**XR-Aluma-Pro™**

Gooseneck-Style Push-Pull Gun

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**Quick Specs**

<table>
<thead>
<tr>
<th>Heavy Industrial Applications</th>
<th>Processes (GMAW)</th>
<th>Wire Types</th>
<th>Rated Output at 100% Duty Cycle</th>
</tr>
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<tbody>
<tr>
<td>Emergency vehicles</td>
<td>MIG (GMAW)</td>
<td>Aluminum</td>
<td>Air-cooled: 300 A</td>
</tr>
<tr>
<td>Recreational vehicles</td>
<td></td>
<td>Stainless steel</td>
<td>Water-cooled: 400 A</td>
</tr>
<tr>
<td>Trucks and trailers</td>
<td>Pulsed MIG (GMAW-P)</td>
<td>Cored (gas-shielded)</td>
<td>Net Weight (Gun Only)</td>
</tr>
<tr>
<td>Heat exchangers</td>
<td></td>
<td></td>
<td>Air-cooled: 2.5 lb. (1.1 kg)</td>
</tr>
<tr>
<td>Sign manufacturers</td>
<td></td>
<td></td>
<td>Water-cooled: 2.9 lb. (1.3 kg)</td>
</tr>
</tbody>
</table>

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

**Fights fatigue.** New lighter XR-Aluma-Pro guns reduce fatigue, improve output and are rugged to withstand industrial environments.

**Balanced design.** XR-Aluma-Pro guns are balanced and have a natural feel, so welders have improved joint access and can maintain proper gun angles, stick out and travel speeds.

**Industrial-quality cable.** Gun cable failure is expensive, not only in creating downtime, but also in the cost of repairing the gun. XR-Aluma-Pro guns have a durable cable covering and strain relief to withstand industrial environments and resist damage, reducing downtime and costs.

**Aluminum-series-specific tension settings** ensure 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.

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**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 cable cover with full-length hook-and-loop closure and integrated strain relief for easy cable maintenance and protection. The gun also features quick connectors between the control cable and electrical components (trigger, motor, and potentiometer).

**Isolated, common, knurled drive roll** helps reduce wear, reducing downtime and cost. Gun feeds .030–3/64 inch right out of the box without need for separate drive rolls. Kit 230708 is required to run 1/16-inch (1.6 mm) wire.

**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 one year, parts and labor.

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**XR-Aluma-Pro™ Gooseneck-Style Push-Pull Gun**

**Processes (GMAW) with pulsing power source**

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**Rated Output at 100% Duty Cycle**

<table>
<thead>
<tr>
<th>Process</th>
<th>Air-cooled: 300 A</th>
<th>Water-cooled: 400 A</th>
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<tbody>
<tr>
<td>Pulsed MIG</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

---

**Wire Types**

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

---

**Net Weight (Gun Only)**

<table>
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<tr>
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---

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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.) dependent on control box or Millermatic® used</td>
<td>.030–.1/16 in. (0.8–1.6 mm) aluminum wire</td>
<td>H: 5 in. (127 mm) W: 2.5 in. (64 mm) D: 17 in. (432 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></td>
<td></td>
<td></td>
<td>2.9 lb. (1.3 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>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 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>227408</td>
<td>227161</td>
<td>229674</td>
<td>229891 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>227408</td>
<td>227161</td>
<td>229674</td>
<td>232321 35 ft. (10.6 m)</td>
</tr>
<tr>
<td>3/64 in. (1.2 mm)</td>
<td>206190 .061 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>227161</td>
<td>229674</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>230711</td>
<td>230239</td>
<td>229431</td>
<td></td>
</tr>
</tbody>
</table>

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 .035 in. (0.9 mm)
  - 209027 .045 in. (1.2 mm)
  - 209029 .052 in. (1.3 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
- Diffuser D-1AP (large)
- Diffuser DS-1AP (small)
- 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)
- XR-Aluma-Pro™ Diffuser Conversion Kits for .035–1/16 inch aluminum
  - 230669 For D-1AP diffuser
  - 230670 For DS-1AP diffuser
- Insulator 10012
- Diffuser D-1AP (large)
- Diffuser DS-1AP (small)
- Large Nozzles
  - 4323R
- Large Nozzles
  - N-3414C Copper, 3/4 in. I.D., 1/4 in. tip recess
  - N-3418B 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., 1/4 in. tip recess
- Small Nozzles
  - 207313 5/8 in. orifice, tapered 15/16 O.D.
  - 209035 3/8 in. orifice, tapered
  - 209036 1/2 in. orifice, tapered
  - NS-5818B Brass, 5/8 in. I.D., 1/8 in. tip recess
  - NS-1218B Brass, 1/2 in. I.D., flush tip
  - NST-3818B Brass, 3/8 in. I.D., 1/8 in. tip recess

Standard Consumables – FasTip™ Series

- Nozzles
  - Screw-On Brass
  - 196010 1/2 in. orifice, tapered
  - 196011 3/4 in. orifice, straight
  - 196012 3/4 in. orifice, straight HD
  - 196013 5/8 in. orifice, tapered
  - 196014 5/8 in. orifice, tapered HD
  - Screw-On Copper
  - 196015 1/2 in. orifice, tapered
  - 196016 3/4 in. orifice, straight
  - 196017 3/4 in. orifice, straight HD
  - 198855 5/8 in. orifice, tapered
  - 196018 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 Head Tube Assemblies

<table>
<thead>
<tr>
<th>Model</th>
<th>Description</th>
<th>Code 1</th>
<th>Code 2</th>
<th>Code 3</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>45 Degree/4 Inch</strong></td>
<td></td>
<td>255037</td>
<td>255338</td>
<td></td>
</tr>
<tr>
<td><strong>45 Degree/6 Inch</strong></td>
<td></td>
<td>255040</td>
<td>231517</td>
<td>255038</td>
</tr>
<tr>
<td><strong>60 Degree/4 Inch</strong></td>
<td></td>
<td>231519</td>
<td>255038</td>
<td></td>
</tr>
<tr>
<td><strong>60 Degree/6 Inch</strong></td>
<td></td>
<td>231518</td>
<td>255041</td>
<td></td>
</tr>
<tr>
<td><strong>180 Degree/4 Inch</strong></td>
<td>(standard on XR™-Pistol Pro)</td>
<td>255716</td>
<td>255717</td>
<td>255042</td>
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<tr>
<td><strong>180 Degree/6 Inch</strong></td>
<td></td>
<td>258476</td>
<td>258477</td>
<td></td>
</tr>
<tr>
<td><strong>180 Degree/8 Inch</strong></td>
<td></td>
<td>255042</td>
<td>255043</td>
<td></td>
</tr>
<tr>
<td><strong>45 Degree/10 Inch</strong></td>
<td>Tight Access</td>
<td>258295</td>
<td></td>
<td>258293</td>
</tr>
<tr>
<td><strong>180 Degree/6 Inch</strong></td>
<td>with Centerfire™</td>
<td></td>
<td>258474</td>
<td>258475</td>
</tr>
<tr>
<td><strong>60 Degree/6 Inch</strong></td>
<td></td>
<td>262206</td>
<td>258293</td>
<td>258294</td>
</tr>
<tr>
<td><strong>180 Degree/6 Inch</strong></td>
<td>Heavy-Duty</td>
<td>262208</td>
<td>259535</td>
<td></td>
</tr>
<tr>
<td><strong>Flex Neck/10 Inch</strong></td>
<td></td>
<td>267517</td>
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</table>

**Heavy-Duty Head Tube Assemblies**

For high-duty-cycle applications.

<table>
<thead>
<tr>
<th>Model</th>
<th>Description</th>
<th>Code 1</th>
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<th>Code 3</th>
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<tr>
<td><strong>45 Degree/6 Inch</strong></td>
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<td>262206</td>
<td>258293</td>
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</tr>
<tr>
<td><strong>60 Degree/6 Inch Heavy-Duty</strong></td>
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<td></td>
<td>262208</td>
<td>259535</td>
<td></td>
</tr>
</tbody>
</table>
Liners for Optional Head Tube Assemblies

**Fastip™ Liners (4-inch assemblies)**
- 227161 .030–.040 in. (0.8–1.0 mm)
- 230239 3/64 and 1/16 in. (1.2 and 1.6 mm)

**Fastip Liners (6-inch assemblies)**
- 229674 .030–.040 in. (0.8–1.0 mm)
- 229431 3/64 and 1/16 in. (1.2 and 1.6 mm)

**Fastip Liners (8-inch assemblies)**
- M1434 .030–.040 in. (0.8–1.0 mm)
- M1435 3/64 and 1/16 in. (1.2 and 1.6 mm)

**Bernard® Quik Tip™ Tight-Access Liners (10-inch assemblies)**
- M1428 .030–.040 in. (0.8–1.0 mm)
- M1429 3/64 and 1/16 in. (1.2 and 1.6 mm)

**Fastip Liners (6-inch heavy-duty water-cooled assemblies)**
- M1425 .030–.040 in. (0.8–1.0 mm)
- M1426 3/64 and 1/16 in. (1.2 and 1.6 mm)

**Phosphorous Bronze Liners (6-inch heavy-duty water-cooled assemblies)**
- M1436 .030–1/16 in. (0.8–1.6 mm)

**Universal Teflon® Liner Kit**
- 262707 .030–.040 in. (0.8–1.0 mm)
- 262705 3/64 and 1/16 in. (1.2 and 1.6 mm)

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

Genuine Miller® Accessories

**Cable Cover**
- M1681 15 ft. (4.6 m)
- M1682 25 ft. (7.6 m)
- M1683 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.

**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-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)
- 233998 Short head tube (air only)
For use with hardwire liner kit 198377 above when used in XR-Aluma-Pro gun.
Wire Feeder 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® MIGRunner® Package  951833
Includes the same as 951834, plus MIGRunner cart and industrial MIG 4/0 kit with Dinse-style connector. Other system packages available. See literature DC/34.0.

AlumaFeed® Welding System  951834
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-Aluma-Pro™ push-pull gun with contact tips, drive rolls and liners. Other system packages available. See literature DC/34.0.

Millermatic® 350P Aluminum/XR-Aluma-Pro™ System  
951452  200(208)/230/460 V
Includes Millermatic 350P Aluminum, 25-foot (7.6 m) XR-Aluma-Pro air-cooled push-pull gun, .035- and 3/64-inch FasTip™ contact tips, and .035- and 3/64-inch reversible U-groove drive rolls. (Standard MIG gun not included.) See literature DC/12.56.
Typical Installations

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

Miller® CV or CV/CC power source equipped with a 14-pin receptacle and 24 VAC power

PSA-2 115/24 VAC

Miller® CV or competitive CV power source with 115 VAC power

Contactor 115 VAC

10-foot (3 m) 24 VAC and contactor cord supplied with feeder

XR-AlumaFeed® Suitcase®

XR-Aluma-Pro™ Gun

XR-Aluma-Pro™ Gun Hook-Up Recommendations

<table>
<thead>
<tr>
<th>CV Power Supply</th>
<th>Control</th>
</tr>
</thead>
<tbody>
<tr>
<td>Millermatic® 252, 255, 350P, 350P Aluminum</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>Deltaweld® Series</td>
<td></td>
</tr>
<tr>
<td>Invision™ Series</td>
<td></td>
</tr>
<tr>
<td>XMT® Series (except VS model)</td>
<td></td>
</tr>
<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 74MPa Plus feeders.
## Ordering Information

**XR-Aluma-Pro guns require the following:**
- **XR-AlumaFeed Suitcase** (See at right.)
- **Recommended Miller® 14-pin power source** (See list below.) OR
- **Millermatic 252, 255, 350P, 350P Aluminum, or Multimatic 255** (See literature DC/12.49, DC/12.8, DC/12.51, DC/12.56, or DC/12.9.)

**Important notes:**
- XR-Aluma-Pro guns are not compatible with 74MPa Plus feeders.
- XR-Control must be serial number KK309906 or higher to be used with products and descriptions mentioned in this literature. To confirm a product’s compatibility with older equipment, please contact the factory at 1-920-735-4505.

### Equipment

<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-Aluma-Pro™ Gun (Air-Cooled)</td>
<td>301568</td>
<td>15 ft. (4.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Aluma-Pro™ Gun (Air-Cooled)</td>
<td>301569</td>
<td>25 ft. (7.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Aluma-Pro™ Gun (Air-Cooled)</td>
<td>301570</td>
<td>35 ft. (10.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Aluma-Pro™ Gun (Water-Cooled)</td>
<td>301571</td>
<td>15 ft. (4.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Aluma-Pro™ Gun (Water-Cooled)</td>
<td>301572</td>
<td>25 ft. (7.6 m) cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Aluma-Pro™ Gun (Water-Cooled)</td>
<td>301573</td>
<td>35 ft. (10.6 m) cable</td>
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<td></td>
</tr>
</tbody>
</table>

**XR-AlumaFeed® Suitcase®** (See literature DC/34.0)

| XR-AlumaFeed® Suitcase® | 301567 | Includes .035 and 3/64 in. drive rolls, and adds Profile Pulse™, synergic control, trigger schedule select, lock capabilities and flowmeter |

**XR-AlumaFeed® Welding System (Air-Cooled)** (See literature DC/34.0)

| XR-AlumaFeed® Welding System (Air-Cooled) | 951834 | Includes XR-AlumaFeed Suitcase feeder 301567, AlumaPower™ 350 MPa power source, and 25 ft. air-cooled XR-Aluma-Pro gun |

**XR-AlumaFeed® MIGRunner™ Package (Air-Cooled)** (See literature DC/34.0)

| XR-AlumaFeed® MIGRunner™ Package (Air-Cooled) | 951833 | Includes the same as 951834, plus MIGRunner cart and industrial MIG 4/0 kit with Dinse-style connector |

**Millermatic® 350P Aluminum/ XR-Aluma-Pro System (Air-Cooled)** (See literature DC/12.56)

| Millermatic® 350P Aluminum/ XR-Aluma-Pro System (Air-Cooled) | 951452 | 200(208)/230/460 V. True torque motor push-pull system. Note: Millermatic 350P Aluminum is only compatible with push-pull guns — not standard MIG guns |

### Consumables and Accessories

| Consumables | See page 2 |
| LIners for Optional Head Tube Assemblies | See page 3 |
| Cable Cover | See page 4 |

**50-Degree Curved Nozzle Kit-A**

| 50-Degree Curved Nozzle Kit-A | 264064 |

**Replacement Contact Tips for Curved Nozzle**

| Replacement Contact Tips for Curved Nozzle | See page 4 |

**50-Degree Curved Nozzle Insulator Kit**

| 50-Degree Curved Nozzle Insulator Kit | 264066 |

**1/16-Inch (1.6 mm) Wire Kit**

| 1/16-Inch (1.6 mm) Wire Kit | 230708 |

**Hardwire Liner Kit for Steel and Stainless**

| Hardwire Liner Kit for Steel and Stainless | 198377 |

**Phosphorous Bronze Liners**

| Phosphorous Bronze Liners | See page 4 |

**Coolant Systems**

| Coolant Systems | See literature AY/7.2 |

## Recommended Power Sources

- **AlumaPower** MPa
  - 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/23.6

- **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.

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