

# Trailblazer® 325X Diesel

**Diesel Engine-Driven  
Welder/AC Generator**



## Quick Specs

### Industrial Applications

Fabrication  
Maintenance  
Repair  
Structural steel work  
Sheet metal  
Pipe

### Processes

Stick (SMAW)  
MIG (GMAW)\*  
Flux-cored (FCAW)\*  
RMD®\*\*  
Pulsed MIG (GMAW-P)\*\*  
DC TIG (GTAW)  
Air carbon arc (CAC-A) cutting and gouging  
Rated: 3/16-inch carbons  
Capable: 1/4-inch carbons

**Output Range** DC stick 20–325 A  
MIG/flux-cored 15–40 V  
DC TIG 20–325 A

**Generator Power Output Rated at 40°C (104°F)**  
9,600 watts

**Excel™ Power**  
2,400 watts (120 V, 20 A) at 2,400 rpm\*\*\*

\*With wire feeder.

\*\*With optional ArcReach Smart Feeder.

\*\*\*Excel power rpm may vary while welding.

**Trailblazer welder/generators deliver unbeatable arc performance providing the smoothest, most stable arc in the industry.**

The Trailblazer exclusive technologies — Auto-Speed™ and Excel™ power — deliver superior runtimes, increased fuel efficiency, and improved welder/generator performance.

No other compact machine in the 300-amp class delivers more welding power or more auxiliary power with better fuel efficiency and less noise — for productive, profitable, quieter jobsites.

## ArcReach®

Remote control of the power source without a cord. See page 2.



Welder/generator is warranted for three years, parts and labor.  
Engine is warranted separately by the engine manufacturer.



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An ITW Welding Company  
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f t y i n



## Dynamic DIG™ technology



**Ultra-adaptive arc control.** Unlike conventional DIG that provides a preset amount of short-clearing current, Miller-exclusive Dynamic DIG technology works on a time-based algorithm that automatically

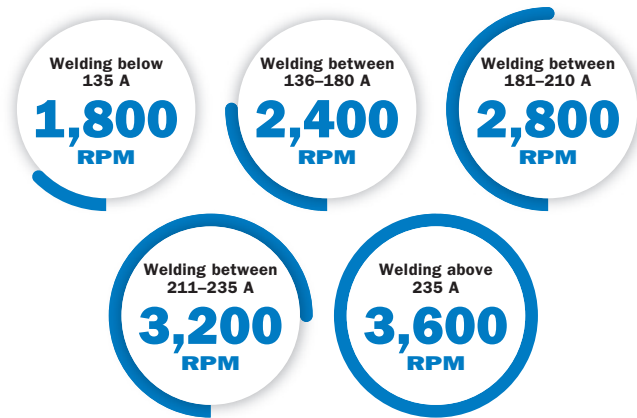
adjusts the amount of current required to clear a short. Delivers a smoother more consistent arc that can be tailored to match application, material, fit-up and welder technique.

## Auto-Speed™ technology

**Matches engine speed to load — a Miller exclusive.** Get the welding power you need — plus reduced fuel consumption and lower noise levels for a more-profitable, safer jobsite.

Auto-Speed technology responds to weld requirements by automatically adjusting engine speed to one of five rpm levels so the engine never works harder than necessary. Weld up to 135 amps while the engine remains at idle (1,800 rpm), saving up to 15 percent in fuel over competitive units, and drastically reducing jobsite noise.

Welding at idle speed



Auto-Speed in XX18 mode.

## Excel™ power

**Power at idle — a Miller exclusive.** Unlike competitive machines that provide auxiliary power only at 3,600 rpm (max), Excel power delivers a full 2,400 watts (20 A) of 120-volt inverter-based, pure sine wave power at 2,400 rpm while not welding. With Excel power you can operate jobsite tools like grinders at quiet, fuel-saving speeds.

Refueling time and operating costs are reduced with Excel power, which means more productivity and profitability. Plus everyone on the jobsite gets a better working environment because noise levels and exhaust emissions are lowered. Excel power — available only from Miller.



UP TO **52%**  
MORE FUEL EFFICIENT  
WITH EXCEL POWER

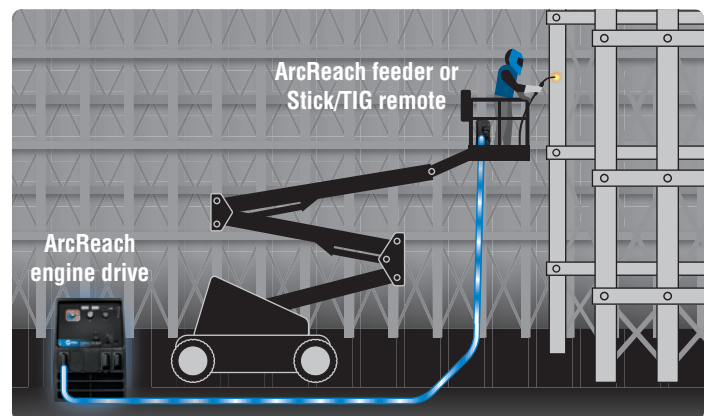
Based on generator-only use for total runtime.

## ArcReach® technology



**Parameter control at the wire feeder or pendant without needing a control cord.** An ArcReach system allows you to change weld settings from your ArcReach feeder or Stick/TIG remote,

saving a trip to the power supply. ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or Stick/TIG remote and the power source. This technology eliminates the need for control cords, and their associated problems and costs.



## Trailblazer® Benefits

### Fewer refueling trips

No other diesel welder/generator in the 300-amp class lets your crews spend more time working and less time refueling — because only Trailblazer welder/generators provide Auto-Speed™ technology, plus Excel™ power, to deliver maximum runtime.

### Maximum cost savings

Less money spent on fuel means more profit for you. Every Trailblazer welder/generator has fuel-saving Auto-Speed technology and Excel power to save even more on fuel costs. This combination of advanced, profit-enhancing features are only available on a Trailblazer welder/generator.

### Quieter jobsites

Quieter jobsites are more productive because work crews can communicate easier, and work can start earlier and end later — even in noise-sensitive areas. Miller-exclusive Auto-Speed technology makes this welder/generator the quietest Trailblazer diesel yet — rated at 70 db at idle (1,800 rpm). If your jobsite needs a welder/generator, it needs a Trailblazer welder/generator — because no other diesel-fueled choice in this category is as quiet.



IT WOULD TAKE  
**3** TRAILBLAZERS  
TO EQUAL THE  
SOUND OUTPUT OF  
**1** COMPETITOR  
MACHINE.

### More portable, uses less truck and jobsite space

Trailblazer welder/generators use up to 24 percent less cubic space and weigh up to 10 percent less than other welder/generators in their class — which means moving them is faster and easier, for maximum productivity. And because they take up less space, Trailblazer welder/generators let work trucks carry more equipment and gear — so your work crews can be ready for anything.



UP TO  
**24%**  
LESS CUBIC SPACE

### Cleaner and stronger generator power

Combined with a 25-horsepower engine, Trailblazer welder/generators offer 9,600 watts of clean, truly usable generator power that is Accu-Rated™, not inflated.

An independent welder and generator power system ensures no interaction between jobsite tools and the welding arc, while advanced generator technology virtually eliminates power spikes and other electrical imperfections — so welds are cleaner and jobsite tools can run without interruption — maximizing quality, productivity and profit.

# Specifications (Subject to change without notice.)



Welding Mode	Process	Amp/Volt Ranges	Rated Weld Output at 40°C (104°F)*	Single-Phase Generator Power	Sound Levels at 7 m (23 ft.)	Dimensions	Net Weight**
CC/DC	Stick/TIG	20–325 A	325 A at 33 V, 100% duty cycle	9,600 watts <b>Excel™ power</b> 2,400 watts of generator power at speeds of 2,400 rpm and up	<b>Weld</b> 135 A load: 70 dB (94 Lwa) 325 A load: 81.5 dB (106.5 Lwa) (in XX18 mode) <b>Generator power</b> Excel power: 75 dB (100 Lwa) 9.6 kW standard power: 81.5 dB (106.5 Lwa)	H: 711 mm (28 in.) H: 873 mm (34.375 in.) (to top of exhaust) W: 508 mm (20 in.) D: 1,153 mm (45.375 in.)	281 kg (620 lb.)
CV/DC	MIG/FCAW	15–40 V	325 A at 33 V, 100% duty cycle				

\*Rated at sea level. \*\*Net weight without fuel. Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

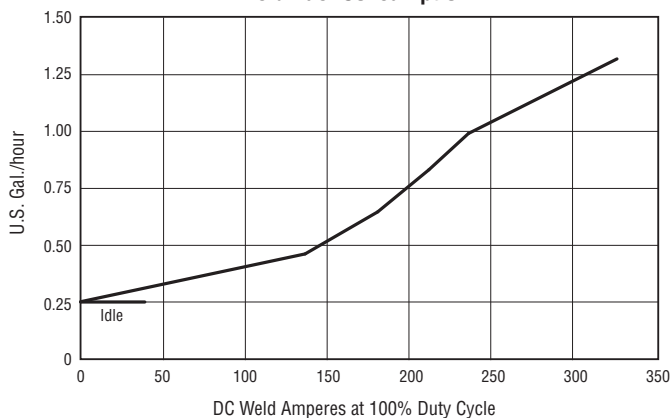
## Engine Specifications (Engines warranted separately by the engine manufacturer.)

Engine Brand and Warranty	Horsepower (HP)	Type	Weld Speed	Idle Speed	Fuel Capacity	Oil Capacity	Standard Shutdowns
Kubota D902, 1 year/1,000 hours	24.8 hp at 3,600 rpm	Three-cylinder, industrial liquid-cooled diesel	Auto-Speed™ 1,800, 2,400, 2,800, 3,200 or 3,600 rpm	1,800 rpm or 2,400 rpm (wire modes)	45 L (12 gal.)	3.7 L (3.9 qt.)	High coolant temperature/low oil pressure/low fuel

## Performance Data

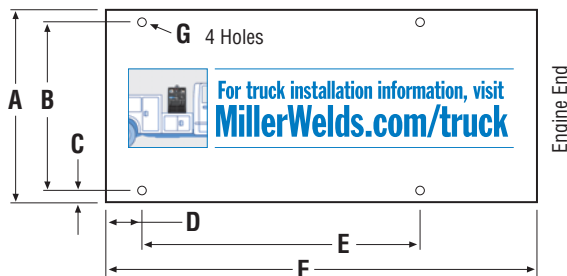
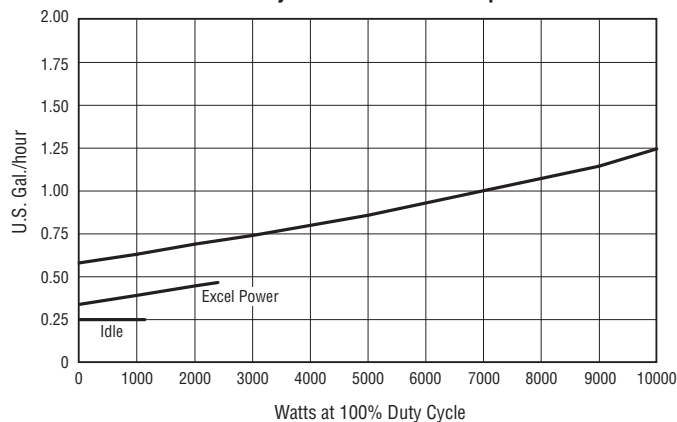
## Mounting Specifications

Weld Fuel Consumption\*



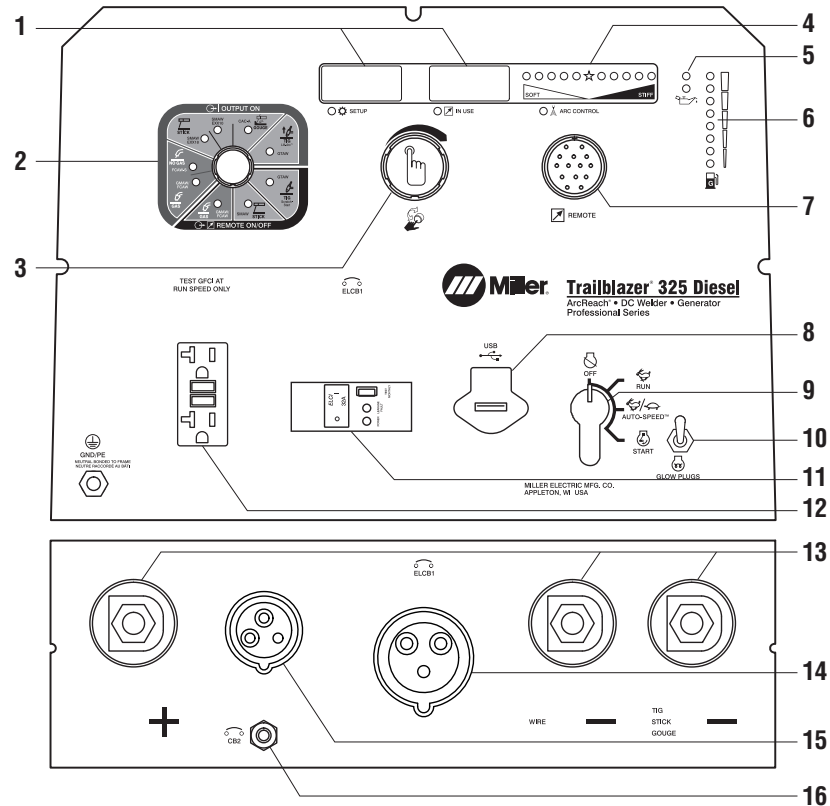
\*Fuel curve was generated using NEMA recommended voltage/amperage levels.

Auxiliary Power Fuel Consumption



- A. 508 mm (20 in.)
- B. 419 mm (16.5 in.)
- C. 44 mm (1.75 in.)
- D. 154 mm (6.062 in.)
- E. 832 mm (32.75 in.)
- F. 1,153 mm (45.375 in.)
- G. 10.3 mm (.406 in.) diameter

# Function and Benefit Guide



**1. Self-calibrating digital meters with SunVision™**

- Preset and actual amperage/voltage
- Process settings
- Maintenance functions: hour meter, oil change interval, rpm

**2. Weld process selection switch**

**3. Pushbutton main control knob** used for adjusting amperage/voltage, adjusting arc control, and accessing the service menu.

**4. Adjustable arc control** adjusts DIG when process control is in stick modes and adjusts inductance when process control is in FCAW or MIG modes. The amount of DIG determines how much amperage (heat) varies with stick arc length. Inductance determines the “wetness” of the weld puddle.

**5. Maintenance interval reminder.** Yellow and red indicator lights let an operator know when the machine is approaching, and finally in need of routine maintenance.

**6. Front panel fuel gauge** LEDs indicate fuel level. Low fuel shutdown automatically detects and shuts engine off prior to running out of fuel.

**7. Standard 14-pin receptacle** for simple connection of remote controls and wire feeders. Includes **Auto Remote Sense™** which automatically switches from panel to remote amperage/voltage (A/V) control with remote connected. Eliminates confusion of a panel/remote switch.

**8. USB port** allows software updates from a USB drive. A summary file of recorded data from the unit will be saved to a USB drive that is inserted.

**9. Engine control:** Run/idle position adjusts engine to run at lower speeds depending on total power needed for welding.

**10. Glow plugs** assist in cold weather starting.

**11. Earth Leakage Circuit Breaker (ELCB).** Provides GFCI and overcurrent protection for 240 V international receptacle (14).

**12. 120 V GFCI receptacle with Excel power.** Provides 2,400 watts (120 V, 20 A) of pure generator power as low as 2,400 rpm while not welding. Also provides GFCI protection for 120 V international receptacle (15).

**13. Weld output terminals**

**14. 240 V international receptacle**

**15. 120 V international receptacle with Excel power.** Provides 2,400 watts (120 V, 20 A) of pure generator power as low as 2,400 rpm while not welding.

**16. 20 A circuit breaker.** Provides overcurrent protection for 120 V international receptacle (15).

## Genuine Miller® Options

**Cold Weather Kit 301115** Field  
Includes block heater for improved starting, and a fuel heater for optimal filtration in cold temperatures.

**Spark Arrestor 043579** Field  
Mandatory when operating on California grasslands, brush or forest-covered land, and all national forests. For other areas, check your state and local laws.

**Diesel Engine Filter Kit 259935** Field  
Includes air filter, oil filter, fuel pre-filter and primary fuel filter.

## Genuine Miller® Accessories



**All-Purpose Running Gear 300477**  
Includes two heavy-duty 15-inch Never Flat™ tires, two 8-inch rubber swivel casters and a heavy-duty handle. Recommended for all surfaces and applications, and is easy to move around the jobsite.



**Protective Cage with Cable Holders 195331**  
Rugged cage with cable holders protects your investment. Can be used with running gear, gas cylinder mounting assembly, or with trailer.  
*Note: Not for use with protective cover.*

### Protective Cover



**Protective Cover 301099**  
Heavy-duty, water-resistant and mildew-resistant cover protects and maintains the finish of the welder.

### MIG (GMAW) or Flux-cored (FCAW)



**ArcReach® SuitCase® 8**  
951726 With Bernard® BTB Gun 300 A  
951727 With Bernard® S-Gun™  
951728 With Bernard® Dura-Flux™ gun  
**ArcReach® SuitCase® 12**  
951729 With Bernard® BTB Gun 300 A  
951730 With Bernard® S-Gun™  
951731 With Bernard® Dura-Flux™ gun  
Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature M/6.55.



**ArcReach® Smart Feeder 951733**  
*For use with ArcReach models only (see page 2 for more information).* Includes drive rolls and Bernard® PipeWorx 300-15 MIG gun. For MIG, FCAW, and advanced RMD® and pulse processes. See literature M/6.55.



**SuitCase® 12RC Wire Feeder 951580**  
Lightweight and flexible enough to run wires up to .062-inch diameter. Includes remote voltage control, drive roll kit and Bernard® BTB Gun 300 A. See literature M/6.5.



**Spoolmatic® 30A Spool Gun 130831**  
Air-cooled, 200-amp, one-pound spool gun for aluminum MIG. See literature M/1.73. Requires WC-24 Control (137549).

**XR™ Wire Feeders and Guns**  
Push-pull system designed to handle difficult-to-feed soft alloy wires such as aluminum. See literature M/1.7 through M/1.74.

### Stick (SMAW) Welding



**Weld Leads**  
**2/0 Stick Cable Set, 15 m (50 ft.) 173851**  
Consists of 15 m (50 ft.) 2/0 electrode cable with holder, and 15 m (50 ft.) work cable with clamp. 350 A, 100% duty cycle.

**2/0 Stick Cable Set, 30.5/15 m (100/50 ft.) 043952**  
Consists of 30.5 m (100 ft.) 2/0 electrode cable with holder, and 15 m (50 ft.) work cable with clamp. 300 A, 100% duty cycle.

### AC TIG (GTAW) Welding



**Dynasty® 210 Series**  
For portable AC/DC TIG. See literature AD/4.81.

## Genuine Miller® Accessories (Continued)

### Plasma Cutting



*Spectrum 375 X-TREME and 625 X-TREME shown.*

**Spectrum® 375 X-TREME™ 907529**

See literature PC/9.2.

**Spectrum® 625 X-TREME™ 907579**

See literature PC/9.6.

**Spectrum® 875 907583**

See literature PC/9.8.

The Spectrum 375 X-TREME and 625 X-TREME come complete with protective X-CASE™ (not shown).

### Remote Controls



**ArcReach® Stick/TIG Remote 301325**

When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time

and money. See literature AY/14.5.



**Wireless Remote Hand Control 300430**

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



**RHC-14 Hand Control 242211020**

Miniature hand control for remote current and contactor control. Dimensions: 102 x 102 x 82 mm (4 x 4 x 3.25 in.). Includes 6 m (20 ft.) cord and 14-pin plug.



**RMLS-14 129337**

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



**RCC-14 Remote Contactor and Current Control 151086**

Rotary-motion fingertip control fastens to TIG torch using two hook-and-loop fasteners. Includes 8 m (26.5 ft.) control cord and 14-pin plug.

**Extension Cables for 14-Pin Remote Controls**

**242208025** 7.6 m (25 ft.)

**242208050** 15.2 m (50 ft.)

**242208080** 24.4 m (80 ft.)

## Trailers and Hitches (Note: Trailers are shipped unassembled.)



**HWY-Mid Frame Trailer 301438**

646 kg (1,424 lb.) capacity highway trailer with welded steel tubing frame, heavy-duty axle with roller bearing hubs and leaf-spring suspension. Includes jack stand, fenders, lights, and dual hitch with 50 mm (2 in.) ball hitch and 76 mm (3 in.) lunette eye.



**Cable Tree 043826**

Provides an area to conveniently wrap weld cables and extension cords.



**2-In-1 Document/Fire Extinguisher Holder 301236**

Stores documents and holds a five-pound fire extinguisher.

*Note: Holder shown mounted on trailer. Fire extinguisher not included.*

### Trailer Specifications (Subject to change without notice.)

Model	Gross Axle Weight Rating	Gross Vehicle Weight Rating	Net Payload	Height of Bed	Road Clearance	Track (Center to center of tires)	Standard Tires (Standard rating or P-size rating)	Dimensions	Net Weight
HWY-Mid Frame	728 kg (1,605 lb.)	646 kg (1,424 lb.)	646 kg (1,424 lb.)	495 mm (19.5 in.)	203 mm (8 in.)	1,168 mm (46 in.)	ST175/80D-13 Load Range C	Length: 2,565 mm (101 in.) Width: 1,397 mm (55 in.)*	82 kg (181 lb.)

\*Width at outside of fenders.

## Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>Trailblazer® 325X Diesel</b>	<b>907799007</b>	Kubota engine with international receptacles, Excel™ power and ArcReach™		
<b>Field Options</b> <i>Options listed below can be added to the above model. Installation is required.</i>				
Cold Weather Kit	<b>301115</b>	Recommended for operation below -10°C (15°F)		
Spark Arrestor	<b>043579</b>			
Diesel Engine Filter Kit	<b>259935</b>			
<b>Accessories</b>				
All-Purpose Running Gear	<b>300477</b>	With Never Flat™ tires		
Protective Cage with Cable Holders	<b>195331</b>	<i>Not for use with Protective Cover</i>		
Protective Cover	<b>301099</b>			
<b>MIG/Flux-cored Welding</b>				
ArcReach® SuitCase® 8	<b>951726</b> <b>951727</b> <b>951728</b>	With Bernard® BTB Gun 300 A With Bernard® S-Gun™ With Bernard® Dura-Flux™ gun		
ArcReach® SuitCase® 12	<b>951729</b> <b>951730</b> <b>951731</b>	With Bernard® BTB Gun 300 A With Bernard® S-Gun™ With Bernard® Dura-Flux™ gun		
ArcReach® Smart Feeder	<b>951733</b>	MIG/FCAW/RMD®/pulse feeder with Bernard® PipeWorx 300-15 MIG gun. Tweco®-style connectors		
SuitCase® 12RC	<b>951580</b>	With Bernard® BTB Gun 300 A. See literature M/6.5		
Spoolmatic® 30A Spool Gun	<b>130831</b>	Requires WC-24 control. See literature M/1.73		
WC-24 Control	<b>137549</b>	See literature M/1.73		
XR™ Wire Feeder Control and Guns		See literature M/1.7 through M/1.74		
<b>Stick Welding</b>				
		See page 6		
<b>TIG Welding</b>				
		See page 6		
<b>Plasma Cutting</b>				
		See page 7		
<b>Remote Controls and Extension Cables</b>				
ArcReach® Stick/TIG Remote	<b>301325</b>			
Wireless Remote Hand Control	<b>300430</b>			
RHC-14 Hand Control	<b>242211020</b>			
RMLS-14	<b>129337</b>			
RCC-14	<b>151086</b>			
Extension Cables		See page 7		
<b>Trailers and Hitches</b>				
HWY-Mid Frame Trailer	<b>301438</b>	Trailer with lights, fenders and dual hitch. For highway use		
Cable Tree	<b>043826</b>	Trailer-mounted cable holder		
2-In-1 Document/Fire Extinguisher Holder	<b>301236</b>	Stores documents and holds a five-pound fire extinguisher		

Date:

Total Quoted Price:

Distributed by:

