

## Industrial Ready-to-Weld Mig Package Migmaster® 275

- More power for those tough jobs
- Rated 275 amps at 40% duty cycle - 200 amps continuous 100%.
- DC welding output from 30 to 300 amps - new heavy plate parameters 5/8" and above.
- 24 overlapping heat (voltage) steps for accurate fine tuning.
- Flat and Slope taps for accurate fine tuning of short arc parameters for reduced spatter.
- Feeds wire from 40 to 750 ipm; pulse width modulated, solid state speed control
- Solid State contactor control for high reliability under repetitive short cycle welds.
- Toolless polarity change
- NAS gun connection with built-in torch wrap.
- Built-in spool-on-gun control.

### Ordering Information

#### Migmaster® 275 Packages

Each of the following packages includes power source with built-in wire feeder, factory-installed undercarriage with cylinder rack, GunMaster NAS Mig gun with .035 in. and .045 in. accessories, dual groove (.035 in. – .045 in.) feed roll, R-33 flowmeter-regulator, 6 ft. gas hose, 15 ft. work cable and clamp, 8 ft. primary input cable with plug, 10 lb. sample of .035 ESAB Spoolarc 87HP welding wire, and an ESAB Mig Welding Handbook.

<b>Migmaster® 275 Package w/12 ft. GM-250 NAS Torch/Argon</b>	
208/230 vac, 1ph, 50/60 Hz .....	0558008708
208-575 vac multi-voltage*, 1ph, 50/60 Hz .....	0558008709
<b>Migmaster® 275 Package w/15 ft. GM-250 NAS Torch/Argon</b>	
208/230 vac, 1ph, 50/60 Hz .....	0558008707
208-575 vac multi-voltage*, 1ph, 50/60 Hz .....	0558008710
<b>Migmaster® 275 Package w/15 ft. GM-400 NAS Torch/Argon</b>	
208/230 vac, 1 phase, 50/60 Hz .....	0558008711
<b>Migmaster® 275 Package w/o Torch/Argon</b>	
208/230 vac, 1 phase, 50/60 Hz .....	0558008714

#### Migmaster® 275 Packages with Spool-On-Gun

Spool-On-Gun Packages also include the indicated spool gun and all components necessary to install it on the Migmaster® 250. The spool gun is set up to run 3/64 in. wire.

<b>Migmaster® 275 Package w/15 ft. GM-250 NAS Torch and MT-250SG / Argon</b>	
208/230 vac, 1 phase, 50/60 Hz .....	0558008712
<b>Migmaster® 275 Package w/15 ft. GM-250 NAS Torch and ST-23A / Argon</b>	
208/230 vac, 1 phase, 50/60 Hz .....	0558008713

\*Multi-Voltage model is equipped with 208/230/380/400/460/575 vac selections.

<b>Instruction Manual.....</b>	<b>0558008552</b>
<b>Sales Literature .....</b>	<b>(12-01-2008) ARC-23244</b>



### Special Order

#### Migmaster® 275 for use with MIG-41A Push-Pull Gun

Push-Pull Ready Package is set up to accept the Esab MIG-41A Push-Pull gun (order gun, gun fittings and package accessories separately)

#### Migmaster® 275 console with Push-Pull Module Installed

208/230 vac, 1 phase, 50/60 Hz .....	0558008621
208-575 vac, 1 phase, 50/60 Hz .....	0558008622

### Specifications

Rated DCCV Output (10 min base)	
100% duty cycle, 60 Hz Input .....	200 amps @ 27 vdc
60% duty cycle (NEMA Class I), 60 Hz Input...	250 amps @ 29 vdc
40% duty cycle, 50 Hz Input .....	275 amps @ 27 vdc
Output Current Range.....	30-280 amps
Open Circuit Voltage.....	55 vdc
Primary Input Voltage & Current	
@ 250 amp rated load, 50/60 Hz, 1 phase	
208/230/380/400/460/575 vac.....	71/62/37/36/31/25 amps
Wire Feed Range .....	20-750 ipm (0.5-16.3 m/min)
Net Weight.....	210 lbs. (95 kg)
Shipping Weight.....	220 lbs. (100 kg)
W x L x H.....	19.5 in. (50 cm) x 40 in. (102 cm) x 32.25 in. (82 cm)

**Table 1. Drive Roll & Guide Tube Selection**  
Use for: Migmaster 275

Wire Diameter	Description	Drive Roll P/N	Qty	Outlet Guide	Qty	Inlet Guide	Qty
.023 in. (0.6 mm)	V-Solid	0558008700	1	0558008651	1	23612461**	1
.030 in. (0.8 mm)	V-Solid	0558008700	1	0558008651	1	23612461**	1
.035 in. (0.9 mm)	V-Solid	0558008536**	1	0558008650**	1	23612461**	1
.040 in. (1.0 mm)	V-Solid	0558008536**	1	0558008650**	1	23612461**	1
.045 in. (1.2 mm)	V-Solid	0558008536**	1	0558008650**	1	23612461**	1
.052 in. (1.4 mm)	V-Solid	0558008537	1	0558008649	1	23612461**	1
1/16 in. (1.6 mm)	V-Solid	0558008537	1	0558008649	1	23612461**	1
3/64 in. (1.2 mm)	U-Soft	0558008538	1	0558008654	1	23612461**	1
1/16 in. (1.6 mm)	U-Soft	0558008538	1	0558008654	1	23612461**	1
.035 in. (0.9 mm)	K-Cored	0558008540	1	0558008650	1	23612461**	1
.045 in. (1.2 mm)	K-Cored	0558008540	1	0558008650	1	23612461**	1
.052 in. (1.4 mm)	K-Cored	0558008541	1	0558008649	1	23612461**	1
1/16 in. (1.6 mm)	K-Cored	0558008541	1	0558008649	1	23612461**	1
5/64 in. (2.0 mm)	K-Cored	0558008542	1	0558008649	1	23612461**	1

\*\* As supplied from the factory.

### Optional Equipment

- Spot/Stitch/Burn Back Plug-in Module ..... 0558008623
- Digital Meter Plug-in Module ..... 0558008585
- Spool Spacer - use for 8 in. (20.3 cm) diameter spools ..... 17511
- Spool Spacer - use for 10 in. (25.4 cm) diameter spools..... 34330
- Drive Rolls and Guide Tubes ..... see Table 1
- GunMaster Contact Tips, Liners and Nozzles ..... see under Mig Gun Accessories

- Auto FanTM Kit .....16781
- MT-250SG Spool Gun ..... 36779
- ST-23A Spool Gun (must use adapter below) ..... 19164
- ST-23A Spool Gun Adaptor .....37301
- Primary Extension Cord (25 ft.) 50 amp..... 37833
- Gas Meter (measures gas flow at the gun)..... 19043

