

Millermatic® 125 Hobby

**MIG Power Source,
Wire Feeder and Gun Pkg**



Quick Specs

Light Industrial Applications

Light fabrication
Farm/home

Processes

MIG (GMAW)
Flux-cored (FCAW)

Weld Thickness

MIG: 24 ga.–1/8 in.
Flux-cored: 18 ga.–3/16 in.

Input Power

115 V, 20 A, 60 Hz, single-phase

Rated Output

85 A at 18.25 VDC, 20% duty cycle

New!



**115 VOLT
INPUT POWER**

Uses common household power

**MAX 3/16" (4.8 mm)
MIN 24 ga. (0.8 mm)**

Weld capacity

**AUTO-SET™
MATERIAL THICKNESS**

Quick and easy setup

Auto-Set™ automatically provides the right settings to weld mild steel while **tapped voltage control** allows the flexibility to manually set your own parameters.

- Turn the Wire Speed knob to Auto-Set, a blue light shows Auto-Set is activated
- Dial in the thickness of what you're welding
- Start welding with the exact parameters you need!

Quick Select™ drive roll makes setup quicker by offering three grooves — two for different size solid wires and a third for flux-cored wire.

Cast-aluminum drive system with calibrated tension knob creates consistent feeding and easy setup.

Factory-installed gas solenoid makes it easy to switch between MIG welding and flux-cored wire.

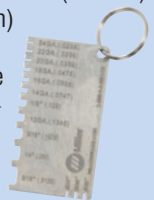
Thermal overload protection shuts down unit and activates the **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when unit cools.

Uses 4- or 8-inch (102 or 203 mm) spools and can be set up to weld with .024–.030 inch (0.6–0.8 mm) solid wire and .030–.035 inch (0.8–0.9 mm) flux-cored wire.

Comes complete with:

- Power source
- Power cord with plug
- 8 ft. (2.4 m) M-80 MIG gun and cable assembly
- 8 ft. (2.4 m) work cable with clamp
- Argon and AR/CO₂ mix flow gauge regulator with gas hose
- Hobart® spool of .030 in. (0.8 mm) solid wire
- Two contact tips for .030 in. (0.8 mm) wire
- Quick Select™ drive roll for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire
- Material thickness gauge ➤

Note: Shielding gas and safety equipment not included.



**TRUE BLUE®
3 YR. WARRANTY**

Welder is warranted for three years, parts and labor.
Original main power rectifier parts are warranted for five years.
Gun warranted for 90 days, parts only.



Miller Electric Mfg. Co.
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

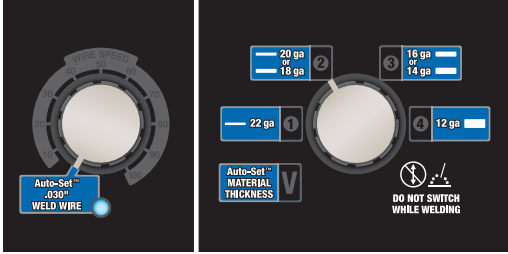
Equipment Sales US and Canada
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

MillerWelds.com
f t y



Operation Modes

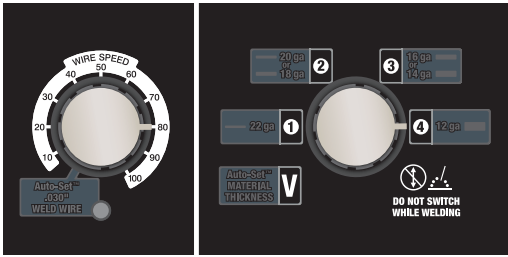
Auto-Set™ Mode



Auto-Set eliminates guesswork and saves you time on setup. When using .030-inch wire, turn Wire Speed control fully counter clockwise to select Auto-Set mode. The Auto-Set light indicates mode is activated. Then select material thickness using the Voltage/Material Thickness control.

Use Auto-Set when you want the speed, convenience and confidence of pre-set controls. Auto-Set automatically sets your welder to the proper parameters. It's available for welding 22-gauge through 12-gauge mild steel, and works with .030 solid wire and C25 shielding gas (75% argon, 25% CO₂).

Manual Mode



When welding outside of the Auto-Set capabilities, or if you prefer custom parameters, use manual mode. The parameter chart on the inside of the access door is an easy-to-use guide for determining your voltage and wire feed speed settings. Reference the white areas on the controls when welding in manual mode.

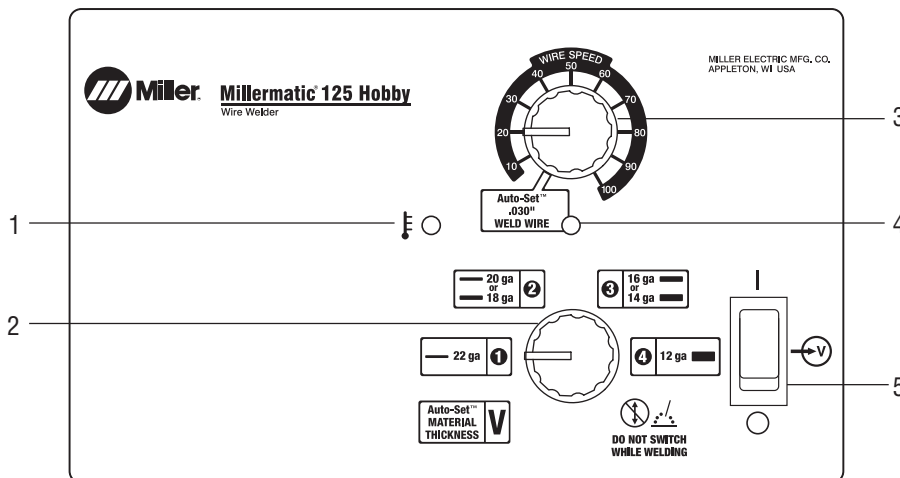
Specifications (Subject to change without notice.)



Amperage Range	Rated Output	Amps Input at Rated Output, 60 Hz			Wire Feed Speed	Wire Type and Diameter	Max. Open-Circuit Voltage	Dimensions	Net Weight
		115 V	KVA	KW					
30–130 A	85 A at 18.25 VDC, 20% duty cycle	20	2.79	2.65	0–500 ipm (0–13 mpm) at no load 0–415 ipm (0–11 mpm) feeding wire	Solid: .024–.030 in. (0.6–0.8 mm) Stainless: .024 in. (0.6 mm) Flux-cored: .030–.035 in. (0.8–0.9 mm)	31	H: 16.875 in. (429 mm) W: 9.875 in. (251 mm) D: 12.125 in. (308 mm)	49.7 lb. (22.5 kg)

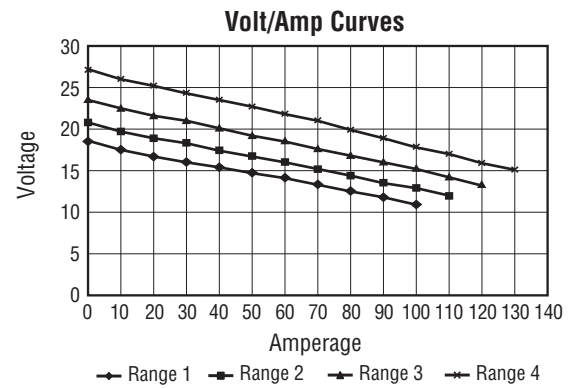
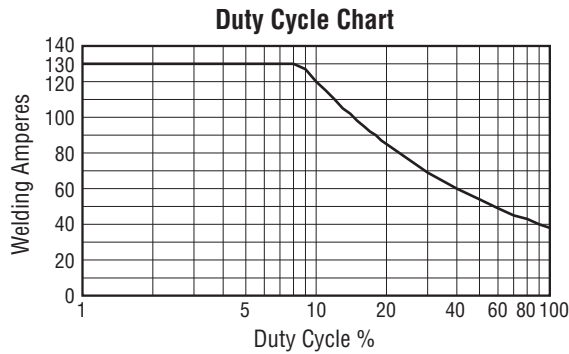
Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Control Panel



1. Over Temperature Light
2. Voltage/Material Thickness Control
3. Wire Speed/Auto-Set Control
4. Auto-Set Indicator Light
5. Power Switch

Performance Data



Genuine Miller® Accessories



Millermatic Protective Cover #301 333



**Running Gear/
Cylinder Rack
#301 239**

Heavy-duty construction with 8-inch rubber rear wheels. Convenient front handles, cable

holders and plastic consumable box. For gas cylinders no greater than 7 inches (178 mm) in diameter or 65 pounds (29.5 kg) in weight.

Replacement MIG Gun

M-80 Gun #273 618 8 ft. (2.4 m)

Consumables for M-80 Gun (Order from Miller Service Parts.)



Contact Tips

#087 299 .024 in. (0.6 mm)
#000 067 .030 in. (0.8 mm)
#000 068 .035 in. (0.9 mm)



Contact Tip Adapter #169 716



Replacement Liners

#194 010 .024 in.
#194 011 .030-.035 in. (standard)
 15-foot length — trim to size needed.



Nozzle #169 715

1/2-inch (13 mm) diameter orifice.
 Nozzle flush with contact tip (standard).



**Gasless Flux-Cored
Nozzle #226 190**

For use with self-shielding flux-cored wires. Improves visibility, eases access in tight corners, protects tip adapter/gas diffuser from spatter and from shorting to the workpiece.



Quick Select™ Drive Rolls #261 157

For .024-inch (0.6 mm) or .030/.035-inch (0.8/0.9 mm) solid wire, and .030/.035-inch (0.8/0.9 mm) flux-cored wire.



M-Series Gun Consumable Kits

#234 607 .024 in. (0.6 mm)
#234 608 .030 in. (0.8 mm)
#234 609 .035 in. (0.9 mm)

Each kit contains ten contact tips, one nozzle, and one contact tip adapter.