

Maxstar® 150 STH

Issued July 2004 • Index No. DC/27.2

TIG/Stick Welding
Power Source



Quick Specs

Light Industrial Applications

Dairy Industry
Food/Beverage Industry
Restaurant/Kitchen Repair
Experimental Aircraft
Petrochemical
Shipboard Installation/Repair
Maintenance Repair

Processes

TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)

Input Power

1-Phase Power

Amperage Range 115 VAC: 5–150 A (DC TIG)
20–100 A (DC Stick)
230 VAC: 5–150 A (DC TIG)
20–150 A (DC Stick)

Max. Open-Circuit Voltage 90

Weight 13.7 lb (6.2 kg)

The Power of Blue.®



NEW! Low OCV Stick is a simple design that reduces the open-circuit voltage to 15 volts when the welding power source is not in use. This circuit design is now built into the Maxstar 150 STH eliminating the need for add-on voltage reducers.

Portable in the shop or at the job site — at 13.7 lb the shoulder strap allows the end user to easily move from location to location.

Best in class TIG and Stick arc characteristics for those demanding jobs.

Built-in pulsing capabilities allow the operator to select from four fixed pulse frequencies to satisfy the application.

HF start for non-contact arc starting that eliminates tungsten or material contamination.

Lift-Arc™ start provides TIG arc starting without the use of high frequency.



Maxstar® 150 STH Stick/TIG package with case and remote (#907 136-01-2) shown.

Easy installation — Auto-Line™ provides state-of-the-art flexibility to the end user. The Auto-Line circuitry automatically connects to 115–230 VAC, single-phase power without removing the covers to relink the power source. No longer is there a concern if you have the correct machine for the shop or job site.

Base Unit (#907 136) Comes Complete With:

Power source with cord, 13 ft (4 m) stick electrode holder, 10 ft (3 m) work clamp, International flow-thru adapter and shoulder strap.

Inverter-based, DC power source has a **simple-to-use operator interface** providing only the necessary controls in a compact machine.

Thermal overload protection with indicator light helps prevent machine damage if the duty cycle is exceeded or airflow is blocked.

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

Full function remote control allows operator to crater out when doing critical work.

Selectable trigger configuration allows the operator to choose standard or 2T trigger method to meet the application.

Built-in gas solenoid eliminates the need for bulky torch with a gas valve.

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



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



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Specifications (Subject to change without notice.)

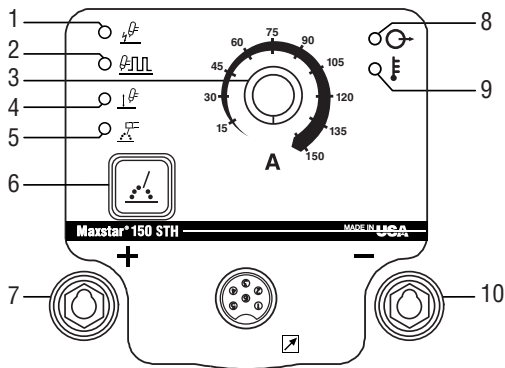


Input Power	Rated Output	Welding Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 50/60 Hz	KVA at Duty Cycle	KW	Dimensions	Weight
115 VAC Stick	70 A at 22.8 VDC, 100% Duty Cycle	20–100 A	90, 12–16 V*	17.4	2.0	1.9	H: 9 in (229 mm) W: 5-1/2 in (140 mm) D: 13-1/4 in (337 mm)	13.7 lb (6.2 kg)
	100 A at 24.0 VDC, 35% Duty Cycle			26.4	3.0	3.0		
115 VAC TIG	100 A at 14.0 VDC, 100% Duty Cycle	5–150 A	90, 12–16 V*	18.4	2.1	2.1		
	150 A at 16.0 VDC, 30% Duty Cycle			28.0	3.4	3.1		
230 VAC Stick	100 A at 24.0 VDC, 100% Duty Cycle	20–150 A	90, 12–16 V*	13.1	3.0	2.8		
	150 A at 26.0 VDC, 30% Duty Cycle			21.6	4.9	4.7		
230 VAC TIG	100 A at 14.0 VDC, 100% Duty Cycle	5–150 A	90, 12–16 V*	8.3	2.0	1.9		
	150 A at 16.0 VDC, 30% Duty Cycle			14.2	3.2	3.1		

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

*Sense voltage for stick and lift-arc TIG.

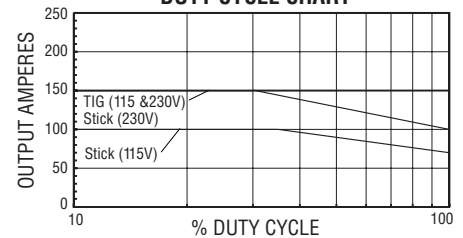
Control Panel



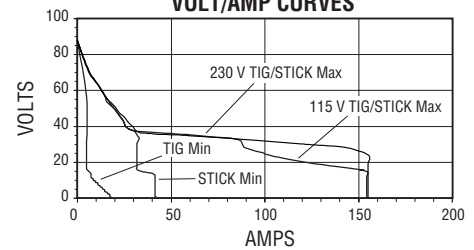
1. TIG HF Impulse Selector Light
2. Pulsed TIG Selector Light
3. Amperage Adjustment Control
4. TIG Selector Light
5. Stick Selector Light
6. Process Selector Touch Pad
7. Positive Weld Output Receptacle
8. Ready Light
9. Overtemperature Light
10. Negative Weld Output Receptacle with Flow Thru

Performance Data

DUTY CYCLE CHART



VOLT/AMP CURVES



Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
Maxstar® 150 STH Stick Package	#907 136	Single-phase, 115–230 VAC, 50/60 Hz, includes 13 ft (4 m) electrode holder, 10 ft (3 m) work clamp, shoulder strap and primary cord		
Maxstar® 150 STH Stick/TIG Package with Case and Remote Fingertip Control	#907 136-01-2	Includes #907 136 plus protective carrying case, DB1712RD125 torch with adapter, remote fingertip control (#195 184), gas hose and regulator		
Maxstar® 150 STH CE	#907 139	CE model, single-phase, 115–230 VAC, 50/60 Hz, includes 13 ft (4 m) electrode holder, 10 ft (3 m) work clamp, shoulder strap, primary cord, international flow thru connector and 6-pin plug		
RCCS-6M	#195 184 #195 503	13.25 ft, Remote Fingertip Control for Maxstar 150 STL and STH only 26.5 ft, Remote Fingertip Control for Maxstar 150 STL and STH only		
RMS-6M	#195 269	26.5 ft, Remote On/Off Control for Maxstar 150 STL and STH only		
RFCS-6M	#195 183 #195 504	13.25 ft, Remote Foot Control for Maxstar 150 STL and STH only 20 ft, Remote Foot Control for Maxstar 150 STL and STH only		
TIG Torch/Regulator Kit	#195 226			
Diamondback TIG Torches	DB1712RDI25 DB1725RDI25	150 A, 12 ft (3.7 m) air-cooled with flow thru adapter 150 A, 25 ft (7.6 m) air-cooled with flow thru adapter		
International-Style Flow Thru Adapter	#195 234	25 mm		
Protective Carrying Case	#195 180	Case only		

Date: _____ Total Quoted Price: _____

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