

S-32S and S-32SL

Quick Specs

Heavy Industrial Applications

Structural Steel
Building Construction
Bridge Construction
Field Maintenance and Repair
Outdoor Equipment Repair and Build-Up Work

Processes

MIG (GMAW)
Flux-Cored (FCAW)
(Gas- and Self-Shielded)

Input Power

15–100 VDC Operating Voltage

Wire Diameter Capacity

S-32S: .023–5/64 in. (0.6–2.0 mm)
S-32SL: 5/64–7/64 in. (2.0–2.8 mm)

Wire Feed Speed

S-32S: 50–700 IPM (1.3–18 m/min.)
S-32SL: 25–325 IPM (0.6–8.2 m/min.)

Net Weight 33 lb. (15 kg)

Operates on open-circuit and arc voltages. Requires only the secondary weld cable to power feeder, no control cord needed.

Voltage-sensing control circuit with CC/CV switch allows the feeder to be used with most constant-current and constant-voltage DC power sources.

Polarity insensitive. Operates on straight (electrode negative) or reverse (electrode positive) polarity.

High-torque, 24 VDC drive motor with two gear-driven drive rolls offers excellent wire feeding performance and long uninterrupted service life.



S-32S shown with optional wire reel assembly.

Solid-state speed control and brake circuit. Exceptional speed control and regulation; eliminates the need for electrical or mechanical relays and increases service life.

Overload protection protects motor and control circuit against possible damage due to overloading conditions.

Quick-change drive rolls and quick-connect for Miller® guns. No tools required. Easy attachment.

Insulated gun-holding bracket. Convenient place for holding gun when not welding or when transporting the feeder.



Wire feeder is warranted for 3 years, parts and labor.



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Specifications (Subject to change without notice.)

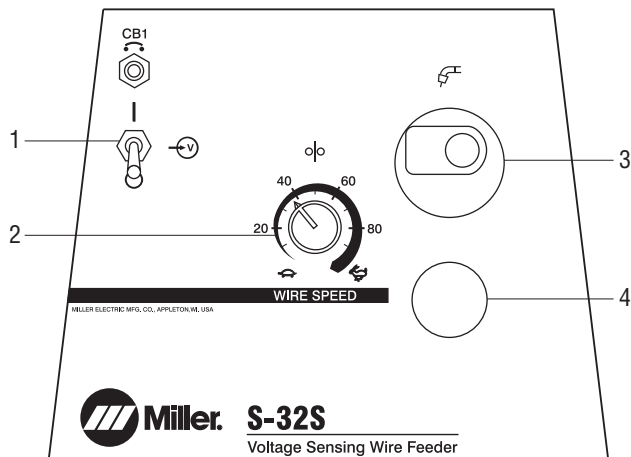


(Use with CC/CV, DC Power Sources.)

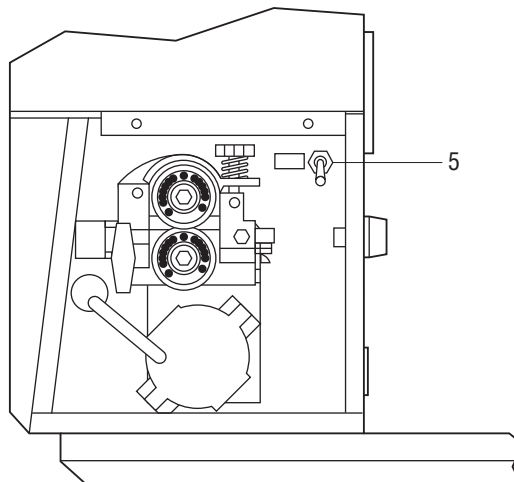
Model	Input Power	Wire Feed Speed**	Wire Diameter Capacity	Dimensions	Net Weight
S-32S	Operates on open-circuit voltage and arc voltage 15–100 V	50–700 IPM (1.3–18 m/min.)	.023–5/64 in. (0.6–2.0 mm)	H: 10 in. (254 mm) W: 10.75 in. (273 mm) D: 22.5 in. (572 mm)	33 lb. (15 kg)
S-32SL*		25–325 IPM (0.6–8.2 m/min.)	5/64–7/64 in. (2.0–2.8 mm)		

*When using an 8-inch (203 mm) diameter spool of welding wire, compression spring #057 745 is required. **Actual range is dependent on arc voltage applied.

Control Panel



Front Panel







Side Panel

1. Power Control Switch
2. Wire Speed Control
3. Gun Connection
4. Trigger Receptacle
5. CC/CV Switch

Drive Roll Kits and Guides (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include the necessary guides and feature an anti-wear sleeve for inlet guide.

Wire Size	"V" groove for hard wire 	"U" groove for soft wire or soft-shelled cored wires 	"V" knurled for hard-shelled cored wires 	"U" clogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types) 
.023/.025 in. (0.6 mm)	#087 131	—	—	—
.030 in. (0.8 mm)	#079 594	—	—	—
.035 in. (0.9 mm)	#079 595	#044 749	#079 606	—
.040 in. (1.0 mm)	—	—	—	—
.045 in. (1.1/1.2 mm)	#079 596	#079 599*	#079 607	#083 318
.052 in. (1.3/1.4 mm)	#079 597	—	#079 608	—
1/16 in. (1.6 mm)	#079 598	#079 601	#079 609	#079 614
.068/.072 in. (1.8 mm)	—	—	#089 984	—
5/64 in. (2.0 mm)	—	—	#079 610	—
3/32 in. (2.4 mm)	—	—	#079 611	—

*Accommodates .045 and .047 in. (3/64 mm) wire.

Genuine Miller® Options and Accessories

Gas Solenoid Valve #093 768 Field
 Required when using gas-shielded type wires. Includes purge control. Operates off the arc voltage and is designed for use with hot wire set-up or when using an external secondary contactor.



Spool Cover #090 389
 For 12-inch (305 mm) spool.

Spool Adapter #047 141
 For use with 14-pound (6.4 kg) spool of Lincoln self-shielding wire.



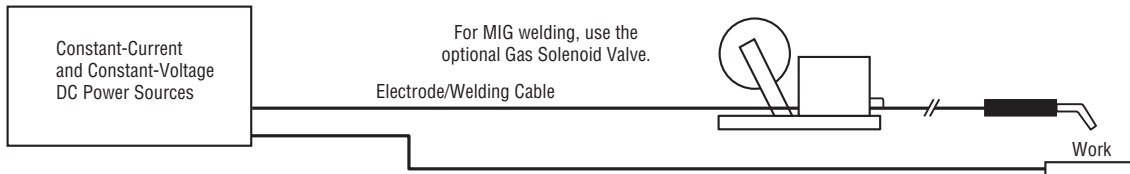
Wire Reel Assembly #108 008
 For 60-pound (27 kg) coil of wire.

Reel Cover #091 668
 For 60-pound (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.

Compression Spring #057 745
 Required when using 8-inch (203 mm) diameter, 10- or 15-pound (4.5 or 6.8 kg) spools of wire.

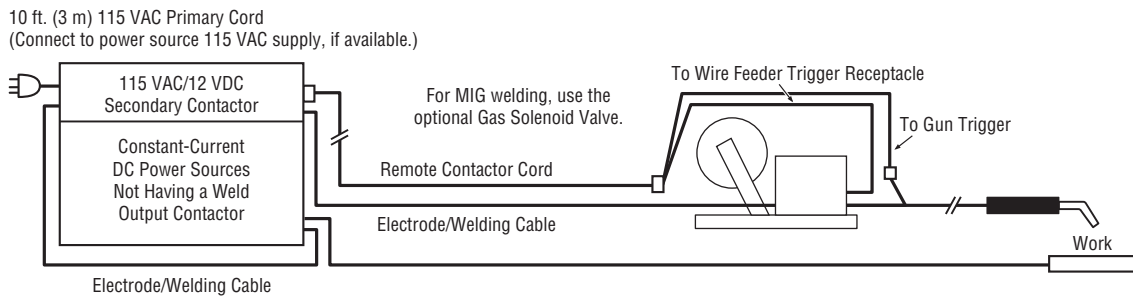
Typical Installations

BASIC SETUP — HOT WIRE



WITH OPTIONAL EXTERNAL SECONDARY CONTACTOR — COLD WIRE

Note: The secondary contactor can be wired to operate off 115 VAC or powered off a 12 VDC battery of an engine driven welder.



Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
S-32S	#088 816			
S-32SL	#109 294			
Gas Solenoid Valve	#093 768	Field		
Power Sources				
Dimension™ Series		See Lit. Index No. DC/19.2		
Gold Star® Series		See Lit. Index No. DC/8.1		
Bobcat™ Series		See Lit. Index No. ED/4.4		
Trailblazer® Series		See Lit. Index No. ED/4.75		
Accessories				
Drive Roll Kits		See page 2		
Compression Spring	#057 745			
Spool Cover	#090 389			
Spool Adapter	#047 141			
Wire Reel Assembly	#108 008			
Reel Cover	#091 668			
Miscellaneous				
Primary Power Cable				
Secondary Weld Cable				
Work Cable with Work Clamp				
Gas Cylinder				
Gas Hose with Fittings				
Flowmeter Regulator				
Welding Wire				
Helmet				
Welding Gloves				

Date:

Total Quoted Price:

Distributed by:

