

20 Series

Constant-Speed Wire Feeder 

Quick Specs

Industrial Applications

Heavy- or light-duty fabrication shops
Trailer manufacturers
Furniture manufacturers
Automotive products
Educational institutions

Processes

MIG (GMAW)
Flux-cored (FCAW)
(gas- and self-shielded)

Input Power 24 VAC, 7 A, 50/60 Hz

Wire Diameter Capacity

22A: .023–5/64 in. (0.6–2.0 mm)
24A: .023–3/32 in. (0.6–2.4 mm)

Wire Feed Speed 75–750 ipm (1.9–19 m/min.)

Net Weight **22A:** 36 lb. (15.4 kg) **24A:** 40 lb. (18 kg)



Models: **22A:** Two gear-driven drive rolls
24A: Four gear-driven drive rolls

Models include Bernard™ BTB Gun 300 A, .035/.045-inch drive rolls and Centerfire™ contact tips!

Wire feed speed range is 75–750 ipm! This offers a wider operating range than the competition.

Trigger hold control allows operator to make long extended welds without having to hold gun trigger.

Gear-driven drive rolls offer smooth, positive and accurate wire feed with long, uninterrupted service life. 24A has four drive rolls for larger wire diameters.

On-board burnback and motor ramp control offers unmatched starting and stopping performance on a variety of power sources. This helps to ensure positive arc starting performance.

16-gauge sheet metal housing is robust in rough service applications and less prone to damage.

Remote voltage control is standard on 24A. Parameter adjustments can be made in weld cell or at a remote location. Optional for 22A.

Adjustable run-in control is standard on 24A for better arc-starting performance on a variety of wires. Optional for 22A.



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



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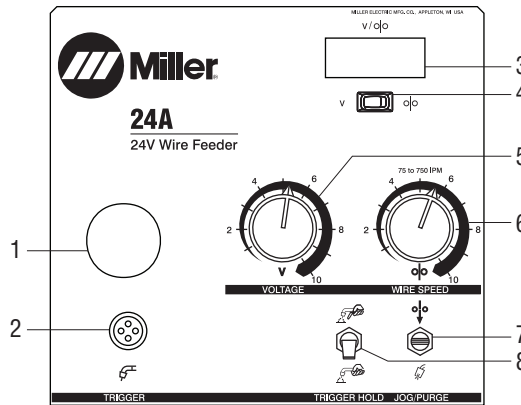
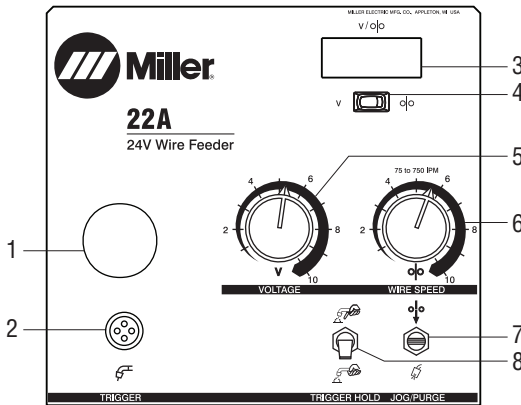
Specifications (Subject to change without notice.)

CV DC (Use with CV, DC power sources.)

Model	Input Power	Wire Feed Speed	Wire Diameter Capacity	Dimensions	Net Weight
22A	24 VAC, 7 A, 50/60 Hz	75–750 ipm (1.9–19 m/min.)	.023–5/64 in. (0.6–2.0 mm)	H: 11 in. (279 mm) W: 10.75 in. (273 mm) D: 23.5 in. (597 mm)	36 lb. (15.4 kg)
24A			.023–3/32 in. (0.6–2.4 mm)		40 lb. (18 kg)

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

Control Panels



1. Gun Connection
 2. Trigger Receptacle
 3. Voltage/Wire Speed Meter*
 4. Meter Selection Switch*
 5. Remote Voltage Control**
 6. Wire Speed Control
 7. Jog/Purge
 8. Trigger Hold (On/Off)
- Power On/Off (on rear panel)

*Optional
**Optional on 22A,
standard on 24A

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)	
	22A 2-Roll Kit	24A 4-Roll Kit	22A 2-Roll Kit	24A 4-Roll Kit	22A 2-Roll Kit	24A 4-Roll Kit	22A 2-Roll Kit	24A 4-Roll Kit
.023/.025 in. (0.6 mm)	087131	—	—	—	—	—	—	—
.030 in. (0.8 mm)	079594	046780	—	—	—	—	—	—
.035 in. (0.9 mm)	079595	046781	044749	044750	079606	046792	—	—
.040 in. (1.0 mm)	—	161190	—	—	—	—	—	—
.045 in. (1.1/1.2 mm)	079596	046782	079599*	046785	079607	046793	083318	—
.052 in. (1.3/1.4 mm)	079597	046783	—	046786	079608	046794	—	—
1/16 in. (1.6 mm)	079598	046784	079601	046787	079609	046795	079614	046800
.068/.072 in. (1.8 mm)	—	—	—	—	089984	—	—	—
5/64 in. (2.0 mm)	—	—	—	046788	079610	046796	—	—
3/32 in. (2.4 mm)	—	—	—	—	—	046797**	—	—

*Accommodates .045 and .047 in. (3/64 mm) wire. **3/32 in. inlet guide 194264 is required when using 3/32 in. drive rolls.

Nylon Wire Guides for Feeding Aluminum Wire

Wire Size	Inlet Guide
.035–.047 in. (1.2 mm)	151203
1/16 in. (1.6 mm)	151205

Note: "U" groove drive rolls are recommended when feeding aluminum wire.

Genuine Miller® Options and Accessories

Digital Display V/WFS 186498 Field
Dual-function, backlit LCD digital meter with selector switch. The digital meter allows the wire feed speed to be preset in inches per minute or meters per minute. The voltage function, if used with a current Miller-manufactured, electronically controlled, constant-voltage power source, allows the arc voltage to be preset and monitored on the digital display. When used with voltage control **194211**.

Voltage Control 194211 Field
Standard on 24A. Installs in front panel of the feeder to allow remote voltage control of most Miller, electronically controlled CV or CC/CV power sources.

Note: The field kit voltage control includes a 10-foot (3 m) cord that replaces the standard cord supplied with the feeder.

Run-In Control 193391 Field
Standard on 24A. A separate wire feed speed adjustment to control wire speed prior to arc initiation. This control may be beneficial to aid arc starting with certain types of power sources.



Carrying Cart 056301
A utility cart for the wire feeder and other miscellaneous welding supplies. Cart is 34 inches high x 30 inches wide x 17 inches deep (864 x 762 x 432 mm). Lower tray height is 9 inches (228 mm). Shipped disassembled.



Feeder Cart 142382
A low-profile, creeper cart which allows the operator to easily move the feeder around the work area. Shipped disassembled.

Turntable Assembly 146236
Allows rotation of the feeder as operator changes work positions. This reduces strain and bending on gun cable.

Hanging Bail (Electrically Isolated) 058435
Used for suspending feeder over work area.



Spool Cover 057607
For 12-inch (305 mm) spool.

Spool Adapter 047141
For use with 14-pound (6.4 kg) spool of Lincoln self-shielding wire.



Wire Reel Assembly 108008
For 60-pound (27 kg) coil of wire.

Reel Cover 195412
For 60-pound (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.



PSA-2 Control 141604
Required when using the 22A wire feeder with power sources having only 115 V available. The PSA-2 control can be conveniently mounted on the wire feeder or positioned at the power

source. The control is equipped with a 14-pin receptacle for direct connection of the wire feeder control cord. A short cord with a four-pin amp plug is hard wired to the control. A 10-foot (3 m) interconnecting cord with a four-pin amp for connection to the PSA-2 and Hubbell connectors for older-style Miller CV power sources is included. The PSA-2 control can also be used with competitive power sources requiring a contact closure for contactor control.

Extension Cables for 14-Pin Plugs to 14-Pin Sockets*

242208025 25 ft. (7.6 m)

242208050 50 ft. (15.2 m)

242208080 80 ft. (24.4 m)

Provides 14-pin, 24 VAC, contactor and voltage control. Add to the standard 10-foot (3 m) feeder cable to extend feeder farther from power source.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
22A	951190			
	951191	With run-in control		
	951192	With digital display and voltage control		
24A	951193			
	951194	With digital display		
Digital Display Meter	186498	Field		
Voltage Control	194211	Field. Standard on 24A		
Run-In Control	193391	Field. Standard on 24A		
Power Sources				
CP-302		22A only. See literature DC/13.0		
Deltaweld® Series		See literature DC/16.2		
Dimension™ 650		See literature DC/19.3		
XMT® 304/350/450		See literature DC/18.8, DC/18.93 and DC/18.94		
Invision™ 352 MPa and 450 MPa		See literature DC/23.6		
Accessories				
Drive Roll Kits		See page 2		
Carrying Cart	056301			
Feeder Cart	142382			
Turntable Assembly	146236			
Hanging Bail	058435			
Spool Cover	057607			
Spool Adapter	047141			
Wire Reel Assembly	108008			
Reel Cover	195412			
PSA-2 Control	141604			
Extension Cables	242208025	25 ft. (7.6 m)		
	242208050	50 ft. (15.2 m)		
	242208080	80 ft. (24.4 m)		
Bernard™ BTB Guns				
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:

