Front panel port provides the ability to easily update software, back-up settings and transfer saved weld programs from one unit to the next.

Visit MillerWelds.com/TIGSoftware for the latest software updates and expansions.

Cooler Power Supply (CPS) is a dedicated-use receptacle for the Coolmate™ PRO 4.

Cooler-On-Demand™ feature operates the auxiliary cooling system only when needed, reducing noise, energy use, and airborne contaminants pulled through the cooler.

TRUE BLUE® 3 YR. WARRANTY

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

Miller Electric Mfg. LLC
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
Phone: 866-931-9730
International Phone: 920-735-4554

MillerWelds.com

Certified System ISO 9001 Quality

Weld Process Features

DC TIG

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.

Pulse Waveforms

Square provides a fast freezing puddle for ultimate arc control.

Sine produces a reduced audible sound and provides a more fluid puddle that is good for overlaying applications.

Triangular provides a quick-forming puddle while further reducing heat for thin materials.

QuietPulse™. Activate QuietPulse by selecting sine or triangular waveshape to reduce audible noise.

DC Stick

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.)

CC DC 3 Phase 1 Phase

INPUT POWER	WELDING AMPERAGE RANGE	RATED OUTPUT	AMPS INPUT AT RATED OUTPUT, 50/60 HZ 208 V	230 V	400 V	460 V	600 V	KVA	KW	MAX. OPEN-CIRCUIT VOLTAGE	DIMENSIONS	NET WEIGHT
3-phase	3–400 A	250 A at 30 V, 100% duty cycle	27	24	14	12	9	9.4	9.1	75 VDC (10–15 VDC*)	H: 24.125 in. (613 mm) W: 13.875 in. (352 mm) D: 24.313 in. (618 mm) with TIGRunner® H: 43.125 in. (1,095 mm) W: 23.125 in. (587 mm) D: 41.625 in. (1,057 mm)	126 lb. (57 kg) with TIGRunner® 246 lb. (112 kg)
		300 A at 32 V, 60% duty cycle	33	30	17	15	11	12	11.6			
1-phase	3–400 A	200 A at 28 V, 100% duty cycle	36	33	18	15	11	7.4	6.9			
		250 A at 30 V, 60% duty cycle	48	43	24	20	15	10	9.2			

**Sense voltage for low OCV stick and Lift-Arc™ TIG.*

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

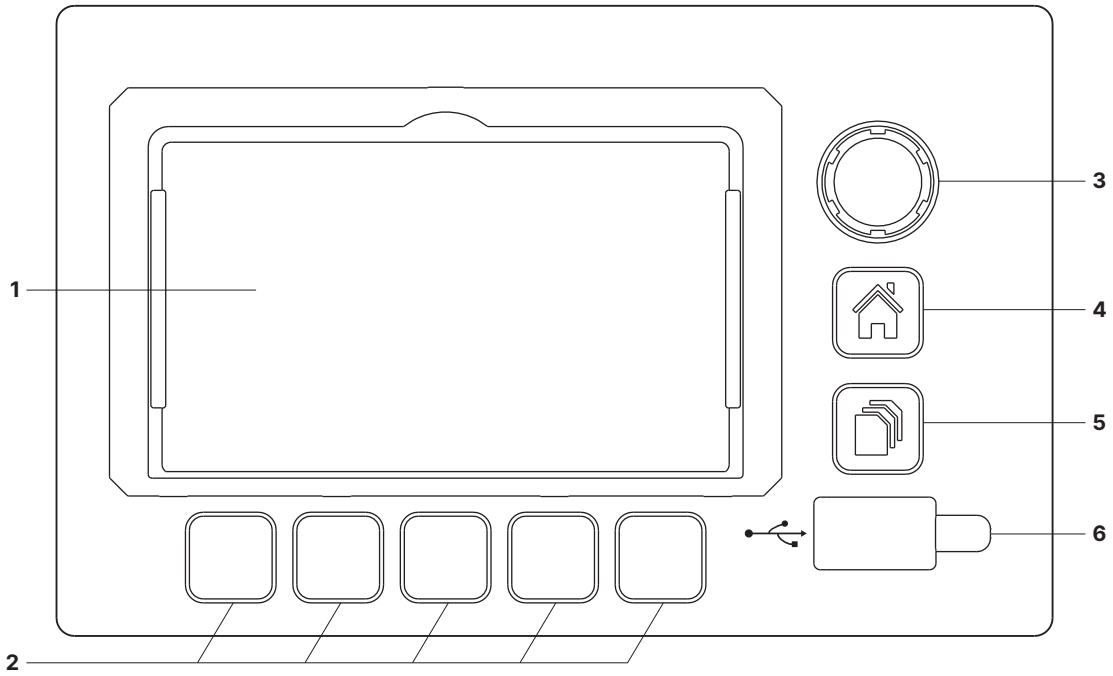
All CE models conform to the applicable parts of the IEC 60974 series of standards.

Performance Data

INPUT POWER	TIG (GTAW) DUTY CYCLE	STICK (SMAW) DUTY CYCLE	DC TIG MATERIAL THICKNESS RANGE	STICK ELECTRODE MAXIMUM DIAMETER	CARBON ARC GOUGING (CAC-A) MAXIMUM	GENERATOR REQUIREMENT
3-phase	400 A, 20% 300 A, 60% 250 A, 100%	400 A, 20% 300 A, 60% 250 A, 100%	.012–5/8 in. (0.3–15.9 mm)	6010: 1/4 in. (6.4 mm) 7018: 1/4 in. (6.4 mm) 7024: 1/4 in. (6.4 mm)	1/4 in. (6.4 mm)	20 kW
1-phase	300 A, 20% 250 A, 60% 200 A, 100%	300 A, 20% 250 A, 60% 200 A, 100%				

Maxstar® 400 Control Panel

1. Color LCD Display
2. Soft Keys *(multiple functions depending on screen displayed)*
3. Control Knob *(adjusts amperage or parameter values depending on mode)*
4. Home Button
5. Program Button
6. USB Port



Amperage	
TIG	3–400 A**
Stick	3–400 A
Process	DC TIG HF, DC TIG Lift-Arc™, DC Stick, Carbon Arc Gouge
Tungsten (inch)	.020, .040, 1/16, 3/32, 1/8, 5/32, 3/16 inch, General (.05, 1.0, 1.6, 2.4, 3.2, 4.0, 4.8 mm)
Trigger	Remote Standard: Foot, Finger, Pushbutton Sequencer: Pushbutton Hold (2T), 3T 4T, 4TE, 4TL, 4TM
Pulse	
Pulses per Second*	0.1–5,000 pps
Peak Time*	5–95%
Background Amps*	5–95%
Pulse Waveshape:	Square, Sine, Triangular

Sequencer Control	
Initial Amps	3–400 A**
Initial Time	0.0–25.0 seconds
Initial Slope	0.0–50.0 seconds
Weld Time	0.0–999 seconds
Final Slope	0.0–50.0 seconds
Final Amps	3–400 A**
Final Time	0.0–25.0 seconds
Preflow	0.0–25.0 seconds
Postflow	Auto/Off–50 seconds
DIG*	Off–100%
Hot Start™	On, Off
Stick-Stuck	On, Off
OCV	Normal, Low
Programs	1–99 (user defined program names)
Locks and Limits	Individual Parameters
Languages	English, Spanish, French, German, Italian, Dutch, Swedish, Polish

**Pro-Set parameter selectable. **Amperage range is tungsten size dependent.*

Maxstar® 400 Models/Packages

Machines and Preconfigured Water-Cooled Packages —
Order machine only or use a single stock number to order a complete preconfigured system

907955 model shown.

907955001 package shown.

951000265 package shown.

Machine Only	TIGRunner® Package	Complete Package
Maxstar 400 907955 **Maxstar 400, CE** 907955002 Maxstar 400 comes with: • 8 ft. power cord (no plug) • Two 50 mm Dinse-style connectors	**Maxstar 400** 907955001 **Maxstar 400, CE** 907955003 Maxstar 400 TIGRunner comes with: • 8 ft. power cord (no plug) • Coolmate™ PRO 4 (quick connect model on CE TIGRunner) • Runner™ cart	**Maxstar 400 with Wireless Foot Control** **951000265** Complete package includes TIGRunner at left, plus: • Coolant (4 one-gallon bottles) • W-375 torch kit (see page 6 for contents) • Wireless foot control

Maxstar® 400 Models/Packages

Build a Water-Cooled Package — select desired stock number for each step

907955001 Maxstar 400 TIGRunner® shown with four bottles of 043810 Low-Conductivity Coolant.

301580 remote shown.

301268 kit shown.

Step 1 • Select Dynasty TIGRunner® and Coolant		Step 2 • Select Remote Control		Step 3 • Select Torch Kit	
Maxstar 400 TIGRunner	**907955001**	**Wireless Foot**	**301580**	**W-250 Kit**	**300185**
Maxstar 400 TIGRunner, CE	**907955003**	**RFCS-14 HD Foot**	**301589**	**W-280 Kit**	**300990**
&		**RCC-14 E/W Fingertip**	**151086**	**W-375 Kit**	**301268**
Low-Conductivity Coolant	**043810**	**RCCS-14 N/S Fingertip**	**043688**	(recommended for 400 model)	
(must be ordered in quantities of four)		**RMS-14 Pushbutton**	**187208**	**W-400 (WP-18SC) Kit**	**300186**
		RMLS-14 Momentary/Maintained	**129337**	See page 6 for kit contents.	
		RHC-14 Hand	**242211020**	*Note: If ordering torch or torch kit for the CE TIGRunner, the **QRW** water hose quick connects are required.*	
		Wireless Hand	**301582**		
		See page 7 for remote descriptions.			

Genuine Miller® Accessories

Runner™ Cart 300244
Designed to accommodate Dynasty 400/800 or Maxstar 400 power sources and a Coolmate™ PRO 4 cooler. Cart features single cylinder rack, foot pedal holder, three cable/torch holders, and two TIG electrode filler holders.

Protective Cover
301920
Heavy-duty cover used to protect your welder from damage, wear, and corrosion when not in use.

Protective cover shown with runner cart (sold separately).

Coolmate™ PRO 4
301905 CE
301911 CE, quick connect
120/240 V, 50/60 Hz. Industrial 4-gallon cooler for use with water-cooled torches rated up to 600 amps. Designed to integrate with the Dynasty 400/800 and Maxstar 400 power sources.

Low-Conductivity Coolant 043810
Must be ordered in quantities of four. One-gallon recyclable plastic bottle. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37 degrees Fahrenheit (-38°C) or boiling to 227 degrees Fahrenheit (108°C). Also contains a compound that resists algae growth.

Performance TIG Gloves
263346 Small
263347 Medium
263348 Large
263349 X-Large
Completely unlined, goat grain leather with triple-padded palm.

Performance TIG/Multitask Gloves
263352 Small
263353 Medium
263354 Large
263355 X-Large
Goat grain leather with dual-padded palm and wool back.

Cut-Resistant TIG Gloves
290401 Small
290402 Medium
290403 Large
290404 X-Large
290411 2X-Large
Protects against cuts and abrasions with an ANSI A5 cut rating, level 4 puncture and abrasion ratings, and level 3 heat rating.

Automation Interface Connection Kit
278161 Field
Provides control of power source welding parameters through a 28-pin receptacle. The 28-pin receptacle replaces the standard 14-pin receptacle and requires a PLC controller to operate the power source. Ideal for automated equipment integration.

Weld Current Sensor 300179 Field
Detects when work clamp is not connected and prevents expensive damage to disconnect devices and input power cord and wiring.

TIG Torches, Kits and Connectors

Contractor Kit 301549
All-in-one TIG/stick welding kit comes with a Weldcraft™ A-200 TIG torch, RFCS-14 HD foot control, 200-amp stick electrode holder and 300-amp work clamp with 15-foot (4.6 m) cables, flow gauge regulator with 12-foot (3.7 m) gas hose, gas hose coupler, AK2C torch accessory kit and TIG torch connector.

Weldcraft™ A-200 (WP-26) TIG Torch
WP-26-12-R 12 ft.
WP-26-25-R 25 ft.
200-amp air-cooled torch. Torch body gas valve models are available.

*Note: A-200 (WP-26) torches require **195379** connector.*

Air-Cooled TIG Torch Connector 195379
50 mm Dinse-style for one-piece A-200 (WP-26) torch air-cooled torch.

W-280 Water-Cooled Torch Kit 300990
Kit comes with Weldcraft™ W-280 25-foot (7.6 m) TIG torch with Dinse-style connector, torch cable cover, work clamp with 15-foot (4.6 m) 1/0 cable and Dinse-style connector, flowmeter regulator with gas hose and AK4GL gas lens torch accessory kit.

W-375 Water-Cooled Torch Kit 301268
Standard torch kit included in Maxstar® 400 Complete package. Kit comes with Weldcraft™ W-375 25-foot (7.6 m) TIG torch with Dinse-style connector, torch cable cover, work clamp with 15-foot (4.6 m) 1/0 cable and Dinse-style connector, flowmeter regulator with gas hose and AK4GL gas lens torch accessory kit.

Genuine Miller® Accessories

TIG Torches, Kits and Connectors (cont.)

W-400 (WP-18SC) Water-Cooled Torch Kit 300186
Kit comes with Weldcraft™ W-400 25-foot (7.6 m) TIG torch with thread-lock connector, torch cable cover, work clamp with 12-foot (3.7 m) 4/0 cable and thread-lock connector, flowmeter regulator with gas hose and AK18C torch accessory kit.

Water-Cooled TIG Torch Connector 195377
50 mm Dinse-style with water return line. For use with all Weldcraft™ water-cooled torches.

Weldcraft™ Gas Hose Quick Connect QRG
Sold individually. Allows for quick connection and removal of torch shielding gas hoses.

Weldcraft™ Water Hose Quick Connect QRW
Sold individually. Allows for quick connection and removal of torch coolant hoses.

Remote Controls and Switches

Wireless Remote Foot Control 301580
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

RFCS-14 HD Foot Control 301589
Heavy-duty foot pedal current and contactor control provides increased stability and durability from larger base and heavier cord. Includes 20-foot (6 m) cord with plug.

RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCCS-14 Remote Contactor and Current Control 043688
North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

RMS-14 On/Off Control 187208
Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

RMLS-14 Switch 129337
Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.

RHC-14 Hand Control 242211020
Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 83 mm). Includes 20-foot (6 m) cord and 14-pin plug.

Wireless Remote Hand Control 301582
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

Extension Cables for 14-Pin Remote Controls
242208025 25 ft. (7.6 m)
242208050 50 ft. (15.2 m)
242208080 80 ft. (24.4 m)

Educational Materials

To order, please call Miller Literature at 866-931-9732 or visit MillerWelds.com/resources/tools.

Gas Tungsten Arc Welding (TIG) Publication 250833

Tungsten

TUNGSTEN	AMP RANGE	2% CERIATED (AC/DC)	2% LANTHANATED (AC/DC)
1/16 in. (1.6 mm)	70–150 A	**WC116X7**	**WL2116X7**
3/32 in. (2.4 mm)	140–250 A	**WC332X7**	**WL2332X7**
1/8 in. (3.2 mm)	225–400 A	**WC018X7**	**WL2018X7**
5/32 in. (4.0 mm)	300–500 A	**WC532X7**	**WL2532X7**

Ordering Information

EQUIPMENT AND OPTIONS	STOCK NO.	DESCRIPTION	QTY.	PRICE
Maxstar® 400	**907955** **907955002**	Auto-Line™ 208–600 V, 50/60 Hz. 8 ft. power cord Auto-Line™ 380–600 V, 50/60 Hz, **CE**. 8 ft. power cord		
Maxstar® 400 TIGRunner®	**907955001** **907955003**	Auto-Line™ 208–600 V, 50/60 Hz. 8 ft. power cord (Torch kit, accessories and coolant sold separately) Auto-Line™ 380–600 V, 50/60 Hz, **CE**. 8 ft. power cord (Torch kit, accessories and coolant sold separately)		
Maxstar® 400 Complete with Wireless Foot Control	**951000265**	Auto-Line™ 208–600, 50/60 Hz. 8 ft. power cord		
Accessories				
Runner™ Cart	**300244**	See page 6		
Protective Cover	**301920**	See page 6		
Coolmate™ PRO 4	**301905** **301911**	120/240 V, 50/60 Hz, **CE**. *Requires coolant* 120/240 V, 50/60 Hz, **CE**. Quick connect. *Requires coolant*		
TIG Coolant (must be ordered in quantities of four)	**043810**	1-gallon plastic bottle. Protects against freezing to -37° Fahrenheit (-38°C) or boiling to 227° Fahrenheit (108°C)		
TIG Gloves		See page 6		
Automation Interface Kit	**278161**	Field installation required. Provides 28-pin automation connections		
Weld Current Sensor	**300179**	Field installation required. Detects when work clamp is not connected		
Dinse-Style Connector 50 mm (1 male)	**042418**	Used to connect weld cable to Dinse terminal machine		
Dinse-Style Connector 50 mm (1 male, 1 female)	**042419**	Used to extend weld cables		
Dinse/Tweco® Adapter	**042465**	Male Dinse to female Tweco		
Dinse/Cam-Lok Adapter	**042466**	Male Dinse to female Cam-Lok		
TIG Torches, Kits and Connectors				
Air-Cooled Contractor Kit		See page 6		
Weldcraft™ A-200 (WP-26) TIG Torch		For Dynasty 400 only. Requires **195379** connector		
Water-Cooled Torch Kits		See page 6		
Water-Cooled TIG Torch Connectors	**195377**	Connects Weldcraft™ water-cooled torches to Dinse-style connector		
Weldcraft™ Quick Connects (sold individually)	**QRG** **QRW**	For gas hoses For water hoses		
Tungsten		See page 7		
Remote Controls		See page 7		
Educational Materials		See page 7		

DATE: TOTAL QUOTED PRICE:

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The Power of Blue®

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