

# Thunderbolt® XL AC/DC

**Stick Welding Power Source** 

## Quick Specs

### Light Industrial Applications

Garage/Job Shops  
Plant Fabrication/Maintenance  
Vocational Training  
Light Production Line Work

### Process

AC/DC Stick (SMAW)

**Input Power** 1-Phase Power

**Max. Open-Circuit Voltage** 80

### Amperage Range

AC Low: 30–150 A  
AC High: 40–235 A  
DC: 30–160 A

**Net Weight** 104 lb. (47 kg)

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

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

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

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

**High 100 percent duty cycle rating.** 100 amps AC, 65 amps DC.



### Comes complete with:

- 15-ft. (4.5 m) No. 4 electrode cable with heavy-duty electrode holder
- 10-ft. (3 m) work cable with clamp
- Power cord with 230 V plug

*Note: Does not include wall receptacle.*

**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.)



Input Power	Mode	Welding Amperage Range	Rated Output at 20% Duty Cycle	Rated Output at 100% Duty Cycle	Amps Input at Rated Output 230 V	Max. Open-Circuit Voltage	Dimensions	Net Weight
230 VAC, 50/60 Hz	AC	Low: 30–150 A High: 40–235 A	225 A at 25 VAC, 60 Hz (15% duty cycle at 50 Hz)	100 A	47.5	80	H: 18.75 in. (476 mm) W: 12.75 in. (323 mm) D: 17.5 in. (445 mm)	104 lb. (47 kg)
	DC	30–160	150 A at 25 VDC, 60 Hz (15% duty cycle at 50 Hz)	65				

 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.



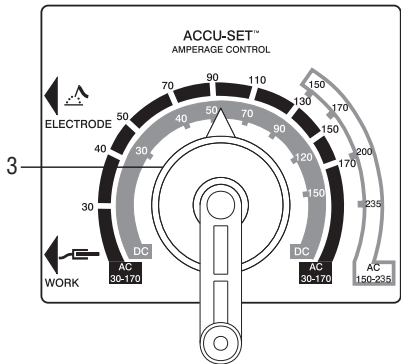
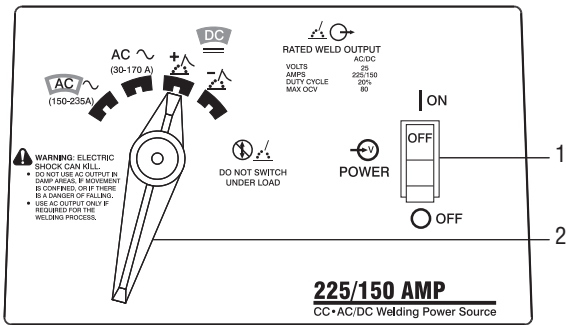
**Miller Electric Mfg. Co.**  
An ITW Welding Company  
1635 West Spencer Street  
P.O. Box 1079  
Appleton, WI 54912-1079 USA

**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**  
   



# Control Panel



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

# Electrode Charts

ELECTRODE POLARITY CHART

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	
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-Cr	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

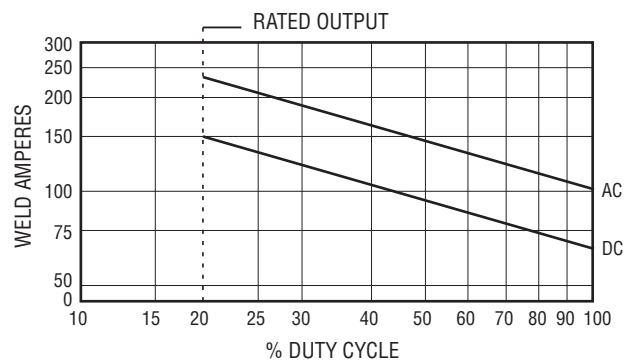
\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

ELECTRODE/AMPERAGE CHART

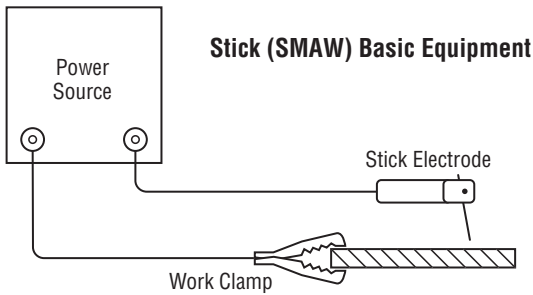
ELECTRODE	DIAMETER		AMPERAGE RANGE					
	IN	MM	MIN	50A	100A	150A	200A	MAX.
6010 & 6011	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
6013	3/16	4.8						
	1/16	1.6						
	5/64	2.0						
6013	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
	3/16	4.8						
	7014	3/32	2.4					
7014	1/8	3.2						
	5/32	4.0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

# Performance Data

DUTY CYCLE CHART



# 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 with 230 V plug		
<b>Accessories</b>				
Thunderbolt XL Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and handle		
Stick Electrodes		See charts above		
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				

Date: \_\_\_\_\_ Total Quoted Price: \_\_\_\_\_

Distributed by:

