Miller® M-Series to Miller MDX™ MIG Guns and Consumables Cross Reference

Converting from M-Series to MDX Series Guns

The following tables are provided to help users familiar with M-Series Guns select an MDX Gun of a similar wire size, amperage, length, etc. Miller Machine compatibility is also noted by gun model.

M-100 to MDX™-100 MIG Gun

M-100 Part #	Description	MDX-100 Part #	Description	Miller Machine Compatibility
248282	M-100 Gun, 10 ft, .030”-.035”	1770028	MDX-100 Gun, 10 ft, 100A, .030”-.035”, MDX Consumables	Millermatic® 141, 211 Multimatic® 215, 220 AC/DC

M-25 to MDX™-250 MIG Gun

M-25 Part #	Description	MDX-250 Part #	Description	Miller Machine Compatibility
169594	M-25 Gun, 10 ft, .030”-.035”’	1770035	MDX-250 Gun, 10 ft, 250A, .030”-.035”, MDX Consumables, Standard Duty	Millermatic 212, 252 Multimatic 200
169596	M-25 Gun, 12 ft, .030”-.035”	1770037	MDX-250 Gun, 15 ft, 250A, .030”-.035”, MDX Consumables, Standard Duty	Millermatic 212, 252 Multimatic 200
169598	M-25 Gun, 15 ft, .030”-.035”	1770037	MDX-250 Gun, 15 ft, 250A, .030”-.035”, MDX Consumables, Standard Duty	Millermatic 212, 252 Multimatic 200
169599	M-25 Gun, 15 ft, .035”-.045”	1770038	MDX-250 Gun, 15 ft, 250A, .035”-.045”, MDX Consumables, Standard Duty	Millermatic 212, 252 Multimatic 200

Converting from M-Series to MDX™ Series Nozzles and Contact Tips

The following tables are provided to help users convert M-Series Guns to MDX Nozzles and Contact Tips.

IMPORTANT: Do not use front load liners. M-Series Guns with MDX Consumables must continue to use their existing liner and power pin.

M-Series Gun to MDX™ Nozzle and Contact Tip Conversion Kits

Kit Part #	Kit Description	Component Part #	Component Description	Quantity
1880269	M-100 to MDX Consumables	1070115	Conversion Diffuser for M-100 MIG Guns	1
		T-M030	Standard Duty Contact Tip, .030" (0.8mm)	5
		T-M035	Standard Duty Contact Tip, .035" (0.9mm)	5
		NS-M1200B	MDX-100 Nozzle, 1/2 Orifice, Flush, Brass	1

Kit Part #	Kit Description	Component Part #	Component Description	Quantity
1880270	M-25 to MDX Standard Duty	1070116	Standard Duty Conversion Diffuser for M-25 MIG Guns	1
		T-M030	Standard Duty Contact Tip, .030" (0.8mm)	5
		T-M035	Standard Duty Contact Tip, .035" (0.9mm)	5
		T-M045	Standard Duty Contact Tip, .045" (1.2mm)	5
		N-M1200C	MDX-250 Standard Duty Nozzle, 1/2 Orifice, Flush, Copper	1
		4623RM	Insulator Cap	1

Kit Part #	Kit Description	Component Part #	Component Description	Quantity
1880271	M-25 to MDX Heavy Duty	1070117	Heavy Duty Conversion Diffuser for M-25 MIG Guns	1
		T-A035CHM	Heavy Duty Contact Tip, .035" (0.9mm)	5
		T-A045CHM	Heavy Duty Contact Tip, .045" (1.2mm)	5
		N-A5800CM	MDX-250 Heavy Duty Nozzle, 5/8 Orifice, Flush, Copper	1
		4623RM	Insulator Cap	1

How to Install MDX MIG Gun Consumables on M-Series MIG Guns

1. Remove the contact tip, diffuser, and nozzle.
2. Leave the liner in place. There should also be no need to trim the liner as long as it was trimmed correctly during initial installation.
3. If damaged, the M-25 Shock Washer (169730) should be replaced with a 4623RM Neck Insulator.
4. Install the new MDX diffuser, contact tip and nozzle.

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