

# XMT<sup>®</sup> 425 Series

Multiprocess Welding  
Power Source 

## Quick Specs



### Heavy Industrial Applications

Construction  
Shipbuilding  
Railroad  
Truck/Trailer Manufacturing  
Fabrication  
Repair Shops  
Rental Fleets  
Power Generation Plants

### Processes

MIG (GMAW)/Pulsed MIG (GMAW-P)\*  
Stick (SMAW)  
TIG (GTAW)  
Flux Cored (FCAW)  
Air Carbon Arc Cutting and Gouging (CAC-A)

\*XMT 425 CC/CV requires optional control;  
not available with XMT 425 VS model.

**Input Power** Requires 3- or 1-Phase Power,  
208–460 VAC, 50/60 Hz CE

**Rated Output** 10–38 V, 5–425 A

**Weight** Net: 80 lb (36.3 kg)  
Ship: 89.1 lb (40.4 kg)

## The Power of Blue.<sup>®</sup>

**Wind Tunnel Technology<sup>™</sup>** protects electrical components and PC boards from contamination.

**Fan-On-Demand<sup>™</sup>** cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through machine.

**Lift-Arc<sup>™</sup>** allows TIG starting without the use of high-frequency. Starts the arc without contaminating the weld with tungsten.

**Adaptive Hot Start<sup>™</sup>** increases the output amperage at the start of a weld if necessary, eliminating electrode sticking.

**Lightweight, aerospace-grade aluminum case** offers protection with the benefit of reduced weight.

**Auto-Line<sup>™</sup> Power Management Technology** allows for any input voltage hook-up (208–460 V) with no manual linking required, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

**Inverter arc control technology** provides greater puddle control for superior 6010 Stick electrode performance, and outstanding MIG weld performance.

**Process selector switch** reduces the number of control setup combinations without reducing any features.



XMT 425 CC/CV

XMT 425 VS

The XMT 425 Series is packed with features to meet the most demanding welding needs.

**Line voltage compensation** keeps welding output constant even if input power varies by +/-10%. XMT 425 models further expand line voltage compensation on 460 VAC to an amazing +37%, -59%.

**Large, dual digital meters** are easy to view and are presettable to ease setting weld output.

**Exceptional electrical efficiency.** At 400 A, efficiency is 87.24%!

**350 A of welding output** at 60% duty cycle with superior low-end performance.

**Power factor of .95** enables smaller fuses/breakers and primary wiring. Primary amperage draw at rated output is 25% less than the competition.

**Ultra-tough, polycarbonate-blended cover for control panel** protects front controls from damage.

**Low OCV Stick** — A built-in, selectable feature, that reduces the Stick mode open-circuit voltage (OCV) to nearly 15 volts when the welding power source is not in use. Eliminates the need for add-on voltage reducers.

**Dinse International-style weld disconnects** provide high-quality weld cable connections.

### Additional Features for XMT 425 CC/CV

**Auto Remote Sense<sup>™</sup>** enables unit to automatically use remote control if connected to remote control receptacle.

**115 VAC auxiliary power** provides 10 amps of circuit-breaker-protected power for water circulators. Available on CE model.

**Pulsed MIG (GMAW-P) capabilities** with optional Optima<sup>™</sup> control reduces spatter and distortion, allows better out-of-position puddle control, and provides potential reduction of fume particle emission.

## XMT<sup>®</sup> 425 Specifications (Subject to change without notice.)



Input Power	Rated Output at 60% Duty Cycle	Voltage Range in CV Mode	Amperage Range in CC Mode	Max. Open-Circuit Voltage	Amps Input at Rated Load Output, 60 Hz,							Dimensions	Weight
					208 V	230 V	400 V	460 V	575 V	KVA	KW		
Three-Phase	350 A at 34 VDC	10–38 V	5–425 A	75 VDC	40.4	36.1	20.6	17.8	14.1	14.2	13.6	H: 17 in (432 mm) W: 12-1/2 in (318 mm) D: 24 in (610 mm)	80 lb (36.3 kg)
Single-Phase	300 A at 32 VDC	10–38 V	5–425 A	75 VDC	60.8	54.6	29.7	24.5	19.9	11.7	11.2		