

Dynasty® 210 Series

**TIG/Stick Welding
Power Source**



Quick Specs



Industrial Applications

Aerospace
Heavy fabrication
Precision fabrication
Aluminum ship repair
Pipe and tube fabrication
Anodized aluminum fabrication

Processes

AC/DC TIG (GTAW)
Pulsed TIG (GTAW-P)
Stick (SMAW)

Input Power 120–480 V, 3-phase or 1-phase power

Amperage Range 1–210 A (DC)
2–210 A (AC)

Rated Output 210 A at 18.4 V, 60% duty cycle

Net Weight 47 lb. (21.3 kg)

Reimagined for Your Pursuit of Perfection.

Experience unfailing precision arc performance paired with a state-of-the-art, user-friendly interface that puts advanced capabilities at your fingertips. Dynasty TIG power sources help minimize error and achieve high-precision welds every time, making the best welders even better.



Easy-to-understand interface with 4.5-inch LCD display.

- Ensures proper machine setup and parameter selection
- Informative on-screen explanations and dynamic images enhance the parameter selection process



**Dynasty 210
Machine only**



**Dynasty 210
Wireless Complete**

Program memory allows easy naming, saving and recalling of favorite weld settings.

- Deliver more productivity by eliminating the need to manually set the parameters
- Deliver consistent quality by welders of all skills

Pro-Set™ eliminates the guesswork when setting weld parameters.

Locks and limits. Provides control of weld parameter ranges minimizing deviation from the welding procedure specification (WPS).



Allows for any input voltage hookup (120–480 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

Blue Lightning™ provides more consistent high-frequency (HF) arc starts and greater reliability compared to traditional arc starters.

USB. Front panel port provides the ability to easily update software, back-up settings and transfer saved weld programs from one unit to the next.

Visit MillerWelds.com/TIGSoftware for the latest software updates and expansions.

Cooler Power Supply (CPS) is an integrated 120-volt dedicated-use receptacle for the Coolmate™ 1.3. Available on select models.

Cooler-On-Demand™ feature operates the auxiliary cooling system only when needed, reducing noise, energy use, and airborne contaminants pulled through the cooler. Available on CPS models only.



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



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



Weld Process Features

AC TIG

Balance control provides adjustable oxide removal which is essential for creating the highest quality aluminum welds.

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




AC Waveforms

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

DC TIG

Exceptionally smooth and precise arc for welding exotic materials.

Pulse Waveforms

-  **Square** provides a fast freezing puddle for ultimate arc control.
-  **Sine** produces a reduced audible sound and provides a more fluid puddle that is good for overlaying applications.
-  **Triangular** provides a quick-forming puddle while further reducing heat for thin materials.

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 at 60% Duty Cycle | Phase | Amps Input at Rated Load Output, 50/60 Hz 120 V 208 V 240 V 400 V 480 V KVA KW | | | | | | | Max. Open-Circuit Voltage | Dimensions | Net Weight |
|--------------|-------------|------------------------------|--------------------------------|---------|---|----|----|----|----|-----|-----|---------------------------|--|--|
| TIG (GTAW) | 208–480 V | 2–210 A (AC) 1–210 A (DC) | 210 A at 18.4 V | 3-phase | — | 16 | 14 | 8 | 7 | 5.7 | 5.2 | 80 VDC (30 VDC*) | H: 13.88 in. (352 mm) W: 8.5 in. (216 mm) D: 21.88 in. (555 mm) | 47 lb. (21.3 kg) 50 lb. (22.7 kg) with CPS |
| | | | | 1-phase | — | 28 | 23 | 14 | 12 | 5.8 | 5.6 | | | |
| Stick (SMAW) | 120 V | 2–150 A (AC) 1–150 A (DC) | 125 A at 15 V | 1-phase | 26 | — | — | — | — | 2.8 | 2.7 | | | |
| | 208–480 V | 5–210 A | 160 A at 26.4 V | 3-phase | — | 16 | 14 | 9 | 8 | 6.0 | 5.8 | | | |
| | | | | 1-phase | — | 28 | 24 | 14 | 12 | 6.4 | 5.5 | | | |
| | 120 V | 5–100 A | 90 A at 23.6 V | 1-phase | 27 | — | — | — | — | 2.9 | 2.8 | | | |

* Sense voltage for low OCV 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.  All CE models conform to the applicable parts of the IEC 60974 series of standards.

Performance Data

| Input Power | TIG (GTAW) Duty Cycle | Stick (SMAW) Duty Cycle | AC TIG Material Thickness Range | DC TIG Material Thickness Range | Stick Electrode Maximum Diameter | Generator Requirement |
|-------------|---|---|---------------------------------|---------------------------------|---|-----------------------|
| 208–480 V | 210 A, 60% 175 A, 100% | 210 A, 30% 160 A, 60% 125 A, 100% | 0.012–1/4 in. (0.3–6.4 mm) | 0.002–1/4 in. (0.05–6.4 mm) | 6010: 3/16 in. (4.8 mm) 7018: 5/32 in. (4.0 mm) 7024: 5/32 in. (4.0 mm) | 9 kW |
| 120 V | 150 A, 40% 125 A, 60% 100 A, 100% | 100 A, 40% 90 A, 60% 75 A, 100% | | | | |

Coolmate™ 1.3 Cooler



- Dynasty® 210 models with CPS turn Coolmate 1.3 on and off
- Power indicator light
- 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, 50/60 Hz | 5.9 A (50 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: 11.38 in. (289 mm) W: 10.38 in. (264 mm) D: 24.25 in. (616 mm) | 46 lb. (21 kg) |

Weldcraft™ W-250 (WP-20) TIG Torch

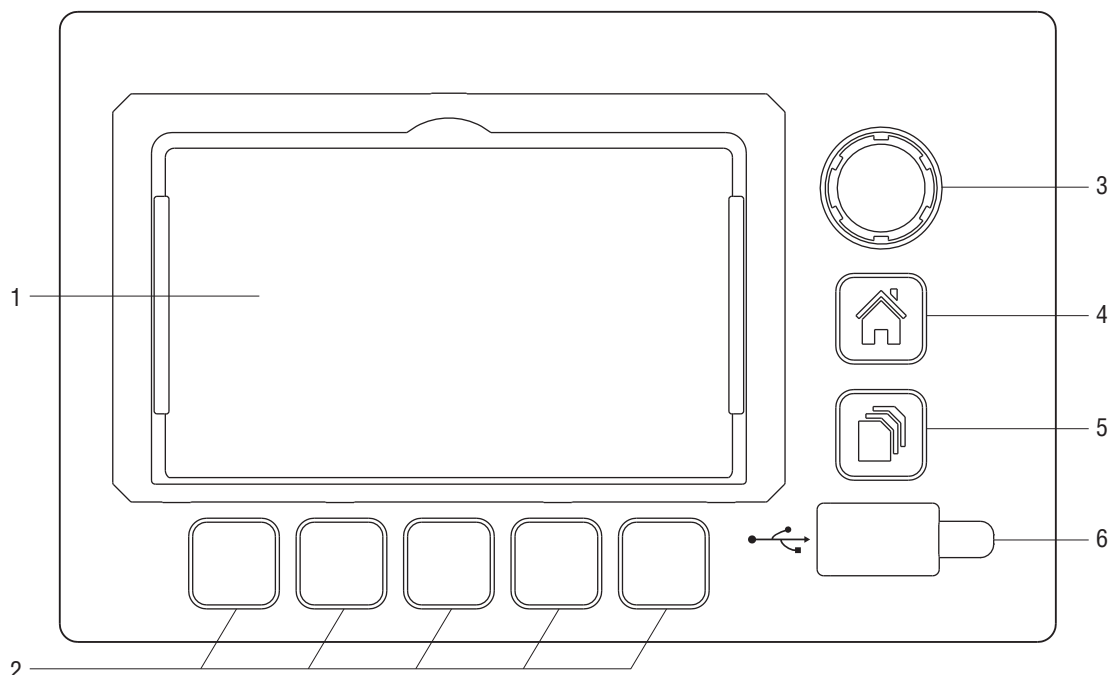


- Efficient around-the-head cooling design extends torch life and minimizes downtime due to overheating
- Lightweight, compact body design for increased comfort and control

| Cooling Method | AC Rating | DC Rating | Consumables | Electrode Range |
|----------------|------------------------|------------------------|-------------|---------------------------|
| Water-cooled | 180 A, 100% duty cycle | 250 A, 100% duty cycle | 13N | .020–1/8 in. (0.5–3.2 mm) |

Dynasty® 210 Control Panel

1. Color LCD Display
2. Soft Keys
(Multiple functions depending on screen displayed.)
3. Control Knob
(Adjusts amperage or parameter values depending on mode.)
4. Home Button
5. Program Button
6. USB Port



Amperage

| | |
|--------|-----------|
| TIG AC | 2–210 A** |
| TIG DC | 1–210 A** |
| Stick | 5–210 A |

Process

AC TIG HF, DC TIG HF,
AC TIG Lift-Arc™, DC TIG Lift-Arc™,
AC Stick, DC Stick

Tungsten (inch)

.020, .040, 1/16, 3/32, 1/8 inch, General
(.05, 1.0, 1.6, 2.4, 3.2 mm)

Trigger

Remote Standard: Foot, Finger, Pushbutton
Sequencer: Pushbutton Hold (2T), 3T 4T, 4TE,
4TL, 4TM

Pulse

| | |
|---------------------|------------------------------------|
| Pulses per Second* | DC: 0.1–500 pps AC: 0.1–500 pps |
| Peak Time* | 5–95% |
| Background Amps* | 5–95% |
| DC Pulse Waveshape: | Square, Sine, Triangular |

AC Waveshape

| | |
|-------------|--|
| Balance* | Ball: 30–99% EN |
| Frequency* | 20–400 Hz |
| Waveshape | Advanced Square, Soft Square, Sine, Triangular |
| Independent | EN Amperage: 2–210 A** EP Amperage: 2–210 A** EN Waveshape: Advanced Square, Soft Square, Sine, Triangular EP Waveshape: Advanced Square, Soft Square, Sine, Triangular |
| Commutation | Low, High |

Sequencer Control

| | |
|---------------|--------------------------------|
| Initial Amps | AC: 2–210 A** DC: 1–210 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: 2–210 A** DC: 1–210 A** |
| Final Time | 0.0–25.0 seconds |

Preflow

0.0–25.0 seconds

Postflow

Auto/Off–50 seconds

DIG*

Off–100%

Hot Start™

On, Off

Stick-Stuck™

On, Off

OCV

Normal, Low

Programs

1–99 (user defined program names)

Locks and Limits

Individual Parameters

Languages

English, Spanish, French, German, Italian,
Dutch, Swedish, Polish

*Pro-Set parameter selectable. **Amperage range is tungsten size dependent.

Dynasty® 210 Models/Packages

Build an Air-Cooled Package

Select desired stock number for each step.



907816
Dynasty shown.



301311
kit shown.

Step 1 • Select Dynasty

| | |
|-----------------------|-----------|
| Dynasty 210 | 907816 |
| Dynasty 210 (CPS) | 907816001 |
| Dynasty 210 (CPS), CE | 907816003 |

Dynasty comes with:

- Adjustable shoulder strap and center carry handle
- 8 ft. power cord (no plug)
- Two 50 mm Dinse-style connectors

Note: For models without the Cooler Power Supply (CPS), the Coolmate 1.3 must be powered through an external 120-volt facility power.

Step 2 • Select Contractor Kit

| | |
|--|--------|
| A-150 TIG Torch and RFCS-14 HD Foot Control | 301309 |
| A-150 TIG Torch with RCCS-14 Fingertip Control | 301311 |
| A-200 TIG Torch with RFCS-14 HD Foot Control | 301549 |
| A-200 TIG Torch with RCCS-14 Fingertip Control | 301550 |

See page 6 for kit contents.

Build a Water-Cooled Package

Select desired stock number for each step.



907816002 Dynasty 210
TIGRunner® shown with
four bottles of 043810
Low-Conductivity Coolant.



301580 remote shown.



300185 kit shown.

Step 1 • Select Dynasty TIGRunner® and Coolant

| | |
|---|-----------|
| Dynasty 210 (CPS) TIGRunner | 907816002 |
| Dynasty 210 (CPS) TIGRunner, CE | 907816004 |
| & | |
| Low-Conductivity Coolant (must be ordered in quantities of four) | 043810 |

Dynasty TIGRunner comes with:

- Adjustable shoulder strap and center carry handle
- 8 ft. power cord (no plug)
- Coolmate™ 1.3 (quick connect model on CE TIGRunner)
- Small Runner™ cart

Step 2 • Select Remote Control

| | |
|------------------------------|-----------|
| Wireless Foot (recommended) | 301580 |
| 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 | 301582 |

See page 7 for remote descriptions.

Step 3 • Select Torch Kit

| | |
|-----------------------------|--------|
| W-250 Kit | 300185 |
| (recommended for 210 model) | |
| W-280 Kit | 300990 |

See page 6 for kit contents.

Note: If ordering torch or torch kit for the CE TIGRunner, the QRW water hose quick connects are required.

Water-Cooled Packages

Use a single stock number to order a complete preconfigured system.



Water-Cooled Complete Package

| | |
|---|--------|
| Dynasty 210 (CPS) Complete with Wireless Foot Control | 951936 |
|---|--------|

Water-cooled complete package comes with:

- Dynasty 210 (907816)
- Coolmate™ 1.3
- Coolant (4 one-gallon bottles)
- Small Runner™ cart
- Wireless foot control
- W-250 torch kit (see page 6 for contents)

Genuine Miller® Accessories



2-Wheel Trolley Cart 300971

For Dynasty® 210/300 and Maxstar® 210/280 with or without Coolmate 1.3 cooler. Easy-to-manuever two-wheel cart features single-cylinder rack, chain for cylinder, cable holders, torch holder, storage area, and filler rod storage area.



Small Runner™ Cart 301615

For Dynasty® 210/300 and Maxstar® 210/280 with 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

301616 CE
301617 CE, quick connect
120 V, 50/60 Hz
1.3-gallon cooler designed to cool torches up to 280 amps.



Low-Conductivity Coolant 043810

Must be ordered in quantities of four. One-gallon recyclable plastic bottle. 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.



Protective Cover 301382

Fits Dynasty® 210/300 and Maxstar® 280.



Performance TIG Gloves

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

TIG Torches, Kits and Connectors



Contractor kit 301311 shown.

Contractor Kits

301309 A-150 with RFCS-14 HD

301311 A-150 with RCCS-14

301549 A-200 with RFCS-14 HD

301550 A-200 with RCCS-14

All-in-one TIG/stick welding kit comes with either a Weldcraft™ A-150 **OR** A-200 TIG torch, RFCS-14 HD foot control **OR** RCCS-14 fingertip control, 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-150 (WP-17) TIG Torch
WP-17-12-R (12 ft.)
WP-17-25-R (25 ft.)
150-amp air-cooled torch. Torch body gas valve models are available.

Note: A-150 (WP-17) torches require 195378 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

195378* All air-cooled torches (except A-200)

195379 A-200 (WP-26)
50 mm Dinse-style for one-piece air-cooled torch.

*A-80 (WP-24) torches require 24-5 connector.



Torch kit 300185 shown.

Water-Cooled Torch Kits

300185 W-250 (recommended)

300990 W-280

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 AK4GL gas lens torch accessory kit.



Weldcraft™ W-225 Modular (WP-225) TIG Torch
WP-225-12-R (12 ft.)
WP-225-25-R (25 ft.)
225-amp water-cooled torch. Includes 1726 and 9-70 torch heads.

Note: W-225 Modular (WP-225) torch requires 195377 connector.



Water-Cooled TIG Torch Connector 195377

50 mm Dinse-style with water return line. For use with all Weldcraft™ water-cooled torches.



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



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

Genuine Miller® Accessories

Remote Controls and Switches



Wireless Remote Foot Control 301580

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 301582

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

Tungsten

| Tungsten | Amp Range | 2% Ceriated (AC/DC) | 2% Lanthanated (AC/DC) |
|-------------------|-----------|---------------------|------------------------|
| 1/16 in. (1.6 mm) | 70–150 A | WC116X7 | WL2116X7 |
| 3/32 in. (2.4 mm) | 140–250 A | WC332X7 | WL2332X7 |
| 1/8 in. (3.2 mm) | 225–400 A | WC018X7 | WL2018X7 |
| 5/32 in. (4.0 mm) | 300–500 A | WC532X7 | WL2532X7 |

Ordering Information

| Equipment and Options | Stock No. | Description | Qty. | Price |
|---|-------------|---|------|-------|
| Dynasty® 210 | 907816 | Auto-Line™ 120–480 V, 50/60 Hz. 8 ft. power cord | | |
| Dynasty® 210 (CPS) | 907816001 | Auto-Line™ 120–480 V, 50/60 Hz. 8 ft. power cord | | |
| | 907816003 | Auto-Line™ 120–480 V, 50/60 Hz, CE . 8 ft. power cord | | |
| Water-Cooled Packages | | | | |
| Dynasty® 210 (CPS) TIGRunner® | 907816002 | Auto-Line™ 120–480 V, 50/60 Hz. 8 ft. power cord (Torch kit, accessories and coolant sold separately) | | |
| | 907816004 | Auto-Line™ 120–480 V, 50/60 Hz, CE . 8 ft. power cord (Torch kit, accessories and coolant sold separately) | | |
| Dynasty® 210 (CPS) Complete with Wireless Foot Control | 951936 | Auto-Line™ 120–480 V, 50/60 Hz. 8 ft. power cord | | |
| Accessories | | | | |
| 2-Wheel Trolley Cart | 300971 | For Dynasty 210/300 and Maxstar® 210/280 with or without Coolmate 1.3 | | |
| Small Runner™ Cart | 301615 | For Dynasty 210/300 and Maxstar® 210/280 with Coolmate 1.3 | | |
| Coolmate™ 1.3 | 301616 | 120 V, 50/60 Hz, CE . <i>Requires coolant</i> | | |
| | 301617 | 120 V, 50/60 Hz, CE . Quick connect. <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) | | |
| Protective Cover | 301382 | For Dynasty 210/300 and Maxstar 280 | | |
| TIG Gloves | | See page 6 | | |
| TIG Torches, Kits and Connectors | | | | |
| Air-Cooled Contractor Kits | | See page 6 | | |
| Weldcraft™ A-150 (WP-17) TIG Torch | WP-17-12-R | 12 ft. (3.7 m) cable. Requires 195378 connector | | |
| | WP-17-25-R | 25 ft. (7.6 m) cable. Requires 195378 connector | | |
| Weldcraft™ A-200 (WP-26) TIG Torch | WP-26-12-R | 12 ft. (3.7 m) cable. Requires 195379 connector | | |
| | WP-26-25-R | 25 ft. (7.6 m) cable. Requires 195379 connector | | |
| Air-Cooled TIG Torch Connectors | 195378 | Connects all air-cooled Weldcraft™ torches (except A-200) to Dinse-style connector. A-80 (WP-24) torches require 24-5 connector | | |
| | 195379 | Connects Weldcraft™ A-200 (WP-26) torch to Dinse-style connector | | |
| Water-Cooled Torch Kits | | See page 6 | | |
| Weldcraft™ W-225 Modular (WP-225) TIG Torch | WP-225-12-R | 12 ft. (3.7 m) cable. Requires 195377 connector | | |
| | WP-225-25-R | 25 ft. (7.6 m) cable. Requires 195377 connector | | |
| Water-Cooled TIG Torch Connector | 195377 | Connects Weldcraft™ water-cooled torches to Dinse-style connector | | |
| Weldcraft™ Quick Connects (sold individually) | QRG | For gas hoses | | |
| | QRW | For water hoses | | |
| Tungsten | | See page 7 | | |
| Remote Controls | | See page 7 | | |

Date:

Total Quoted Price:

Distributed by:

