

XMT® 425 Series

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Multiprocess Welding 
Power Source

Quick Specs



Heavy Industrial Applications

Construction
Shipbuilding
Railroad
Truck/trailer manufacturing
Fabrication
Repair shops
Rental fleets
Power generation plants

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)*
Flux-cored (FCAW)
Stick (SMAW)
TIG (GTAW)
Air carbon arc (CAC-A) cutting and gouging
Rated: 6 mm carbons

*CC/CV model requires optional control.

Input Power 230–575 V, 50/60 Hz,
3-phase power

Rated Output 275 A at 100% duty cycle,
425 A at 30% duty cycle

Max. Open-Circuit Voltage 75 V

Net Weight 43 kg (94.8 lb.)

Wind Tunnel Technology™ protects electrical components and PC boards from contamination.

Fan-On-Demand™ cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through machine.

Lift-Arc™ allows TIG starting without the use of high-frequency. Starts the arc without contaminating the weld with tungsten.

Adaptive Hot Start™ increases the output amperage at the start of the weld if necessary, reducing electrode sticking.

Inverter arc control technology provides greater puddle control for superior 6010 stick electrode performance, and outstanding MIG weld performance.

Low OCV stick. Selectable feature that reduces open-circuit voltage to nearly 15 volts when power source is not in use. Eliminates need for add-on voltage reducers.

Process selector switch reduces the number of control setup combinations without reducing any features.



Large, dual digital meters are easy to view and are presettable to ease setting weld output.

115-volt auxiliary power provides 10 amps of circuit-breaker-protected power for coolant systems, etc.

Auto Remote Sense™ enables unit to automatically use remote control if connected to remote control receptacle.

Pulsed MIG capabilities. MPa model has built-in capability and CC/CV model requires optional Optima™ control.

Additional MPa model benefits

Advanced arc control enables an improved pulse welding arc. The operator has more control over puddle and bead characteristics using SharpArc. In addition, the unit provides a more robust and stable arc at very low arc length, reducing heat input, and providing the ability to weld on a wider range of material thickness.

SharpArc® controls the arc in pulsed MIG mode and gives total control over the arc cone shape, puddle fluidity and bead profile.

Auto-Line™ power management technology allows for any input voltage hookup (230–575 V) with no manual linking required, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.



Power source is warranted for three years, parts and labor. Original main power rectifier parts are warranted for five years.

Specifications (Subject to change without notice.)



Voltage Range in CV Mode	Amperage Range in CC Mode	Rated Output	IP Rating	Amps Input at Rated Output, 50/60 Hz 230 V 400 V 460 V 575 V KVA KW	Max. Open-Circuit Voltage	Dimensions	Net Weight
10–38 V	5–425 A	275 A at 21 VDC, 100% duty cycle 425 A at 27 VDC, 30% duty cycle	IP23	36.1 20.6 17.8 14.1 14.2 13.6	75 V	H: 432 mm (17 in.) W: 318 mm (12.5 in.) D: 610 mm (24 in.)	36.3 kg (80 lb.) without aux. pwr. 43 kg (94.8 lb.) with aux. pwr.



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Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
XMT® 425 CC/CV	907557	Auto-Line™ 230–575 V with auxiliary power		
	907557002	Auto-Line™ 230–575 V		
	907557003	Auto-Line™ 230–575 V with auxiliary power, gas valve		
XMT® 425 MPa	907559	Auto-Line™ 230–575 V with auxiliary power		
Wire Feeders/Torch				
SuitCase® X-TREME 8VS	300877	See literature M/6.42		
SuitCase® X-TREME™ 12VS	300876	See literature M/6.42		
SuitCase® 12RC	301121	See literature M/6.5		
XR™-S Control	300601	Standard model with wire feed speed digital display, jog/purge, run-in control, and trigger hold. See literature M/1.7		
XR™-D Control	300687	Enhanced model has same features as XR-S model plus advanced digital and programming capabilities. See literature M/1.7		
XR-AlumaFeed™	300509	Advanced model adds Profile Pulse™, synergic control for XMT 425 MPa, trigger schedule select, lock capabilities and flow meter		
70 Series	300616002	S-74S. See literature M/3.0		
	300617003	S-74D. See literature M/3.0		
	300618003	S-74DX. See literature M/3.0		
	300577	S-74 MPa Plus. Single-wire synergic feeder for XMT 425 MPa. See literature M/3.0		
	300578	D-74 MPa Plus. Dual-wire synergic feeder for XMT 425 MPa. See literature M/3.0		
ST-24	029007395	Non-synergic feeder. See literature WFM/4.0		
	029007396	Non-synergic feeder with quick-connect coolant fittings and remote voltage control		
	029007397	Same as 029007396 plus digital meters		
ST-44	029007406	Non-synergic feeder. See literature WFM/51.2		
	029007404	Non-synergic feeder w/digital meters, quick-connect coolant fittings, remote voltage control		
Interconnecting Cables	058019028	Air-cooled, 3 m (10 ft.), for SuitCase 12RC, ST-24 and ST-44		
	058019044	Air-cooled, 5 m (16.4 ft.), for SuitCase 12RC, ST-24 and ST-44		
	058019039	Air-cooled, 10 m (32.8 ft.), for SuitCase 12RC, ST-24 and ST-44		
	058019032	Water-cooled, 3 m (10 ft.), for SuitCase 12RC, ST-24 and ST-44		
	058019033	Water-cooled, 5 m (16.4 ft.), for SuitCase 12RC, ST-24 and ST-44		
	058019046	Water-cooled, 10 m (32.8 ft.), for SuitCase 12RC, ST-24 and ST-44		
	058019174	Water-cooled, 3 m (10 ft.), for MPa Plus feeders		
	058019175	Water-cooled, 5 m (16.4 ft.), for MPa Plus feeders		
	058019176	Water-cooled, 10 m (32.8 ft.), for MPa Plus feeders		
Torch	D4015BB8EESF	Bernard™ D-4015 water-cooled, 1.2 mm, 4.57 m (15 ft.)		
Accessories				
HydraCool® 1	028042103	115 V coolant system		
	028042104	230 V coolant system		
HydraCool® 2	028042105	115 V coolant system		
	028042106	230 V coolant system		
Blu-Liquid Coolant	050024004	Low conductivity, 10 litres		
HF 5000	V29012345	HF starter. See literature AYM/5.1		
Optima™ MIG Pulse Control	043389	Adds MIG pulsing capability for XMT 425 CC/CV model		
Optima™ Extension Cables	242205025	7.6 m (25 ft.)		
	242205050	15 m (50 ft.)		
	242205080	24.4 m (80 ft.)		
MT Running Gear	018035025	With gas cylinder rack. Used for TIG configuration		
MT-1 Running Gear Kit	058066101	Use with MT running gear to get MIG configuration		
MT-2 Wire Feeder Turntable Kit	028066291	Use with MT-1 running gear kit		
Single Gas Cylinder Cart	018035021	RG 60 with single gas cylinder support bracket		
Double Gas Cylinder Cart	018035022	RG 75 with double gas cylinder support bracket		
Welding Intelligence™	301072	Insight Core™ 14-pin module		
Remote Controls				
Wireless Remote Foot Control	300429	Foot control with wireless 27.4 m (90 ft.) operating range		
Wireless Remote Hand Control	300430	Hand control with wireless 91.4 m (300 ft.) operating range		
RFCS-14	043554	6 m (20 ft.), foot control		
RHC-14	242211020	6 m (20 ft.), remote current/contactor hand control		
	242211100	30.5 m (100 ft.), remote current/contactor hand control		
RHC-14-P	028040220	Hand control		
RHC-14-P Cord	027112331	15 m (49.2 ft.) cord		
SHRC-14	058040019	5 m (16.4 ft.), single-hand control for current only		
	058040020	10 m (32.8 ft.), single-hand control for current only		
	058040021	20 m (65.6 ft.), single-hand control for current only		

Date:

Total Quoted Price:

Distributed by:

