# S-32S and S-32SL

## Quick Specs

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<th>Heavy Industrial Applications</th>
<th>Processes</th>
<th>Wire Diameter Capacity</th>
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<td>Structural Steel</td>
<td>MIG (GMAW)</td>
<td>S-32S: .023 – 5/64 in. (0.6 – 2.0 mm)</td>
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<tr>
<td>Building Construction</td>
<td>Flux-Cored (FCAW)</td>
<td>S-32SL: 5/64 – 7/64 in. (2.0 – 2.8 mm)</td>
</tr>
<tr>
<td>Bridge Construction</td>
<td>(Gas- and Self-Shielded)</td>
<td></td>
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<tr>
<td>Field Maintenance and Repair</td>
<td>Input Power</td>
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<tr>
<td>Outdoor Equipment Repair and Build-Up Work</td>
<td>15 – 100 VDC Operating Voltage</td>
<td></td>
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</table>

### 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)

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**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.

**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.

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

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**MillerWelds.com**

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**S-32S shown with optional wire reel assembly.**
### Control Panel

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

**Front Panel**

**Side Panel**

### Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Wire Feed Speed**</th>
<th>Wire Diameter Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>S-32S</td>
<td>Operates on open-circuit voltage and arc voltage 15 – 100 V</td>
<td>50–700 IPM (1.3 – 18 m/min.)</td>
<td>.023 – .0564 in. (0.6 – 2.0 mm)</td>
<td>H: 10 in. (254 mm)</td>
<td>33 lb. (15 kg)</td>
</tr>
<tr>
<td>S-32SL*</td>
<td></td>
<td>25 – 325 IPM (0.6 – 8.2 m/min.)</td>
<td>.0564 – .0764 in. (2.0 – 2.8 mm)</td>
<td>W: 10.75 in. (273 mm)</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>D: 22.5 in. (572 mm)</td>
<td></td>
</tr>
</tbody>
</table>

*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.

### Drive Roll Kits and Guides

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.

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

*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.

**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.

**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.

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**Typical Installations**

**BASIC SETUP — HOT WIRE**

For MIG welding, use the optional Gas Solenoid Valve. Constant-Current and Constant-Voltage DC Power Sources Electrode/Welding Cable

**WITH OPTIONAL EXTERNAL SECONDARY CONTACTER — 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.

10 ft. (3 m) 115 VAC Primary Cord
(Connect to power source 115 VAC supply, if available.)

115 VAC/12 VDC Secondary Contactor Constant-Current DC Power Sources Not Having a Weld Output Contactor

For MIG welding, use the optional Gas Solenoid Valve. To Wire Feeder Trigger Receptacle To Gun Trigger

Electrode/Welding Cable

Electrode/Welding Cable

Work

Work
## 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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<tbody>
<tr>
<td>S-32S</td>
<td>#088 816</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S-32SL</td>
<td>#109 294</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Gas Solenoid Valve</td>
<td>#093 768</td>
<td>Field</td>
<td></td>
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</tbody>
</table>

### 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: