# Maxstar® 350 and 700

## Industrial Applications
- Precision Metal 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)

*350: 1/4 in maximum
700: 3/8 in maximum*

## Input Power
- 208 – 575 V, 3- or 1-Phase

## Amperage Range
- **350:** 3 – 350 A
- **700:** 5 – 700 A

## Rated Output
- **350:** 300 A at 32 V, 60% Duty Cycle
- **700:** 600 A at 44 V, 60% Duty Cycle

## Weight
- **350:** 135.5 lb (61 kg)
- **700:** 198 lb (90 kg)

## Quick Specs

## The Power of Blue®

**Auto-Line**

Allows for any input voltage hookup (208–575 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

**NEW! Blue Lightning™**

High Frequency Arc Starter for non-contact arc initiation. More consistent arc starts compared to traditional HF arc starters. Greater reliability and no maintenance on solid-state components. Preset parameters for tungsten sizes from .020 – ¼ inch provide optimized starting for applications from thick to micro thin. For unique applications, custom settings are programmable.

**Lift-Arc™** start provides arc starting without the use of high frequency.

**Meter Calibration** allows meters to be calibrated for certification.

**120 V auxiliary power** receptacle for cooling system or small tools.

**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 though the machine.

**Program memory** features 9 independent program memories that maintain/save your parameters.

**Auto-Postflow** calculates the length of postflow time based on the amperage setting. This eliminates the need to independently set the postflow time for different amperages. This feature preserves your tungsten and prevents porosity.

## DC TIG Features

Exceptionally smooth and precise arc for welding exotic materials.

**High-Speed DC TIG Pulse Control** — pulse frequency capable of pulsing 5000 pulses per second. Pulsing adds arc stability, reduces heat input and warpage and can increase travel speeds. Other parameters include peak amperage, peak time and background amperage.

## DC Stick Features

**Tailored arc control (DIG)** allows the arc characteristic to be changed for specific applications and electrodes. Smooth running 7018 or stiffer, more penetrating 6010.

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

## DC 350

Program memory features 9 independent program memories that maintain/save your parameters.

## True Blue®

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

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

**Equipment Sales US and Canada**
Phone: 866-931-9730
Fax: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

**Web Site**
www.MillerWelds.com
### Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Welding Amperage Range</th>
<th>Max. Open-Circuit Voltage</th>
<th>Rated Output</th>
<th>Amps Input at Rated Load Output, 50/60 Hz</th>
<th>Dimensions</th>
<th>Net Weight</th>
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</thead>
<tbody>
<tr>
<td>Maxstar 350</td>
<td>3–350 A</td>
<td>75 VDC 10–15 VDC*</td>
<td>250 A at 30 V, 100% Duty Cycle</td>
<td>27 24 14 12 9</td>
<td>9.7 9.3</td>
<td>H: 24-3/4 in (629 mm) W: 13-3/4 in (349 mm) D: 22 in (559 mm) with TIGRunner® H: 45-1/8 in (1146 mm) W: 23-1/8 in (587 mm) D: 43-3/4 in (1111 mm)</td>
<td>135.5 lb (61 kg)</td>
</tr>
<tr>
<td></td>
<td>3–350 A</td>
<td>75 VDC 10–15 VDC*</td>
<td>300 A at 32 V, 60% Duty Cycle</td>
<td>33 30 17 15 12 12 11.5</td>
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<td>with TIGRunner®</td>
<td>308 lb (140 kg)</td>
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<td>Maxstar 700</td>
<td>5–700 A</td>
<td>75 VDC 10–15 VDC*</td>
<td>180 A at 27.2 V, 100% Duty Cycle</td>
<td>32 16 — 14 11 6.4 6</td>
<td></td>
<td>H: 34-5/8 in (879 mm) W: 13-3/4 in (349 mm) D: 22 in (559 mm)</td>
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<td>5–700 A</td>
<td>75 VDC 10–15 VDC*</td>
<td>225 A at 29 V, 60% Duty Cycle</td>
<td>41 37 — 19 15 8.6 8.2</td>
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<td>with TIGRunner®</td>
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*Indicates sense-voltage for Lift-Arc TIG and Low OCV Stick.

#### Performance Data

### DUTY CYCLE

<table>
<thead>
<tr>
<th>Model</th>
<th>%</th>
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<td>Maxstar 350</td>
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<tr>
<td>60%</td>
<td>300 A</td>
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<tr>
<td>100%</td>
<td>250 A</td>
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<tr>
<td>Maxstar 700</td>
<td>3-PHASE</td>
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<tr>
<td>30%</td>
<td>700 A</td>
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<tr>
<td>60%</td>
<td>600 A</td>
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<tr>
<td>100%</td>
<td>500 A</td>
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<tr>
<th>Model</th>
<th>%</th>
<th>AMPERAGE</th>
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<td>10%</td>
<td>350 A</td>
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<tr>
<td>30%</td>
<td>250 A</td>
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<td>60%</td>
<td>225 A</td>
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<tr>
<td>100%</td>
<td>180 A</td>
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<tr>
<td>Maxstar 700</td>
<td>1-PHASE</td>
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<tr>
<td>10%</td>
<td>700 A</td>
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<td>30%</td>
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<td>60%</td>
<td>450 A</td>
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<tr>
<td>100%</td>
<td>360 A</td>
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Maxstar® 350 and 700 Control Panel

Control Panel Parameter Values

1. Memory
   18 Combinations
   (9 DC TIG)
   (9 DC Stick)

2. Process/Arc Starting
   TIG: HF Impulse, Lift Arc
   STICK: Adaptive Hot Start

3. Output Control
   Standard Remote,
   2T Trigger Hold,
   Output ON

4. Pulser Control
   Pulses per Second: DC: 0.1–5000 PPS
   Peak Time: 5–95%
   Background Amps: 5–95%

5. Sequencer Control
   Initial Amps: Maxstar 350: 3–350 A
   Maxstar 700: 5–700 A
   Initial Slope: 0.0–50.0 Seconds
   Final Slope: 0.0–50.0 Seconds
   Final Amps: Maxstar 350: 3–350 A
   Maxstar 700: 5–700 A

6. Gas/DIG Preflow
   Postflow: 0.0–25.0 Seconds
   Auto Postflow, Adjust 0.0–50 Seconds
   DIG: 0–100%

7. Amperage Control

8. Encoder Control

9. Ammeter Display

10. Voltmeter Display

11. Memory Display

Additional Setup Parameter Values

Preprogrammed Starts
   Maxstar 350: .020 – 3/16 in Tungsten
   Maxstar 700: .020 – 1/4 in Tungsten

Programmable Starts
   Amperage: Maxstar 350: 3–200 A
   Maxstar 700: 5–200 A
   Time: 1–200 Milliseconds
   Ramp Time: 0–250 Milliseconds
   Minimum Amperage: Maxstar 350: 3–25 A
   Maxstar 700: 5–25 A

Additional Triggers: 3T, 4T, Mini Logic,
4T Momentary

Spot/Weld Timer: 0.0–999 Seconds

OCV: Low OCV, Normal OCV
Stick Stuck Check: On/Off
Lockouts: Four levels
Arc Timer: 0.0–9999 Hours
and 0–59 Min
Cycle Counter: 0–999,999 Cycles
Meter Calibration: ±0–20.0 A amps
±0–20.0 Volts
**Pulse TIG Controls**

**High Speed DC TIG-Pulse Controls**
- **PPS Pulses per second (Hz):** DC = 0.1 – 5,000 PPS
- **% ON – % Peak Time:** 5 - 95% (Controls the amount of time during each pulse cycle at the PEAK amperage.)
- **Background Amps:** 5 – 99% (Sets the low-pulse amperage value as a % of the Peak Amps.)

### CONVENTIONAL PULSED TIG

Typically from 1 to 10 PPS. Provides a heating and cooling effect on the weld puddle and can reduce distortion by lowering the average amperage. This heating and cooling effect also produces a distinct ripple pattern in the weld bead. The relationship between pulse frequency and travel speed determines the distance between the ripples. Slow pulsing can also be coordinated with filler metal addition and can increase overall control of the weld puddle.

![Conventional Pulsed TIG Diagram](image)

### HIGH SPEED PULSED TIG

In excess of 40 PPS, Pulsed TIG becomes more audible than visible — causing increased puddle agitation for a better as-welded microstructure. Pulsing the weld current at high speeds — between a high Peak and a low Background amperage — can also constrict and focus the arc. This results in maximum arc stability, increased penetration and increased travel speeds (Common Range: 100 – 500 PPS).

The Arc-Sharpening effects of high speed pulsing are expanded to new dimensions. The ability to pulse at 5,000 PPS further enhances arc stability and concentration potential — which is extremely beneficial to automation where maximum travel speeds are required.

![High Speed Pulsed TIG Diagram](image)
Maxstar® Power Sources

Maxstar® 350  #907 334  (CSA)  
(Auto-Line™ 208–575 VAC)
Maxstar® 350  #907 334-02-1  (CE)  
(Auto-Line™ 380–575 VAC)

8 ft (2.4 m) primary cord, (2) international (Dinse 50) connectors, and CD-ROM Setup and Simulator.

Note: TIG torch adapter must be ordered separately.

Maxstar® 700  #907 103  (CSA)  
(Auto-Line™ 208–575 VAC)
Maxstar® 700  #907 103-02-1  (CE)  
(Auto-Line™ 380–575 VAC)

(2) thread lock weld cable connectors (#225 029), (1) water-cooled thread lock torch adapter (#225 028) for #18 or #20 torches, and CD-ROM Setup and Simulator.

Note: Primary cord and TIG torch must be ordered separately.

TIGRunner® Package

Maxstar 350 TIGRunner®  
#907 334-01-1  (CSA)

Completely assembled.

Package includes:
- Maxstar® 350 (#907 334)
- RFCS-14 HD remote foot control
- Coolmate® 3.5 Coolant System
- Cart with the following features:
  - single cylinder rack, foot pedal holder,
  - (3) cable/torch holders, (2) TIG electrode filler holders and a convenient drawer
  - for tungsten and consumable storage

Note: Torch package and coolant must be ordered separately.

Complete Package

Maxstar 350 Complete  #951 073  (CSA)

Completely assembled.

Package includes:
- Maxstar® 350 TIGRunner® (#907 334-01-1)
- 25 ft (7.6 m) Weldcraft CS310 torch
- Torch cable cover
- CS310AKC torch accessory kit includes shielding cups, collets, collet bodies and 2% cerium tungsten electrodes (1/16, 3/32, and 1/8 in)
- Smith regulator/flowmeter HM2051A-580
- 12 ft (3.7 m) rubber gas hose (regulator to machine)
- Water-cooled Dinse torch adapter
- 15 ft (4.6 m) 1/0 weld lead with clamp (work or ground lead) and Dinse connector
- 4 gallons of pre-mixed low-conductivity coolant (#043 810)
Genuine Miller Accessories

Torch Kits

250 A Water-Cooled Torch Kit #300 185
- 25 ft (7.6 m) Weldcraft® WP20 torch
- Torch cable cover
- AK4C torch accessory kit includes shielding cups, collets, collet bodies and 2% cerium tungsten electrodes (1/16, 3/32 and 1/8 in)
- Smith® regulator/flowmeter HM2051A-580
- 12 ft (3.7 m) rubber gas hose (regulator to machine)
- Water-cooled Dinse torch adapter
- 15 ft (4.6 m) 1/0 weld lead with clamp (work or ground lead) and Dinse connector

300 A Water-Cooled Torch Kit #300 183
Recommended for Maxstar 350
- 25 ft (7.6 m) Weldcraft® CS310 torch
- Torch cable cover
- CS310AKC torch accessory kit includes shielding cups, collets, collet bodies and 2% cerium tungsten electrodes (1/16, 3/32 and 1/8 in)
- Smith® regulator/flowmeter HM2051A-580
- 12 ft (3.7 m) rubber gas hose (regulator to machine)
- Water-cooled Dinse torch adapter
- 15 ft (4.6 m) 1/0 weld lead with clamp (work or ground lead) and Dinse connector

400 A Water-Cooled Torch Kit #300 186
Recommended for Maxstar 700
- 25 ft (7.6 m) Weldcraft® WP18SC torch
- Torch cable cover
- AK18C torch accessory kit includes shielding cups, collets, collet bodies and 2% cerium tungsten electrodes (3/32, 1/8 and 5/32 in)
- Smith® regulator/flowmeter H1954D-580
- 12 ft (3.7 m) rubber gas hose (regulator to machine)
- Water-cooled thread lock torch adapters
- 12 ft (3.7 m) 4/0 weld lead with clamp (work or ground lead)

Automation Interface Kit #195 516
Field Includes automation PC board, 28-pin socket receptacle with harness, 28-pin plug connector. Provides required and advanced automation controls.

Weld Current Sensor #300 179
Detects when work clamp is not connected and prevents expensive damage to disconnect devices and input power cord and wiring.

Educational Materials

To order these items, distributors can call the Miller Literature Distribution Center at 1-920-735-4356, or FAX 1-920-735-4011.

Gas Tungsten Arc (TIG) Welding Book #170 555
86 pages — 8-1/2 x 11 in. A comprehensive text on all aspects of the GTA welding process. Filled with figures and tables to illustrate process technique and equipment setup. Glossary of TIG terms also provided.

CD-ROM #233 558
Simulator and setup video (included with machine).

Runner Cart #300 244
Designed to accommodate the Dynasty® or Maxstar™ 350 or 700 power sources and the Coolmate™ 3.5 Cooler. Cart features: single cylinder rack, foot pedal holder, (3) cable/torch holders, (2) TIG electrode filler holders and a convenient drawer for tungsten and consumable storage.

Runner Cart

Tungsten

Tungsten is 7 in length and available in pkgs of 10. Order from Miller Parts.

2% Ceriated (orange) for AC/DC applications
#WC040X7 .040 in, 10–80 A
#WC116X7 1/16 in, 70–150 A
#WC332X7 3/32 in, 140–250 A
#WC018X7 1/8 in, 225–400 A
#WC532X7 5/32 in, 300–500 A

1.5% Lanthanum (gold) for AC/DC applications
#WL040X7 .040 in, 10–80 A
#WL116X7 1/16 in, 70–150 A
#WL332X7 3/32 in, 140–250 A
#WL018X7 1/8 in, 225–400 A
#WL532X7 5/32 in, 300–500 A

2% Thoriated (red) for DC applications only
#WT040X7 .040 in, 10–80 A
#WT116X7 1/16 in, 70–150 A
#WT332X7 3/32 in, 140–250 A
#WT018X7 1/8 in, 225–400 A
#WT532X7 5/32 in, 300–500 A

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**Remote Controls and Switches**

**RCCS-14 Remote Contactor and Current Control** #043 688
14-pin plug
North/south rotary-motion fingertip control fastens to TIG torch using two Velcro® straps. Great for applications that require a finer amperage control. Includes 26.5 ft (8 m) control cord.

**RFCS-14 HD Foot Control** #194 744
Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote current and contactor control. Includes 20 ft (6 m) cord and 14-pin plug.

**TIG Coolant** #043 810
Sold in multiples of 4. Pre-mixed low-conductivity Miller coolant contains ethylene glycol and deionized water to protect from freezing and boiling -37°F (-38°C) to 227°F (108°C). 1-gallon plastic recyclable bottles.

**RHC-14 Hand Control** #129 340
Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3-1/4 in (102 x 102 x 83 mm). Includes 20 ft (6 m) cord and 14-pin plug.

**RMS-14 On/Off Control** #187 208
Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5 ft (8 m) cord and 14-pin plug.

**RMLS-14 Switch** #129 337
Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5 ft (8 m) cord and 14-pin plug.

**Water-Cooled Dinse** #195 377
For Maxstar® 350. Used to adapt WP20, WP18, and CS310 to dinse-style connector. Order from Miller Parts.

**Water-Cooled Thread Lock** #225 028
For Dynasty and Maxstar 700. Used with (WP125, WP24W, WP25, WP20, WP18, WP12, CS310, CS410, WP22, WP27) water-cooled torch. Order from Miller Parts.
## Ordering Information

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<thead>
<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Maxstar® 350</strong></td>
<td>#907 334</td>
<td>Auto-Line™ 208 – 575 VAC, 50/60 Hz, <strong>CSA</strong>. 8 ft primary cord</td>
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<tr>
<td><strong>Maxstar® 350 International</strong></td>
<td>#907 334-02-1</td>
<td>Auto-Line™ 380 – 575 VAC, 50/60 Hz, <strong>CE</strong>. 8 ft primary cord</td>
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<tr>
<td><strong>Maxstar® 350 TIGRunner®</strong></td>
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<td>Auto-Line™ 208 – 575 VAC, 50/60 Hz, <strong>CSA</strong>. 8 ft primary cord. <strong>Requires coolant</strong></td>
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<tr>
<td><strong>Maxstar® 350 Complete</strong></td>
<td>#951 073</td>
<td>Auto-Line™ 208 – 575 VAC, 50/60 Hz, <strong>CSA</strong>. 8 ft primary cord.</td>
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<td>Auto-Line™ 208 – 575 VAC, 50/60 Hz, <strong>CSA</strong></td>
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<td>See page 6</td>
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<td>Weldcraft® 300 A Water-Cooled Torch Kit</td>
<td>#300 183</td>
<td>See page 6. Recommended for Maxstar 350</td>
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<td>RCCS-14</td>
<td>#043 688</td>
<td>North/south fingertip control</td>
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<td>RFCS-14 HD</td>
<td>#194 744</td>
<td>Heavy-duty foot control</td>
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<td>RHC-14</td>
<td>#129 340</td>
<td>Hand control</td>
<td></td>
<td></td>
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<tr>
<td>RML-14</td>
<td>#129 337</td>
<td>Momentary/maintained rocker switch</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMS-14</td>
<td>#187 208</td>
<td>Momentary rubber dome switch</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Extension Cords</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>#122 973</td>
<td>25 ft (7.6 m)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>#122 974</td>
<td>50 ft (15.2 m)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>#122 975</td>
<td>75 ft (22.9 m)</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td><strong>Accessories</strong></td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>Runner™ Cart</td>
<td>#300 244</td>
<td>See page 6</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Coolmate™ 3.5</td>
<td>#300 245</td>
<td><strong>Requires coolant</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>TIG Coolant</td>
<td>#043 810</td>
<td>Sold in multiples of 4. 1-gallon plastic bottles.</td>
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<td></td>
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<tr>
<td>Automation Interface Kit</td>
<td>#195 516</td>
<td>Field. Provides required automation connections</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Weld Current Sensor</td>
<td>#300 179</td>
<td>Field. Installation required.</td>
<td></td>
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<tr>
<td>Gas Tungsten Arc (TIG) Welding Book</td>
<td>#170 555</td>
<td>Order at MillerWelds.com/resources/tools</td>
<td></td>
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<tr>
<td>CD-ROM</td>
<td>#233 558</td>
<td>Simulator and setup video (included with machine)</td>
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<tr>
<td><strong>Torch Adapters</strong></td>
<td></td>
<td>Supplied with power source and torch kits</td>
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<tr>
<td>Water-Cooled Dinse</td>
<td>#195 377</td>
<td>Used to connect water-cooled torch to Dinse terminal machine. For WP20, WP18 and CS310 (adapter included in Complete Package). <strong>Order from Miller Parts</strong></td>
<td></td>
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<tr>
<td><strong>Water-Cooled Thread Lock</strong></td>
<td>#225 028</td>
<td>Used to connect water-cooled torch to Dynasty/Maxstar 700. <strong>Order from Miller Parts</strong></td>
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<tr>
<td><strong>Cable Connectors</strong></td>
<td></td>
<td>Supplied with power source and torch kits</td>
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<tr>
<td>Dinse Connector 50 mm (1 male)</td>
<td>#042 418</td>
<td>Used to connect weld lead to Dinse terminal machine</td>
<td></td>
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</tr>
<tr>
<td>Thread Lock Connectors (2 male)</td>
<td>#225 029</td>
<td>Used to connect weld lead to Dynasty 700 or Maxstar 700. <strong>Order from Miller Parts</strong></td>
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</tr>
<tr>
<td>Dinse Connector 50 mm (1 male, 1 female)</td>
<td>#042 419</td>
<td>Used to extend weld cables</td>
<td></td>
<td></td>
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<tr>
<td><strong>Tweco Terminal Adapter</strong></td>
<td>#042 465</td>
<td>Male Dinse to female Tweco</td>
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<tr>
<td><strong>Cam-Lok Terminal Adapter</strong></td>
<td>#042 466</td>
<td>Male Dinse to female Cam-Lok</td>
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<tr>
<td><strong>Miscellaneous</strong></td>
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<tr>
<td><strong>Stick Electrodes</strong></td>
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<tr>
<td><strong>Welding and Work Cables</strong></td>
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<tr>
<td><strong>Welding Gloves and Helmet</strong></td>
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</tbody>
</table>

**Date:**

**Total Quoted Price:**

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Distributed by:

Miller

Litho in USA