AlumaFeed
Syneric Aluminum Welding System

Quick Specs

**Processes**
- Aluminum MIG (GMAW)
- Aluminum pulsed MIG (GMAW-P)
- Aluminum synergic pulsed MIG

**XR-AlumaFeed**
- **Input Power**: 24 VAC, 50/60 Hz
- **Wire Feed Speed**: 50–900 ipm (1.3–22.9 m/min.)
- **Net Weight**: 42.5 lb. (19.2 kg)

**AlumaPower 350 MPa and 450 MPa**
- **Input Power**:
  - **350**: Requires 3- or 1-phase power, 208–575 V, 50/60 Hz
  - **450**: Requires 3-phase power, 230/460 V, 60 Hz
- **Rated Output**
  - **350**: 10–38 V, 5–425 A
  - **450**: 10–38 V, 15–600 A
- **Net Weight**
  - **350**: 80 lb. (36.3 kg)
  - **450**: 122 lb. (55.3 kg)

The XR-AlumaFeed™ and AlumaPower™ 350 MPa or 450 MPa combine for a synergic system that simplifies and improves MIG and pulsed MIG welding applications for aluminum welding.

Ultra portable and versatile.
The slim ergonomic design of the XR-Aluma-Pro torch allows access into the tightest of quarters. Coupled with the XR-AlumaFeed feeder and the AlumaPower 350 MPa or 450 MPa synergic power supply, it has the features for all of your aluminum fabrication needs.

Syneric pulsed welding mode offers the simplicity of single-knob control. The machine will select the correct pulse power based on the wire feed speed (WFS) set by the operator.

Profile Pulse™: Achieve “stacked dime” weld bead appearance without back-stepping. See page 2 for more information.

Parameter and system locks provide three levels of protection to prevent accidental modification of welding parameters or manipulation of setup menu items.

Synchronized, true push-pull wire feed system. Slave/torque motor ensures smooth, consistent feeding and improved arc performance, while reducing the problems normally associated with feeding aluminum.

Comes complete with:
- XR-AlumaFeed push-pull wire feeder
- AlumaPower 350 MPa OR 450 MPa power source
- XR-Aluma-Pro™ OR XR™-Pistol push-pull welding gun
- .035- and 3/64-inch (0.9 and 1.2 mm) contact tips, drive roll and liners for guns
- .035- and 3/64-inch (0.9 and 1.2 mm) drive rolls for wire feeder, 3/64-inch installed

Note: All AlumaFeed systems come set up out of the box to run 3/64-inch (1.2 mm) 5356 wire. Order weld cables and other accessories separately.

AlumaFeed synergic aluminum welding system with AlumaPower 450 MPa and XR-Aluma-Pro gun shown.

Power source/wire feeder are warranted for three years, parts and labor.
Original main power rectifier parts are warranted for five years.
Gun warranted for one year, parts and labor.

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

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Phone: 866-931-9730
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International FAX: 920-735-4125

MillerWelds.com

ISO 9001
REGISTERED QUALITY SYSTEM
AlumaFeed™ Synergic Aluminum Welding System Features

**Drive assembly.** Improved drive assembly with numeric scale for different wire sizes prevents wire slippage and deformation. Helps improve wire feeding by making sure the proper drive-roll tension is used. Comes factory-installed with 3/64-inch drive rolls.

**Flowmeter.** Standard integrated flowmeter helps to regulate and maintain proper gas flow rate. Helpful when feeder is located long distances from gas supply. Helps ensure weld quality.

**Gun bushing.** Improved gun connection uses a bushing that captures the power end of gun to ensure correct alignment to drive rolls and provides exceptional ruggedness and durability.

**Profile Pulse.** Achieve “stacked dime” weld bead appearance without back-stepping. Profile Pulse frequency can be changed to increase or decrease the spacing between the ripple pattern to achieve the desired weld appearance.

**Synergic “one-knob” control.** Set the wire feed speed control on the gun and the system handles the rest, greatly simplifying set-up and reducing training time. No need to travel back to the power source to change multiple parameters.

Begin and end welds with ease and confidence. **Hot Start™** eliminates incomplete fusion at the beginning of a weld, a common issue with aluminum welding. **Crater** gradually decreases weld current at the end of a weld to eliminate crater defects. Adjustable preflow and postflow rates ensure that the puddle always has adequate gas coverage.
XR-AlumaFeed Wire Feeder

Gun calibration allows control box to sync with the welding gun for precise wire feed control that is critical for reducing weld defects and providing flawless synergic operation.

Advanced trigger provides “trigger interlock” capability and the ability to control the amount of time spent in the arc start and arc crater steps.

Bright digital displays are easy to read, and display voltage or arc length and wire feed speed or amperage. Also have indicators for start and crater, setup, schedule select and advanced trigger operations. Two-knob, three-button panel layout makes it simple to change parameters and reduces training time.

XR-AlumaFeed Specifications (Subject to change without notice.) (Use with CC/CV, DC power sources.)

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Input Welding Circuit Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Type and Diameter Capacity</th>
<th>Maximum Spool Size Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>24 VAC, 5 A, 50/60 Hz</td>
<td>400 A at 100% duty cycle System duty cycle is limited to gun rating</td>
<td>50–900 ipm (1.3–22.9 m/min.)</td>
<td>Aluminum .035–.062 in. (0.9–1.6 mm) Solid Wire .035–.045 in. (0.9–1.2 mm) Drive roll kit 268850 required to run 1/16 in. (1.6 mm) wire</td>
<td>12 in. (305 mm)</td>
<td>H: 16 in. (406 mm) W: 9.5 in. (241 mm) D: 21.25 in. (540 mm)</td>
<td>42.5 lb. (19.2 kg)</td>
</tr>
</tbody>
</table>

XR-AlumaFeed Control Panel

Power Source Compatibility for XR-AlumaFeed Wire Feeder

<table>
<thead>
<tr>
<th>Power Source</th>
<th>Pulse Capable</th>
<th>Synergic Pulsed MIG</th>
<th>Profile Pulse Capability</th>
<th>Electronic Inductance/SharpArc®</th>
<th>Compatibility</th>
</tr>
</thead>
<tbody>
<tr>
<td>AlumaPower® 350 and 450 MPa</td>
<td>Yes (Aluminum only)</td>
<td>Yes (Aluminum only)</td>
<td>Yes</td>
<td>Yes</td>
<td>Optimized</td>
</tr>
<tr>
<td>Invision® 350 and 450 MPa</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Best</td>
</tr>
<tr>
<td>Invision® 450 CC/CV</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>XMT® 350 and 450 CC/CV</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>XMT® 304 CC/CV</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 456P</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 456MP</td>
<td>Yes</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 354P</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 354MP</td>
<td>Yes</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Deltaweld® (after KF790532)</td>
<td>No</td>
<td>No</td>
<td>No</td>
<td>No</td>
<td>Good</td>
</tr>
</tbody>
</table>

Note: Power sources not included in this list are not recommended. For specific information, please contact your local Miller distributor.
**XR-Aluma-Pro™ 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-Aluma-Pro™ (air-cooled)</td>
<td>300 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)</td>
<td>H: 5 in. (127 mm)</td>
<td>2.5 lb. (1.1 kg)</td>
</tr>
<tr>
<td>XR-Aluma-Pro™ (water-cooled)</td>
<td>400 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>Metal wire required to run 1/16 in. (1.6 mm) wire</td>
<td>W: 2.5 in. (64 mm)</td>
<td>2.9 lb. (1.3 kg)</td>
</tr>
</tbody>
</table>

**XR-Aluma-Pro Parts Breakdown**

1. Air-Cooled Assembly
   - Short Head Tube, 4 in.
     - 231519
   - Long Head Tube, 6 in.
     - 231518
   - Head Tube Liner (see chart below)
   - Head Tube O-Rings
     - 230969
   - Lock Nut
     - 227168
   - Insulator Ring Rear
     - 227416

2. Head Tube Liner (see chart below)
3. Head Tube O-Rings
4. Lock Nut
5. Insulator Ring Rear
6. Outer Insulating Jacket
7. Gas Diffuser
8. FasTip™ Contact Tip (see chart below)
9. Nozzle

*Optional

**XR-Aluma-Pro Standard Replacement Consumables**

(Order from Miller Service Parts.)

<table>
<thead>
<tr>
<th>Aluminum Wire Size</th>
<th>FastTip Contact Tip (Qty. 25)</th>
<th>Drive Rolls</th>
<th>Idler Rolls</th>
<th>Inlet Guides</th>
<th>Liner for Short Air-Cooled Head Tube 4 in. (102 mm)</th>
<th>Liner for Long Air- or Water-Cooled Head Tube 6 in. (152 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>227408</td>
<td>227161</td>
<td>229674</td>
<td>229887</td>
</tr>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>206187 .047 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>227161</td>
<td>229674</td>
<td>229891</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>206188 .053 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>227161</td>
<td>229674</td>
<td>232321</td>
</tr>
<tr>
<td>.064 in. (1.2 mm)</td>
<td>206189 .061 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>230239</td>
<td>229431</td>
<td></td>
</tr>
<tr>
<td>.071 in. (1.6 mm)</td>
<td>206191 .071 in. ID</td>
<td>227434</td>
<td>230710</td>
<td>230711</td>
<td>230239</td>
<td>229431</td>
<td></td>
</tr>
</tbody>
</table>

**XR-Aluma-Pro Genuine Miller® Accessories**

- **Leather Cable Cover**
  - 234109 15 ft. (4.6 m)
  - 234110 25 ft. (7.6 m)
  - 234111 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.

- **Short Leather Gun Cover**
  - 234416 Cover is 17 inches (432 mm).
  - \[231519\]
  - 60-degree/4-inch (102 mm) standard head tube includes liner.
  - \[231518\]
  - 60-degree/6-inch (152 mm) optional head tube includes liner.

- **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-Aluma-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 233998 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**
    - \[233999\]
    Long Head Tube (air or water)
    Short Head Tube (air only)
    For use with hardwire liner kit \[198377\] above when used in XR-Aluma-Pro gun.

Important: A wider selection of FasTip™ and Centerfire™ Series consumables are available — see Gooseneck-Style Guns literature M/1.71.
XR™-Pistol 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</th>
</tr>
</thead>
</table>
| XR-Pistol (air-cooled) | 200 A at 100% duty cycle  
250 A at 60% duty cycle | 70–875 ipm  
(1.8–22.2 m/min.) | .030–.1/16 in.  
(0.8–1.6 mm) aluminum wire | H: 7.375 in. (187 mm)  
W: 1.875 in. (48 mm)  
D: 10.625 in. (270 mm) | Gun only: 2.2 lb. (1 kg)  
15 ft. gun with cable: 13 lb. (5.9 kg)  
30 ft. gun with cable: 21 lb. (9.5 kg) |
| XR-Pistol (water-cooled) | 400 A at 100% duty cycle |                |                        |            | Gun only: 2.4 lb. (1.1 kg)  
15 ft. gun with cable: 14 lb. (6.4 kg)  
30 ft. gun with cable: 21.5 lb. (9.8 kg) |

XR-Pistol Air-Cooled Parts Breakdown

1. Air-Cooled Assembly  
Kit 231523
2. Water-Cooled Assembly*  
Kit 231524
3. Head Tube Liner  
212156
4. O-Ring .614 ID  
134800
5. Head Tube (Air-cooled)  
Head Tube (Water-cooled)*  
221519
6. Head Tube Pistol Insulator  
219795
7. Outer Insulating Jacket  
219794
8. Nozzle Insulator  
232284
9. Diffuser  
227749
10. Contact Tip (see chart below)  
11. Nozzle  
199613
*Order water-cooled parts from Miller Service Parts.

Important: A wider selection of FasTip™ and Centerfire™ Series consumables are available—see Pistol-Grip Guns literature M/1.73.

XR-Pistol Standard Replacement Consumables (Air-cooled only.) (Order from Miller Service Parts.)

<table>
<thead>
<tr>
<th>Aluminum Wire Size</th>
<th>FasTip Contact Tip (Qty. 25)</th>
<th>Drive Rolls</th>
<th>All-Wire Dual Groove Drive Rolls</th>
<th>Head Tube Liner</th>
<th>Cable Liners</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030 in. (0.8 mm)</td>
<td>206186 .041 in. ID</td>
<td>183357</td>
<td>136135</td>
<td>212156</td>
<td>191065</td>
</tr>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>206187 .047 in. ID</td>
<td>183357</td>
<td>136135</td>
<td>212156</td>
<td>191065</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>206188 .053 in. ID</td>
<td>183357</td>
<td>136135</td>
<td>212156</td>
<td>191065</td>
</tr>
<tr>
<td>3/64 in. (1.2 mm)</td>
<td>206189 .061 in. ID</td>
<td>183358</td>
<td>136135</td>
<td>212156</td>
<td>191065</td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>206191 .071 in. ID</td>
<td>183358</td>
<td>136135</td>
<td>212156</td>
<td>191065</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>191065</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>15 or 30 ft.</td>
</tr>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(4.6 or 9 m)</td>
</tr>
</tbody>
</table>
AlumaPower™ 350/450 MPa Power Source

Auto-Line™ power management technology on 350 model allows for any input voltage hook-up (208–575 V) with no manual linking. Ideal solution for dirty or unreliable input power. (450 model is manual link.)

Fan-On-Demand™ cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through machine.

Large, dual digital meters are easy to view and are presettable to ease setting weld output.

Inverter arc control technology provides greater puddle control for outstanding MIG and pulsed MIG weld performance.

Lightweight, aerospace-grade aluminum case offers protection and the benefit of reduced weight.

Ultra-tough, polycarbonate-blended cover for control panel protects front controls from damage.

Easy setup for MIG and pulsed MIG applications.

Line voltage compensation keeps welding output constant even if input power varies by +/-10 percent. 350 models further expand line voltage compensation to an amazing +37%/-59 percent when operating on 460 V.

SharpArc® controls the arc in pulsed MIG mode and gives control over the arc cone shape, puddle fluidity, and bead profile. If a gas is used other than Ar 100% (argon), SharpArc can be adjusted to help customize your arc to the gas being used.

Weld Cross Section

Additional Features

Power factor of .95 enables smaller fuses/breakers and primary wiring. Primary amperage draw at rated output is 25-percent less than the competition.

Built-in synergic or standard pulsed MIG capabilities. See the list below of built-in pulsed MIG (GMAW-P) aluminum programs.

<table>
<thead>
<tr>
<th>Wire Type</th>
<th>Gas Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035 AL 4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.040 AL 4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>3/64 AL 4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>1/16 AL 4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.035 AL 5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.040 AL 5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>3/64 AL 5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>1/16 AL 5356</td>
<td>Ar 100% (argon)</td>
</tr>
</tbody>
</table>

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

AlumaPower Specifications (Subject to change without notice.)

(450 model is 3-phase only.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Amp/Volt Ranges</th>
<th>Rated Output</th>
<th>Amps Input at Rated Load Output, 60 Hz</th>
<th>KVA</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1-phase</td>
<td>3-phase</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>AlumaPower 350 MPa</td>
<td>CC mode: 5–425 A</td>
<td>208 V 230 V 400 V 460 V 575 V</td>
<td>350 A at 34 VDC, 60% duty cycle</td>
<td>4.0</td>
<td>36.1</td>
<td>20.6</td>
<td>17.8</td>
<td>14.1</td>
</tr>
<tr>
<td></td>
<td>CV mode: 10–38 V</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>AlumaPower 450 MPa</td>
<td>CC mode: 15–600 A</td>
<td>208 V 230 V 400 V 460 V 575 V</td>
<td>450 A at 36.5 VDC, 100% duty cycle</td>
<td>4.9</td>
<td>37.2</td>
<td>27.2</td>
<td>23.6</td>
<td>21.6</td>
</tr>
<tr>
<td></td>
<td>CV mode: 10–38 V</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Performance Data

AlumaPower 350 MPa Duty Cycle Chart

AlumaPower 450 MPa Duty Cycle Chart

1. Output ON Indicator Light
2. Left Display
3. Voltage Indicator
4. Arc Length Indicator
5. Wire Feeder Receptacle
6. Adjustment Control
7. Right Display
8. Setup Indicator
9. Amperage Indicator
10. Setup Indicator Lights
   • Arc Control Indicator
   • Process Indicator
   • Wire/Gas Type Indicator
   • Setup Button

MPa M (MIG), P (Pulse), a (Advanced Arc Control)

Advanced arc control enables an improved pulse welding arc. The operator has more control over puddle and bead characteristics using SharpArc. In addition, the unit provides a more robust and stable arc at very low arc length, reducing heat input, and providing the ability to weld on a wider range of material thickness.

What are some benefits of synergic pulsed MIG?
1. Easier to set up
2. No more changing wire speed, and then having to go back to the power source to reset the welding output.

Miller
AlumaPower™ Genuine Miller® Accessories

Industrial MIG 4/0 Kit with Dinse Connectors 300405

For AlumaPower 350 MPa power source. Includes flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable with Dinse-style connector on one end and a lug on the other, 15-foot (4.6 m) work cable with Dinse-style connector on one end and 600-amp C-clamp on the other.

Industrial MIG 4/0 Kit 300390

For AlumaPower 450 MPa power source. Includes the same as the kit above, except weld and work cables have lugs instead of Dinse-style connectors.

Remote Control Extension Kits

- 242205025 25 ft. (7.6 m)
- 242205050 50 ft. (15 m)
- 242205080 80 ft. (24.3 m)

Fully loaded 14-pin extension cords for remote controls or 24 V and 115 V feeders.

Cable Connectors and Adapters

Note: AlumaPower 350 power sources are equipped with Dinse-style connectors for secondary connections.

- Dinse/Tweco® Adapter 042465
- Dinse/Cam-Lok Adapter 042466

One-piece adapter with Dinse-style male plug (to power source) on one end and female receptacle (Tweco or Cam-Lok for weld cable connection) on other end.

Remote Connector Kit 300898

Field Useful when pairing XR-AlumaFeed with an automated system. Allows remote trigger function, or remote voltage or arc length when used with XR-Aluma-Pro® or XR™-Pistol guns and remote. See XR-Aluma-Pro literature M/1.73 or XR-Pistol literature M/1.71 for gun stock numbers.

MIGRunner™ Cart 195445

Small footprint and easily maneuverable, with cylinder rack low enough that you do not have to lift bottles.

Universal Carrying Cart and Cylinder Rack 042934

Holds power source, and gas cylinder up to 56 inches (142.2 cm) high measuring 6 to 9 inches (15.2 to 22.8 cm) in diameter.

Coolant Systems

For more information see literature AY/7.2.

- Coolmate™ 3 043007 115 V
- Coolmate™ 3 043008 230 V

For use with water-cooled torches rated up to 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ 4 042288 115 V

For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Coolant 043809

Sold in cases of four one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37 degrees Fahrenheit (-38° C) or boiling to 227 degrees Fahrenheit (108° C). Also contains a compound that resists algae growth.

AlumaFeed MIGRunner™

AlumaFeed 350 MIGRunner with 25-foot (7.6 m) air-cooled XR-Aluma-Pro gun shown.

951151 AlumaFeed 350 with 25 ft. (7.6 m) air-cooled XR-Aluma-Pro gun
951555 AlumaFeed 350 with 25 ft. (7.6 m) water-cooled XR-Aluma-Pro gun
951153 AlumaFeed 350 with 30 ft. (9 m) air-cooled XR-Pistol gun
951256 AlumaFeed 350 with 30 ft. (9 m) water-cooled XR-Pistol gun
951149 AlumaFeed 450 with 25 ft. (7.6 m) air-cooled XR-Aluma-Pro gun
951559 AlumaFeed 450 with 25 ft. (7.6 m) water-cooled XR-Aluma-Pro gun

Packages include:
- AlumaPower 350 or 450 MPa power source (350 MPa water-cooled packages and all 450 MPa packages have 115 V auxiliary power)
- XR-AlumaFeed wire feeder
- Air- or water-cooled XR-Aluma-Pro (gooseneck-style) or XR-Pistol (pistol-grip-style) push-pull gun
- MIGRunner cart
- Industrial MIG 4/0 MIG kit with Dinse connectors
- Gun and feeder drive rolls and consumables to run .035–3/64 inch (0.9–1.2 mm) wire (1/16-inch consumables not included, order separately)
- Coolmate 3 and coolant included with water-cooled packages
Ordering Information

<table>
<thead>
<tr>
<th>Power Source and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tr>
<td>AlumaFeed™ Synergic Aluminum Welding Systems (Includes AlumaPower™ 350 MPa or 450 MPa power source, XR-AlumaFeed™ wire feeder, gooseneck or pistol-grip push-pull gun (air- or water-cooled), plus gun and feeder drive rolls and consumables to run .035–3/64 inch (0.9–1.2 mm) wire. 1/16-inch drive rolls and consumables NOT included — order separately below. Coolmate™ 3 and coolant included with water-cooled packages. 350 MPa water-cooled packages and all 450 MPa packages have 115 V auxiliary power.)</td>
<td>951162</td>
<td>350 MPa with 10-foot (3 m) air-cooled XR-Aluma-Pro™ gun</td>
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<td>951160</td>
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<td>951550</td>
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<td>951460</td>
<td>450 MPa with 25-foot (7.6 m) air-cooled XR-Aluma-Pro™ gun</td>
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<td>951557</td>
<td>450 MPa with 25-foot (7.6 m) water-cooled XR-Aluma-Pro™ gun</td>
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<td>AlumaFeed™ MIGRunner™ Packages (Includes the same as above plus MIGRunner cart and industrial MIG 4/0 kit with Dinse-style connectors. 350 MPa water-cooled packages and all 450 MPa packages have 115 V auxiliary power.)</td>
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<td>350 MPa with 25-foot (7.6 m) air-cooled XR-Aluma-Pro™ gun</td>
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<td>AlumaPower™ 350 MPa Power Source</td>
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<td>Power source only. 208–575 V with Auto-Line™</td>
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<td>907420001</td>
<td>Power source only. 208–575 V with Auto-Line™ and auxiliary power</td>
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<td>907484</td>
<td>Power source only. 575 V with auxiliary power</td>
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<td>XR-AlumaFeed™ Wire Feeder</td>
<td>300509</td>
<td>Feeder only. Full synergetic operation when used with MPa power sources only. Other Miller 14-pin power sources may be used, but feature operation may be limited. Call your Miller distributor for more information.</td>
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<td>XR-AlumaFeed™ Wire Feeder with Remote Connector</td>
<td>300509001</td>
<td>Required with 1/16-inch drive roll kit below to run 1/16-inch wire</td>
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Gun Accessories
- XR-Aluma-Pro™ 1/16-inch (1.6 mm) Wire Kit 230708
- Replacement Cable Covers  See page 4
- Tube Assemblies and Liners  See page 4

Feeder and Power Supply Accessories
- XR-AlumaFeed™ 1/16-inch (1.6 mm) Drive Roll Kit 268850
- Industrial MIG 4/0 Kit with Dinse Connectors 300405
- Remote Control Extension Kits  See page 7
- Cable Connectors and Adapters  See page 7

System Accessories
- Remote Connector Kit 300898
- MIGRunner™ Cart 195445
- Universal Carrying Cart and Cylinder Rack 042934
- Coolant Systems  See page 7. See literature AY/7.2

Date:                                                                                       Total Quoted Price: