

Gooseneck-Style Guns

XR-Aluma-Pro™ Lite Gun

Issued March 2013 • Index No. M/1.75

MIG Gun for
Push-Pull System 

Quick Specs

Light Industrial Applications

Emergency Vehicles
Recreational Boats and Vehicles
Utility Trailers
Sign Manufacturers
Tool Boxes
Fabrication

Processes

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

Wire Types

Aluminum
Stainless Steel
Cored (Gas-shielded)

Weight (Torch only)

2.0 lb. (0.9 kg)

The Power of Blue.®

The 175-amp XR-Aluma-Pro Lite is a **compact, lightweight, air-cooled push-pull gun** with a 25-foot (7.6 m) cable. It allows operators to easily access hard-to-reach welds, reducing hand and welder fatigue.

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



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.

Trigger mounted at the back of the gun allows operator to easily access hard-to-reach weldments.

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.

New!



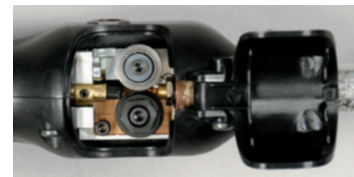
TRUE BLUE
WARRANTY

Guns are warranted for 1 year, parts and labor.



The XR-Aluma-Pro™ Lite is designed to be used with the XR™-S/D Control, XR-AlumaFeed™, or Millermatic® 252/350P/350P Aluminum as part of a push-pull system.

Integrated with standard Bernard® rotatable head tube to allow better access into tight spots. Numerous optional Bernard head tubes are available in many sizes and lengths, for custom applications and to improve operator comfort. Optional head tubes require optional long head tube liners. Order optional head tube liners from the Standard Replacement Consumables section (see page 3).



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.

Centerfire™ consumables provide superior gas coverage and arc performance. **Also compatible with Miller Roughneck®, FasTip™ consumables.** Order gas diffuser, contact tip and nozzle from Optional FasTip Consumables section (see page 2).



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Specifications (Subject to change without notice.)

Welding Output Rating	Electrode Wire Diameter Capacity	Wire Speed	Dimensions	Net Weight (Torch only)
175 A at 60% Duty Cycle with 25-ft. (7.6 m) air-cooled gun	.030–.047 in.* (0.8–1.2 mm) aluminum wire	70–900 IPM (1.8–23 m/min.) dependent on feeder used	H: 4 in. (102 mm) W: 1.9 in. (48 mm) L: 15 in. (381 mm)	2.0 lb. (0.9 kg)

*Note: .047-inch wire and consumables are also referenced as 3/64-inch.

Standard Centerfire™ Series Consumables (Order from Miller Service Parts.)

Aluminum-Specific T Series Contact Tips

T-035AL* .035 in. (0.9 mm)

T-047AL* .047 in. (1.2 mm)

T Series Contact Tips for Hard or Cored Wires

1.5 in. (38.1 mm)

T-030 .030 in. (0.8 mm)

T-035 .035 in. (0.9 mm)

T-039 .039 in. (1.0 mm)

T-045 .045 in. (1.2 mm)

TT Series Contact Tips for Hard or Cored Wires

2 in. (50.8 mm)

TT-030 .030 in. (0.8 mm)

TT-035 .035 in. (0.9 mm)

TT-045 .045 in. (1.2 mm)

Diffuser DS-1AP* (small)

D-1AP (large)

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-1218C* Copper, 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

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

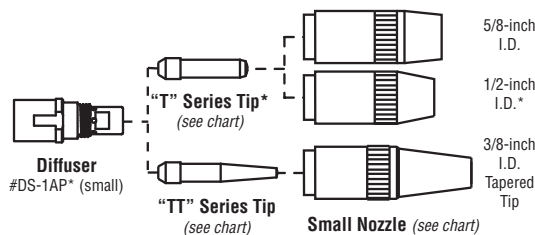
N-3414B Brass, 3/4-in. I.D., 1/4-in. tip recess

N-5814C Copper, 5/8-in. I.D., 1/4-in. tip recess

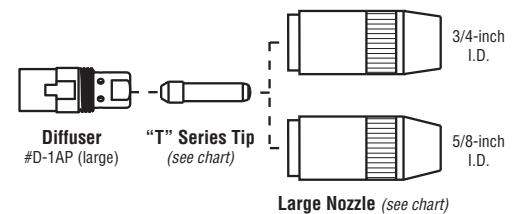
N-5818B Brass, 5/8-in. I.D., 1/8-in. tip recess

N-5814B Brass, 5/8-in. I.D., 1/4-in. tip recess

*Comes standard with XR-Aluma-Pro Lite gun.



Standard Small Nozzle Configuration



Optional Large Nozzle Configuration

Optional FasTip™ Consumables* (Order from Miller Service Parts.)

Nozzles

Screw-On Brass

#199 610 1/2-in. orifice, tapered

#199 611 3/4-in. orifice, straight

#199 612 3/4-in. orifice, straight HD

#199 613 5/8-in. orifice, tapered

#199 614 5/8-in. orifice, tapered HD

Screw-On Copper

#199 615 1/2-in. orifice, tapered

#199 616 3/4-in. orifice, straight

#199 617 3/4-in. orifice, straight HD

#198 855 5/8-in. orifice, tapered

#199 618 5/8-in. orifice, tapered HD

#207 313 5/8-in. orifice, tapered 15/16 OD

#209 035 3/8-in. orifice, tapered

#209 036 1/2-in. orifice, tapered

FasTip™ Contact Tips (25 per package)



Heavy-Duty (Aluminum Wire)

#206 186 .030 in. (0.8 mm)

#206 187 .035 in. (0.9 mm)

#206 188 .040 in. (1.0 mm)

#206 189 3/64 in. (1.2 mm)

#206 191 1/16 in. (1.6 mm)

Tapered (Aluminum Wire)

#209 026 .030 in. (0.8 mm)

#209 027 .035 in. (0.9 mm)

#209 029 3/64 in. (1.2 mm)

#209 030 1/16 in. (1.6 mm)

Gas Diffusers (Aluma-Pro specific)



#206 195 Standard

1/8-inch tip recess for heavy-duty FasTip™ contact tips.

#210 664

1/4-inch tip recess for heavy-duty FasTip™ contact tips.

#206 196

Flush tip for heavy-duty FasTip™ contact tips.

*The use of FasTip consumables requires the use of long head tube liners. Order long head tube liners from the standard replacement consumables section (see page 3).

Standard Replacement Consumables (Order from Miller Service Parts.)

Aluminum Wire Size	Drive Rolls	Idler Rolls	Inlet Guides	Head Tube Liner: For use with Standard Head Tube and Centerfire Consumables (5 pk)	Long Head Tube Liner: For use with Optional Head Tube or Fastip Consumables (5 pk)*	Cable Liner: 25 ft. (7.6 m)
.030 in. (0.8 mm)	#254 756	#227 439	#227 408	#258 541	#258 726	M-1440
.035 in. (0.9 mm)	#254 756	#227 439	#227 408	#258 541	#258 726	M-1440
.040 in. (1.0 mm)	#254 756	#227 439	#227 408	#258 542	#258 727	M-1440
3/64 in. (1.2 mm)	#254 756	#227 439	#227 408	#258 542	#258 727	M-1440

*Long head tube liners must be cut to fit.

Replacement and Optional Head Tubes

Replacement Head Tube #254 477

Standard replacement head tube assembly for an XR-Aluma-Pro Lite gun.

Optional Head Tubes

Numerous optional Bernard® head tubes are available in many sizes and lengths, for custom applications and to improve operator comfort. For more information on optional head tubes, visit the following links:

bernardwelds.com/files/SpSh_Necks.pdf

bernardwelds.com/files/SpSh_FlexNeck.pdf

Note: The use of optional head tubes requires the use of long head tube liners. Order long head tube liners from the standard replacement consumables section above. Long head tube liners are 14 inches long and must be cut to fit.

To locate the nearest Bernard distributor, visit:

bernardwelds.com/locator/locator_search.php

Genuine Miller® Accessories

Leather Cable Cover

#234 110 25 ft. (7.6 m)

Protects gun hose and cable assembly from wear and abrasion. Features a full length velcro seam.

Short Leather Gun Cover #234 416

Optional cover is 17 inches (432 mm).

Machines and Wire Feeders



**Millermatic® 350P Aluminum/
XR-Aluma-Pro™ Lite System**
#951 454 200(208)/230/460 V
Includes Millermatic 350P Aluminum,
25-foot XR-Aluma-Pro Lite push-pull
gun, .035- and 3/64-inch Centerfire™
contact tips, and .035-, .040- and
3/64-inch U-groove drive rolls.



Millermatic® 252
#907 321 200(208)/230 V
#907 322 230/460/575 V
Standard all-in-one power supply
features superior aluminum MIG
welding with direct connection of
optional push/pull and spool guns.



Millermatic® 350P
#907 300 200(208)/230/460 V
Standard all-in-one power supply
features superior aluminum MIG
welding with direct connection of
optional push/pull and spool guns.
Also features built-in Pulsed MIG
programs and four-drive-roll system.



XR™-S Control #300 601
XR™-D Control #300 687
The updated XR Controls offer
unsurpassed performance and
reliability for feeding aluminum and
other difficult-to-feed wire types.
Models include .035-inch and
factory-installed 3/64-inch drive rolls.
See Lit. Index No. M/1.7.



XR-AlumaFeed™ Wire Feeder
#300 509
Advanced push-pull wire feeder
designed for high-volume, high-
production aluminum MIG welding
where quality and consistency is a
high priority. See Lit. Index No. DC/34.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
XR-Aluma-Pro™ Lite	#300 948	175-amp, air-cooled push-pull gun with 25-ft. (7.6 m) cable		
Machines and Wire Feeders				
Millermatic® 350P Aluminum/ XR-Aluma-Pro Lite System (See Lit. Index No. DC/12.56)	#951 454	200(208)/230/460 V. True torque motor push-pull system. <i>Note: The Millermatic® 350P Aluminum is compatible only with push-pull guns — not standard MIG guns</i>		
Millermatic® 350P (See Lit. Index No. DC/12.51)	#907 300	200(208)/230/460 V. Standard power supply with constant-speed motor		
Millermatic® 252 (See Lit. Index No. DC/12.49)	#907 321 #907 322	200(208)/230 V. Standard power supply with constant-speed motor 230/460/575 V. Standard power supply with constant-speed motor		
XR™-S Control (See Lit. Index No. M/1.7)	#300 601	Standard model includes .035- and 3/64-in. drive rolls, wire feed speed digital display, jog/purge, run-in control, and trigger hold		
XR™-D Control (See Lit. Index No. M/1.7)	#300 687	Enhanced model includes .035- and 3/64-in. drive rolls, has same features as XR-S, plus advanced digital and programming capabilities		
XR-AlumaFeed™ (See Lit. Index No. DC/34)	#300 509	Advanced model includes .035- and 3/64-in. drive rolls, and adds Profile Pulse™, synergic control, trigger schedule select, lock capabilities and flowmeter		
Accessories				
Leather Cable Cover	#234 110	25 ft. (7.6 m)		
Short Leather Gun Cover	#234 416	17 in. (432 mm)		

Date:

Total Quoted Price:



Distributed by: **Kristian Electric Ltd.**

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