

XR™ Plus Guns

MIG Guns for Aluminum Welding 

Gooseneck- and Pistol-Style Push-Pull Guns

Quick Specs

Heavy Industrial Applications

Emergency vehicles
Recreational vehicles
Trucks and trailers
Heat exchangers
Sign manufacturers

Shipbuilding
Tool boxes
Railcars
Fabrication

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P) with pulsing power source

Wire Types

Aluminum
Stainless steel
Cored (gas-shielded)

Rated Output at 100% Duty Cycle

XR-Aluma-Pro Plus (air-cooled): 300 A
XR-Aluma-Pro Plus (water-cooled): 400 A
XR-Pistol Plus (air-cooled): 200 A
XR-Pistol Plus (water-cooled): 400 A

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



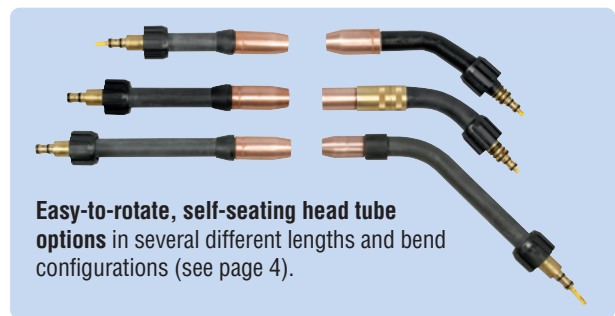
The XR-Aluma-Pro Plus gun is available in air- or water-cooled versions with 15-, 25- or 35-foot (4.6, 7.6 or 10.6 m) cable lengths.



The XR-Aluma-Pro Plus and XR-Pistol Plus guns are designed to be used with the Intelix™ Elite, Continuum™ or 74 MPa Plus feeders as part of a push-pull system.



The XR-Pistol Plus gun is available in air- or water-cooled versions with 15- or 25-foot (4.6 or 7.6 m) cable lengths.



Easy-to-rotate, self-seating head tube options in several different lengths and bend configurations (see page 4).



Guns are warranted for one year, parts and labor.



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XR™ Plus Guns Features



Aluminum-series-specific tension settings ensure smooth wire feeding performance with 4000 or 5000 series aluminum wires.

Fights fatigue. XR Plus guns reduce fatigue, improve output and are rugged to withstand industrial environments.

Balanced design. XR Plus 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 Plus guns have a durable cable covering and strain relief to withstand industrial environments and resist damage, reducing downtime and costs.

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.

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. XR Plus guns feature a cable cover with full-length hook-and-loop closure and integrated strain reliefs 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.

Specifications (Subject to change without notice.)



Model	Welding Current Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Dimensions	Net Weight (Gun only)
XR-Aluma-Pro™ Plus (air-cooled)	300 A at 100% duty cycle	70–780 ipm (1.8–19.8 m/min.)	Aluminum*: .030–1/16 in. (0.8–1.6 mm)	H: 5 in. (127 mm) W: 2.5 in. (64 mm) D: 17 in. (432 mm)	2.5 lb. (1.1 kg)
XR-Aluma-Pro™ Plus (water-cooled)	400 A at 100% duty cycle				2.9 lb. (1.3 kg)
XR-Pistol Plus (air-cooled)	200 A at 100% duty cycle	70–780 ipm (1.8–19.8 m/min.)	Aluminum*: .030–1/16 in. (0.8–1.6 mm)	H: 7.375 in. (187 mm) W: 1.875 in. (48 mm) D: 10.625 in. (270 mm)	2.2 lb. (1 kg)
XR-Pistol Plus (water-cooled)	400 A at 100% duty cycle				2.4 lb. (1.1 kg)

*Wire kit **230708** required to run 1/16-inch (1.6 mm) wire.

Standard Consumables

Aluminum Wire Size	Drive Rolls	Idler Rolls	Inlet Guides	Liner for Short Air-Cooled Head Tube 4 in. (102 mm)	Liner for Long Air- or Water-Cooled Head Tube 6 in. (152 mm)
.030 in. (0.8 mm)	227434	227439	227408	227161	229674
.035 in. (0.9 mm)	227434	227439	227408	227161	229674
.040 in. (1.0 mm)	227434	227439	227408	227161	229674
3/64 in. (1.2 mm)	227434	227439	227408	230239	229431
1/16 in. (1.6 mm)	227434	230710	230711	230239	229431

Cable Liners
229887 15 ft. (4.6 m)
229891 25 ft. (7.6 m)
232321 35 ft. (10.6 m)

Insulator 10012
4323R

Diffuser D-1AP (large)
DS-1AP (small)

Aluminum-Specific T Series Contact Tips

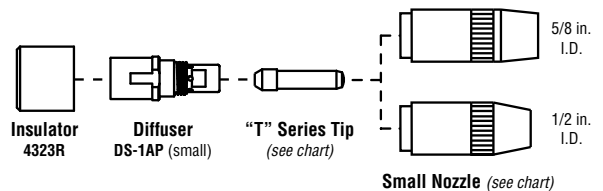
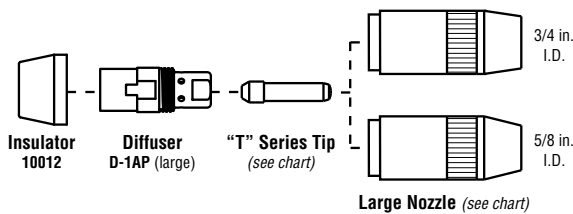
T-035AL .035 in. (0.9 mm)
T-047AL .047 in. (1.2 mm)
T-062AL 1/16 in. (1.6 mm)

Large Nozzles

N-3414C Copper, 3/4 in. I.D., 1/4 in. tip recess
N-3418B Brass, 3/4 in. I.D., 1/8 in. tip recess
N-3414B 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., 1/8 in. tip recess
N-5814B Brass, 5/8 in. I.D., 1/4 in. tip recess

Small Nozzles

NS-5818B Brass, 5/8 in. I.D., 1/8 in. tip recess
NS-1218B Brass, 1/2 in. I.D., 1/8 in. tip recess
NS-1200B Brass, 1/2 in. I.D., flush tip
NST-3818B Brass, 3/8 in. I.D., 1/8 in. tip recess



Optional Head Tube Assemblies



45 Degree/4 Inch
255037 Air-cooled
255338 Water-cooled



180 Degree/4 Inch
 (standard on XR™-Pistol Pro)
255716 Air-cooled
255717 Water-cooled



45 Degree/6 Inch with Centerfire™
246205 Water-cooled
 (standard on XR-Aluma-Pro™ Plus)



45 Degree/6 Inch
255040 Air-cooled
231517 Water-cooled
 (standard on XR-Aluma-Pro™)



180 Degree/6 Inch
258476 Air-cooled
258477 Water-cooled

60 Degree/6 Inch with Centerfire™
246301 Air-cooled



60 Degree/4 Inch
231519 Air-cooled
 (standard on XR-Aluma-Pro™)
255038 Water-cooled



180 Degree/8 Inch
255042 Air-cooled
255043 Water-cooled



180 Degree/4 Inch with Centerfire™
 (standard on XR™-Pistol Plus)
258474 Air-cooled
258475 Water-cooled



60 Degree/6 Inch
231518 Air-cooled
255 041 Water-cooled



45 Degree/10 Inch Tight Access
258295 Air-cooled
 For hard-to-reach welds where a smaller nozzle and longer reach is needed.

Heavy-Duty Head Tube Assemblies

For high-duty-cycle applications.



45 Degree/6 Inch Heavy-Duty
262206 Air-cooled
258293 Water-cooled

60 Degree/6 Inch Heavy-Duty
262207 Air-cooled
258294 Water-cooled



Flex Neck/10 Inch
267517 Air-cooled
 Ideal for hard-to-reach welds.



180 Degree/6 Inch Heavy-Duty
262208 Air-cooled
259535 Water-cooled

Liners for Optional Head Tube Assemblies

Replacement 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)

Replacement 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)

Replacement 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)

Replacement 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)
 black liners
262705 3/64 and 1/16 in. (1.2 and 1.6 mm)
 yellow liners

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



Deltaweld® 350 MIGRunner™ Aluminum Packages (Air-Cooled)

951952001 with single-wire IntelliX™ Elite feeder

951953001 with dual-wire IntelliX™ Elite feeder

Includes Deltaweld 350 power source, IntelliX Elite feeder with 25 ft. (7.6 m) XR-Aluma-Pro Plus gun, Deltaweld running gear, and cart accessory kit. Dual-wire package adds 15 ft. (4.6 m) Bernard® BTB Gun 400 A. See literature DC/16.5.

Continuum™ MIGRunner™ Push-Pull Packages (Air-Cooled)

951865001 with Continuum 350 power source

951866001 with Continuum 500 power source

Includes Continuum power source, Continuum dual-wire feeder with 25 ft. (7.6 m) XR-Aluma-Pro Plus gun and 15 ft. (4.6 m) Bernard® BTB Gun 400 A, Continuum running gear/cylinder rack, control/motor cable, and industrial MIG 4/0 kit. See literature DC/36.0.



74 MPa Plus Wire Feeders

XR Plus guns (gooseneck and pistol grip) are designed to work with MPa Plus feeders to coordinate wire feed speed of the gun and the feeder. This provides optimized aluminum feeding and welding performance. Feeders are for heavy-duty industrial applications with features for weld control and programs. Optimized with AlumaPower™ MPa or XMT® MPa power sources. See literature M/3.0.

Ordering Information

XR-Aluma-Pro Plus and XR-Pistol Plus guns require the following:

- **Intellix™ Elite feeder with Deltaweld® 350 or 500 power source**
OR
- **Continuum™ feeder with Continuum™ 350 or 500 power source**
OR
- **74 MPa Plus feeder with AlumaPower™ MPa or XMT® Series power source**
(except XMT polarity reversing models)

Important notes:

XR-Aluma-Pro Plus and XR-Pistol Plus guns are not compatible with XR™-Control boxes or XR-AlumaFeed® feeders.

Equipment	Stock No.	Description	Qty.	Price
XR-Aluma-Pro™ Plus Gun (Air-Cooled)	301575	15 ft. (4.6 m) cable		
	301574	25 ft. (7.6 m) cable		
	301739	35 ft. (10.6 m) cable		
XR-Aluma-Pro™ Plus Gun (Water-Cooled)	301576	15 ft. (4.6 m) cable		
	301577	25 ft. (7.6 m) cable		
	301740	35 ft. (10.6 m) cable		
XR™-Pistol Plus Gun (Air-Cooled)	300753	15 ft. (4.6 m) cable		
	300754	25 ft. (7.6 m) cable		
XR™-Pistol Plus Gun (Water-Cooled)	300757	25 ft. (7.6 m) cable		
Deltaweld® 350 MIGRunner™ Aluminum Packages (Air-Cooled) (See literature DC/16.5)	951952001	Includes single-wire Intellix™ Elite feeder with 25 ft. (7.6 m) XR-Aluma-Pro Plus gun, Deltaweld running gear, and cart accessory kit		
	951953001	Same as above, but with dual-wire Intellix™ Elite feeder with 25 ft. (7.6 m) XR-Aluma-Pro Plus gun and 15 ft. (4.6 m) Bernard® BTB Gun 400 A		
Continuum™ 350 MIGRunner™ Push-Pull Package (Air-Cooled) (See literature DC/36.0)	951865001	Includes Continuum dual-wire feeder with 25 ft. (7.6 m) XR-Aluma-Pro Plus gun and 15 ft. (4.6 m) Bernard® BTB Gun 400 A, Continuum running gear/cylinder rack, control/motor cable, and industrial MIG 4/0 kit		
Continuum™ 500 MIGRunner™ Push-Pull Package (Air-Cooled) (See literature DC/36.0)	951866001	Same as above, but with Continuum 500 power source		
74 MPa Plus® Feeder (See literature M/3.0)		Single- and dual-wire models available — optimized for MPa power sources with push-pull capability		
Consumables and Accessories				
Consumables		See page 3		
Optional Head Tube Assemblies		See page 4		
Liners for Optional Head Tube Assemblies		See page 5		
Cable Cover	M1681	15 ft. (4.6 m)		
	M1682	25 ft. (7.6 m)		
	M1683	35 ft. (10.6 m)		
50-Degree Curved Nozzle Kit-A	264064			
Replacement Contact Tips for Curved Nozzle		See page 5		
50-Degree Curved Nozzle Insulator Kit	264066	For use with 50-Degree Curved Nozzle Kit-A		
1/16-Inch (1.6 mm) Wire Kit	230708	Required when running 1/16-inch wire		
Hardwire Liner Kit for Steel and Stainless	198377			
Phosphorous Bronze Liners		See page 5		
Coolant Systems		See literature AY/7.2		

Date:

Total Quoted Price:

Distributed by:

