

Gooseneck-Style Guns

XR-Aluma-Pro™ Guns

Issued Feb. 2009 • Index No. M/1.71

MIG Gun for
Push-Pull System 

Quick Specs



Heavy Industrial Applications

Emergency Vehicles	Shipbuilding
Recreational Vehicles	Tool Boxes
Trucks and Trailers	Railcars
Heat Exchangers	Fabrication
Sign Manufacturers	

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
with pulsing power source

Wire Types

Aluminum
Stainless Steel
Cored (Gas-shielded)

Weight (Torch only)

XR-Aluma-Pro A Gun:
2.5 lb (1.1 kg)
XR-Aluma-Pro W Gun:
2.9 lb (1.3 kg)

The Power of Blue.®

The XR-Aluma-Pro air-cooled gun offers 300 amps—more amperage than the competition can handle.

Aluminum-series-specific tension setting ensures smooth wire feeding performance with 4000 or 5000 series aluminum wires.

At 900 inches per minute, this gun will feed wire faster than any of its predecessors. (Dependent on feeder used.)

3-3/4 turn potentiometer provides better resolution when selecting the right wire speed for the job. The recessed WFS (wire feed speed) control offers durability yet is easy to use while wearing welding gloves.

The easy-to-rotate, self-seating head tube allows for better access into tight spots, preventing leaks and providing excellent current transfer.

The XR-Aluma-Pro trigger has a wiping action to keep contact points clean for a more reliable electrical connection.

Trigger hold reduces fatigue by allowing operator to weld without holding trigger. (Feature available when paired with XR-Control.)

Isolated, common, knurled drive roll helps reduce wear, reducing downtime and cost. Gun feeds .030–3/64 in right out of the box without need for separate drive rolls. (Kit #230 708 is required to run 1/16 in [1.6 mm] wire.)

The XR-Aluma-Pro™ Gun is available in air- or water-cooled versions with 15, 25, or 35 ft (4.6, 7.6, or 10.6 m) cable lengths.



The XR-Aluma-Pro™ is designed to be used with the XR™-Control or Millermatic® 350P as part of a push-pull system.

Replaceable feed cable liner is designed to provide consistent arc performance. It also reduces parts cost and service time by allowing a simple means of removing and replacing liner and not the complete feed cable.

Serviceability. This gun features a full-length Velcro®-seamed leather jacket with integrated strain reliefs for easy cable maintenance and protection. The gun also features quick connectors between the control cable and electrical components (trigger, motor, potentiometer).

Head tubes are standard Roughneck®, FasTip™ and are Bernard® Centerfire™ compatible. Requires diffuser conversion kit (see page 3).

Easy access to drive assembly and removable head tube reduces service time. Pressure release lever allows drive rolls to be held open for wire changeover.



Guns are warranted for 1 year, parts and labor.

MADE IN USA
APPLETON, WI



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Specifications (Subject to change without notice.)

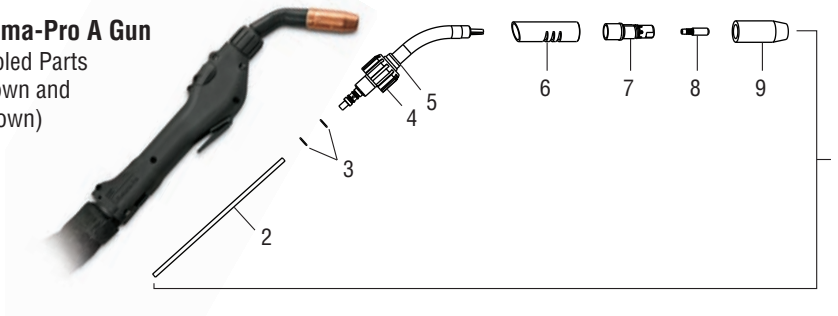
Model	Welding Output Range with 100% Argon and Peak Amperages	Electrode Wire Diameter Capacity	Wire Speed	Dimensions	Net Weight (Torch only)
XR-Aluma-Pro A Gun (Air-Cooled)	300 A at 100% Duty Cycle with 15, 25, or 35 ft (4.6, 7.6, or 10.6 m) gun	.030–1/16 in (0.8–1.6 mm) aluminum wire Wire kit #230 708 required to run 1/16 in (1.6 mm) wire	70–900 IPM (1.8–23 m/min) Dependent on feeder used.	H: 5 in (127 mm) W: 2-1/2 in (64 mm) D: 17 in (432 mm)	2.5 lb (1.1 kg)
XR-Aluma-Pro W Gun (Water-Cooled)	400 A at 100% Duty Cycle with 15, 25, or 35 ft (4.6, 7.6, or 10.6 m) gun	.030–1/16 in (0.8–1.6 mm) aluminum wire Wire kit #230 708 required to run 1/16 in (1.6 mm) wire	70–900 IPM (1.8–23 m/min)	H: 5 in (127 mm) W: 2-1/2 in (64 mm) D: 17 in (432 mm)	2.9 lb (1.3 kg)

A=Air-Cooled W=Water-Cooled

 Certified to both the Canadian and U.S. Standards for welding equipment.  Conforms to European standards.

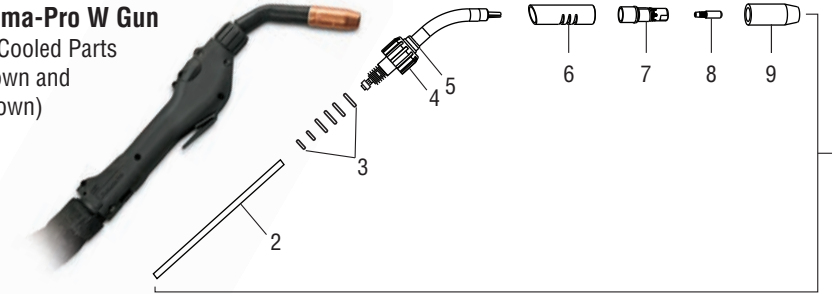
Guns

XR-Aluma-Pro A Gun
(Air-Cooled Parts Breakdown and Gun Shown)



1. Air-Cooled Assembly
Short Head Tube, 4 in **#231 519**
Long Head Tube, 6 in **#231 518***
 2. Head Tube Liner (See chart below)
 3. Head Tube O-Rings **#230 969**
 4. Lock Nut **#227 168**
 5. Insulator Ring Rear **#227 416**
 6. Outer Insulating Jacket
Short **#227 159**
Long **#229 673**
 7. Gas Diffuser **#229 670**
 8. FasTip™ Contact Tip (See pg 3 chart)
 9. Nozzle **#198 855**
- *Optional*

XR-Aluma-Pro W Gun
(Water-Cooled Parts Breakdown and Gun Shown)



1. Water-Cooled Assembly
Long Barrel, 6 in **#231 517**
2. Head Tube Liner (See chart below)
3. Head Tube O-Rings **#230 970**
4. Lock Nut **#229 889**
5. Insulator Ring Rear **#227 416**
6. Outer Insulating Jacket **#230 420**
7. Gas Diffuser **#229 670**
8. FasTip™ Contact Tip (See pg 3 chart)
9. Nozzle **#199 618**

Standard Replacement Consumables (Order from Miller Service Parts.)

Aluminum Wire Size	FasTip Contact Tip (Qty. 25)	Drive Rolls	Idler Rolls	Inlet Guides	Air-Cooled Head Tube Liner Short Barrel 4 in (102 mm)	Air- and Water-Cooled Head Tube Liner Long Barrel 6 in (152 mm)
.030 in (0.8 mm)	#206 186 .041 in ID	#227 434	#230 439	#227 408	#227 161	#229 674
.035 in (0.9 mm)	#206 187 .047 in ID	#227 434	#230 439	#227 408	#227 161	#229 674
.040 in (1.0 mm)	#206 188 .053 in ID	#227 434	#230 439	#227 408	#227 161	#229 674
3/64 in (1.2 mm)	#206 189 .061 in ID	#227 434	#230 439	#227 408	#230 239	#229 431
1/16 in (1.6 mm)	#206 191 .071 in ID	#227 434	#230 710	#230 711	#230 239	#229 431

Cable Liners	
#229 887	15 ft (4.6 m)
#229 891	25 ft (7.6 m)
#232 321	35 ft (10.6 m)

Standard Consumables (Order from Miller Service Parts.)

Nozzles

Screw-On Brass

- #199 610 1/2 in orifice, tapered
- #199 611 3/4 in orifice, straight
- #199 612 3/4 in orifice, straight HD
- #199 613 5/8 in orifice, tapered
- #199 614 5/8 in orifice, , tapered HD

Screw-On Copper

- #199 615 1/2 in orifice, tapered
- #199 616 3/4 in orifice, straight
- #199 617 3/4 in orifice, straight HD
- #198 855 5/8 in orifice, tapered
- #199 618 5/8 in orifice, tapered HD
- #207 313 5/8 in orifice, tapered 15/16 OD
- #209 035 3/8 in orifice, tapered
- #209 036 1/2 in orifice, tapered

FasTip™ Contact Tips (25 per package)



Heavy-Duty (Aluminum Wire)

- #206 186 .030 in (0.8 mm)
- #206 187 .035 in (0.9 mm)
- #206 188 .040 in (1.0 mm)
- #206 189 3/64 in (1.2 mm)
- #206 191 1/16 in (1.6 mm)

Tapered (Aluminum Wire)

- #209 026 .030/.035 in (0.8/0.9 mm)
- #209 027 .035/.045 in (0.9/1.2 mm)
- #209 029 3/64 in (1.2 mm)
- #209 030 1/16 in (1.6 mm)

Gas Diffusers (Aluma-Pro specific)



#229 670 Standard
1/8 in tip recess for heavy-duty FasTip contact tips.

#230 678
1/4 in tip recess for heavy-duty FasTip contact tips.

#230 679
Flush tip for heavy-duty FasTip contact tips.

Centerfire™ Series Optional Consumables (Order from Miller Service Parts.)

T Series Contact Tips 1.5 in (38.1 mm)

- T-030 .030 in (0.8 mm)
- T-035 .035 in (0.9 mm)
- T-039 .039 in (1.0 mm)
- T-045 .045 in (1.2 mm)
- T-052 .052 in (1.4 mm)
- T-062 1/16 in (1.6 mm)
- T-072 .068–.072 in (1.7–1.8 mm)

TT Series Contact Tips 2 in (50.8 mm)

- TT-030 .030 in (0.8 mm)
- TT-035 .035 in (0.9 mm)
- TT-045 .045 in (1.2 mm)
- TT-052 .052 in (1.4 mm)
- TT-062 1/16 in (1.6 mm)

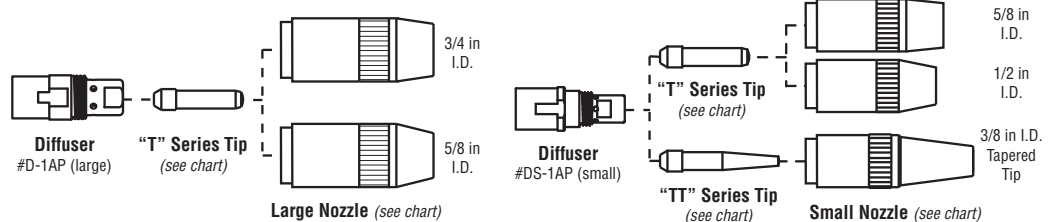
Diffuser D-1AP (large)
DS-1AP (small)

Aluma-Pro Diffuser Conversion Kits for .035–1/16 in aluminum

#230 669 For D-1AP diffuser
#230 670 For DS-1AP diffuser
Diffuser kits must be used to convert to Centerfire™ Series consumables. Kit includes diffuser and head tube liners.

Nozzles

- N-3414C Copper, 3/4 in I.D., 1/4 in tip recess
- N-3418B Brass, 3/4 in I.D., 1/8 in tip recess
- N-3414B Brass, 3/4 in I.D., 1/4 in tip recess
- N-5814C Copper, 5/8 in I.D., 1/4 in tip recess
- N-5818B Brass, 5/8 in I.D., 1/8 in tip recess
- N-5814B Brass, 5/8 in I.D., 1/4 in tip recess
- NS-5818B Brass, 5/8 in I.D., 1/8 in tip recess
- NS-1218B Brass, 1/2 in I.D., 1/8 in tip recess
- NS-1200B Brass, 1/2 in I.D., flush tip
- NST-3818B Brass, 3/8 in I.D., 1/8 in tip recess



Genuine Miller Accessories

Leather Cable Cover

- #234 109 15 ft (4.6 m)
 - #234 110 25 ft (7.6 m)
 - #234 111 35 ft (10.6 m)
- Protects gun hose and cable assembly from wear and abrasion. Features a full length velcro seam.

Short Leather Gun Cover #234 416

Cover is 17 in (432 mm).

Long Air-Cooled Head Tube Assembly #231 518

6-inch (152 mm) barrel includes liner.

1/16 Inch (1.6 mm) Wire Kit #230 708

Specially designed for 1/16 in wire. Includes idler roll, head tube liner and inlet guide. Required when running 1/16 in wires. Not included with standard Aluma-Pro Gun.

Hardwire Liner Kit for Steel and Stainless #198 377

For 15, 25, or 35 ft guns (4.6, 7.6 or 10.6 m)
Kit consists of gun head tube liner and feed cable liner. Recommend using .030–.045 in mild steel, or stainless steel electrode wire. .052 and 1/16 in wires not recommended.

Phosphorous Bronze Liner (Optional)

- #233 999 Long Head Tube (air or water)
- #233 998 Short Head Tube (air only)

Steel Liner (Optional)

- #242 191 Short Head Tube (air only)

Systems



Millermatic 350P/XR-Aluma-Pro™ Push-Pull Gun Aluminum System

#907 379 200/230/460 V

#907 380 460/575 V

The ideal aluminum welding package. Includes Millermatic 350P, 25 ft XR-Aluma-Pro™ push-pull gun, .035 and 3/64 in FasTip™ contact tips, and .035 & 3/64 in reversible U-groove drive rolls. (MIG gun not included.)



XMT 350 MPa with XR™-Control and XR-Aluma-Pro™ Gun System

#951 097 208–575 V

The XR-Control and new XR-Aluma-Pro gun combine with the XMT 350 MPa to make a great Pulsed MIG system. Welding aluminum has never been easier.

Ordering Information

A Complete System Consists of the Following:

- **XR™-Control Box**
with recommended 14-pin Miller power source (see below)
- **XR-Aluma-Pro™ Gun**
- **XR™-Control Drive Rolls**
- **Millermatic 350P Complete Aluminum System** *(see above)*

Important notes:

The XR-Control or Millermatic 350P must be ordered separately (unless ordering a Millermatic 350P/XR-Aluma-Pro System).

XR-Control Drive Roll Kits must be ordered separately and consist of control box drive rolls.

The products and descriptions mentioned in this literature are for use with XR-Control systems with serial #KK309906 or higher, or any Millermatic 350P. To confirm a product's compatibility with older equipment, please contact the factory at 1-920-735-4505.

Equipment	Stock No.	Description	Qty.	Price
XR-Aluma-Pro™ A Gun (Air-Cooled)	#300 000	15 ft (4.6 m) cable		
	#300 001	25 ft (7.6 m) cable		
	#300 264	35 ft (10.6 m) cable		
XR-Aluma-Pro™ W Gun (Water-Cooled)	#300 003	15 ft (4.6 m) cable		
	#300 004	25 ft (7.6 m) cable		
	#300 265	35 ft (10.6 m) cable		
XR™-Control (See Lit. Index No. M/1.7)	#181 538 #181 538-03-3	Standard model w/digital display W/digital display, voltage control & gas flow meter		
XMT 350 MPa with XR-Control and XR-Aluma-Pro Gun System	#951 097	208–575 V		
Millermatic® 350P/XR-Aluma-Pro Aluminum System	#907 379	200/230/460 V		
	#907 380	460/575 V		
Millermatic® 350P (See Lit. Index No. DC/12.51)	#907 168	460/575 V		
	#907 300	200/230/460 V		
XR-Control Drive Rolls (Required when using XR-Aluma-Pro guns)	#194 118	.030 in (0.8 mm) <i>(Order from Miller Service Parts.)</i>		
	#194 118	.035 in (0.9 mm) <i>(Order from Miller Service Parts.)</i>		
	#196 301	.040 in (1.0 mm) <i>(Order from Miller Service Parts.)</i>		
	#194 119	.047 in (1.2 mm) <i>(Order from Miller Service Parts.)</i>		
	#195 591	.062 in (1.6 mm) <i>(Order from Miller Service Parts.)</i>		
Accessories				
Water Coolant Systems		See Lit. Index No. AY/7.2		
Leather Cable Cover	#234 109	15 ft (4.6 m)		
	#234 110	25 ft (7.6 m)		
	#234 111	35 ft (10.6 m)		
Short Leather Gun Cover	#234 416	17 in (432 mm)		
Long Air-Cooled Head Tube Assembly	#231 518	6 in (152 mm)		
1/16 Inch (1.6 mm) Wire Kit	#230 708	Includes idler roll, head tube liner and inlet guide		
Hardware Liner Kit for Steel and Stainless (.035-.045 in)	#198 377	For 15, 25 or 35 ft (4.6, 7.6 or 10.6 m)		
Phosphorous Bronze Liner (Optional)	#233 999	Long Head Tube		
	#233 998	Short Head Tube		
Steel Liner (Optional)	#242 191	Short Head Tube		

All XR-Aluma-Pro guns have CE approval.

Date:

Total Quoted Price:

Distributed by:

