

# XMT® 350/SuitCase™ X-TREME™ 8 OFFSHORE

**Multiprocess  
Welding System** 

<b>Quick Specs</b>	<b>Industrial Applications</b> Offshore Platform Construction	<b>XMT 350 OS</b>	<b>SuitCase X-TREME 8 OS</b>
	<b>Processes</b> Stick (SMAW) TIG (GTAW) MIG (GMAW) Self-Shielded Flux Cored (SS-FCAW)	<b>Input Power</b> Requires 3- or 1-Phase Power 208–575 VAC, 50/60 Hz	<b>Input Power</b> 14–48 VDC Operating Voltage 110 VDC Maximum OCV
		<b>Rated Output</b> 10–38 V, 5–425 A	<b>Wire Feed Speed</b> 25–780 IPM (.64–19.8 m/min)
		<b>Weight</b> Net: 80 lb (36.3 kg) Ship: 89.1 lb (40.4 kg)	<b>Weight</b> 30 lb (14 kg)

## The Power of Blue.®

The XMT 350 OS and SuitCase 8 OS are designed specifically for the construction of jackets and other structures used in offshore oil production. The welding machine has processes designed for materials used in this type of construction (ASTM A537, API-2H). The small, lightweight feeder handles large-diameter flux- and metal-cored wires commonly used in these structures, ensuring smooth and reliable wire feeding.

### SuitCase X-TREME 8 OS Features

Trigger hold, wire jog, and gas purge are all located on front panel.

**New High Torque Motor** specifically designed for feeding 5/64 in flux cored wire. The motor and gear train were optimized to push large diameter core wire without significant increasing the weight of the feeder.

**Digital meters** with SunVision™ technology can display voltage and wire speed, and also amperage if desired. Meters can be seen clearly even in direct sunlight.

**Wider voltage range** for small and large wires with no contactor chatter and reduction of arc outages.

**Double-filtered gas valve** helps keep dirt from clogging and affecting gas flow.

**Excellent starts and improved superior arc performance** for all types and sizes of wires whether using CV or CC power supply.

**Polypropylene case with built-in slide rails** and the ability to open the door to change wire with feeder in vertical position.

**Potted and trayed main printed circuit board** for the harshest environments adds exceptional reliability. Board has full-trigger isolation so a shorted gun trigger will not affect feeder operation.



### XMT 350 OS Features

**Versi-Shield™** self shielded flux core process control technology offers superior material transfer and operator appeal. Spatter is reduced and narrow flat beads are possible over a wide range of wire feed speeds, and welding positions.

**Wind Tunnel Technology™** protects electrical components and PC boards from contamination.

**Fan-On-Demand™** cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through machine.

**Lift-Arc™** allows TIG starting without the use of high frequency. Starts the arc without contaminating the weld with tungsten.

**Adaptive Hot Start™** increases the output amperage at the start of a weld if necessary, eliminating electrode sticking.

**Lightweight, aerospace-grade aluminum case** offers protection with the benefit of reduced weight.

**Auto-Line™** Power Management Technology allows for any input voltage hook-up (208–575 V) with no manual linking required, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

**Inverter arc control technology** provides greater puddle control for superior 6010 Stick electrode performance, and outstanding MIG weld performance.

**Line voltage compensation** keeps welding output constant even if input power varies by +/-10%. This model further expands line voltage compensation on 460 VAC to an amazing +37%, -59%.

**Process selector switch** reduces the number of control setup combinations without reducing any features.



Power source is warranted for 3 years, parts and labor. Original main power rectified parts are warranted for 5 years. Gun warranted for 90 days, parts and labor.

MADE IN USA  
APPLETON, WI



**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



# XMT® 350 OS Specifications (Subject to change without notice.)



Input Power	Rated Output at 60% Duty Cycle	Voltage Range in CV Mode	Amperage Range in CC Mode	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 60 Hz,								Dimensions	Weight
					208 V	230 V	400 V	460 V	575 V	KVA	KW			
Three-Phase	350 A at 34 VDC	10–38 V	5–425 A	75 VDC	40.4	36.1	20.6	17.8	14.1	14.2	13.6	H: 17 in (432 mm) W: 12-1/2 in (318 mm) D: 24 in (610 mm)	80 lb (36.3 kg)	
Single-Phase	300 A at 32 VDC	10–38 V	5–425 A	75 VDC	60.8	54.6	29.7	24.5	19.9	11.7	11.2			

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

## Additional Features

**Exceptional electrical efficiency. At 400 A, efficiency is 87.24%!**

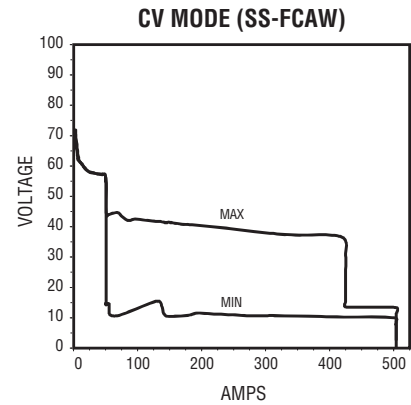
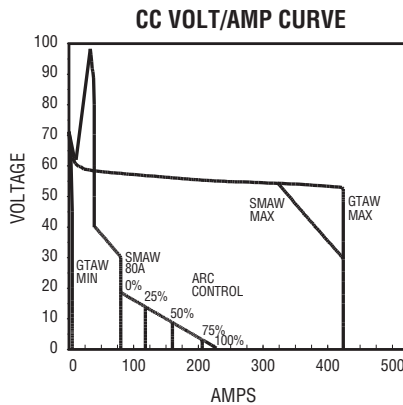
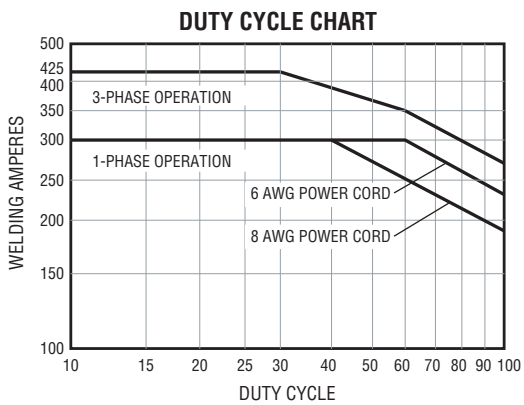
**350 A of welding output at 60% duty cycle with superior low-end performance.**

**Power factor of .95** enables smaller fuses/breakers and primary wiring. Primary amperage draw at rated output is 25% less than the competition.

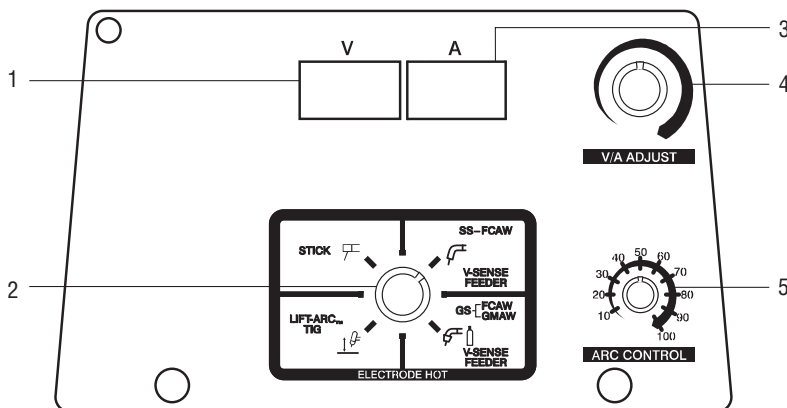
**Ultra-tough, polycarbonate-blended cover for control panel** protects front controls from damage.

**Optional gas solenoid for TIG welding.**

## XMT® 350 OS Performance Data



## XMT® 350 OS Control Panel



**Low OCV Stick** — A built-in, selectable feature, that reduces the Stick mode open-circuit voltage (OCV) to nearly 15 volts when the welding power source is not in use. Eliminates the need for add-on voltage reducers.

*Note: OS model is available only with Tweco-style weld cable disconnects. Tweco cable connectors are not supplied with the unit and must be ordered separately.*

1. Voltmeter
2. Process Selector Switch (Rotary Switch)
3. Ammeter

4. Voltage/Amperage Adjustment Control
5. Arc Control

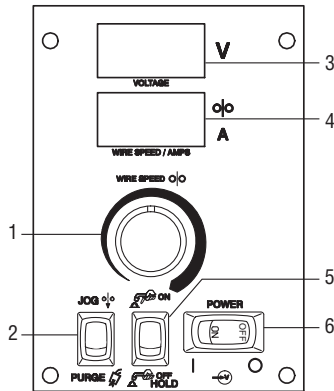
**NOTE:** Equipped with Tweco-style output connector.

# SuitCase™ X-TREME™ 8 OS Specifications (Subject to change without notice.)



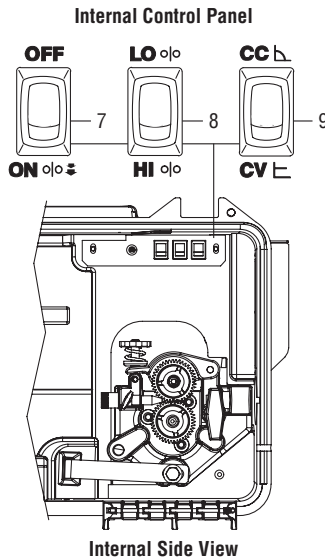
Input Power	Welding Power Source Type	Input Welding Circuit Rating	Electrode Wire Diameter Capacity	Max. Spool Size Capacity	Wire Speed	Dimensions	Net Weight
Operates on open-circuit voltage and arc voltage: 14–48 VDC/ 110 Max OCV	CC or CV DC power sources. AC type not recommended.	330 A at 60% Duty Cycle	<b>Solid Wire:</b> .023–.062 in (0.6–1.6 mm) <b>Flux Cored:</b> .030–.078 in (0.8–2 mm)	8 in (203 mm) 10 lb (4.5 kg)	Low Range 25–200 IPM (.65–5.2 m/min) High Range 175–780 IPM (4.5–19.8 m/min) dependent on arc voltage	H: 12-3/4 in (324 mm) W: 7-1/4 in (184 mm) D: 18 in (457 mm)	30 lb (14 kg)

## Control Panel



SuitCase X-TREME 80S

1. Wire Speed Control
2. Jog/Purge Switch
3. Voltmeter
4. Wire Speed/Amperage Meter (Optional)
5. Trigger Hold Switch
6. Power Control Switch



7. Soft Start Switch
8. WFS Range Switch
9. CC/CV Switch

## Drive Roll Kits (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include 2 drive rolls, the necessary guides and feature an anti-wear inlet guide.

Wire size	"V" knurled for hard-shelled cored wires	"U" cogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types)
1/16 in (1.6 mm)	#079 609	#079 614
.068/.072 in (1.8 mm)	#089 984	—
5/64 in (2.0 mm)	#079 610	#079 615

## Genuine Miller Accessories

### Gas Solenoid Kit #195 286

Easy to install, optional gas solenoid kit for TIG welding applications. Kit only works with XMT 350.



**Protective Cover #195 478**  
Mildew and water resistant, odor-free cover protects your machine's finish.

### Inverter Racks



#### Four or Six-Arc Welding System

The Inverter Rack conveniently houses multiple XMT power sources for multiple welders. Both 4-pack and 6-pack models are available. Features include:

- Provision to parallel power sources or common work connections
- Two lifting eyes for transportation
- Rugged skids for dragging or pushing
- Customer can install up to a maximum of 4 XMT 350 power sources

For detailed information on customized Inverter Rack systems see Lit. Index No. DC/18.81.

### Running Gear



#### XMT Cylinder Cart #042 537

Carries two 160 lb (72.6 kg) gas cylinders, or one gas cylinder and one coolant system for TIG (GTAW) welding. Feeder mounts to tray above power source.



#### Universal Carrying Cart and Cylinder Rack #042 934

Holds power source, and gas cylinder up to 56 in (142.2 cm) high measuring 6 to 9 in (15.2 to 22.8 cm) in diameter.

# Ordering Information

Power Source	Stock No.	Description	Qty.	Price
<b>NEW! XMT® 350 OS</b>	<b>#907 224 001</b>	208–575 VAC with Auto-Line™		
<b>Wire Feeders</b>				
<b>NEW! SuitCase™ X-TREME™ 8 OS</b>	<b>#300 594</b>	Includes Bernard® Dura-Flux™ Flux Cored gun		
<b>Accessories</b>				
Shoulder Strap	<b>#246 250</b>			
Gas Solenoid Kit	<b>#195 286</b>	For XMT 350 models only		
Protective Cover	<b>#195 478</b>			
Inverter Racks (full or empty)		See Lit. Index No. DC/18.81		
<b>Guns</b>				
Bernard® Dura-Flux™ (FCAW) Gun	<b>#FLX 351505M-1</b>	See Welding Components and Parts Guide		
12 in Replacement Head Tube	<b>#7010060</b>			
<b>Consumables</b>				
Drive Rolls	<b>#079 610</b>	5/64 in (2 mm) “V” Knurled		
Wire	<b>#S292025-032</b>	Hobart® FABSHIELD OffShore 71Ni		
Inlet Guide	<b>#229 919</b>	Anti-wear inlet guide		
<b>Running Gear</b>				
XMT Cylinder Cart	<b>#042 537</b>			
Universal Carrying Cart and Cylinder Rack	<b>#042 934</b>			

Date:

Total Quoted Price:



Distributed by: