



SWSI

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Welding | Industrial | Safety

International Wholesale Distribution

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SMAW STICK



MillerWelds.com/Stick

Product Guide

	Page	Class	Stick	DC TIG	DC TIG-P	Flux-Cored*	CAC-A	Portability	Weldable Metals	Welding Amperage Range	Special Features	Typical Applications	
Thunderbolt® XL 225 AC	32	●	●					Optional running gear	Steel, stainless	30-235 AC	Infinite control	Education, maintenance/repair, farm	1-Phase
Thunderbolt® XL 225 AC/150 DC	32	●	●							30-235 AC 30-160 DC	Infinite control	Education, maintenance/repair, farm	
Maxstar® 150 S	32	●	●							Shoulder strap, optional case	20-150 DC	115-230 V Auto-Line™ MVP™ plugs	
Maxstar® 200 STR	33	●	●	●				Shoulder strap, handle, optional cart	Most metals	1-200 DC	115-460 V Auto-Line™ Stick/TIG machine	Construction, fabrication, pipe, steel erection, shipbuilding	1 & 3-Phase
CST™ 280	33	●	●	●				Handle, optional cart		5-280 DC	High output, portable at 41 lb., also available in multi-unit rack	Construction, fabrication, pipe, steel erection, shipbuilding	
XMT® Series	46	●	See the Multiprocess section on page 44.										
Gold Star® 302	32	●	●	●	●	●	1/4"	Lift eye, optional running gear	Most metals	15-395 DC	Built-in arc control	Steel erection, pipe, fab, shipbuilding, foundries	3-Phase
Gold Star® 452	32	●	●	●	●	5/16"				20-590 DC	Built-in arc control	Steel erection, pipe, fab, shipbuilding, foundries	
Gold Star® 652	32	●	●	●	●	3/8"				50-850 DC	Built-in arc control	Steel erection, pipe, fab, shipbuilding, foundries	
Dimension™ Series	45	●	See the Multiprocess section on page 44.										

PRODUCT KEY

CLASS: ● Light Industrial ● Industrial ● Heavy Industrial CAPABILITY: ● Designed for this process ● Capable of this process
 *Constant-current (Stick) machines can utilize voltage-sensing wire feeders for some Flux-Cored applications.
 For more detailed information, see individual specification sheets.

Also see the TIG section (page 34) for machines that can Stick weld.

Thunderbolt® XL 225 AC and 225 AC/150 DC

See Literature No. AC/2.0 for AC model and AD/8.0 for AC/DC model



Thunderbolt XL 225 AC shown.

Economical Stick machines with precise, dependable control.

- **Accu-Set™** amperage indicator.
- **Unit allows higher duty cycle when amperage decreases.**
- **Infinite current control.**
- **Output selector switch on AC/DC units.**
- **Certified by Canadian Standards Association to both the Canadian and U.S. Standards.**

Light Industrial ● **CC AC DC 1** Phase 225 AC model is AC only.

Process • Stick (SMAW)

Comes Complete With

- 15-ft. (4.5 m) No. 4 electrode cable with heavy-duty electrode holder
- 10-ft. (3 m) work cable with clamp
- Power cord with plug

Visit MillerWelds.com or your distributor for Miller® options and accessories.

Model	Stock Number	Welding Amperage Ranges	Rated Output at 20% Duty Cycle, 60 Hz (15% Duty Cycle, 50 Hz)	Rated Output at 100% Duty Cycle	Amps Input at Rated Output 220 V 230 V	Max. Open-Circuit Voltage	Dimensions	Net Weight
Thunderbolt XL 225 AC (CSA)	(#903 641) 230 V, 50/60 Hz	AC 30-235	AC 225 A at 25 VAC	AC 100 A	— 47.5	80	H: 18.75 in. (476 mm) W: 12.75 in. (323 mm) D: 17.5 in. (445 mm)	85 lb. (39 kg)
Thunderbolt XL 225 AC/150 DC (CSA)	(#903 642) 230 V, 50/60 Hz	AC 30-235 DC 30-160	AC 225 A at 25 V DC 150 A at 25 V	AC 100 A DC 65 A	— 47.5	80		104 lb. (47 kg)

Gold Star® Series

See Literature No. DC/8.1



See pages 42 and 43 for wireless remote controls.

Gold Star 452 shown.

Rugged, reliable performance and superior arc characteristics.

- **Hot Start™** and built-in arc control.
- **Enclosed circuit board.**
- **Thermal overload protection with light.**
- **Fan-On-Demand™**
- **15 A, 115 VAC duplex receptacle.**
- **Power efficient.**
- **Remote control capability.**
- **Optional digital volt and amp meters.**

Heavy Industrial ● **CC DC 3** Phase

Processes

- Stick (SMAW) • TIG (GTAW)
- Air Carbon Arc Cutting and Gouging (CAC-A) (Carbons — 302: 1/4 in., 452: 5/16 in., 652: 3/8 in.)
- Flux-Cored (FCAW)
- MIG Spray Transfer (GMAW) with voltage-sensing feeder

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Model	Stock Number	Amperage Range in CC Mode	Rated Output	Amps Input at Rated Output, 60 Hz 200 V 230 V 460 V 575 V	KVA KW	Max. Open-Circuit Voltage	Dimensions (Includes lift eye and strain relief.)	Net Weight
Gold Star 302	(#903 373) 200(208)/230/460 V (#903 398) 230/460/575 V	15-395	300 A at 32 VDC, 60% Duty Cycle	70 61 31 25	24.5 13.8	72 VDC	H: 30 in. (762 mm) W: 23 in. (585 mm) 302 D: 30.5 in. (775 mm) 450 D: 38 in. (966 mm) 675 D: 38 in. (966 mm)	352 lb. (160 kg)
Gold Star 452	(#903 374) 200(208)/230/460 V (#903 400) 230/460/575 V	20-590	450 A at 38 VDC, 60% Duty Cycle	102 89 45 36	35.5 23.3	72 VDC		404 lb. (183 kg)
Gold Star 652	(#903 402) 230/460/575 V	50-850	650 A at 44 VDC, 60% Duty Cycle	— 124 62 50	49.4 36	72 VDC		505 lb. (229 kg)

Maxstar® 150 S

See Literature No. DC/27.0

Best in class—provides maximum portability and performance in the most compact Stick package in the industry. Packs dependability and performance all in one machine.



Maxstar 150 S with Case (#907 134-01-2) shown.

Multi-voltage plug (MVP™) allows connection to 115 or 230 V receptacles without tools—choose the plug that fits the receptacle and connect it to the power cord.

AUTO-LINE™ Power Management Technology Auto-Line™ circuitry automatically connects to 115-230 VAC, single-phase power without removing the covers to relink the power source.

Portable with adjustable shoulder strap. At 13.2 pounds you can take it anywhere.

Adaptive Hot Start™ for Stick arc starts prevents electrode from sticking.

Single amperage range allows operator to accurately set amperage on both 115 or 230 V primary power.

Light Industrial ● **CC DC 1** Phase

Process • Stick (SMAW)

#907 134 Comes Complete With

- Primary cord and MVP™ plugs
- 13-ft. (4 m) lead with electrode holder and 25-mm Dinse connector
- 10-ft. (3 m) work lead with clamp and 25-mm Dinse connector

#907 134-01-2 Includes Above Plus

- Protective X-CASE™
- **Most Popular Accessories**
- MVP™ Plugs (pg 86)
- Protective X-CASE™ #300 184 (pg 86)

Visit MillerWelds.com or your distributor for other Miller® options and accessories.

Stock Number	Input Power	Welding Amperage Range	Rated Output	Amps Input at Rated Output, 50/60 Hz	KVA at Duty Cycle	KW	Max. Open-Circuit Voltage	Dimensions	Net Weight
(#907 134) 115-230 VAC, 50/60 Hz	115 VAC	20-100	100 A at 24 VDC, 35% Duty Cycle	26.4	3.0	3.0	90 (12-16 VDC*)	H: 9 in. (229 mm) W: 5.5 in. (140 mm) D: 13.25 in. (337 mm)	13.2 lb. (6.0 kg)
(#907 134-01-2) 115-230 VAC, 50/60 Hz w/Case	230 VAC	20-150	150 A at 26 VDC, 30% Duty Cycle	21.6	4.9	4.7			



Maxstar® 200 STR See Literature No. DC/29.5

Unit provides maximum flexibility by automatically connecting to any input power while maintaining the best DC Stick/TIG welding performance in its product class.



Allows for any input voltage hook-up (115-460 V, single- or three-phase) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

Low OCV Stick™ model reduces open-circuit voltage to 9-14 VDC when power source is not in use. This built-in circuit design eliminates the need for add-on voltage reducers. See chart below for Low OCV model stock number.

Excellent for thin and medium wall pipe welding.

Lift-Arc™ start for TIG arc starts without the use of high frequency.

Remote amperage control provided through 14-pin receptacle on front of the machine.

Adaptive Hot Start™ for Stick arc starts automatically increases output amperage at start of weld should the start require it. Prevents electrode from sticking and creating an inclusion.

Portable with adjustable shoulder strap. At 32 pounds you can take it anywhere.

Note: See page 36 in the TIG section for Maxstar 200 Series.
*Sense voltage for Stick and Lift-Arc TIG.

Industrial ● **CC DC 3 1**
Phase Phase

Processes

• Stick (SMAW) • TIG (GTAW)

Comes Complete With

- 8-ft. (2.4 m) primary cord
- Two 50-mm Dinse connectors

Most Popular Accessories

- Air-Cooled TIG Torch Adapter #195 378 (pg 80)
 - Protective Cover #195 321 (pg 87)
 - RCCS-14 Remote Fingertip Control #043 688 (pg 87)
 - RFCS-14 HD Remote Foot Control #194 744 (pg 87)
 - Weldcraft® WP17V12RM TIG Torch
- Visit MillerWelds.com or your distributor for other Miller® options and accessories.

Stock Number	Welding Process	Input Power	Welding Amperage Range	Rated Output	Amps Input at Rated Load Output, 50/60 Hz						Max. Open-Circuit Voltage	Dimensions	Net Weight	
					115 V	230 V	400 V	460 V	KVA	KW				
#907 036) Low OCV #907 036-00-1) Normal OCV	Stick	Three-Phase	1-200	150 A at 26 V, 60% Duty Cycle	—	13.1	7.4	6.4	5.2	5.0	70 VDC (9-14 VDC*)	H: 13.5 in. (343 mm) W: 7.5 in. (191 mm) D: 17.5 in. (445 mm)	32 lb. (14.5 kg)	
		Single-Phase	1-200 (1-90 on 115 VAC)	150 A at 26 V, 60% Duty Cycle 125 A at 25 V, 50% Duty Cycle	—	21.7	—	—	5.0	5.0				4.0
	TIG	Three-Phase	1-200	175 A at 17 V, 60% Duty Cycle	—	10.5	6.0	5.2	4.2	4.0	70 VDC (9-14 VDC*)			
		Single-Phase	1-200 (1-150 on 115 VAC)	175 A at 17 V, 60% Duty Cycle 150 A at 16 V, 70% Duty Cycle	—	17.4	—	—	4.0	4.0				29.7

CST™ 280 See Literature No. DC/29.55

Durable Stick/TIG power source in a lightweight package designed for the construction industry. 280 amps of output is ideal for Stick electrodes up to 3/16-inch and TIG welding of pipe and plate.



See pages 42 and 43 for wireless remote controls.

Easy voltage changeover between voltage ranges through a two-position manual switch. Conveniently located on the rear panel, it simplifies voltage change in racks.

Simple-to-operate **process selector knob automatically sets proper DIG setting** on E6010 and E7018 electrodes providing superior Stick performance.

Lift-Arc™ start for TIG arc starts without the use of high frequency.

Fan-On-Demand™ cooling system operates only when needed providing power efficiency and noise reduction.

Stand-alone or rack-mounted. Optional 4-pack or 8-pack rack often used in construction/shipyards is available for multioperator applications. All controls including power switch are located on front of machine for easy access. See page 50.

Remote amperage control provided through 14-pin receptacle on front of the machine. This permits use of standard amperage control devices.

Tweco®- or Dinse-style connectors available. The Dinse-style includes one set of male connectors; the Tweco-style does not.

Industrial ● **CC DC 3 1**
Phase Phase

Processes

• Stick (SMAW) • TIG (GTAW)

Most Popular Accessories

- Wireless Remote Hand Control #300 430 (pg 43)
- CST 280 Rack (pg 50)
- RCC-14 Remote Fingertip Control #151 086 (pg 87)
- RCCS-14 Remote Fingertip Control #043 688 (pg 87)
- RFCS-14 Remote Foot Control #043 554 (pg 87)
- RFCS-14 HD Remote Foot Control #194 744 (pg 87)
- RHC-14 Remote Hand Control (pg 87) 20 ft. (6 m) #242 211 020 100 ft. (30.5 m) #242 211 100
- For TIG torches see Lit. No. DC/29.55

Visit MillerWelds.com or your distributor for other Miller® options and accessories.

Note: Primary input current draw is limited to 50 amps.

Stock Number	Welding Process	Input Power	Welding Amperage Range	Rated Output	Amps Input at Rated Load Output, 50/60 Hz								Max. Open-Circuit Voltage	Dimensions	Net Weight	
					208 V	220 V	230 V	400 V	440 V	460 V	575 V	KVA				KW
#907 244) Dinse-style 220-230/460-575 V #907 244-01-1) Tweco-style 220-230/460-575 V	Stick/TIG	Three-Phase	5-280	280 A at 31.2 V, 35% Duty Cycle	—	35.0	34.2	—	—	17.8	14.7	14.6	10.2	77 VDC	H: 13.5 in. (343 mm) W: 7.5 in. (191 mm) D: 18 in. (457 mm)	41 lb. (18.6 kg)
				200 A at 28 V, 100% Duty Cycle	—	23.3	22.5	—	—	11.7	9.7	9.6	6.4			
Single-Phase	5-200	200 A at 28 V, 50% Duty Cycle	—	43.9	43.0	—	—	—	—	10.1	6.6					
		150 A at 26 V, 100% Duty Cycle	—	32.7	32.0	—	—	—	—	7.3	4.6					
#907 251) Dinse-style 208-230/400-460 V #907 251-01-1) Tweco-style 208-230/400-460 V	Stick/TIG	Three-Phase	5-280	280 A at 31.2 V, 35% Duty Cycle	36.0	33.0	28.8	18.0	17.5	—	14.0	10.2	67 VDC			
				200 A at 28 V, 100% Duty Cycle	23.5	23.0	22.8	13.5	12.0	12.7	—	10.2				6.9
		Single-Phase	5-200	200 A at 28 V, 50% Duty Cycle	43.9	43.3	43.0	—	—	—	—	9.9				6.5
				150 A at 26 V, 100% Duty Cycle	35.0	33.9	32.9	—	—	—	—	7.6				4.8