XR™-Pistol-Pro
Pistol-Grip Push-Pull Gun

Quick Specs

Heavy Industrial Applications
- Emergency vehicles
- Recreational vehicles
- Trucks and trailers
- Boat/yacht building
- Sign manufacturers

Shipbuilding
- Tool boxes
- Railcars
- Fabrication

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

Wire Types
- Aluminum
- Stainless steel
- Cored (gas-shielded)

Rated Output at 100% Duty Cycle
- Air-cooled: 200 A
- Water-cooled: 400 A

Net Weight (Gun Only)
- Air-cooled: 2.2 lb. (1 kg)
- Water-cooled: 2.4 lb. (1.1 kg)

The industry’s most reliable line of push-pull welding guns.

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

The XR-Pistol-Pro gun is available in air- or water-cooled versions with 15-, 25- or 35-foot (4.6, 7.6 or 10.6 m) cable lengths.

Easy access to drive assembly and removable toolless head tube reduce service time by allowing a means of changing drive rolls and head tube, or performing routine maintenance, without disassembly of gun.

Durable motor and drive design improves feedability and arc consistency while helping reduce downtime and maintenance costs associated with complex drive systems.

The XR-Pistol-Pro gun is designed to be used with the Millermatic® 355 power source or XR-AlumaFeed® Suitcase® feeder as part of a push-pull system.

Easy-to-rotate, self-seating head tube options in several different lengths and bend configurations (see page 4).

Guns are warranted for one year, parts and labor.
Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Welding Current Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Diameter Capacity</th>
<th>Dimensions</th>
<th>Net Weight (Gun only)</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR™-Pistol-Pro (air-cooled)</td>
<td>200 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire</td>
<td>H: 7.375 in. (187 mm)</td>
<td>2.2 lb. (1 kg)</td>
</tr>
<tr>
<td>XR™-Pistol-Pro (water-cooled)</td>
<td>400 A at 100% duty cycle</td>
<td></td>
<td>Wire kit 230708 required to run 1/16 in. (1.6 mm) wire</td>
<td>W: 1.875 in. (48 mm)</td>
<td>2.4 lb. (1.1 kg)</td>
</tr>
</tbody>
</table>

Standard Replacement Consumables

<table>
<thead>
<tr>
<th>Aluminum Wire Size</th>
<th>FasTip Contact Tip (Qty. 25)</th>
<th>Drive Rolls</th>
<th>Idler Rolls</th>
<th>Head Tube Liner 4 in. (102 mm)</th>
<th>Cable Liners</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030 in. (0.8 mm)</td>
<td>206186 .041 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1272</td>
<td>M1115 15 ft. (4.6 m)</td>
</tr>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>206187 .047 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1272</td>
<td>248359 25 ft. (7.6 m)</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>206188 .053 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1272</td>
<td>248375 35 ft. (10.6 m)</td>
</tr>
<tr>
<td>3/64 in. (1.2 mm)</td>
<td>206189 .061 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1273</td>
<td></td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>206191 .071 in. ID</td>
<td>227434</td>
<td>230710</td>
<td>M1273</td>
<td></td>
</tr>
</tbody>
</table>

Standard Consumables – FasTip™ Series

Gas Diffusers

229670 1/8 in. tip recess (Standard)
For heavy-duty FasTip contact tips.

230678 1/4 in. tip recess
For heavy-duty FasTip contact tips.

230679 Flush tip
For heavy-duty FasTip contact tips.

FasTip Contact Tips (25 per package)

Heavy-Duty (Aluminum Wire)

206186 .030 in. (0.8 mm)
206187 .035 in. (0.9 mm)
206188 .040 in. (1.0 mm)
206189 3/64 in. (1.2 mm)
206191 1/16 in. (1.6 mm)

Tapered (Aluminum Wire)

209026 .030 in. (0.8 mm)
209027 .035 in. (0.9 mm)
209029 3/64 in. (1.2 mm)
206030 1/16 in. (1.6 mm)

Nozzles

Screw-On Brass
199610 1/2 in. orifice, tapered
199611 3/4 in. orifice, straight
199612 3/4 in. orifice, straight HD
199613 5/8 in. orifice, tapered
199614 5/8 in. orifice, tapered HD

Screw-On Copper
199615 1/2 in. orifice, tapered
199616 3/4 in. orifice, straight
199617 3/4 in. orifice, straight HD
198855 5/8 in. orifice, tapered
199618 5/8 in. orifice, tapered HD
207313 5/8 in. orifice, tapered 15/16 O.D.
209035 3/8 in. orifice, tapered
209036 1/2 in. orifice, tapered

Optional Consumables – Centerfire™ Series

Insulator 10012 4323R
Diffuser D-1AP (large)
DS-1AP (small)

XR-Aluma-Pro® Diffuser Conversion Kits for .035–1/16 inch aluminum
230669 For D-1AP diffuser
230670 For DS-1AP diffuser
Diffuser kits must be used to convert to Centerfire™ Series consumables. Kit includes diffuser and head tube liners.

Aluminum-Specific T Series Contact Tips

T-035AL .035 in. (0.9 mm)
T-047AL .047 in. (1.2 mm)
T-062AL 1/16 in. (1.6 mm)

Large 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

Small Nozzles
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

Insulator 10012 4323R
Diffuser D-1AP (large)
‘T’ Series Tip (see chart)

Large Nozzle (see chart)
3/4 in. I.D.

Insulator 4323R
Diffuser DS-1AP (small)
‘T’ Series Tip (see chart)

Small Nozzle (see chart)
5/8 in. I.D.
1/2 in. I.D.
Optional Head Tube Assemblies

45 Degree/4 Inch
- 255037 Air-cooled
- 255338 Water-cooled

45 Degree/6 Inch
- 255040 Air-cooled
- 231517 Water-cooled
  (standard on XR-Aluma-Pro™)

60 Degree/4 Inch
- 231519 Air-cooled
  (standard on XR-Aluma-Pro™)
- 255038 Water-cooled

60 Degree/6 Inch
- 231518 Air-cooled
- 255041 Water-cooled

180 Degree/4 Inch
- (standard on XR™-Pistol Pro)
  - 255716 Air-cooled
  - 255717 Water-cooled

180 Degree/6 Inch
- 258476 Air-cooled
- 258477 Water-cooled

180 Degree/8 Inch
- 255042 Air-cooled
- 255043 Water-cooled

45 Degree/10 Inch
- Tight Access
  - 258295 Air-cooled
    For hard-to-reach welds where a smaller nozzle and longer reach is needed.

45 Degree/6 Inch
- with Centerfire™
  - 246205 Water-cooled
    (standard on XR-Aluma-Pro™ Plus)

60 Degree/6 Inch with Centerfire™
- 246301 Air-cooled

180 Degree/4 Inch with Centerfire™
- (standard on XR™-Pistol Plus)
  - 258474 Air-cooled
  - 258475 Water-cooled

180 Degree/6 Inch
- 258474 Air-cooled
- 258475 Water-cooled

Heavy-Duty Head Tube Assemblies

For high-duty-cycle applications.

45 Degree/6 Inch
- Heavy-Duty
  - 262206 Air-cooled
  - 258293 Water-cooled

60 Degree/6 Inch Heavy-Duty
- 262207 Air-cooled
- 258294 Water-cooled

180 Degree/6 Inch Heavy-Duty
- 262208 Air-cooled
- 259535 Water-cooled

Flex Neck/10 Inch
- 267517 Air-cooled
  Ideal for hard-to-reach welds.
Genuine Miller® Accessories

Leather Cable Cover
241159 15 ft. (4.6 m)
248355 25 ft. (7.6 m)
248377 35 ft. (10.6 m)

Protects gun hose and cable assembly from wear and abrasion. Features full-length hook-and-loop closure for ease of maintenance or replacement.

One-Pound (0.5 kg) Spool Canister 132230

Ideal for use with XR guns if a small job arises requiring a different wire size and/or wire type that does not justify a 12-inch (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. Canister accommodates 4-inch (102 mm) spools of wire.

Liners for Optional Head Tube Assemblies

Fastip® Liners (4-inch assemblies)
M1272 .030–.040 in. (0.8–1.0 mm)
M1273 3/64 and 1/16 in. (1.2 and 1.6 mm)

Fastip Liners (6-inch assemblies)
M1430 .030–.040 in. (0.8–1.0 mm)
M1365 3/64 and 1/16 in. (1.2 and 1.6 mm)

Fastip Liners (8-inch assemblies)
M1337 .030–.040 in. (0.8–1.0 mm)
M1338 3/64 and 1/16 in. (1.2 and 1.6 mm)

Bernard® Quik Tip™ Tight-Access Liners
(10-inch assemblies)
M1427 .030–.040 in. (0.8–1.0 mm)
M1421 3/64 and 1/16 in. (1.2 and 1.6 mm)

Fastip Liners
(6-inch heavy-duty water-cooled assemblies)
M1423 .030–.040 in. (0.8–1.0 mm)
M1424 3/64 and 1/16 in. (1.2 and 1.6 mm)

Phosphorous Bronze Liners
(6-inch heavy-duty water-cooled assemblies)
M1437 .030–.040 in. (0.8–1.0 mm)

50-Degree Curved Nozzle Kit-A 264064

Directly attaches to XR-Aluma-Pro® or XR®-Pistol-Pro for access to confined weld joint areas. Used with .030–1/16 inch (0.8–1.6 mm) wire. Kit includes two of each size contact tip to accommodate all wire sizes, nozzle adapter kit and curved nozzle. Uses standard straight head tube liner.

Replacement Contact Tips for 50-Degree Curved Nozzle
148155 .030 and .035 in. (0.8 and 0.9 mm) wire
148154 .047 in. (1.2 mm) wire
148156 1/16 in. (1.6 mm) wire

50-Degree Curved Nozzle Insulator Kit 264066
Sleeve goes over center of curved nozzle to protect operator from heat. For use with 50-Degree Curved Nozzle Kit-A above.

1/16-inch (1.6 mm) Wire Kit 230708
Specially designed for 1/16-inch wire. Includes idler roll, head tube liner and inlet guide. Required when running 1/16-inch wires. Not included with standard XR-Pistol-Pro gun.

Hardwire Liner Kit for Steel and Stainless 198377
For 15, 25, or 35 ft. (4.6, 7.6 or 10.6 m) guns. Kit consists of gun head tube liner M1461 listed below and feed cable liner. Recommend using .030–.045 inch mild steel or stainless steel electrode wire.

Note: .052- and 1/16-inch wires not recommended.

Phosphorous Bronze Liner
M1461 4-inch
M1462 6-inch
For use with hardwire liner kit above when used in XR-Pistol-Pro gun.

Universal Teflon Liner Kit
262707 .030–.040 in. (0.8–1.0 mm)
black liners
262705 3/64 and 1/16 in. (1.2 and 1.6 mm)
yellow liners
Includes five 14-inch liners and cutter. Liners can be cut to correct length for any pistol or gooseneck-style gun. Cutter provides a straight, clean cut to reduce shaving and feeding problems.

Teflon Liner Cutter 258863
Wire Feeders and System Packages

**XR-AlumaFeed® Suitcase® Wire Feeder  301567**
Push-pull wire feeder designed for high-volume, high-production aluminum MIG welding where quality and consistency is a high priority. Features impact-resistant flame-retardant suitcase-style case. See literature DC/34.0.

**AlumaFeed® Welding System  951836**
Includes XR-AlumaFeed® Suitcase® push-pull wire feeder with drive rolls, AlumaPower™ 350 MPa synergic power source, and 25-foot (7.6 m) air-cooled XR™-Pistol-Pro push-pull gun with contact tips, drive rolls and liners. Other system packages available. See literature DC/34.0.

**AlumaFeed® MIGRunner™ Package  951841**
Includes the same as 951836, plus MIGRunner cart and industrial MIG 4/0 kit with Dinse-style connector. Other system packages available. See literature DC/34.0.
**Typical Installations**

Note: Cords and cables are supplied unless noted otherwise on drawings below. Refer to Owner's Manual for complete installation instructions.

![Diagram](image)

**Note: XR-Aluma-Pro guns are not compatible with Continuum®, Intellx™ Elite or MPa Plus feeders.**

### XR™-Pistol-Pro Gun Hook-Up Recommendations

<table>
<thead>
<tr>
<th>CV Power Supply</th>
<th>Control</th>
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<tr>
<td>Millermatic® 252, 255, 355</td>
<td>Direct Hook-Up</td>
</tr>
<tr>
<td>Multimatic® 255</td>
<td></td>
</tr>
<tr>
<td>AlumaPower™ 350 MPa, 450 MPa</td>
<td>XR-AlumaFeed® Suitcase®</td>
</tr>
<tr>
<td>Invision™ Series</td>
<td></td>
</tr>
<tr>
<td>XMT® Series (except VS model)</td>
<td></td>
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<tr>
<td>Trailblazer® 325, 302 Air Pak™</td>
<td></td>
</tr>
<tr>
<td>Big Blue® Series (with 14-pin receptacle)</td>
<td></td>
</tr>
</tbody>
</table>

**Note:** XR-Aluma-Pro guns are not compatible with Continuum®, Intellx™ Elite or MPa Plus feeders.
### Ordering Information

<table>
<thead>
<tr>
<th>Equipment</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR-Pistol-Pro Gun (Air-Cooled)</td>
<td>300782</td>
<td>15 ft. (4.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>300783</td>
<td>25 ft. (7.6 m) cable</td>
<td></td>
<td></td>
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<tr>
<td></td>
<td>300784</td>
<td>35 ft. (10.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Pistol-Pro Gun (Water-Cooled)</td>
<td>300786</td>
<td>15 ft. (4.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>300787</td>
<td>25 ft. (7.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>300788</td>
<td>35 ft. (10.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-AlumaFeed® Suitcase® (Air-Cooled)</td>
<td>301567</td>
<td>Includes .035 and 3/64 in. drive rolls, and adds Profile Pulse™, synergic control, trigger schedule select, lock capabilities and flowmeter</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-AlumaFeed® Welding System (Air-Cooled)</td>
<td>951836</td>
<td>Includes XR-AlumaFeed Suitcase feeder 301567, AlumaPower™ 350 MPa power source, and 25 ft. air-cooled XR-Pistol-Pro gun</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-AlumaFeed® MIGRunner™ Package (Air-Cooled)</td>
<td>951841</td>
<td>Includes the same as 951836, plus MIGRunner™ cart and industrial MIG 4/0 kit with Dinse-style connector</td>
<td></td>
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#### Consumables and Accessories

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<td>Liners for Opt. Head Tube Assemblies</td>
<td>See page 5</td>
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<tr>
<td>Leather Cable Cover</td>
<td></td>
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<tr>
<td></td>
<td>241159</td>
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<td></td>
<td>248355</td>
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<td></td>
<td>248377</td>
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<tr>
<td>One-Pound Spool Canister</td>
<td>132230</td>
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<tr>
<td>50-Degree Curved Nozzle Kit-A</td>
<td>264064</td>
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<td>Replacement Contact Tips for Curved Nozzle</td>
<td>See page 5</td>
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<tr>
<td>50-Degree Curved Nozzle Insulator Kit</td>
<td>264066</td>
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<tr>
<td>1/16-Inch (1.6 mm) Wire Kit</td>
<td>230708</td>
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<td>Hardwire Liner Kit for Steel and Stainless</td>
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<td>Phosphorous Bronze Liners</td>
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<td>Coolant Systems</td>
<td>See literature AY/7.2</td>
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**Recommended Power Sources**

| AlumaPower™ MPa                  | See literature DC/34.0 |
| See literature DC/34.0          | (For synergic use with AlumaFeed™) |
| XMT™ 350 Series                 | See literature DC/18.93 |
| XMT™ 450 Series                 | See literature DC/18.94 |
| Invision™ MPa                   | See literature DC/20.6 |
| Trailblazer® Series             | See literature ED/4.75 and ED/4.8 |
| Big Blue® 800 Series            | See literature ED/14.0 |

**Note:** Other power sources may be used.