

Dynasty[®] 280 DX Multiprocess **Multiprocess Welding Power Source**

Quick Specs



Industrial Applications

Shipbuilding
Construction
Rental
Maintenance and repair
Precision fabrication
Heavy fabrication
Pipe and tube fabrication

Processes

AC/DC TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)
Air carbon arc (CAC-A)
MIG (GMAW)*
Flux-cored (FCAW)*

Input Power 208–575 V, 1-phase or 3-phase power

Amperage Range 1–280 A (DC)
2–280 A (AC)

Voltage Range 14–28 V (DC)

Rated Output 200 A at 28 V, 60% duty cycle

Net Weight 55 lb. (25 kg)

**With ArcReach SuitCase feeder.*

The Dynasty 280 DX Multiprocess, paired with an ArcReach[®] SuitCase[®] feeder, provides a superior solution for all portable applications.

With multiprocess capabilities and features like Auto-Line™, AC TIG, pulse and high-frequency arc starts, the Dynasty 280 DX Multiprocess is the most versatile, portable machine in its class.



More Jobsite Productivity and Efficiency

AC/DC CC/CV multiprocess equipment means always having the right equipment for the job. This also simplifies logistics and translates into less time locating and moving equipment and more time welding.



Reduced Training Time

Reduced training time by utilizing one piece of equipment, saving labor costs and helping to keep projects on schedule.



More Operator Control

Weld operators can quickly and easily adjust parameters, reducing the risk of operators trying to get by with less than ideal settings. Also, state-of-the-art TIG functions such as pulse, high-frequency starting, and AC (for aluminum) allow for optimization for virtually any material type.



Improved Jobsite Safety

Portable welding equipment allows for easy movement of equipment to point of use. The chances of slip, trip or fall injuries are virtually eliminated because there is no need to travel through multi-story and cluttered jobsites back to the power source since adjustment is point of use.



Dynasty 280 DX Multiprocess (907514007) shown with ArcReach SuitCase 8 feeder (951726).



Increased Uptime

Low power draw can mean additional welding equipment on the same circuit, getting work done faster by reducing the chances of power outages from tripped breakers or blown fuses.



Power source is warranted for three years, parts and labor.



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MillerWelds.com



Weld Process Features

AC TIG

Balance control provides adjustable oxide removal which is essential for creating the highest quality aluminum welds. DX models provide extended ranges.

Frequency controls the width of the arc cone and can improve directional control of the arc.

AC Waveforms

-  **Advanced squarewave**, fast freezing puddle, deep penetration and fast travel speeds.
-  **Soft squarewave** for a soft buttery arc with maximum puddle control and good wetting action.
-  **Sine wave** for customers that like a traditional arc. Quiet with good wetting.
-  **Triangular wave** reduces the heat input and is good on thin aluminum. Fast travel speeds.

MIG

CV output of the power source gives this unit MIG process capabilities when paired with a ArcReach® SuitCase® feeder (or other voltage-sensing feeder). The feeder is powered off the arc voltage of the power source and can run both solid and flux-cored wires

AC/DC Stick

DIG control allows the arc characteristics to be changed for specific applications and electrodes. Lower the DIG setting for smooth running electrodes like E7018 and increase the DIG setting for stiffer, more penetrating electrodes like E6010.

Hot Start™ adaptive control provides positive arc starts without sticking.

AC frequency control adds stability for smoother welds when AC stick welding.

Stick-Stuck detects if the electrode is stuck to the part and turns the welding output off to safely and easily remove the electrode. Menu selectable.

Specifications (Subject to change without notice.)



Welding Mode	Input Power	Welding Amperage Range	Rated Output	Amps Input at Rated Load Output, 50/60 Hz						Max. Open-Circuit Voltage	Dimensions	Net Weight	
				208 V	230 V	400 V	460 V	575 V	KVA				KW
TIG (GTAW)	3-phase	2–280 A (AC) 1–280 A (DC)	235 A at 19.4 V, 60% duty cycle	19	17	10	9	7	7.0	6.7	60 VDC (11 VDC**)	H: 13.6 in. (346 mm) W: 8.6 in. (219 mm) D: 22.5 in. (569 mm)	55 lb. (25 kg) with CPS
	1-phase	2–280 A (AC) 1–280 A (DC)	235 A at 19.4 V, 60% duty cycle	33	30	17	15	12	6.9	6.8			
Stick (SMAW)	3-phase	5–280 A	200 A at 28 V, 60% duty cycle	22	20	11	10	8	8.2	7.9			
	1-phase	5–280 A	180 A at 27.2 V, 60% duty cycle*	34	31	17	15	12	7.1	7.0			

* Refer to owner's manual for 208 V output ratings and duty cycle. ** Low OCV sense voltage for stick and Lift-Arc™ TIG.

IP23 rating — This equipment is designed for outdoor use. It may be stored, but is not intended to be used outside during precipitation unless sheltered.

Operating temperature range is 14 to 104°F (-10 to 40°C). Storage temperature range is -22 to 149°F (-30 to 65°C). Portions of the preceding text are contained in EN 60974-1: "Welding power sources for arc welding equipment."

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

Performance Data

Input Power	TIG (GTAW) Duty Cycle	Stick (SMAW) Duty Cycle	MIG (GMAW)/ Flux-cored (FCAW) Duty Cycle	TIG Material Thickness Range	Stick Electrode Max. Diameter	Air Carbon Arc Gouging (CAC-A) Max.	MIG Ranges	Generator Requirement
380–575 V	280 A, 40% 250 A, 60% 200 A, 100%	280 A, 35% 250 A, 60% 200 A, 100%	280 A, 35% 250 A, 60% 200 A, 100%	AC: 0.012–3/8 in. (0.3–9.5 mm) DC: 0.004–3/8 in. (0.1–9.5 mm)	6010: 1/4 in. (6.4 mm) 7018: 7/32 in. (5.6 mm) 7024: 3/16 in. (4.8 mm)	3/16 in. (4.8 mm)	Voltage: 14–28 V Wire speed: 50–780 ipm (1.3–19.8 m/min.) Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–.052 in. (0.8–1.4 mm)	12.5 kW
208–240 V	280 A, 40% 250 A, 60% 200 A, 100%	280 A, 15% 180 A, 60% 145 A, 100%	280 A, 20% 200 A, 60% 160 A, 100%					

Material Type	Wire Diameter						
	.024 in.	.030 in.	.035 in.	.045 in. 3/64 in. Al	.052 in.	1/16 in.	5/64 in.
Solid wire (steel/SS)	●	●	●	●	●		
Aluminum			●	●		●	
Dual (gas-) shielded flux-cored/metal core			●	●	●	●	●
Self-shielded flux-cored		●	●	●	●	●	●

● Recommended — refer to wire manufacturer specifications for output requirements. ● Gun length may affect feedability.

TIG Upgrade Chart

Why Upgrade?	Dynasty 280 UPGRADE	Dynasty 280 DX Multiprocess	Benefits
Versatility	AC/DC TIG AC/DC Stick	AC/DC TIG AC/DC Stick MIG Flux-cored	Tackle virtually any welding job with one power source! Pair with a feeder to weld common materials such as steel, stainless and aluminum, or specialty metals such as Inconel®.
AC Frequency Control (Aluminum TIG)	Variable 70–150 Hz	Variable 20–400 Hz	Higher AC frequencies provide better arc control and faster travel speeds.
AC Balance Control (Aluminum TIG)	60–80% electrode negative	50–99% electrode negative	Greater electrode negative helps to produce welds with less etching for more aesthetic welds.
AC Waveforms (Aluminum TIG)	Soft squarewave	Soft squarewave Advanced squarewave Sine wave Triangular wave	Soft squarewave = maximum puddle control Advanced squarewave = faster travel Sine wave = traditional characteristics Triangular wave = reduced heat input
Arc Starting	High frequency (HF) Lift-Arc™	High frequency (HF) Lift-Arc™	High-frequency (HF) arc starter for non-contact arc initiation and refined Lift-Arc help prevent tungsten contamination.
Pulses per second (PPS)	Variable 0.1–250 pps	Variable 0.1–500 pps	Pulsing reduces heat input for sensitive materials. Higher pulse rates improve directional control.
Pulse Peak Time	Fixed 40%	Variable 5–95%	Allows for tailoring of pulse characteristics and reduce heat.
Pulse Background Amperage	Fixed 25%	Variable 5–95%	Allows for tailoring of pulse characteristics and reduce heat.
Portability	55 lb. 13.6 x 8.6 x 22.5 in.	55 lb. 13.6 x 8.6 x 22.5 in.	One person can easily move and compact design makes it ideal for narrow passages.
Power Flexibility	Auto-Line™, 208–575 V 1-phase or 3-phase	Auto-Line™, 208–575 V 1-phase or 3-phase	Auto-Line eliminates the need for manual linking and the power-efficient design allows more welding power sources on one circuit.

ArcReach® SuitCase® 8 and 12 (Note: Dynasty 280 DX is not capable of ArcReach control.)



Portable wire feeding at its best

Voltage-sensing, portable feeders designed to run off of arc voltage from almost any welding power source, provide extreme reliability for construction and fabrication.

- Scaled wire pressure knob provides easy adjustment and consistent pressure on the drive rolls and wire
- Wire drive and motor assembly is specifically designed for mobile welding applications to provide smooth and consistent wire delivery
- Gun locking tab works with guns having corresponding locking grooves to prevent gun from being pulled out if the feeder is dragged by the gun
- Ultra-low drag inlet guide pins make loading the wire easy and do not deform the wire on the way into the drive rolls

Model	Input Power	Input Welding Circuit Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Max. Spool Size Capacity	Dimensions	Net Weight
8	Operates on open-circuit voltage and arc voltage: 14–48 VDC/ 110 max. OCV	330 A at 60% duty cycle	50–780 ipm (1.3–19.8 m/min.) dependent on arc voltage	Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–5/64 in. (0.8–2.0 mm)	8 in. (203 mm) 14 lb. (6.4 kg)	H: 12.75 in. (324 mm) W: 7.25 in. (184 mm) D: 18 in. (457 mm)	28 lb. (13 kg)
12		425 A at 60% duty cycle		Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–5/64 in. (0.8–2.0 mm)	12 in. (305 mm) 45 lb. (20 kg)	H: 15.5 in. (394 mm) W: 9 in. (229 mm) D: 21 in. (533 mm)	35 lb. (15.9 kg)

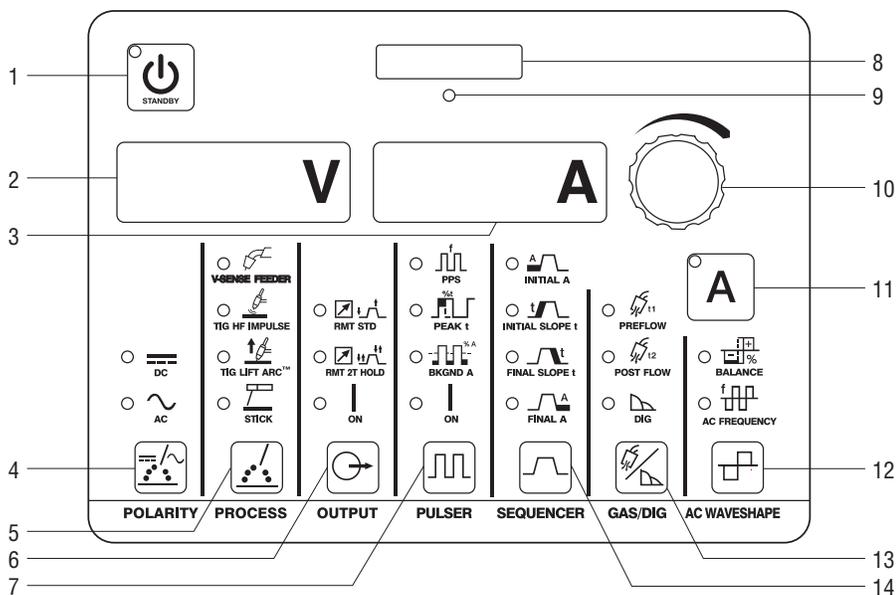
Coolmate™ 1.3 Cooler



- Dynasty® models with CPS turn Coolmate 1.3 on and off
- Power indicator light and fluid level sight window
- Rustproof polyethylene-molded coolant tank and filler spout
- 1/4 hp motor is thermally protected to guard against overheating
- Efficient fin and tube heat exchanger
- Factory-set pressure relief valve (55 psi) maintains consistent pressure during operation
- Filter and coolant filling spout are conveniently located
- Brass-body, positive displacement rotary vane pump provides consistent coolant flow and pressure rating with long pump-life expectancy

Input Power	Maximum Current Draw	Maximum Cooling Capacity	Rated Cooling Capacity	Tank Capacity	Dimensions	Net Weight
115 V, 60 Hz	4.7 A (60 Hz)	3,400 W (11,600 Btu/hr.) 3.8 qt./min. (3.6 L/min.)	1,330 W (4,540 Btu/hr.) 1.1 qt./min. (1 L/min.)	1.3 gal. (4.9 L)	H: 11.25 in. (286 mm) W: 10.375 in. (264 mm) D: 24 in. (610 mm)	43 lb. (20 kg)

Dynasty® 280 DX Control Panel



1. Standby Switch

2. Voltmeter Display

3. Ammeter Display

4. Polarity

AC/DC

5. Process/ Arc Starting

MIG: Voltage-sensing feeder
TIG: HF impulse, Lift-Arc
Stick: Adaptive Hot Start

6. Output Control

Standard remote,
2T trigger hold,
Output on

7. Pulser Control

Pulses per Second* DC: 0.1–500 pps
AC: 0.1–500 pps
Peak Time* 5–95%
Background Amps* 5–95%

8. Memory Card Port

9. Activity Indicator

10. Encoder Control

11. Amperage Button

12. AC Waveshape

Balance* 50–99% EN
Frequency* 20–400 Hz

13. Gas/DIG

Preflow 0.0–25.0 seconds
Postflow Auto / Off–50 seconds
DIG* Off–100%
Arc Control (Inductance)** 0–99% (solid wire - EP)
Flux Core (flux-cored wire - EN)

14. Sequencer Control

Initial Amps AC: 2–280 A
DC: 1–280 A
Initial Time 0.0–25.0 seconds
Initial Slope 0.0–50.0 seconds
Weld Time 0.0–999 seconds
Final Slope 0.0–50.0 seconds
Final Amps AC: 2–280 A
DC: 1–280 A
Final Time 0.0–25.0 seconds

*Pro-Set parameter selectable.

**Inductance control uses the DIG selection on the interface and illuminates that LED when you are in the V-Sense Feeder process.

User Menu (Press Gas and Amperage buttons.)

1. Tungsten Size = .020–1/8 in. / GEN or .05–3.2 mm
2. Remote Trigger = 3T / 4T / 4TL / 4TLE
3. Wave Form = SOFT / ADVS / SINE / TRI
4. Stick Hot Start = ON / OFF

Tech Menu (Hold Gas and Amperage buttons five seconds.)

1. Arc Time 0.0–9,999 hours
0.0–59 minutes
0–999,999 cycles
Resettable
2. Error Log = Error event recorder
3. Sleep Timer = 1 / 5 / 10 / 15 / 30 / 45MIN / 1HR
4. Stick Stuc = OFF / ON
5. OCV = LOW / NORM
6. Weld Timers = OFF / ON
7. Cooler Power = AUTO / ON / OFF (Dynasty models with GPS only)
8. Locks = OFF / 1–4
9. Meter Display
10. External Pulse Control = OFF / ON
11. Machine Reset
12. Software Number
13. Serial Number
14. Insight (Dynasty models with Insight only)

Build a Dynasty® 280 DX Multiprocess System

Air-Cooled System

Step 1 • Order Dynasty

- | | |
|--|-----------|
| • Dynasty 280 DX Multiprocess (with CPS) | 907514007 |
|--|-----------|

Dynasty comes with adjustable shoulder strap, 8 ft. power cord (no plug), quick reference guide, two 50 mm Dinse-style connectors, and two Dinse/Tweco® adapters.

Step 2 • Order TIG Accessory (pick one)

- | | |
|------------------------------------|--------|
| • Foot Control Contractor Kit | 301309 |
| • Fingertip Control Contractor Kit | 301311 |

See page 6 for kit contents.

Step 3 • Order MIG Wire Feeder and Gun (pick one)

- | | |
|---|--------|
| • ArcReach® SuitCase® 8 with Bernard™ BTB Gun 300 A | 951726 |
| • ArcReach® SuitCase® 8 with Bernard™ Dura-Flux™ Gun | 951728 |
| • ArcReach® SuitCase® 12 with Bernard™ BTB Gun 300 A | 951729 |
| • ArcReach® SuitCase® 12 with Bernard™ Dura-Flux™ Gun | 951731 |

See page 3 for feeder features.

Step 4 • Suggested Upgrades

- | | |
|--|--------|
| • Dinse-style Connector Kit for up to #1/0 cable (includes 1 male plug and 1 female receptacle)* | 042419 |
| • Dinse-style Connectors for #1/0 to #2/0 cable (order one of each)* | |
| Single Male Dinse-style Plug | 134460 |
| Single Female Dinse-style Receptacle | 136600 |
| • Gas Hose Quick Release** | QRG |
| • Dual-groove Drive Roll** (.035 in. V-groove/.045 in. V-knurled) | 269480 |
| • Wireless Foot Control | 300429 |

*10 feet of #4 to #1/0 cable recommended to connect feeder (NOT available through Miller).
**Two required per machine.

Water-Cooled System

Step 1 • Order ALL Listed

- | | |
|---|-----------|
| • Dynasty 280 DX Multiprocess (with CPS) | 907514007 |
| • Coolmate 1.3 | 300972 |
| • Small Runner Cart | 301318 |
| • Low-Conductivity Coolant (must be ordered in quantities of 4) | 043810 |

Dynasty comes with adjustable shoulder strap, 8 ft. power cord (no plug), quick reference guide, two 50 mm Dinse-style connectors, and two Dinse/Tweco® adapters.

Step 2 • Order TIG Remote Control (pick one)

- | | |
|--------------------------------|-----------|
| • Wireless Foot (recommended) | 300429 |
| • RFCS-14 HD Foot | 194744 |
| • RCC-14 E/W Fingertip | 151086 |
| • RCCS-14 N/S Fingertip | 043688 |
| • RMS-14 Pushbutton | 187208 |
| • RMLS-14 Momentary/Maintained | 129337 |
| • RHC-14 Hand | 242211020 |
| • Wireless Hand | 300430 |

See page 7 for remote descriptions.

Step 3 • Order TIG Torch Kit (pick one)

- | | |
|---------------------------|--------|
| • W-250 Kit | 300185 |
| • W-280 Kit (recommended) | 300990 |
| • W-375 Kit | 301268 |

See page 6 for kit contents.

Step 4 • Order MIG Wire Feeder and Gun (pick one)

- | | |
|---|--------|
| • ArcReach® SuitCase® 8 with Bernard™ BTB Gun 300 A | 951726 |
| • ArcReach® SuitCase® 8 with Bernard™ Dura-Flux™ Gun | 951728 |
| • ArcReach® SuitCase® 12 with Bernard™ BTB Gun 300 A | 951729 |
| • ArcReach® SuitCase® 12 with Bernard™ Dura-Flux™ Gun | 951731 |

See page 3 for feeder features.

Step 5 • Suggested Upgrades

- | | |
|--|--------|
| • Dinse-style Connector Kit for up to #1/0 cable (includes 1 male plug and 1 female receptacle)* | 042419 |
| • Dinse-style Connectors for #1/0 to #2/0 cable (order one of each)* | |
| Single Male Dinse-style Plug | 134460 |
| Single Female Dinse-style Receptacle | 136600 |
| • Gas Hose Quick Release** | QRG |
| • Water Hose Quick Release** | QRW |
| • Dual-groove Drive Roll** (.035 in. V-groove/.045 in. V-knurled) | 269480 |

*10 feet of #4 to #1/0 cable recommended to connect feeder (NOT available through Miller).
**Two required per machine.

Genuine Miller® Accessories

Protective Cover 301382
Fits Dynasty 210/280 and Maxstar 280.



Small Runner™ Cart 301318
Designed for Dynasty/Maxstar 210 and 280 with or without Coolmate 1.3 cooler. Cart features single-cylinder rack, foot pedal holder, two cable/torch holders, and two TIG filler rod holders.



Coolmate™ 1.3 300972 120 V
1.3-gallon cooler designed to cool torches up to 280 amps.



Low-Conductivity Coolant 043810
Sold in cases of four one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water

to protect against freezing to -37 degrees Fahrenheit (-38°C) or boiling to 227 degrees Fahrenheit (108°C). Also contains a compound that resists algae growth.



Performance TIG Gloves
263345 X-Small
263346 Small
263347 Medium
263348 Large
263349 X-Large
Completely unlined, goat grain leather with triple-padded palm.

Memory Cards

Memory Card Expansion

301151 14-Pin Automation Expansion
Provides the ability to access common automation functions through the 14-pin connection.

301152 14-Pin Modbus® Expansion
Provides the ability to access basic and advanced functions through the 14-pin connection.

301235 Independent AC Expansion
Allows EP and EN amperages and waveforms to be set independently to precisely control heat input to the work and electrode.

Memory Card (Blank) 301080

A blank, commercially available memory card used for transferring software updates and expandable features from your computer to the machine.

TIG Torches, Kits and Connectors



Contractor kit
301311 shown.

Contractor Kits

301309 150 A RFCS-14 HD Foot Pedal Kit
301311 150 A RCCS-14 Fingertip Kit
All-in-one TIG/stick welding kit comes with either a RFCS-14 HD foot control **OR** RCCS-14 fingertip control, Weldcraft™ A-150 TIG torch, 200-amp stick electrode holder and 300-amp work clamp with 15-foot (4.6 m) cables, flow gauge regulator with 12-foot (3.7 m) gas hose, gas hose coupler, AK2C torch accessory kit and TIG torch connector.



Weldcraft™ A-200 (WP-26) TIG Torch
WP-26-12-R (12 ft.)
WP-26-25-R (25 ft.)
200-amp air-cooled torch. Torch body gas valve models also available.

*Note: A-200 (WP-26) torches require **195379** connector.*



Air-Cooled TIG Torch Connectors

195379 A-200 (WP-26)
195378* All others
50 mm Dinse-style for one-piece air-cooled torch.
A-80 (WP-24) torches require **24-5 connector.*



Torch kit
300990 shown.

Water-Cooled Torch Kits

300185 W-250
300990 W-280 (recommended)
301268 W-375

Kit comes with Weldcraft™ 25-foot (7.6 m) TIG torch with Dinse-style connector, torch cable cover, work clamp with 15-foot (4.6 m) cable, flowmeter regulator with gas hose and torch accessory kit (1/16-, 3/32- and 1/8-inch 2% ceriated tungsten, nozzles, collets and collet bodies).



Water-Cooled TIG Torch Connector 195377
50 mm Dinse-style with water return line. For use with all Weldcraft™ water-cooled torches.



Dinse/Tweco® Adapter 042465

A one-piece adapter which has a Dinse-style male plug (to power source) on one end and a female Tweco receptacle (for weld cable connection) on other end.



Weldcraft™ Gas Hose Quick Connect QRG
Allows for quick connection and removal of torch shielding gas hoses.



Weldcraft™ Water Hose Quick Connect QRW
Allows for quick connection and removal of torch coolant hoses.

Genuine Miller® Accessories (Continued)

Wire Feeders



ArcReach® SuitCase® 8

951726 With Bernard™ BTB Gun 300 A

951728 With Bernard™ Dura-Flux™ gun

ArcReach® SuitCase® 12

951729 With Bernard™ BTB Gun 300 A

951731 With Bernard™ Dura-Flux™ gun

Portable feeder designed to run off of arc voltage. Holds up to an 8-inch (SuitCase 8) or 12-inch (SuitCase 12) spool of wire. See literature M/6.55.

Note: Dynasty 280 DX is not capable of ArcReach control.

Remote Controls and Switches



Wireless Remote Foot Control 300429

For remote current and contactor control.

Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.



RFCS-14 HD Foot Control 194744

Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.



RCC-14 Remote Contactor and Current Control 151086

East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.



RCCS-14 Remote Contactor and Current Control 043688

North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.



RMS-14 On/Off Control 187208

Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.



RMLS-14 Switch 129337

Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.



RHC-14 Hand Control 242211020

Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 83 mm). Includes 20-foot (6 m) cord and 14-pin plug.



Wireless Remote Hand Control 300430

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

Educational Materials

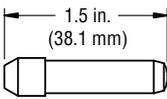
To order, please call Miller Literature at 866-931-9732 or visit MillerWelds.com/resources/tools.

Gas Tungsten Arc Welding (TIG) Publication 250833

Setup DVD 251116

Video topics include tungsten selection, setup menus, DC pulse, sequencer, balance and frequency settings.

Consumables (Order from Miller Service Parts.)

Wire Size	Drive Rolls (Two required.)				Centerfire™ Contact Tips
	“V” groove for hard wire 	“U” groove for soft wire or soft-shelled cored wires 	“V” knurled for hard-shelled cored wires 	“U” cogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types) 	“T” Series (.35 in. O.D.) 
.023/.025 in. (0.6 mm)	087130	—	—	—	T-023
.030 in. (0.8 mm)	053695	—	—	—	T-030
.035 in. (0.9 mm)	053700	072000	132958	—	T-035
.040 in. (1.0 mm)	053696	—	—	—	T-039
.045 in. (1.1/1.2 mm)	053697	053701	132957	083489	T-045
.052 in. (1.3/1.4 mm)	053698	053702	132956	083490	T-052
1/16 in. (1.6 mm)	053699	053706	132955	053708	T-062
.068/.072 in. (1.8 mm)	—	—	132959	—	T-072
5/64 in. (2.0 mm)	—	053704	132960	053710	T-078

Select drive rolls from chart according to type and wire size being used. Wire inlet guide comes installed on ArcReach SuitCase wire feeders.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
Dynasty® 280 DX (CPS) Multiprocess	907514007	Auto-Line™ 208–575 V, 50/60 Hz, CSA . 8 ft. power cord		
Accessories				
Protective Cover	301382	For Dynasty 210/280 and Maxstar 280		
Small Runner™ Cart	301318	For Dynasty/Maxstar 210 and 280 with or without Coolmate 1.3		
Coolmate™ 1.3	300972	120 V, 60 Hz, CSA . <i>Requires coolant</i>		
TIG Coolant (must be ordered in quantities of four)	043810	1-gallon plastic bottle. Protects against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C)		
TIG Gloves		See page 6		
Memory Cards		See page 6		
TIG Torches, Kits and Connectors				
Air-Cooled Contractor Kits (see page 6 for contents)	301309 301311	Foot pedal Fingertip		
Weldcraft™ A-150 (WP-17) TIG Torch	WP-17-12-R WP-17-25-R	12 ft. (3.7 m) cable. Requires 195378 connector 25 ft. (7.6 m) cable. Requires 195378 connector		
Weldcraft™ A-200 (WP-26) TIG Torch	WP-26-12-R WP-26-25-R	12 ft. (3.7 m) cable. Requires 195379 connector 25 ft. (7.6 m) cable. Requires 195379 connector		
Air-Cooled TIG Torch Connectors	195379 195378	Connects Weldcraft™ A-200 (WP-26) torch to Dinse-style connector Connects all air-cooled Weldcraft™ torches (except A-200) to Dinse-style connector. A-80 (WP-24) torches require 24-5 connector		
Water-Cooled Torch Kits (see page 6 for contents)	300185 300990 301268	W-250 W-280 (recommended for Dynasty 280) W-375		
Water-Cooled TIG Torch Connector	195377	Connects Weldcraft™ water-cooled torches to Dinse-style connector		
Dinse/Tweco® Adapter	042465	One-piece adapter with Dinse-style male plug and Tweco-style female receptacle		
Weldcraft™ Quick Connects	QRG QRW	For gas hoses For water hoses		
Wire Feeders				
ArcReach® SuitCase® 8 (see literature M/6.55)	951726 951728	With Bernard™ BTB Gun 300 A With Bernard™ Dura-Flux™ gun		
ArcReach® SuitCase® 12 (see literature M/6.55)	951729 951731	With Bernard™ BTB Gun 300 A With Bernard™ Dura-Flux™ gun		
Drive Rolls		See page 7		
Contact Tips		See page 7		
Remote Controls				
Wireless Remote Foot Control	300429	Foot control with wireless 90 ft. (27.4 m) operating range		
RFC-14 HD	194744	Heavy-duty foot control		
RCC-14	151086	Side-to-side (east/west) fingertip control		
RCCS-14	043688	North/south fingertip control		
RMS-14	187208	Momentary rubber dome switch		
RMLS-14	129337	Momentary/maintained rocker switch		
RHC-14	242211020	Hand control		
Wireless Remote Hand Control	300430	Hand control with wireless 300 ft. (91.4 m) operating range		
Educational Materials				
Gas Tungsten Arc Welding (TIG) Publication	250833			
Setup DVD	251116			

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