

# Multioperator Racks

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Multioperator  
Welding Systems 

## Quick Specs

### Heavy Industrial Applications

Construction  
Fabrication  
Shipbuilding  
Rental fleets

### Processes

Stick (SMAW)  
TIG (GTAW)  
MIG (GMAW)/Pulsed MIG (GMAW-P)\*  
Flux-cored (FCAW)\*  
Air carbon arc (CAC-A) cutting and gouging\*  
*\*XMT Racks only.*

### Rack Capacity (depends on rack)

Up to four or eight CST™ 282 power sources  
Up to four or six XMT® 400 power sources  
Up to four XMT® 450 or XMT 650 power sources

### Empty Rack Weight (depends on rack)

166–320 lb. (75–145 kg)



CST™ 282  
8-Pack Rack



XMT® 400 ArcReach™  
4-Pack Rack (shown  
with casters attached)

**One easy connection** allows up to eight power sources to be connected (depends on rack and power source) with one primary power drop.

**Meets IP23**, which is more stringent than IP23S or IP23M ratings.

**Protected from the elements**, the electrical junction box is located well under the galvanized roof panel.

**Lifting eyes simplify** transportation using crane or overhead lifting device.

**Liquid-tight strain reliefs** provided on both welding power source and electrical junction box. Strain relief is designed to resist salt water, alcohol, oil, grease and common solvents.

**Rack roof panel and power source shelves are fabricated from galvanized steel** and painted for added protection in harsh environments.

**Rugged steer skids** stand up to the rugged construction environment.

**Lift truck side and end fork pockets** in base to enable loading and worksite repositioning with fork lift.

**Isolated work terminal** provides a convenient connection point for common workpiece construction.

**Easy power source removal from rack** with ability to wire conventional plug for applications remote from rack.

**All racks factory-equipped with power sources include work lead connections** between the power sources and isolated work terminal.

**All racks factory-equipped with power sources include fuses** to provide primary power line protection for each inverter power supply on 460 volts.

**Meets NEC requirements when properly installed** and utilizing recommended primary circuit protection and proper fuse selection for primary power applied to rack.

**Fuses meet requirements of IEC 60529 for IP-20 finger safe rating.**

**Fuse holders are designed to accommodate fuses for both 300 amps (208–575 V) and 450 amps (380–575 V) inverters** in all voltage ranges applicable to power source.

**Visual indication window is built into fuses** to assist troubleshooting.

**Custom build your own system** by mix and matching power sources and racks.

**All racks (except XMT 650) come equipped with casters that can be bolted to the base of the rack.** Two swivel casters and two non-swivel casters. Large 5-inch diameter wheels enable the rack to be moved over grating and driveway gravel.



Warranted for three years parts and labor.



**Miller Electric Mfg. LLC**  
An ITW Welding Company  
1635 West Spencer Street  
P.O. Box 1079  
Appleton, WI 54912-1079 USA

**Equipment Sales US and Canada**  
Phone: 866-931-9730  
International Phone: 920-735-4554

**MillerWelds.com**





**The CST™ 282 is a durable power source designed for the construction industry.**

Ideal for stick electrodes up to 3/16-inch and TIG welding of pipe and plate with superior stick arc performance even on the difficult-to-run electrodes like E6010.

**Rack Specifications (Subject to change without notice.)**

Rack	Input Power to Rack	Power Source	Rack Capacity	Dimensions (H x W x D) (Includes lift eye)	Net Weight
4-Pack Rack	208–575 V, three-phase, 50/60 Hz*	CST 282	4 units	50.75 x 25.5 x 26.5 in (1,289 x 648 x 673 mm)	330 lb. (150 kg)
8-Pack Rack			8 units	59.38 x 43 x 34.38 in (1,508 x 1,092 x 873 mm)	550 lb. (250 kg)

\*Fuses included for 460-volt operation. 575-volt operation requires separate fuse (248810). 40 A fuse for 208/230-volt operation is **NOT** available from Miller — check with your local distributor or other source. Empty rack orders require ordering the appropriate fuse(s).



**The XMT® 400 ArcReach® is the standard in the welding industry for multiprocess welding.**

The most versatile power source with unbeatable arc performance, providing CC and CV welding processes including stick, TIG, MIG, FCAW and air carbon arc cutting and gouging. It is commonly used with the Miller® line of ArcReach® SuitCase® feeders to provide a reliable and durable solution for construction.

**Rack Specifications (Subject to change without notice.)**

Rack	Input Power to Rack	Power Source	Rack Capacity	Dimensions (H x W x D) (Includes lift eye)	Net Weight
4-Pack Rack	208–575 V, three-phase, 50/60 Hz*	XMT 400 ArcReach	4 units	59 x 34 x 32 in. (1,498 x 863 x 812 mm)	560 lb. (254 kg)
6-Pack Rack			6 units	59.375 x 43 x 34.375 in. (1,508 x 1,092 x 873 mm)	770 lb. (349 kg)

\*Fuses included for 460- or 575-volt (if applicable) operation. Empty rack orders require ordering the appropriate fuse(s).

**Air Carbon Arc Electrode Size**

Single XMT 400 power source: Up to 5/16 in.



**The XMT® 450 CC/CV ArcReach® provides additional power for large cored wire and gouging applications.**

Provides the same multiprocess capability as the XMT 400 with the added benefit of a higher output (450 amps at 100 percent duty cycle). The 230/460 V model leaves the factory linked and fused for 460 V operation.

**Rack Specifications (Subject to change without notice.)**

Input Power to Rack	Power Source	Rack Capacity	Dimensions (H x W x D) (Includes lift eye)	Net Weight
460 V, 60 Hz, three-phase*	XMT 450 CC/CV ArcReach	4 units	59.375 x 43 x 34.375 in. (1,508 x 1,092 x 873 mm)	780 lb. (354 kg)

\*Fuses included for 460-volt operation — not compatible with 230-volt operation. Empty rack orders require ordering the appropriate fuse(s).

**Air Carbon Arc Electrode Size**

Single XMT 450 power source: Up to 3/8 in.



**The XMT® 650 ArcReach® provides additional power for large cored wire and gouging applications.**

Provides the same multiprocess capability as the XMT 400 and 450 with the added benefit of a higher output (650 amps at 100 percent duty cycle). The 380/460 V model leaves the factory linked and fused for 460 V operation while the 575 V model leaves the factory fused for 575 V operation.

**Rack Specifications (Subject to change without notice.)**

Input Power to Rack	Power Source	Rack Capacity	Dimensions (H x W x D) (Includes lift eye)	Net Weight
380/460 V, 50/60 Hz, three-phase*	XMT 650 ArcReach	4 units	76 x 43 x 34.375 in. (1,930 x 1,092 x 873 mm)	950 lb. (431 kg)

\*Fuses included for 460-volt operation. Empty rack orders require ordering the appropriate fuse(s).

**Air Carbon Arc Electrode Size**

Single XMT 650 power source: Up to 3/8 in.

# Customize Your System with Different XMT® Inverters



## Empty XMT Racks

**300970** 208–575 V

Rack holds up to four XMT 400 models (not compatible with the XMT 450).

**195466** 208–575 V

Rack holds up to six XMT 400 models (shown at left) or four XMT 450 models.

*Note: Order fuse kit separately for appropriate power supply and intended primary voltage (see chart below).*



### XMT 400 ArcReach

**907865** 208–575 V with Tweco®-style receptacles

**907865004** 208–575 V with Dinse-style receptacles

- Pulsed MIG capability
  - Rack capacity – 4 or 6 units
- See literature DC/18.97.



### XMT 450 CC/CV

**907481** 230/460 V

**907482** 575 V w/ArcReach®

- Rack capacity – 4 units
- See literature DC/18.94.



### XMT 450 MPa

**907479** 230/460 V

**907480** 575 V

- MIG pulse capability
  - Rack capacity – 4 units
- See literature DC/18.94.

## Line Fuse Size Requirements

Product	Input Voltage (3-Phase)	Recommended Line Fuse Size (Amps)	Miller Replacement Parts			Bussman	
			4-Pack Rack Fuse Kit Stock Number	6-Pack Rack Fuse Kit Stock Number	Individual Fuse Stock Number	Individual Fuse Stock Number	
XMT 350/400	208 V	45 A	Not available	220763	220075	TCF-45	
	230 V						
	460 V	20 A		220766	220765	220074	TCF-20
	575 V						
XMT 450	460 V	30 A	220767	—	220768	TCF-30	
	575 V						
XMT 650	460 V	60 A	271400	—	235270	TCF-60	
	575 V						

# Ordering Information

Racks and Options	Stock No.	Description	Qty.	Price
<b>CST™ 282 Racks</b>	<b>951883</b> <b>907812</b>	4-pack, 208–575 V, fused 460 V, Tweco®-style receptacles 8-pack, 208–575 V, fused 460 V, Tweco®-style receptacles		
<b>Empty CST™ Racks</b>	<b>951934</b> <b>301610</b>	208–575 V. Holds up to four CST 280 models 208–575 V. Holds up to eight CST 280 models <i>Note: Order <b>required</b> fuse(s) below for appropriate primary voltage</i>		
CST Rack Fuses (order 12 per 4-pack rack or 24 per 8-pack rack)	<b>220074</b> <b>248810</b>	20 A, individual fuse for 460 V 15 A, individual fuse for 575 V <i>Note: 40 A fuse for 208/230 V operation is <b>NOT</b> available from Miller — check with your local distributor or other source</i>		
<b>XMT® 400 ArcReach® Racks</b>	<b>907882</b> <b>907883</b>	4-pack, 208–575 V, fused 460/575 V, Tweco®-style receptacles 6-pack, 208–575 V, fused 460 V, Tweco®-style receptacles		
<b>XMT® 350 FieldPro™ Polarity Reversing Racks</b>	<b>907742</b> <b>907741</b>	4-pack, 208–575 V, fused 460 V, Tweco®-style receptacles 6-pack, 208–575 V, fused 460 V, Tweco®-style receptacles		
<b>XMT® 450 CC/CV ArcReach® Rack</b>	<b>907700</b>	4-pack, 230/460 V, fused and linked for 460 V, stud receptacles		
<b>XMT® 650 ArcReach® Rack</b>	<b>907860</b>	4-pack, 380/460 V, fused 460 V, stud receptacles		
<b>XMT® 650 ArcReach® w/Polarity Reversing Rack</b>	<b>907852</b>	4-pack, 380/460 V, fused 460 V, stud receptacles		
<b>Empty XMT® Racks</b>	<b>300970</b> <b>195466</b>	208–575 V. Holds up to four XMT 350 models (not compatible with XMT 450) 208–575 V. Holds up to six XMT 350 models or four XMT 450 models <i>Note: Order <b>required</b> fuse(s) below for appropriate primary voltage</i>		
XMT Rack Fuses	<b>220763</b> <b>220075</b> <b>220766</b> <b>220765</b> <b>220074</b> <b>220767</b> <b>220768</b> <b>271400</b> <b>235270</b>	For XMT 350/400. 45 A, 6-pack fuse kit for 208/230 V For XMT 350/400. 45 A, individual fuse for 208/230 V For XMT 350/400. 20 A, 4-pack fuse kit for 460/575 V For XMT 350/400. 20 A, 6-pack fuse kit for 460/575 V For XMT 350/400. 20 A, individual fuse for 460/575 V For XMT 450. 30 A, 4-pack fuse kit for 460/575 V For XMT 450. 30 A, individual fuse for 460/575 V For XMT 650. 60 A, 4-pack fuse kit for 460/575 V For XMT 650. 60 A, individual fuse for 460/575 V		
<b>Power Source Options</b>				
XMT 350 MPa	<b>907366</b> <b>907366014</b>	208–575 V with Auto-Line™ 208–575 V with Auto-Line™ and Tweco®-style receptacles		
XMT 450 CC/CV	<b>907481</b>	230/460 V		
XMT 450 CC/CV ArcReach	<b>907482</b>	575 V		
XMT 450 MPa	<b>907479</b> <b>907480</b>	230/460 V 575 V		
<b>Accessories</b>				
Rack Running Gear	<b>195114</b>	Only required when purchasing racks and power sources separately. Assembled racks come equipped with casters		

Date:

Total Quoted Price:

*Note: Current Multioperator Racks may not be compatible with older inverter power sources.  
Please contact customer service with compatibility questions.*

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