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› [Miller W-225MOD TIG Torch Kit \(WP-225-25-R\) Instruction Manual](#)

Miller WP-225-25-R

Miller W-225MOD TIG Torch Kit (WP-225-25-R) Instruction Manual

1. INTRODUCTION

This manual provides essential instructions for the safe and effective use of the Miller W-225MOD TIG Torch Kit, model WP-225-25-R. This water-cooled TIG torch kit is designed for Gas Tungsten Arc Welding (GTAW) applications, offering robust performance for various welding tasks. Please read this manual thoroughly before installation, operation, or maintenance to ensure proper handling and to prevent injury or damage.

2. SAFETY INFORMATION

Welding operations involve inherent risks. Always adhere to all applicable safety standards and regulations. Failure to follow safety precautions can result in serious injury or death.

- **Electric Shock Can Kill:** Ensure proper grounding. Do not touch live electrical parts. Wear dry insulating gloves and protective clothing.
- **Fumes and Gases Can Be Hazardous:** Keep your head out of the fumes. Use ventilation or exhaust to remove fumes and gases from the breathing zone.
- **Arc Rays Can Burn Eyes and Skin:** Wear a welding helmet with a proper shade filter. Wear appropriate eye protection with side shields. Protect exposed skin with appropriate protective clothing.
- **Fire and Explosion Hazard:** Remove all flammables from the welding area. Have a fire extinguisher readily available.
- **Hot Parts Can Cause Severe Burns:** Allow equipment to cool before handling. Wear insulated gloves.
- **Cylinders Can Explode If Damaged:** Secure cylinders properly. Keep cylinders away from heat and mechanical shock.

Consult your welding machine's manual for additional safety guidelines.

3. KIT COMPONENTS

The Miller W-225MOD TIG Torch Kit (WP-225-25-R) includes the following components:

- TIG Torch Body (W-225MOD series)
- Torch Handle

- 25-foot Braided Power Cable
- 9-70 Head
- 1726 Head



Figure 1: Overview of the Miller W-225MOD TIG Torch Kit components. This image displays the coiled blue, black, and red braided power cables, along with the black torch handle and two distinct torch heads, illustrating the complete kit contents.

4. SETUP AND INSTALLATION

Proper setup is crucial for safe and efficient operation. Refer to your welding power source manual for specific connection points.

1. **Connect Power Cable:** Attach the 25-foot braided power cable to the appropriate output terminal on your TIG welding power source. Ensure a secure, tight connection.
2. **Connect Water Lines:** As this is a water-cooled kit, connect the water inlet and outlet lines from the torch to your water cooler unit. Ensure proper flow direction and leak-free connections.
3. **Connect Gas Line:** Attach the shielding gas hose from the torch to your gas regulator and cylinder. Verify all gas connections are tight to prevent leaks.
4. **Install Torch Head:** Select either the 9-70 head or the 1726 head based on your application requirements and securely attach it to the torch body.
5. **Install Consumables:** Insert the collet, collet body, tungsten electrode, and ceramic cup into the torch head. Ensure the tungsten is properly ground and extends the correct distance.

6. **Check for Leaks:** Before welding, activate the water cooler and gas flow to check for any leaks in the water or gas lines. Address any leaks immediately.

5. OPERATING INSTRUCTIONS

This section outlines general operating procedures for TIG welding with the W-225MOD torch. Always refer to your welding power source manual for specific settings and procedures.

1. **Prepare Workpiece:** Clean the workpiece thoroughly to remove any contaminants, rust, or paint.
2. **Set Welding Parameters:** Adjust the amperage, gas flow rate, and post-flow time on your welding power source according to the material thickness and type, and tungsten size. The torch supports an output range of 225/200/160 Amp DC and 160/140/115 Amp AC (100% Duty Cycle).
3. **Initiate Arc:** Use either lift-arc or high-frequency (HF) start, depending on your power source capabilities, to initiate the welding arc.
4. **Maintain Arc Length:** Keep a consistent arc length, typically equal to the diameter of the tungsten electrode.
5. **Add Filler Metal (if required):** Introduce filler rod into the weld puddle as needed, maintaining a consistent feed rate.
6. **Terminate Arc:** Gradually reduce amperage at the end of the weld to prevent crater cracking. Allow the shielding gas to flow for the set post-flow time to protect the cooling weld and tungsten.

6. MAINTENANCE

Regular maintenance ensures optimal performance and extends the life of your TIG torch kit.

- **Inspect Cables and Hoses:** Regularly check the power cable, water lines, and gas hose for cuts, abrasions, or leaks. Replace damaged components immediately.
- **Clean Torch Body and Handle:** Wipe down the torch body and handle to remove any spatter or debris.
- **Inspect Consumables:** Check the collet, collet body, and ceramic cup for wear or damage. Replace as necessary. Ensure the tungsten electrode is clean and properly ground.
- **Water Cooler Maintenance:** Follow the manufacturer's instructions for your water cooler, including checking coolant levels and cleaning the filter.
- **Storage:** Store the torch kit in a clean, dry environment when not in use to protect it from dust and damage.

7. TROUBLESHOOTING

This section addresses common issues that may arise during TIG welding. For more complex problems, consult a qualified technician or your welding power source manual.

Problem	Possible Cause	Solution
Poor Arc Start / Unstable Arc	Contaminated tungsten, incorrect tungsten grind, insufficient gas flow, poor ground connection.	Regrind tungsten, check gas flow and connections, clean workpiece and ground clamp.
Tungsten Contamination	Tungsten touching weld puddle, insufficient gas shielding, incorrect gas post-flow.	Maintain proper arc length, increase gas flow, extend post-flow time.

Problem	Possible Cause	Solution
Porosity in Weld	Inadequate gas shielding, gas leaks, contaminated workpiece, excessive gas flow.	Check gas connections for leaks, clean workpiece, adjust gas flow rate.
Torch Overheating	Insufficient water flow, clogged water lines, exceeding duty cycle.	Check water cooler operation and coolant level, inspect water lines for obstructions, reduce amperage or allow torch to cool.

8. TECHNICAL SPECIFICATIONS

- Model:** W-225MOD (Kit Model: WP-225-25-R)
- Type:** Water-cooled TIG Torch Kit
- Power Cable Length:** 25 feet, Braided
- Included Heads:** 9-70 Head, 1726 Head
- Output Range (Amps):**
 - DC: 225/200/160 Amp (100% Duty Cycle)
 - AC: 160/140/115 Amp (100% Duty Cycle)
- Application:** Electrode Range 0.020" to 1/8" TIG / GTAW
- Manufacturer:** Miller Electric
- Package Dimensions:** 21 x 18 x 18 inches
- Weight:** 4 Pounds

9. WARRANTY INFORMATION

Warranty information for the Miller W-225MOD TIG Torch Kit (WP-225-25-R) was not provided in the product data. Please refer to the official Miller Electric website or contact your authorized dealer for specific warranty terms and conditions.

10. CUSTOMER SUPPORT

For technical assistance, replacement parts, or further inquiries regarding your Miller W-225MOD TIG Torch Kit, please contact Miller Electric customer support or visit their official website. Specific contact details were not provided in the product data.

Note: Always provide the model number (WP-225-25-R) and product description when contacting support.



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Related Documents - WP-225-25-R

<p>Miller 2022 Full-Line Catalog: Welding Equipment and Solutions</p> <p>Discover the Miller 2022 Full-Line Catalog, featuring a comprehensive selection of advanced welding equipment for industrial and professional use. This catalog details MIG, Stick, TIG, and Multiprocess welders, wire feeders, MIG guns, TIG torches, and automation solutions. Miller emphasizes innovation, quality, and ease of use, offering solutions like Auto-Line, Auto-Set, and ArcReach technology to enhance productivity and weld performance.</p>	
<p>Miller Bobcat™ Welder/Generators: Process Quick Start Guide</p> <p>Get started quickly with your Miller Bobcat™ welder/generator. This guide covers initial setup, stick welding, MIG/FCAW-G welding, FCAW-S welding, TIG welding, battery jump start, air compressor setup, and plasma cutting capabilities. Includes accessory information and part numbers.</p>	
<p>Miller Bobcat 250 Operator's Manual</p> <p>This manual provides comprehensive operating instructions, safety precautions, and maintenance guidelines for the Miller Bobcat 250 welding generator. Learn about its features, processes, and how to ensure safe and efficient use.</p>	
<p>Miller Big Blue 600DX Owner's Manual - Installation, Operation, and Maintenance Guide</p> <p>Comprehensive owner's manual for the Miller Big Blue 600DX engine-driven welding generator. Covers installation, safety, operation, maintenance, troubleshooting, and specifications for optimal performance.</p>	
<p>Miller Bobcat Welder/Generator Process Quick Start Guide</p> <p>A concise quick start guide for Miller Bobcat welder/generators, detailing initial setup, accessories for Stick, MIG/FCAW-G, FCAW-S, and TIG welding, as well as battery jump start, air compressor, and plasma cutting equipment. Includes part numbers and specifications.</p>	
<p>Miller MTTC Series Owner's Manual - Welding Torch Guide</p> <p>Comprehensive owner's manual for Miller MTTC series welding torches, covering installation, operation, maintenance, safety, and parts. Essential guide for Gas Tungsten Arc Welding (GTAW) processes.</p>	

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TIG/Stick Welding Power Source

Quick Specs

Industrial Applications

Processors

Input Power

Amperage Range

Packed Output

Net Weight

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Weldcraft Modular Series

Hand-Held TIG
Welding Torches

Based on Miller's
TIG-200 Series

Quick Specs

Models	Type	Rated Output ^a	Duty Cycle	Electrode Range ^b
T-150 Modular / A-150 Modular Wave	Arched	DC 15A to 100A	90% (60-100A)	.030" to .063" (1.5-3.0 mm)
A-250 Modular	Water-cooled	DC 25A to 400A	90% (30-400A)	.030" to .063" (1.5-3.0 mm)

^aGas flow: 150 cu. in./min. (2.5 liters/min.)

^bElectrode sizes are not included in the torch assembly. They must be purchased separately.

Modular Series TIG torches

The Miller Modular Series offers high-performance gas-cooled and water-cooled torches. With a modular design, you can easily add a post configuration for various torch applications in your shop.



Miller Modular Series torches are very highly adjustable.

Miller's arched and water-cooled torches

Offering a wide range of torches, Miller's arched and water-cooled torches are designed to withstand extremely hot and harsh environments.

Ever-changing torch needs mean you need a torch that can handle all of them. That's why Miller offers a wide range of torches.

Gas valve options provide greater torching gas control (A-150 Modular Valve and A-250 Modular Valve).



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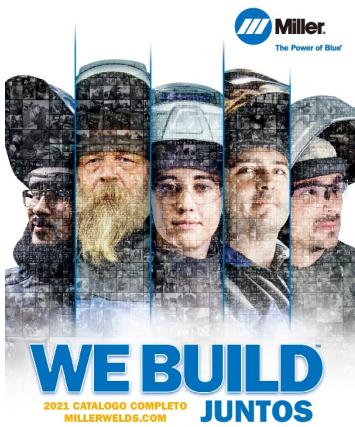
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2018 Parts Catalog MillerWelds.com SERIAL NUMBER REFERENCE The letters of the serial numbers are ... Id Model WP-225 New Name W-225 Modular Braided Rubber 12.5 ft 3.8 m WP-225-12-R 25 ft 7.6 m **WP-225-25-R** Torch packages include torch body, handle, power cable, gas hose, water hose and 1726 a

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Weldcraft Modular Series Hand-Held TIG Welding Torches

Models	Type	Rated Output*	Duty Cycle	Electrode Range*
A-225 Modular / A-150 Modular Valve	Arc-Cooled	50-150 A, AC/DC	60%	5/32" to 1/2" (5.5-12 mm)
A-225 Modular	Water-cooled	50-225 A, AC/DC	100%	5/32" to 1/2" (5.5-12 mm)
W-225 Modular	Water-cooled	50-225 A, AC/DC	100%	5/32" to 1/2" (5.5-12 mm)

*See page 3

Modular Series TIG Torches
The Modular Series is designed with high performance air-cooled and water-cooled technology to allow for high performance air-cooled and water-cooled torches to be used in the same torch body. The torch body is designed to be used with both air-cooled and water-cooled torches.

Build-in, efficient cooling system reduces overheating to extend parts and consumable life.
Modular design minimizes costs and downtime for torch changeover and parts availability.

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Weldcraft Modular Series Hand-Held TIG Welding Torches

Models	Type	Rated Output*	Duty Cycle	Electrode Range*
A-225 Modular / A-150 Modular Valve	Arc-Cooled	50-150 A, AC/DC	60%	5/32" to 1/2" (5.5-12 mm)
A-225 Modular Valve	Water-cooled	50-225 A, AC/DC	60%	5/32" to 1/2" (5.5-12 mm)
W-225 Modular	Water-cooled	50-225 A, AC/DC	100%	5/32" to 1/2" (5.5-12 mm)

*See page 3

Modular Series TIG Torches
The Modular Series is designed with high performance air-cooled and water-cooled technology to allow for high performance air-cooled and water-cooled torches to be used in the same torch body. The torch body is designed to be used with both air-cooled and water-cooled torches.

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Modular design minimizes costs and downtime for torch changeover and parts availability.

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[Miller 2022 Full-Line Catalog: Welding Equipment and Solutions](#)

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ACCESSORIES AND CONSUMABLES CATALOG 2025 Accessories and Consumables Catalog

millerwelds media miller electric import literature file accessories consumables catalog |||

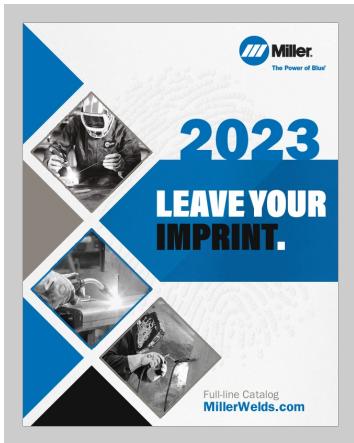
2025 ACCESSORIES AND CONSUMABLES CATALOG MILLERWELDS.COM 2025

ACCESSORIES AND CONSUMABLES CATALOG ... 3.8 m 25 ft 7.6 m Vinyl 25 ft 7.6

m Textured Handle -- WP-225 W-225 Modular WP-225-12-R **WP-225-25-R** WP-225-

25 53N06 Torch packages include torch body, handle, power cable, gas hose, wat...

lang:en **score:9** filesize: 35.25 M page_count: 112 document date: 2025-04-08



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2023 FULL LINE CATALOG millerwelds media miller electric import literature file full line catalog |||

2023 Full-line Catalog MillerWelds.com MILLER DISTRIBUTORS KNOWLEDGE

ADVICE SUPPORT. MILLER PRODU ... Braided Rubber 12.5 ft. 3.8 m WP-225-12-R

25 ft. 7.6 m WP-150-25-R WP-150V-25-R 25 ft. 7.6 m **WP-225-25-R** Vinyl 25 ft. 7.6 m

WP-225-25 Type Air-cooled Type Water-cooled Rated Output Torch ...

lang:en **score:9** filesize: 29.57 M page_count: 132 document date: 2023-04-13



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2024 FULL LINE CATALOG millerwelds media miller electric import literature file full line catalog |||

2024 CATALOG ITW WELDING SOLUTIONS BUILT BY PEOPLE LIKE YOU, FOR

PEOPLE LIKE YOU Careful planning ... Braided Rubber 12.5 ft. 3.8 m WP-225-12-R

25 ft. 7.6 m WP-150-25-R WP-150V-25-R 25 ft. 7.6 m **WP-225-25-R** Vinyl 25 ft. 7.6 m

WP-225-25 Type Air-cooled Type Water-cooled Rated Output Torch ...

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Accessories and Consumables Catalog 2023 millerwelds media miller electric import literature file

accessories consumables catalog |||

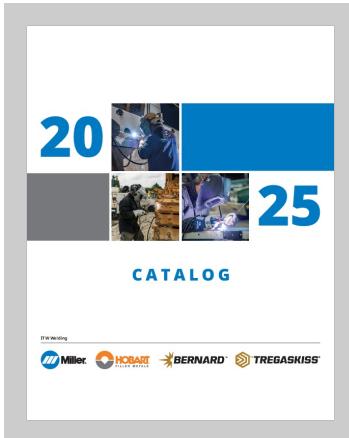
5 4 3 2 7 2023 Accessories and Consumables Catalog SERIAL NUMBER

REFERENCE The letters of the ser ... 3.8 m 25 ft 7.6 m Vinyl 25 ft 7.6 m Textured

Handle -- WP-225 W-225 Modular WP-225-12-R **WP-225-25-R** WP-225-25 53N06

Torch packages include torch body, handle, power cable, gas hose, wat...

lang:en **score:9** filesize: 32.89 M page_count: 108 document date: 2023-09-26



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CATALOG 2025 Full Line Catalog millerwelds media miller electric import literature file full line catalog |||

20 25 CATALOG ITW Welding ITW WELDING SOLUTIONS BUILT BY PEOPLE
LIKE YOU, FOR PEOPLE LIKE YOU Car ... Braided Rubber 12.5 ft. 3.8 m WP-225-
12-R 25 ft. 7.6 m WP-150-25-R WP-150V-25-R 25 ft. 7.6 m **WP-225-25-R** Vinyl 25 ft.
7.6 m WP-225-25 Type Air-cooled Type Water-cooled Rated Output Torch ...

lang:en **score:9** filesize: 29.06 M page_count: 132 document date: 2025-01-15



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Accessories and Consumables Catalog 2023 contentauthor millerwelds media miller electric import literature file accessories consumables catalog |||

5 4 3 2 7 2023 Accessories and Consumables Catalog SERIAL NUMBER
REFERENCE The letters of the ser ... 3.8 m 25 ft 7.6 m Vinyl 25 ft 7.6 m Textured Handle -- WP-225 W-225 Modular WP-225-12-R **WP-225-25-R** WP-225-25 53N06
Torch packages include torch body, handle, power cable, gas hose, wat...

lang:en **score:9** filesize: 33.01 M page_count: 108 document date: 2023-10-19

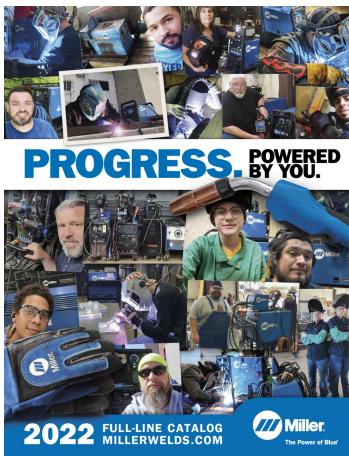


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TThhee PPoowweerr ooff BBlluuuee 5 1 2 3 4 5 2 7 6 10 9 7 6 10 9 4 5 2 1 2 3 9 8 7 7 6
5 11 1 ... 3.8 m 25 ft 7.6 m Vinyl 25 ft 7.6 m Textured Handle -- WP-225 W-225
Modular WP-225-12-R **WP-225-25-R** WP-225-25 53N06 Torch packages include
torch body, handle, power cable, gas hose, wat...

lang:en **score:9** filesize: 27.73 M page_count: 112 document date: 2022-05-02



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PROGRESS. POWERED BY YOU. 2022 FULL-LINE CATALOG
MILLERWELDS.COM MILLER PRODUCTS. BUILT BY PEOPL ... Braided Rubber
12.5 ft. 3.8 m WP-225-12-R 25 ft. 7.6 m WP-150-25-R WP-150V-25-R 25 ft. 7.6 m
WP-225-25-R Vinyl 25 ft. 7.6 m WP-225-25 Type Air-cooled Type Water-cooled Rated Output Torch ...

lang:en **score:9** filesize: 29.87 M page_count: 128 document date: 2022-08-04

