

M-Series MIG Guns

Model	Stock #	Length	Rating and Duty Cycle (CO ₂) ¹	Wire Size
M-100	248 282	10 ft (3 m)	100 A at 100% Duty Cycle	.030–.035 in (0.8–0.9 mm)
	220 606 ²			
M-150	249 039	10 ft (3 m)	150 A at 100% Duty Cycle	.030–.035 in (0.8–0.9 mm)
	249 040	12 ft (3.7 m)		
	249 041	15 ft (4.6 m)		
M-25	169 594	10 ft (3 m)	250 A at 100% Duty Cycle	.030–.035 in (0.8–0.9 mm)
	169 596	12 ft (3.7 m)		
	194 805 ³	12 ft (3.7 m)		
	169 598	15 ft (4.6 m)		
	169 599	15 ft (4.6 m)		
M-40	169 602 (N/A)	10 ft (3 m)	400 A at 100% Duty Cycle	.035–.045 in (0.9–1.2 mm)
	169 604 (N/A)	12 ft (3.7 m)		
	169 606 (N/A)	15 ft (4.6 m)		

¹60% with mixed gases

²#220 606 is an M-10 gun with friction terminals for the Miller Cricket.[®]

³#194 805 is an M-25 gun with friction lugs for the Hobart Beta-MIG 2510.

Miller MIG Gun History

Machine	Serial Number Effective	Original Gun	Recommended Replacement Gun
SideKick™	All Serial Numbers	GA-16C	M-100, pg 19
Cricket [®]	All Serial Numbers	GA-16C1	M-100 w/friction terminals, pg 19
SideKick™ XL/Cricket [®] XL/ Millermatic [®] 90	All Serial Numbers	GA-17C	M-100/M-150, pg 19
Millermatic [®] 35	Prior to JA448186	Original 058 260 Gun	N/A
	Effective with JA448186	GA-20C	M-150, pg 19
Millermatic [®] 120/150	Prior to KF849783	GA-17C	M-150, pg 19
	Effective with KF849783	M-15, pg 19	
Millermatic [®] 130	Prior to KF853420	GA-17C	M-100/M-150, pg 19
	Effective with KF853420	M-15, pg 19	
Millermatic [®] 130 XP	Prior to KK110539	10-A	M-100/M-150, pg 19
	Effective with KK110539	M-10, pg 19	
Millermatic [®] 135/140s/175/180s/DVI [®]	All Serial Numbers	M-10, pg 19	M-100/M-150, pg 19
Millermatic [®] Challenger™	All Serial Numbers	M-15, pg 19	M-100/M-150, pg 19
Millermatic [®] Challenger™ 172	Prior to KK118238	10-A	M-100/M-150, pg 19
	Effective with KK118238	M-10, pg 19	
Millermatic [®] 185	All Serial Numbers	M-15, pg 19	M-150, pg 19
Millermatic [®] 200	All Serial Numbers	GA-20C	M-25, pg 20
Millermatic [®] 210/212/250X/251/252	All Serial Numbers	M-25, pg 20	M-25, pg 20
	Prior to KF851980	GA-21C	M-25, pg 20
Millermatic [®] 250	Effective with KF851980	M-25, pg 20	
	All Serial Numbers	GA-20C; GA-21C; M-25, pg 20	M-25, pg 20
Millermatic [®] 300	All Serial Numbers	M-40, pg 21	Roughneck [®] , pg 25
Millermatic [®] 300 without Gun	All Serial Numbers	No Gun Included	Roughneck [®] , pg 25
Millermatic [®] 350	Prior to LE443589	Roughneck [®] 4012, pg 23	Roughneck [®] 4012, pg 25
	Effective with LE443589	Q3015AE8XM	Q3015AE8XM
Millermatic [®] Passport™ / Passport™ Plus	All Serial Numbers	M-10, pg 19	M-100, pg 19
Millermatic [®] Pulsar	All Serial Numbers	M-15, pg 19 and Spoolmate™ 3035, pg 39	M-150, pg 19 and Spoolmate™ 3035, pg 39



MIGmatic™ M-Series
100–250 Amp, Semi-Automatic,
Air-Cooled MIG Welding Guns

MIG Gun Holder #229 614



M-Series Consumable Kits (#234 607, #234 608, #234 609)
contain 10 contact tips, 1 nozzle and 1 contact tip adapter.



M-Series Consumable Kits (#234 610, #234 611, #234 612)
contain 10 contact tips, 1 nozzle, 1 contact tip adapter and 1 nozzle adapter.

Accessories

For a complete listing of gun consumables information, please refer to pages 19–22.

M-Series MIG Consumable Kits

To better serve you, Miller has introduced six improved, affordable MIG consumable kits that are compatible with the M-Series guns. Each kit contains consumables that are specific to your welding application, including gun type and wire size.

- 234 607–M-10/15, M-100/150 Gun, .023" Wire
- 234 608–M-10/15, M-100/150 Gun, .030" Wire
- 234 609–M-10/15, M-100/150 Gun, .035" Wire
- 234 610–M-25 Gun, .030" Wire
- 234 611–M-25 Gun, .035" Wire
- 234 612–M-25 Gun, .045" Wire

Aluminum Conversion Kit #172 136

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