

# PipeWorx FieldPro™ System

Multiprocess Pipe Welding Systems 

## Quick Specs



### Pipe Welding Field Operations

Process piping  
Refinery  
Petrochemical  
Power  
HVAC and water pipe

### Processes

Stick (SMAW)  
DC Lift-Arc™ TIG (GTAW)  
MIG (GMAW)  
RMD®  
Pulsed MIG (GMAW-P)  
Flux-cored (FCAW)  
Air carbon arc (CAC-A) cutting and gouging (6.0 mm carbons)

**Rated Output** 350 A at 34 VDC, 60% duty cycle

**Output Range** **Stick:** 40–350 A  
**DC Lift-Arc TIG:** 10–350 A  
**MIG/Flux-cored:** 10–44 V

**Net Weight** **PipeWorx 350 FieldPro:** 45.4 kg (100 lb.)  
**FieldPro Remote:** 4.5 kg (10 lb.)  
**SuitCase® 8VS X-TREME™ ArcReach™:** 13 kg (28 lb.)  
**SuitCase® 12VS X-TREME™ ArcReach™:** 15.6 kg (34.5 lb.)  
**FieldPro Smart Feeder:** 23 kg (50 lb.)

**Simplicity-driven performance for your construction site.**



PipeWorx 350 FieldPro shown with optional FieldPro Remote, FieldPro Smart Feeder, and SuitCase X-TREME 12VS ArcReach and SuitCase X-TREME 8VS ArcReach feeders.

### Simplified cable management

- Save time by eliminating the need to trace cables back to change welding parameters and processes.
- No control cables to lay out and manage on the jobsite.

### Complete control at the weld joint

- FieldPro remote reduces weld defects by automatically setting correct polarity for each welding process—without the need to manually swap cables.
- Eliminates the need to adapt to less than optimal settings without control cables, and allows for easy setup of a new weld process with the touch of a button.
- Total remote control of welding processes and parameters improves safety by limiting jobsite movement and reducing slip, trip and fall hazards.

### Arc performance optimized for critical pipe welding

- Industry-leading arc performance in a field-ready package.
- True multiprocess system provides conventional stick, DC Lift-Arc TIG, FCAW and MIG welding, as well as RMD and pulsed MIG.
- Smart Feeder delivers excellent RMD and pulse welding up to 61 m (200 ft.) away from the power source with no control cables. RMD and pulse processes also help reduce weld failures and eliminate backing gas on some stainless and chrome-moly applications.

### New durability standard for field construction

- Designed and built to withstand the harshest field environments.



Power source is warranted for three years, parts and labour.



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## Stick and TIG Welding Processes



PipeWorx 350 FieldPro

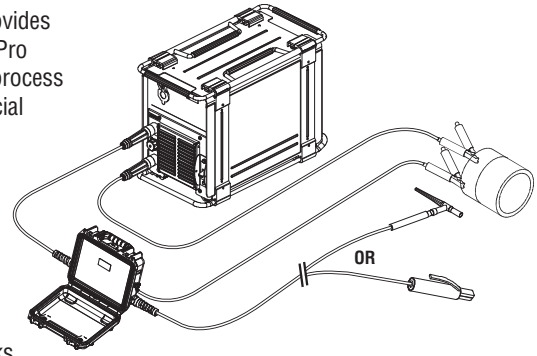


FieldPro Remote

**Complete remote control.** The FieldPro Remote provides all the same functionality of the PipeWorx 350 FieldPro hundreds of feet from the power source, including process changeover, and amperage adjustment with no special cables. Connect the FieldPro Remote in line with the electrode holder or TIG torch with standard welding cables and have *complete remote control*.

**Superior arc performance.** The optimized stick and TIG performance specifically meets the needs of open root pipe welding and helps reduce training time and increases quality. Starts maintain root opening and prepared edge and stops limit arc marks outside of the heat-affected zone.

**Easy to use.** The PipeWorx 350 FieldPro™ is streamlined and simplified to reduce setup time and potential weld defects. Pushbutton process changeover eliminates the need for swapping cables. The robust design will withstand harsh environments common in the field.



Stick/TIG installation diagram

## PipeWorx 350 FieldPro™ Specifications (Subject to change without notice.)



Amperage/Voltage Ranges	Rated Welding Output	IP Rating	RMS Amps Input at Rated Load Output, 60 Hz, at NEMA Load Voltages and Class 1 Rating					KVA	KW	Max. Open-Circuit Voltage	Dimensions (H x W x D)	Net Weight
			230 V	380 V	400 V	460 V	575 V					
10–350 A in CC mode 10–44 V in CV mode	350 A at 34 VDC, 60% duty cycle	IP23	36.1	27.1	25.9	17.8	14.1	15.0	14.4	75 VDC	432 x 305 x 559 mm (17 x 12 x 22 in.)	45.4 kg (100 lb.)

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. All CE models conform to the applicable parts of the IEC 60974 series of standards.

## Solid Wire and Flux-Cored Welding Processes



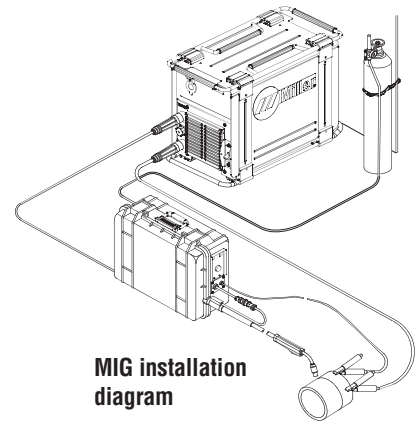
SuitCase X-TREME™  
12VS ArcReach™ and  
SuitCase X-TREME™  
8VS ArcReach™ feeders

**Set volts and wire feed speed remotely.** The simple interface on the feeder allows operators to adjust parameters at the point of use with no control cables.

**Easy process changeover.** Simply connect the SuitCase feeder to your weld lead and you are ready to go. The power source automatically switches settings to run conventional wire processes.

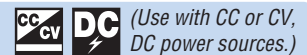
**Easy solution for traditional wire process.** Add the flux-cored capability of the PipeWorx 350 FieldPro™ for fill and cap passes for increased productivity.

**Durable design reduces downtime.** Impact-resistant case and the elimination of feeder control cables provides a solid solution to last in harsh environments.



MIG installation diagram

## SuitCase® Feeder Specifications (Subject to change without notice.)



Model	Input Power	Input Welding Circuit Rating	IP Rating	Wire Speed	Wire Diameter Capacity	Max. Spool Size Capacity	Dimensions (H x W x D)	Net Weight
SuitCase X-TREME 8VS ArcReach	Operates on arc voltage and open-circuit voltage: 14–48 VDC/ 110 max. OCV	330 A at 60% duty cycle	IP23	1.3–19.8 m/min. (50–780 ipm) dependent on arc voltage	<b>Solid wire</b> 0.6–2.0 mm (.023–5/64 in.)	203 mm (8 in.), 6.4 kg (14 lb.)	324 x 184 x 457 mm (12.75 x 7.25 x 18 in.)	13 kg (28 lb.)
SuitCase X-TREME 12VS ArcReach		425 A at 60% duty cycle			<b>Flux-cored</b> 0.8–2.0 mm (.030–5/64 in.)			

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## RMD® and Pulsed MIG Welding Processes



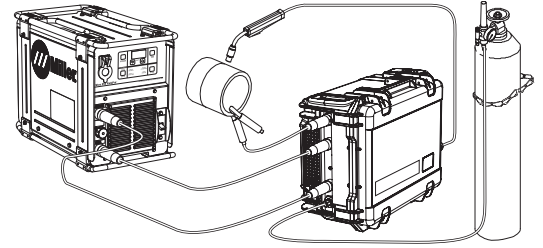
FieldPro Smart Feeder

**Smart Feeder delivers excellent RMD and pulsed MIG welding** up to 61 m (200 ft.) away from the power source with no control cables — twice the distance previously possible. RMD and pulsed MIG processes also help reduce weld failures and eliminate backing gas on some stainless and chrome-moly applications.

**Durable design reduces downtime.** Impact-resistant case and the elimination of feeder control cables provide a solid solution to last in harsh environments.

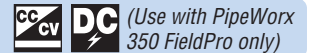
**Synergic processes.** RMD and pulsed MIG welding permits procedures with one wire and one gas to eliminate process switch-over time.

**Easy process changeover.** Simply connect the FieldPro Smart Feeder to your leads and you are ready to go. All controls automatically shift to the FieldPro Smart Feeder.



RMD/pulsed MIG installation diagram

## FieldPro™ Smart Feeder Specifications (Subject to change without notice.)



Input Power	Input Welding Circuit Rating	IP Rating	Wire Speed	Wire Diameter Capacity	Max. Spool Size Capacity	Dimensions (H x W x D)	Net Weight
Operates on arc voltage and open-circuit voltage: 14–110 VDC*	275 A at 60% duty cycle	IP23	1.3–12.7 m/min. (50–500 ipm) dependent on arc voltage	0.9–1.1 mm (.035–.045 in.)	305 mm (12 in.), 15 kg (33 lb.)	457 x 330 x 546 mm (18 x 13 x 21.5 in.)	23 kg (50 lb.)

\*Welding with the FieldPro Smart Feeder requires the PipeWorx 350 FieldPro to be hooked up to three-phase power.

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. All CE models conform to the applicable parts of the IEC 60974 series of standards.

## Bernard™ PipeWorx Guns



PipeWorx guns are capable of root pass welding, and the PipeWorx 300 also does fill and cap pass welding. Both guns are built with the goal of improving your welding productivity and feature the following:

**Versatility.** Can be used for MIG, pulsed MIG and flux-cored.

**Ergonomics.** Compact, lightweight gun with high-amperage capability reduces operator fatigue.

**Visibility.** The combination of tapered tips and nozzles and 60-degree neck provide excellent visibility on root passes in pipe joints.

**Centerfire™ tip.** Provides “drop-in” tip with no threads providing quick changeover. No tools are required.

### Specifications (Subject to change without notice.)

Bernard Model	100% Duty Cycle NEMA	100% Duty Cycle CE	60% Duty Cycle CE	35% Duty Cycle CE	Gas Type	Cable Length	Net Weight
PipeWorx 250-15 (root pass only)	300 A	250 A	300 A	365 A	100% CO <sub>2</sub>	4.6 m (15 ft.)	4.1 kg (9 lb.)
	—	210 A	250 A	300 A	80% argon/20% CO <sub>2</sub>		
PipeWorx 300-15	350 A	320 A	370 A	470 A	CO <sub>2</sub> gas	4.6 m (15 ft.)	4.6 kg (10 lb.)
	—	270 A	310 A	390 A	80% argon/20% CO <sub>2</sub>		

### Key Gun Consumables

Description	Part Number	Package Quantity
0.9 mm (.035 in.) tapered tip	TT-035 <sup>1</sup>	10
1.0 mm (.040 in.) tapered tip	TT-039	10
1.2 mm (.045 in.) tapered tip	TT-045	10
0.9 mm (.035 in.) tip	T-035	10
1.0 mm (.040 in.) tip	T-039	10
1.2 mm (.045 in.) tip	T-045 <sup>2</sup>	10
1.4 mm (.052 in.) tip	T-052	10
1.6 mm (1/16 in.) tip	T-062	10
0.9–1.2 mm (.035–.045 in.) liner	43115 <sup>1,2</sup>	1
1.2–1.6 mm (.045–.062 in.) liner	44215	1






<sup>1</sup>Standard part on PipeWorx 250-15.

<sup>2</sup>Standard part on PipeWorx 300-15.

Description	Part Number	Package Quantity
13 mm (1/2 in.) ID nozzle	NS-1218C	10
16 mm (5/8 in.) ID nozzle	NS-5818C <sup>2</sup>	10
16 mm (5/8 in.) ID nozzle	N-5818C	10
19 mm (3/4 in.) ID nozzle	N-3418C	10
9.5 mm (3/8 in.) ID tapered tip nozzle	NT-3800C	10
9.5 mm (3/8 in.) ID tapered tip nozzle	NST-3800B	10
9.5 mm (3/8 in.) ID extended tapered tip nozzle	NST-38XTB <sup>1</sup>	10
Diffuser	D-1	10
Diffuser	DS-1 <sup>1,2</sup>	10
60° Q tube assembly	QT2-60 <sup>1,2</sup>	1
80° Q tube assembly	QT2-80	1
O-ring	4929	10

## Drive Rolls for FieldPro™ Feeders (Feeders require two drive rolls.)

Select drive rolls from chart below according to type and wire size being used.

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)	 Recommended Wire Inlet Guide
0.6 mm (.023/.025 in.)	087130	—	—	—	221030
0.8 mm (.030 in.)	053695	—	—	—	
0.9 mm (.035 in.)	053700	072000	132958	—	
1.1/1.2 mm (.045 in.)	053697	053701	132957	083489	
1.3/1.4 mm (.052 in.)	053698	053702	132956	083490	
1.6 mm (1/16 in.)	053699	053706	132955	053708	
2.0 mm (5/64 in.)	—	053704	132960	053710	

Note: Part numbers above are for single drive rolls.

## Ordering Information

System Components	Stock No.	Description	Qty.	Price
PipeWorx 350 FieldPro™ Power Source	907633	230–575 V, 50/60 Hz. Dinse-style connectors		
FieldPro™ Remote with Stick/TIG Interface	301176	Dinse-style connectors		
SuitCase® X-TREME™ 8VS ArcReach™	301033	MIG/FCAW feeder		
SuitCase® X-TREME™ 12VS ArcReach™	301032	MIG/FCAW feeder		
FieldPro™ Smart Feeder	301177	MIG/FCAW/RMD/pulse feeder. Dinse-style connectors		
<b>Accessories</b>				
PipeWorx 250-15 MIG Gun	Q2015TF2DEL Q2015TF2DML	Euro connection. See page 3 Miller connection. See page 3		
PipeWorx 300-15 MIG Gun	Q3015TF2DEL Q3015TF2DML	Euro connection. See page 3 Miller connection. See page 3		
MIG Gun Consumables		See page 3		
Feeder Drive Rolls		See above		
PipeWorx Memory Cards	300538 301230 300557 300744 300460 300667 301035 301116	Blank card. Used to store weld programs System software. For free download, visit MillerWelds.com Calibration. Used to calibrate the PipeWorx system. For free download, visit MillerWelds.com (Smart Feeder only) Inconel. Pulsed MIG, 1.2 mm (.045 in.) diameter wire, 100% argon Range locks. Provides ability to set nominal parameter values and ranges for wire feed processes Accu-Power.™ Displays instantaneous power during welding to meet the new ASME requirement for calculating heat input on complex waveform processes (RMD® and pulsed MIG) Trigger select/hold option. Enables trigger select while welding to change processes and parameters without stopping VRD. Voltage reduction device (VRD) lowers open-circuit voltage (OCV) to 15 VDC		
Wireless Remote Hand Control with 14-Pin Receiver	300430	Hand control with wireless 91.4 m (300 ft.) operating range		
Connector, Dinse	134460 136600	70 mmq, male 70 mmq, female		
Kit, Gas Flow Meter	301306			

Date:

Total Quoted Price:

Distributed by:

