

# Dialarc® 250 AC/DC

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**Stick Welding  
Power Source** 

## Quick Specs

### Light Industrial Applications

Production Line Work  
Plant Maintenance  
Garage/Job Shops  
Fabrication  
Vocational School Training

### Process

Stick (SMAW)

**Input Power** 1-Phase Power

**Rated Output** AC: 225 A at 29 V, 30% Duty Cycle  
DC: 175 A at 27 V, 50% Duty Cycle

**Max. Open-Circuit Voltage** AC: 70  
DC: 79

## The Power of Blue.®

**Single-dial current control** simplifies weld adjustment.

**Infinite current control** allows precise weld output adjustment; you always get the exact heat you need to produce a better weld.

**Two weld ranges for both AC and DC welding** allow greater control of weld performance for changes in welding conditions.

**Fully varnished magnetic amplifier technology** provides lower maintenance, and outstanding product reliability with fewer moving parts.

**Forced-draft cooling fan** ensures a cooler running product, extending the life of the power source.



**Superior 6010 and 7018 Stick welding performance** offers a wide range of electrode versatility; welds difficult-to-weld metals.

**High output and duty cycle** allows unit to handle nearly all of your Stick welding needs.

**Industrial, weld output terminal cover.**

**Power factor correction is available** for lower primary power demand.

**Optional remote weld output control** provides current control without going back to the power source — saves time and effort.



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

MADE IN **USA**  
APPLETON, WI **USA**



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**Web Site**  
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# Specifications (Subject to change without notice.)



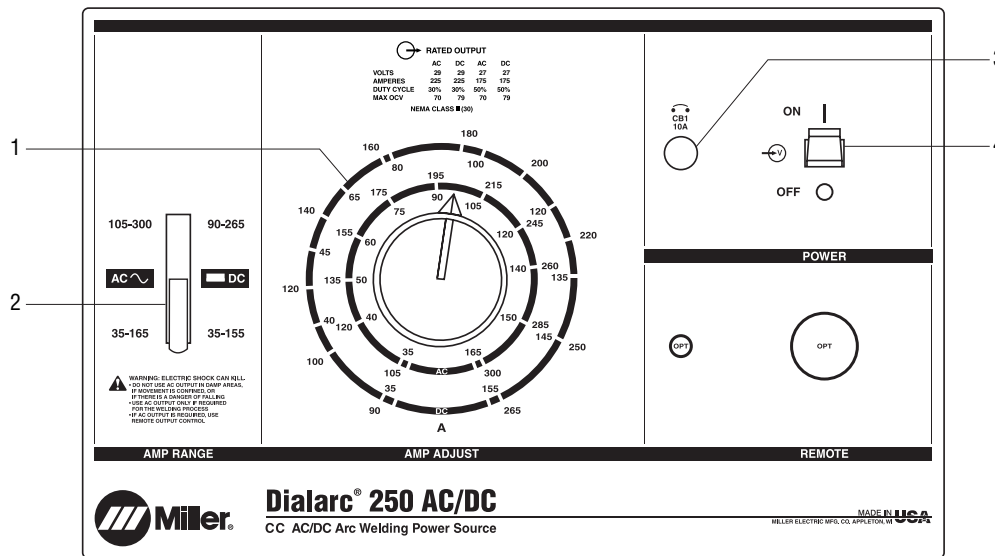
Power Factor Correction	Welding Amperage Ranges	Max. Open-Circuit Voltage	Rated Output*	Amps Input at Rated Output, 50 or 60 Hz, Single-Phase								Dimensions	Weight		
				200 V	208 V	230 V	380 V	440 V	460 V	575 V	KVA			KW	
60 Hz, Without	AC Low: 35–165 High: 105–300	70	225 A at 29 V, 175 A at 27 V	84	—	—	73	—	—	36	29	16.8	9.8	H: 24-1/4 in (616 mm) W: 19 in (483 mm) D: 28 in (711 mm)	<b>Net:</b> 360 lb (163 kg) <b>Ship:</b> 370 lb (168 kg)
	DC Low: 35–155 High: 90–265	79	225 A at 29 V, 175 A at 27 V	92	—	—	80	—	—	40	32	18.6	11.8		
60 Hz, With	AC Low: 35–165 High: 105–300	70	225 A at 29 V, 175 A at 27 V	—	60	—	55	—	—	27	22	12.5	9.9		<b>Net:</b> 365 lb (166 kg) <b>Ship:</b> 375 lb (171 kg)
	DC Low: 35–155 High: 90–265	79	225 A at 29 V, 175 A at 27 V	—	66	—	60	—	—	30	24	13.7	10.8		
50 Hz, With	AC Low: 35–165 High: 105–300	70	225 A at 29 V, 175 A at 27 V	—	—	62	—	36	31	—	—	13.7	10.2		<b>Net:</b> 365 lb (166 kg) <b>Ship:</b> 375 lb (171 kg)
	DC Low: 35–155 High: 90–265	79	225 A at 29 V, 175 A at 27 V	—	—	73	—	42	36	—	—	16	12.2		
				—	—	52	—	30	26	—	—	11.4	8.3		

\*Rated output at low welding amperage ranges is **30% duty cycle**. Rated output at high welding amperage ranges is **50% duty cycle**.

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

## Control Panel

1. Amperage Adjustment Control
2. Range Selector Switch
3. Circuit Breaker CB1
4. Power Switch

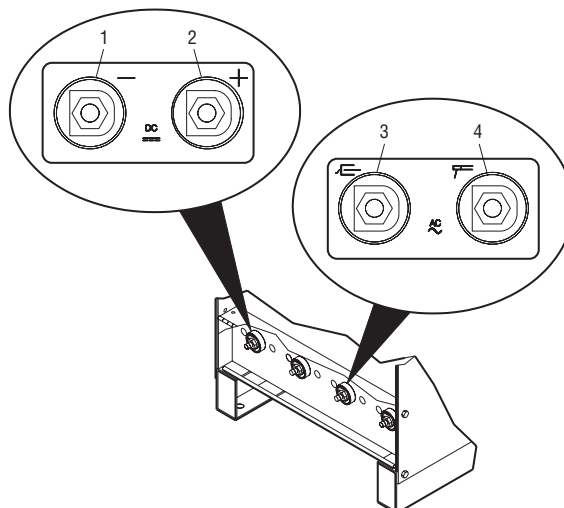


### For DC Weld Output

1. Negative (-) Weld Output Terminal
2. Positive (+) Weld Output Terminal

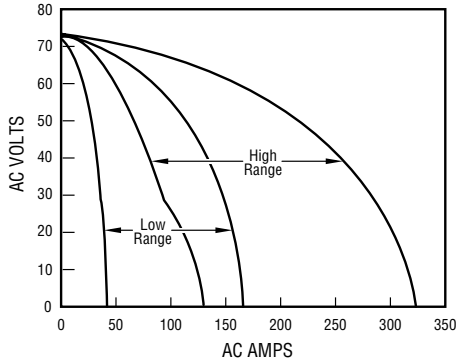
### For AC Weld Output

3. Work Weld Output Terminal
4. Electrode Weld Output Terminal

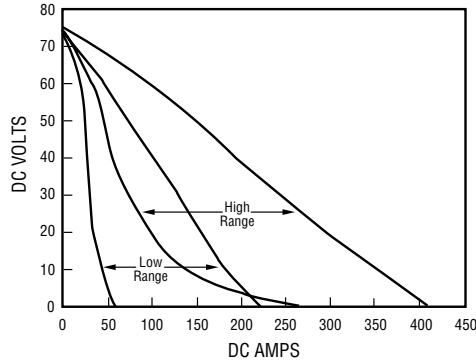


# Performance Data

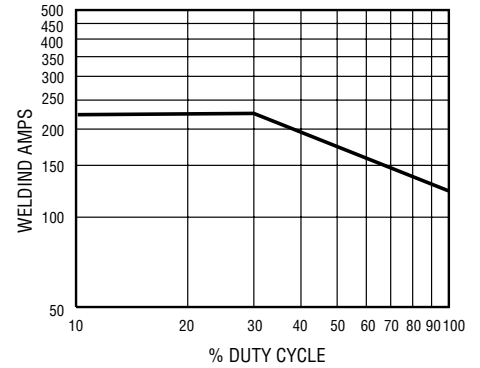
VOLT AMP CURVES



VOLT/AMP CURVES



DUTY CYCLE CHART



# Genuine Miller Accessories



**No. 2 Stick Cable Set, 15 ft #195 196**  
 Consists of 15 ft (4.6 m) No. 2 electrode cable and holder, and 15 ft (4.6 m) work cable and clamp. 200 A, 100% duty cycle.

**No. 2 Stick Cable Set, 50 ft #195 195**  
 Consists of 50 ft (15.2 m) No. 2 electrode cable and holder, and 50 ft (15.2 m) work cable and clamp. 200 A, 100% duty cycle.

**RF-10 Remote Current Control Facilities #041 111** Field  
 Includes receptacle, remote-standard switch and wiring.



**RHC-3 Remote Hand Amperage Control**  
*Requires RF-10 Remote Current Control Facilities.*  
**#040 056** 20 ft (6 m) cord and plug  
**#195 354** 100 ft (30.5 m) cord and plug

**RFC-23A #040 071**  
*Requires RF-10 Remote Current Control Facilities.* Remote foot amperage control with 20 ft (6 m) cord and plug.

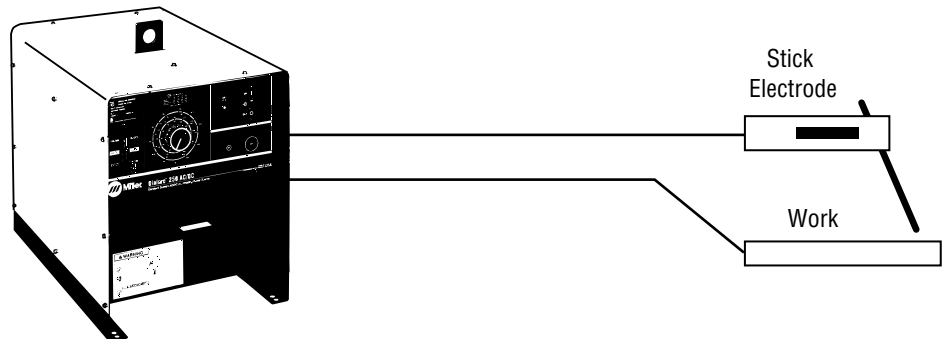


**No. 19 Running Gear #041 580**  
 Four 8 in (203 mm) poly/rubber blend wheels with 30 in (762 mm) towing handle. All running gear shipped unassembled.

# Typical Installations



**Stick (SMAW) Basic Equipment**



# Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Dialarc® 250 AC/DC	#907 017	200/230/460, 60 Hz		
	#907 016	230/460/575, 60 Hz		
Dialarc® 250P AC/DC	#907 047	220/380/440, 50 Hz		
Dialarc® 250P AC/DC	#907 015	200/230/460/575, 60 Hz		
No. 19 Running Gear	#041 580			
<b>Accessories</b>				
No. 2 Stick Cable Set	#195 196	Includes 15 ft (4.6 m) No. 2 electrode cable and holder, 15 ft (4.6 m) work cable and clamp		
	#195 195	Includes 50 ft (15.2 m) No. 2 electrode cable and holder, 50 ft (15.2 m) work cable and clamp		
RF-10	#041 111	Remote current control facilities, field only		
RHC-3	#040 056	Remote hand amperage control with 20 ft (6 m) cord		
	#195 354	Remote hand amperage control with 100 ft (30.5 m) cord		
RFC-23A	#040 071	Remote foot amperage control		
<b>Miscellaneous</b>				
Stick Electrodes				
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Other				

Date:

Total Quoted Price:



Distributed by: