

# MIGmatic™ M-Series

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**Air-Cooled MIG (GMAW)  
Welding Guns**



## Quick Specs

### Industrial Applications

Auto Body  
Fabrication  
Hobby  
Maintenance and Repair

### Process

MIG (GMAW)  
Flux Cored (FCAW)

**Rated Output** M-10: 100 A, M-15: 150 A, M-25/M-25M: 250 A, M-40: 400 A

**Duty Cycle** 100% with CO<sub>2</sub> gas, 60% with mixed gas

**Weight** 3.2–10.9 lb (1.5–4.9 kg) depending on gun

## The Power of Blue.®

M-Series welding guns are an ideal match for Miller integrated MIG packages or other Miller wire feeders.

**Three-piece nozzle construction** extends nozzle life by reducing wear and helps prevent rocking of nozzle on contact tip adapter.

**Interchangeable contact tips** help reduce parts inventory.

**Brass contact tip adapter** helps prevent galling, sticking and stripping of threads.

**Single-piece high-impact handle** is almost indestructible with ergonomic design.



**Steel spring strain relief** protects power cable from wear and helps prevent liner from kinking, allowing better wire feedability. (Not available on M-10).

**360-degree rotatable gooseneck** permits trigger activation with either the finger or thumb

**Interchangeable monocoil liners** help reduce parts inventory and are available in most wire sizes.

**Optional adapter kits** are also available that enable M-Series guns to adapt to other brands of welding equipment.



Guns are warranted for 90 days parts and labor.

## Specifications (Subject to change without notice.)

Model	Stock No.	Cable Length	Rated Output	Duty Cycle	Standard Wire Size	Weight
M-10	#195 605	10 ft (3 m)	100 A	100% with CO <sub>2</sub> gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	3.2 lb (1.5 kg)
M-15	#169 589	10 ft (3 m)	150 A	100% with CO <sub>2</sub> gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	4.4 lb (2.0 kg)
	#169 591	12 ft (3.7 m)				4.7 lb (2.1 kg)
	#169 593	15 ft (4.6 m)				6.0 lb (2.7 kg)
M-25	#169 594	10 ft (3 m)	250 A	100% with CO <sub>2</sub> gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	5.4 lb (2.5 kg)
	#169 596	12 ft (3.7 m)				6.0 lb (2.7 kg)
	#169 598	15 ft (4.6 m)			.030–.035 in (0.8–0.9 mm)	7.2 lb (3.3 kg)
	#169 599				.035–.045 in (0.9–1.2 mm)	
M-25M	#169 601	15 ft (4.6 m)	250 A	100% with CO <sub>2</sub> gas, 60% with mixed gas	.030–.035 in (0.8–0.9 mm)	7.5 lb (3.4 kg)
M-40	#169 602	10 ft (3 m)	400 A	100% with CO <sub>2</sub> gas, 60% with mixed gas	.035–.045 in (0.9–1.2 mm)	8.3 lb (3.7 kg)
	#169 604	12 ft (3.7 m)				9.5 lb (4.3 kg)
	#169 606	15 ft (4.6 m)				10.9 lb (4.9 kg)



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## Genuine Miller Accessories (Order from Miller Service Parts.)

### M-10/15 Gun Convenience Kit #193 973

- 3 – .023/.025 in (0.6 mm) contact tips (#087 399)
- 5 – .030 in (0.8 mm) contact tips (#000 067)
- 5 – .035 in (0.9 mm) contact tips (#000 068)
- 1 – Contact tip/nozzle adapter (#169 716)
- 2 – Shock washers (#169 717)
- 3 – O-rings (#170 471)
- 1 – 1/2 in (13 mm) dia. orifice nozzle (#169 715)

### M-25/40 Gun Convenience Kit #193 975

- 5 – .035 in (0.9 mm) contact tips (#000 068)
- 5 – .045 in (1.2 mm) contact tips (#000 069)
- 2 – Contact tip adapter (#169 728)
- 1 – Nozzle adapter (#169 729)
- 3 – O-rings (#170 468)
- 2 – Shock washers (#169 730)
- 1 – 5/8 in (16 mm) dia. orifice nozzle (#169 726)

### Machine Adapter Kit #201 723

Allows MIGmatic welding guns to adapt to older Hobart products (Handler, Handler 120 and 150, BETA-MIG 170, 1800, 200, 250, 251 and BETA-MIG II).

### Machine Adapter Kit #201 722

Allows MIGmatic welding guns to adapt to older Miller products (10, 30, 70, and 80 Series wire feeders).

### Machine Adapter Kit #201 724

Allows MIGmatic welding guns to adapt to Lincoln products (LN-7, LN-8, LN-9, LN-22 and LN-25 series wire feeders; and SP-150, SP-200 and SP-250 machines).

### Aluminum Conversion Kit #172 136

For M-25 and M-40 only. Allows 10 ft (3 m) guns to feed 3/64 in (1.2 mm) aluminum wire.

## Consumables (Order from Miller Service Parts.)

Consumable	M-10/15	M-25	M-40
<b>Contact Tips</b>			
.023/.025 in (0.6 mm)	#087 299	#087 299	#087 299
.030 in (0.8 mm)	#000 067	#000 067	#000 067
.030 in (0.8 mm) tapered		#176 797	#176 797
.035 in (0.9 mm)	#000 068	#000 068	#000 068
.035 in (0.9 mm) tapered		#176 793	#176 793
.035 in (0.9 mm) heavy-duty		#187 117	#187 117
.045 in (1.2 mm)	#000 069	#000 069	#000 069
.045 in (1.2 mm) tapered		#176 794	#176 794
.045 in (1.2 mm) heavy-duty		#187 118	#187 118
3/64 in (1.2 mm) aluminum wire		#172 034	#172 034
.052 in (1.3 mm)		#044 392	#044 392
1/16 in (1.6 mm)			#172 024
5/64 in (2.0 mm)			#172 025
<b>Contact Tip and Nozzle Adapters</b>			
Contact tip/nozzle adapter	#169 716		
Contact tip adapter		#169 728	#169 728
Nozzle adapter		#169 729	#169 729
<b>Nozzles</b>			
1/2 in (13 mm) orifice flush tip (standard on M-10/15)	#169 715		
Spot flat	#176 237		
Spot inside corner	#176 239		
Spot outside corner	#176 241		
1/2 in (13 mm) orifice flush tip (standard on M-25)		#200 258	#200 258
1/2 in (13 mm) orifice 1/8 in (3.2 mm) recessed tip		#169 724	#169 724
5/8 in (16 mm) orifice flush tip (standard on M-40)		#169 726	#169 726
5/8 in (16 mm) orifice 1/8 in (3.2 mm) recessed tip		#169 725	#169 725
5/8 in (16 mm) orifice 1/8 in (3.2 mm) stickout tip		#169 727	#169 727
Spot flat		#176 238	#176 238
Spot inside corner		#176 240	#176 240
Spot outside corner		#176 242	#176 242
3/8 in (9.5 mm) orifice tapered		#176 243	#176 243
11/32 in (8.7 mm) orifice tapered		#178 386	#178 386
Gasless nozzle	#213 077	#213 078	#213 078
<b>Replacement Liners</b>			
.023/.025 in (0.6 mm)	#194 010	#194 010	#194 010
.030-.035 in (0.8-0.9 mm)	#194 011	#194 011	#194 011
.035-.045 in (0.9-1.2 mm)	#194 012	#194 012	#194 012
1/16-5/64 in (1.6-2.0 mm)			#194 013
3/64 in (1.2 mm) 10 ft (3 m) steel wrapped nylon		#194 014	#194 014

## Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
M-10	#195 605	10 ft (3 m). For .030-.035 in (0.8-0.9 mm) wire		
M-15	#169 589	10 ft (3 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 591	12 ft (3.7 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 593	15 ft (4.6 m). For .030-.035 in (0.8-0.9 mm) wire		
M-25	#169 594	10 ft (3 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 596	12 ft (3.7 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 598	15 ft (4.6 m). For .030-.035 in (0.8-0.9 mm) wire		
	#169 599	15 ft (4.6 m). For .035-.045 in (0.9-1.2 mm) and wire		
M-25M	#169 601	15 ft (4.6 m). For .030-.035 in (0.8-0.9 mm) wire		
M-40	#169 602	10 ft (3 m). For .035-.045 in (0.9-1.2 mm) wire		
	#169 604	12 ft (3.7 m). For .035-.045 in (0.9-1.2 mm) wire		
	#169 606	15 ft (4.6 m). For .035-.045 in (0.9-1.2 mm) wire		

Date: Total Quoted Price:

Distributed by:

