

# Continuum™ Systems

**Advanced MIG  
Welding Systems** 

## Quick Specs

### Heavy Industrial Manufacturing

Construction equipment  
Automotive components  
Recreational vehicles  
Farm machinery  
Office furniture  
Mining machinery  
Industrial fabrication



### Processes

Advanced MIG processes:  
Accu-Pulse® pulsed MIG (GMAW-P)  
Versa-Pulse™  
RMD®  
MIG (GMAW)  
High-deposition MIG (GMAW)  
Flux-cored (FCAW)  
Air carbon arc (CAC-A)  
**350:** Rated for 6 mm carbons  
**500:** Rated for 10 mm carbons

**Input Power** Auto-Line™ 230–575 V  
3-phase, 50/60 Hz

### Rated Output

**350:** 350 A at 100% duty cycle  
**500:** 500 A at 100% duty cycle

### Output Range

**350:** 20–400 A, 10–44 V  
**500:** 20–600 A, 10–44 V

## Take your welding to the next level

*Advanced industrial welding solutions improve productivity through weld quality, ease of use and system flexibility.*

The Continuum system delivers exceptional arc performance with less spatter and higher-quality welds on both thin and thick metals. With user-friendly controls and system modularity, Continuum will make challenging jobs easier, and improve productivity — giving you a competitive advantage.

**Smart and powerful digital design** has the fast response needed to deliver the most stable welding performance for better welding results.

**Developed as a platform** to meet current and future needs with integrated expansion capabilities.

**Welding information management systems**, Insight Core™ (standard) and Insight Centerpoint™ (optional), improve your welding operations by increasing productivity, improving quality and managing costs.

**Wind Tunnel Technology™** Internal air flow that protects electrical components and PC boards from dirt, dust, debris — greatly improving reliability.

**Fan-On-Demand™** operates only when needed reducing noise, power consumption, and the amount of airborne contaminants pulled through the machine.

**Auto-Line™ power management technology** allows for any input voltage hook-up (230–575 V) with no manual linking, providing convenience in any job setting. Eliminates weld defects caused by dirty or unreliable power.



Continuum 500 shown with wire feeder, Bernard™ Best of the Best (BTB) MIG gun and running gear/cylinder rack.

**Display and controls** for program select, volts/arc length and wire feed speed.

**Memory buttons** for quick program recall.

**LCD setup screen** for easy selection of welding processes and functions. Industrial design, full color display.

**Arc control** to fine tune the welding arc.

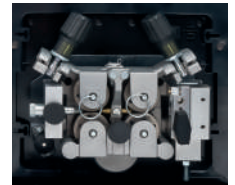
**Trigger hold, jog and purge buttons**

**Tru-Feed™ technology** provides precise feeding operation for stable arc performance.

- **Low-inertia motor** provides faster response for the best arc starts with the least amount of spatter.
- **Balanced-pressure drive-roll design and tensioners** feed wire in its truest and straightest form for consistent feedability, resulting in better welding performance.

**Spring-loaded Accu-Mate™ connection** aligns gun perfectly in the drive-roll carrier — preventing the gun from being pulled loose and providing consistent wire feeding.

**Toolless positive-locking rotatable drive assembly** allows operator to rotate the drive, eliminating severe bends in the wire feed path. This extends gun-liner life and aids in feeding difficult wires.



Power source is warranted for three years, parts and labour.  
Original main power rectifier parts are warranted for five years.  
Gun warranted for 90 days, parts and labour.



### ITW Welding Products BV

Edisonstraat 10  
3261 LD Oud-Beijerland  
Netherlands  
Phone: +44 1695 585 910  
Email: spl@itw-welding.com  
ITWwelding.com

### International Headquarters Miller Electric Mfg. LLC

An Illinois Tool Works Company  
1635 W. Spencer Street  
Appleton, WI 54914 USA  
Phone: +1 920 735 4554  
MillerWelds.com

# Continuum™ System Advantages

## Intuitive user interface makes Continuum easier to use

**Simple to set up** and adjust with minimal training.

**LCD display** shows complete words, graphics and numeric values.

**Memory buttons** allow weld operators to quickly and easily change programs.

**Remote connection** to easily view and adjust machine parameters from virtually anywhere in the world using any Web-enabled device.


**Easily update firmware**, configure machine settings, view diagnostics and more.

**USB functionality** allows custom settings to be saved on a USB flash drive for duplicating settings for a specific operator, job, or to manage fleet configurations. The USB port is also used to update software.




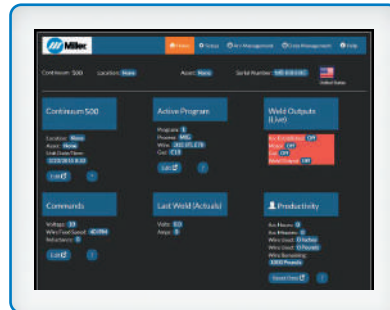
## Easy system interface and configuration via the Continuum webpage interface

• To use the webpage interface connect to the Continuum power source one of three ways:

 Connect to factory network via Wi-Fi

 Connect to factory network via Ethernet cable

 Direct connect to PC via Ethernet cable (see page 4 for recommended Ethernet cable)



• **Select language preference**

• **Check system status and vital information**

• **Configure machine settings**

- Locks and limits
- Enable programs
- Enable processes

• **Set up programs**

• **View productivity information and various logs**

- Resettable/lifetime arc hours
- Error logs
- Heat input
- And more

• **Great for validating proper system setup as well as troubleshooting issues**



## Continuum grows with your business needs

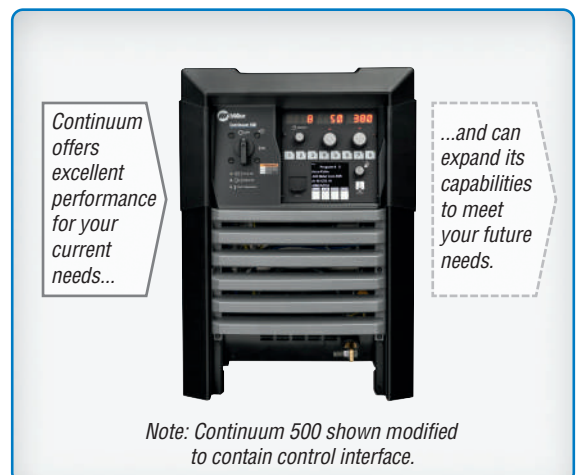
**Adaptable** to a variety of weld cell configurations and requirements.

**Control interface** can be located where it's most convenient to the customer including on the power source, on the feeder and on the remote operator interface (ROI).

**Welding Intelligence™** Improve your welding operations by increasing productivity, improving quality and managing costs with Insight Core™ (standard) and Insight Centerpoint™ (optional) welding information management systems.

**Easily add processes and programs** via the USB interface.

**Key accessories are available** to add value to your Continuum system, including running gear and Insight Centerpoint sensors (wire feed speed and gas flow).



## Welding information solutions – knowledge to drive your business forward



### Insight Core™

A simplified, Internet-based weld data solution that collects, rapidly transmits, and presents actionable information to any Web-connected device in the world.

### Insight Centerpoint™

Advanced, real-time operator feedback to provide process control — to maximize quality and efficiency in welding and fabrication.

**Insight LTD Gun.** Gun provides built-in controls for Insight Centerpoint.™



Learn more at [MillerWelds.com/insight](http://MillerWelds.com/insight)

## Continuum™ System Processes

### Take the performance of each process to the highest level

#### Improvements to Accu-Pulse®

##### Improved arc control.

- Allows increased travel speed for improved productivity.
- Improved weld bead and penetration profiles, including better tie-in at the toes of the weld for better weld quality.
- More tolerant of operator variations making it easier to use by weld operators of all skill levels. Weld operators can start producing higher-quality welds faster.

##### Less spatter.

- Improved arc starts result in less spatter, which is particularly beneficial for parts with many welds.
- Less spatter means less wasted filler metal for reduced material costs.

##### Less heat input.

- Reduces distortion for better parts fit-up through the welding cycle, and helps keep parts in tolerance.
- Easier to fill gaps with less operator skill.

#### Improvements to MIG

- Reduces spatter at arc starts.
- Very forgiving with stick-out changes and all joint designs, providing greater operator appeal.
  - Great for poor fit-up
  - Great for out-of-position welding

#### Improvements to RMD®

- Very forgiving arc makes it easier to weld with regardless of torch angles or location of welding arc to puddle.
- Designed for thin materials and gap filling.

#### Versa-Pulse™

- Fast, low-heat, low-spatter process resulting in faster travel speeds and increased productivity for semi-automated and automated welding. Typically used on thin materials up to 6 mm.
- Greater wire feed speed (WFS) range than the RMD process.
- Great for gap filling on sheet metal and tube applications.

#### High-deposition MIG

- Higher deposition rates than standard spray transfer — resulting in faster welding and increased productivity. Typically used for thicker material and larger welds (6 to 8 mm).
- Lower heat input than standard spray transfer.

## Specifications (Subject to change without notice.)



Model	Amp/Volt Ranges	Rated Output	Amps Input at Rated Output, 50/60 Hz, 3-Phase							IP Rating	Max. Open-Circuit Voltage	Dimensions	Net Weight
			230 V	380 V	400 V	460 V	575 V	KVA	KW				
Continuum 350	20–400 A 10–44 V	350 A at 31.5 VDC, 100% duty cycle	36.7 0–1*	21.8 0–1*	20.8 0–1*	18.8 0–1*	14.6 0–1*	14.4 0.8*	13.8 0.17*	IP23	72 VDC	H: 691 mm (27.19 in.) (including lift eye)	57.6 kg (127 lb.)
Continuum 500	20–600 A 10–44 V	500 A at 39 VDC, 100% duty cycle	57.6 0–1*	34.7 0–1*	33.2 0–1*	28.9 0–1*	23.3 0–1*	23.1 0.8*	21.9 0.17*			W: 444 mm (17.5 in.) D: 714 mm (28.13 in.)	67.1 kg (148 lb.)

Model	Input Power	Welding Power Source	Input Welding Circuit Rating	Wire Feed Speed	Wire Diameter Capacity	Maximum Spool Size Capacity	Dimensions	Net Weight
Continuum Feeder	50 VDC	Continuum 350 or 500	500 A at 100% duty cycle	Standard 1.27–25.4 m/min. (50–1,000 ipm)	0.9–2.0 mm (.035–5/64 in.)	457 mm (18 in.) 27 kg (60 lb.)	H: 351 mm (13.81 in.) Single W: 414 mm (16.31 in.) Dual W: 432 mm (17 in.) D: 754 mm (29.69 in.)	Single 19.5 kg (43 lb.) Dual 27.9 kg (61.5 lb.)

\*While idling.

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. All CE models conform to the applicable parts of the IEC 60974 series of standards.

# Ordering Information

Basic Package Recommendation ● = Air-cooled package ▲ = Water-cooled package

Equipment and Options	Stock No.	Description	Qty.	Price
● ▲ Continuum™ 350	907645	Power source only		
● ▲ Continuum™ 500	907648	Power source only		
<b>Wire Feeders and Gun</b>				
● ▲ Continuum™ Bench-Style Wire Feeders	301195010 301199010	Single-wire model Dual-wire model		
Remote Operator Interface	301227 301434	Control box for single-wire drive assembly Control box for dual-wire drive assembly		
Remote Motor Drive	301216 301215	Left-hand single-wire drive assembly Right-hand single-wire drive assembly		
● Bernard™ BTB Gun	Q4015VS3EML	Air-Cooled, 400 A, 4.6 m (15 ft.). TOUGH LOCK™ HD consumables and QUICK LOAD™ liner AutoLength™ system		
▲ Bernard™ BTB Gun	E4215-45-5-445-Q	Water-cooled, 400 A, 4.6 m (15 ft.). TOUGH LOCK™ HD consumables and QUICK LOAD™ liner AutoLength™ system		
<b>Cables</b>				
Continuum Control/Motor Cables	263368003 263368015 263368020 263368025 263368050 263368080	0.9 m (3 ft.) 4.6 m (15 ft.) 6.1 m (20 ft.) 7.6 m (25 ft.) 15.2 m (50 ft.) 24.4 m (80 ft.)		
● Air-Cooled Interconnecting Cables	058019285 058019286 058019287 058019288 058019289	0.9 m (3 ft.) 4.6 m (15 ft.) 7.6 m (25 ft.) 15.2 m (50 ft.) 24.4 m (80 ft.)	70 mmq weld cable, control cable, gas hose	
▲ Water-Cooled Interconnecting Cables	058019280 058019281 058019282 058019283 058019284	0.9 m (3 ft.) 4.6 m (15 ft.) 7.6 m (25 ft.) 15.2 m (50 ft.) 24.4 m (80 ft.)	70 mmq weld cable, control cable, gas and water hose	
Ethernet Cables	300734 300735 300736	3 m (9.8 ft.) with M12/RJ45 connectors 5 m (16.4 ft.) with M12/RJ45 connectors 10 m (32.8 ft.) with M12/RJ45 connectors		
Volt-Sense Cable	242212050	15.2 m (50 ft.) replacement cable		
<b>Software</b>				
Insight Centerpoint™	301297 301257 301322 301255 301256	Standard capability Advanced capability Standard and advanced capability Version 9.0 single license Version 9.0 site license		
Insight Reporter™	300709	Management reporting system client software		
Insight Reporter™ SQL Database	300710	Management reporting system database software (one required per server)		
Field Application Support	195480	Miller field support (contact distributor for details)		
<b>Accessories</b>				
● ▲ Running Gear/Cylinder Rack	301264	For Continuum power source		
Insight LTD Gun	3DM4015-45Q	Gun provides built-in controls for Insight Centerpoint™		
Continuum Cable Hanger	301213	Used to hang welding cables or MIG guns when not welding		
Hanging Bail	058435	Used for suspending feeder over work area		
▲ Continuum™ Cooler	301214	Coolant system		
▲ Industrial Coolant	043810	3.78-liter plastic bottle ( <i>must be ordered in quantities of 4</i> )		
Primary Power Cable				
Work Cable with Clamp	057014150	3 m (9.8 ft.), 400 A, 70 mmq		
Secondary Welding Cables				

Date:

Total Quoted Price:

Miller recommends  consumables

Distributed by:

