

Thunderbolt® XL AC/DC

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**Stick Welding
Power Source** 

Quick Specs

Light Industrial Applications
Garage/Job Shops
Plant Fabrication/Maintenance
Vocational Training
Light Production-line Work

Processes
Stick (SMAW)
Input Power 1-Phase Power
Max. Open-Circuit Voltage 80

Amperage Range
High: 40–235 A (AC),
Low: 30–150 A (AC)
30–160 (DC)
Weight 104 lb (47 kg)

The Power of Blue.®

Infinite current control allows the operator to adjust output by as little as 1-amp increments. Users can always get the exact heat they need, unlike the step control design on competitive products.

High 100% duty cycle rating.
100 amps AC, 65 amps DC

The exclusive **Accu-Set™** provides precise heat control with infinite amperage control.

High DC weld output. Up to 150 amps available at 20% duty cycle. The Thunderbolt 225 AC/150 DC has 20% more DC output than competitive products.



Comes Complete with:
Power source with 15 ft (4.5 m) electrode cable, electrode holder, 10 ft (3 m) work cable with clamp, and power cord with 230 V plug.
Note: Does not include wall receptacle.

Output selector switch allows you to quickly select AC, DCEP or DCEN without adjusting the output leads.

Fully varnished magnetic coils. Varnish protects and lengthens the life of the coils inside.

Forced-draft cooling fan runs continuously and helps to extend the life of the power source.

Specifications (Subject to change without notice.)



Mode	Rated Output at 20% Duty Cycle	Welding Amperage Range		Max. Open-Circuit Voltage	Amps Input at Rated Output, 50 or 60 Hz 230 V	Dimensions	Net Weight
		High	Low				
AC	225 A at 25 VAC, 60 Hz (15% Duty Cycle at 50 Hz)	40–235	30–150	80	47.5	H: 18-3/4 in (476 mm) W: 12-3/4 in (323 mm) D: 17-1/2 in (445 mm)	104 lb (47 kg)
DC	150 A at 25 VDC, 60 Hz (15% Duty Cycle at 50 Hz)	30–160					

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



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

MADE IN **USA**



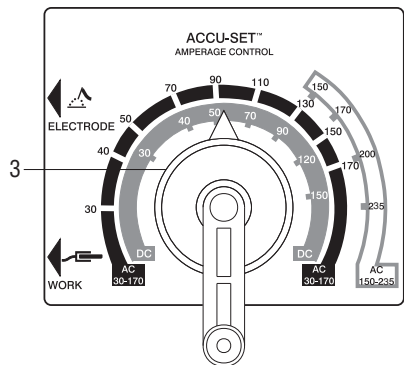
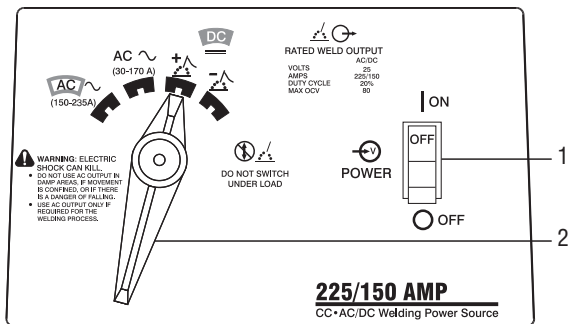
Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

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

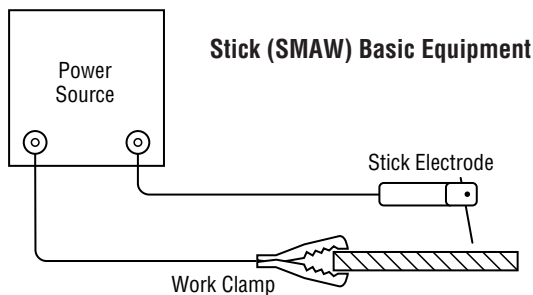


Control Panel



1. Power Switch
2. Selector Switch
3. Amperage Adjustment Control

Typical Installation



Ordering Information

Power Source	Stock No.	Description	Qty.	Price
Thunderbolt® XL 225 AC/150 DC	#903 642	230 V, 50/60 Hz. Includes 5 ft (1.5 m) power cord w/230 V plug		
Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and handle		
Miscellaneous				
Stick Electrodes		See charts above		
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				

Date:

Total Quoted Price:

Electrode Charts

ELECTRODE POLARITY CHART

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	GENERAL
6013	EP, EN	✓	ALL	LOW	GENERAL
7014	EP, EN	✓	ALL	MED.	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	SMOOTH, EASY, FASTER
Ni-Ci	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

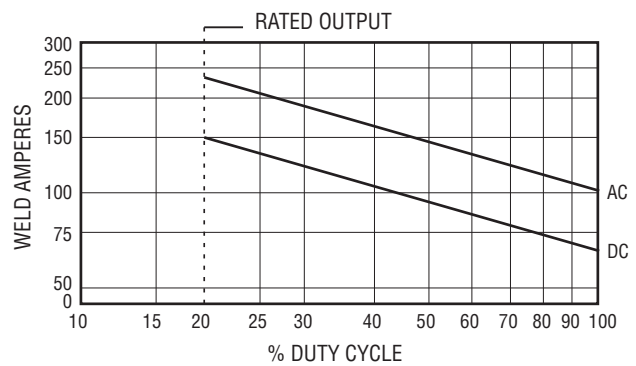
*EP = ELECTRODE POSITIVE (REVERSE POLARITY)
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

ELECTRODE/AMPERAGE CHART

ELECTRODE	DIAMETER		AMPERAGE RANGE					
	IN	MM	MIN.	50A	100A	150A	200A	MAX.
6010 & 6011	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
6013	3/16	4.8						
	1/16	1.6						
	5/64	2.0						
6013	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
7014	3/16	4.8						
	3/32	2.4						
	1/8	3.2						
7014	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
7018	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
7024	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
Ni-Ci	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
308L	5/32	4.0						
	3/32	2.4						
	1/8	3.2						

Performance Data

DUTY CYCLE CHART



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