

HF-251

High-Frequency Arc Starter and Stabilizer

Quick Specs

Industrial/Light Industrial Applications

General manufacturing
Tool and die
Repair shops
All-purpose maintenance

Process
TIG (GTAW)

Input Power 1-phase power

Rated Output 250 A, 60% duty cycle

Net Weight HF-251D-1: 34 lb. (15 kg)
HF-251-2: 36 lb. (16 kg)

The HF-251 is compatible with power sources made by other manufacturers. For use with power sources with 14-pin receptacle (5-pin adapter available).

Increase the flexibility and performance of most AC, DC or AC/DC constant-current welding machines with these portable high-frequency arc starters and stabilizers. The unit impresses high frequency on the welding circuit and provides the arc control needed for TIG welding.

With the addition of an HF unit, your constant-current power source can handle welds on aluminum, magnesium, thin stainless steel, brass, copper and a wide variety of both ferrous and non-ferrous alloys.

Two versions (115 V, 50/60/100 Hz and 230 V, 50/60 Hz) meet most single-phase power configurations, and all are rated at 60% duty cycle.



Power on/off switch with pilot light

Start, off and continuous control

Gas solenoid valve

Built-in postflow eliminates contamination

High-frequency intensity control

Protected secondary terminal

Convenient, portable design can be easily moved from location to location

14-pin receptacle on front panel for remote controls

Specifications (Subject to change without notice.)

1
Phase

Model	Input Volts	Rated Output at 60% Duty Cycle	Dimensions	Net Weight
HF-251D-1	115 V, 50/60/100 Hz	250 A	H: 13 in. (330 mm) W: 9.25 in. (235 mm) D: 16 in. (406 mm)	34 lb. (15 kg)
HF-251-2	230 V, 50/60 Hz			36 lb. (16 kg)



Warranted for one year, parts and labor.



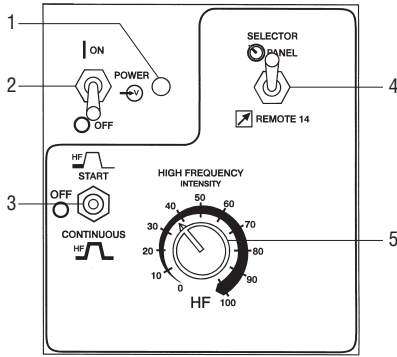
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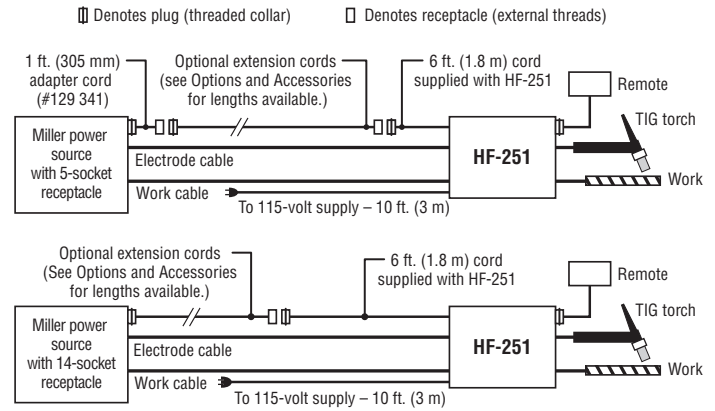



Control Panel



1. Pilot Light
2. Power Switch
3. High Frequency Switch
4. High Frequency Selector Switch
5. High Frequency Intensity Control

Typical Installations



Genuine Miller Options and Accessories



Secondary Contactor Kit

For HF-251D-1 model
#041 969 Field only
 For HF-251-2 model
#041 906 Field only

Mounts inside HF-251 cabinet. For use with a power source that does not have its own contactor.

Remote Controls and Switches

Controls listed below are for use with Miller constant-current power sources with solid-state output control. The controls are used when remote current control is desired. The HF-251 is equipped with a 14-pin plug on a 6 ft. (1.8 m) cord for direct connection to new Miller CC power sources. An adapter cord will be required for older Miller equipment with 5-socket receptacles.

RMLS-14 Switch #129 337

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.

RCC-14 Remote Contactor and Current Control #151 086

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.

RHC-14 Hand Control #242 211 020

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.



RFCS-14 Foot Control #043 554

Foot current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.

Extension Cords

- #242 208 025 25 ft. (7.6 m)
- #242 208 050 50 ft. (15 m)
- #242 208 080 80 ft. (23 m)
- #242 208 100 100 ft. (23 m)

Extends HF-251 farther from power source or extends remote control farther from HF-251.

Adapter Cord #130 003

One-foot (305 mm) cord with 5-pin and 14-pin plugs for use between 5-socket receptacle power source and HF-251.

Adapter Cord #041 947

One-foot (305 mm) cord with 14-pin plug and 5-socket receptacle for use between HF-251 and 5-pin remote controls.

Coolant Systems

For more information, see the Coolmate Series literature sheet, Index No. AY/7.2.

Coolmate™ 3

- #043 007 115 V
- #043 008 230 V

For use with water-cooled torches rated up to 500 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ 4 #042 288 115 V

For use with water-cooled torches rated up to 600 amps. Tough molded-polyethylene case with carrying handle.

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
HF-251D-1	#042 388	115 V, 50/60/100 Hz		
HF-251-2	#042 387	230 V, 50/60 Hz		
Secondary Contactor Kit	#041 969	For HF-251D-1 model. Field only		
	#041 906	For HF-251-2 model. Field only		

Date:

Total Quoted Price:

Distributed by:

