

# AlumaFeed™ Synergic Aluminum Welding System

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**MIG Arc Welding Power Source** 

## Quick Specs

### Industrial Applications

Boat, Ship and Yacht Building  
Recreational Vehicles  
Trucks and Trailer  
Sign Manufacturers  
Emergency Vehicles

### Processes

MIG (GMAW)  
Pulsed MIG (GMAW-P)  
Synergic Pulsed MIG

### XR-AlumaFeed

**Input Power** 24 VAC, 50/60 Hz  
**Wire Feed Speed** 70–780 IPM (1.8–20 m/min)  
**Weight** 42-1/2 lb (19.2 kg)  
**Dimensions** H: 16 in (406 mm)  
W: 9-1/2 in (241 mm)  
D: 21-1/4 in (540 mm)

### AlumaPower 350 MPa

**Input Power** 3- or 1-Phase Power, 50/60 Hz  
**Rated Output** 10–38 V, 5–425 A  
**Weight** 80 lb (36.3 kg)  
**Dimensions** H: 17 in (432 mm)  
W: 12-1/2 in (318 mm)  
D: 24 in (610 mm)

## The Power of Blue.®

The XR-AlumaFeed™ and AlumaPower™ 350 MPa combine for a synergic system that simplifies and improves MIG and Pulsed MIG welding applications for aluminum welding.

### Ultra portable and versatile.

The slim ergonomic design of the XR-Aluma-Pro torch allows access into the tightest of quarters. Coupled with the XR-AlumaFeed feeder and the AlumaPower 350 MPa synergic power supply it has the features for all of your aluminum fabrication needs.

**Synergic pulsed welding** mode offers the simplicity of single knob control. The machine will select the correct pulse power based on the wire feed speed (WFS) set by the operator.

**Profile Pulse™** — Achieve “stacked dime” weld bead appearance without back-stepping. See page 2 for more information.

**Parameter and system lock** provides three levels of protection to prevent accidental modification of welding parameters or manipulation of setup menu items.

**New!**



AlumaFeed Synergic Aluminum Welding System with XR-Aluma-Pro gun shown.

### Comes Complete With:

- XR-AlumaFeed™ push-pull wire feeder
- AlumaPower™ 350 MPa power source
- XR-Aluma-Pro™ **OR** XR™-Pistol Grip push-pull welding gun
- .035 and 3/64 in (0.9 and 1.2 mm) contact tips, drive roll and liners for guns
- .035 and 3/64 in (0.9 and 1.2 mm) drive rolls for wire feeder, 3/64 in installed

*Note: All AlumaFeed systems come set up out of the box to run 3/64 in (1.2 mm) 5356 wire.*

*Order weld cables and other accessories separately.*

**True push-pull wire feed system.** Slave/torque motor ensures smooth, consistent feeding and improved arc performance, while reducing the problems normally associated with feeding aluminum.



AlumaFeed Synergic Aluminum Welding System also available with XR-Pistol Grip gun.

**TRUE BLUE®**  
3YR. WARRANTY

Welder/generator is warranted for 3 years, parts and labor.  
Original main power rectified parts are warranted for 5 years.  
Gun warranted for 1 year, parts and labor.

MADE IN **USA**  
APPLETON, WI **USA**



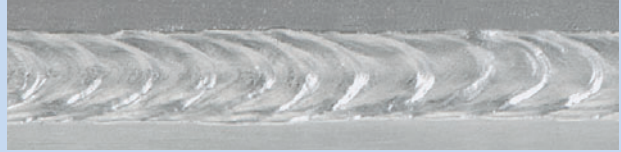
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**Web Site**  
www.MillerWelds.com

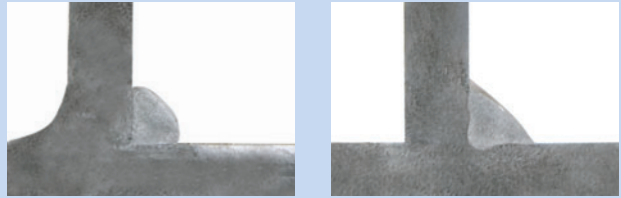


# AlumaFeed™ Synergic Aluminum Welding System Features



**Profile Pulse™** — Achieve “stacked dime” weld bead appearance without back-stepping. Profile Pulse frequency can be changed to increase or decrease the spacing between the ripple pattern to achieve the desired weld appearance.

## Weld Cross Section



Hot Start Off

Hot Start On

Begin and end welds with ease and confidence. **Hot Start™** eliminates incomplete fusion at the beginning of a weld, a common issue with aluminum welding. **Crater** gradually decreases weld current at the end of a weld to eliminate crater defects. Adjustable pre- and post-flow rates ensure that the puddle always has adequate gas coverage.



**Flowmeter** — Standard integrated flowmeter helps to regulate and maintain proper gas flow rate. Helpful when feeder is located long distances from gas supply. Helps ensure weld quality.



**Gun Bushing** — Improved gun connection uses a bushing that captures the power end of gun to ensure correct alignment to drive rolls and provides exceptional ruggedness and durability.



**Drive Assembly** — Improved drive assembly with numeric scale for different wire sizes prevents wire slippage and deformation. Helps improve wire feeding by making sure the proper drive roll tension is used. Comes factory-installed with 3/64 in drive rolls.



**Synergic “One-Knob” Control** — Set the wire feed speed control on the gun and the system handles the rest, greatly simplifying set-up and reducing training time. No need to travel back to the power source to change multiple parameters.

# XR-AlumaFeed™ Wire Feeder

**Gun calibration** allows control box to sync with the welding gun for precise wire feed control that is critical for reducing weld defects and providing flawless synergic operation.

**Advanced trigger** provides “trigger interlock” capability and the ability to control the amount of time spent in the arc start and arc crater steps.

**Bright digital displays** are easy to read and display voltage or arc length and wire feed speed or amperage. Also have indicators for start and crater, setup, schedule select and advanced trigger operations. Two-knob, three-button panel layout makes it simple to change parameters and reduces training time.



**Trigger schedule select (SCHD)** allows the operator to select the alternative schedule by quickly tapping the gun trigger when not welding. Useful when switching between two welding parameters is needed.

**Setup guide** on inner panel of feeder has quick tips to get your system up and running quickly. Also provides a good reference that won't get misplaced like an owner's manual.

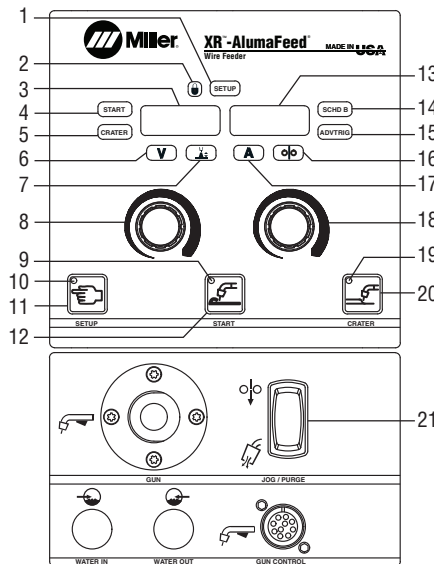
**Rugged steel case** holds up in the harshest environments and protects wire from dirt and moisture. Also has a large carrying handle for improved durability.

## XR-AlumaFeed Specifications (Subject to change without notice.)



| Input Power           | Input Welding Circuit Rating   | Wire Speed                     | Wire Diameter Range   | Maximum Spool Size Capacity | Dimensions   | Net Weight           |
|-----------------------|--|--------------------------------|---|-----------------------------|--|----------------------|
| 24 VAC, 5 A, 50/60 Hz | 400 A at 100% Duty Cycle<br><i>(System duty cycle is limited to gun rating.)</i> | 70–780 IPM<br>(1.8–22.2 m/min) | <b>Aluminum:</b> .035–.062 in (0.9–1.6 mm)<br><b>Solid Wire:</b> .035–.045 in (0.9–1.2 mm)<br>Drive roll kit #195 591 required to run 1/16 in (1.6 mm) wire | 12 in (305 mm)              | H: 16 in (406 mm)<br>W: 9-1/2 in (241 mm)<br>D: 21-1/4 in (540 mm) | 42.5 lb<br>(19.2 kg) |

## XR-AlumaFeed Control Panel



- 1. Setup Menu Indicator
- 2. Lock Indicator
- 3. Left Display
- 4. Start Menu Indicator
- 5. Crater Menu Indicator
- 6. Volts Indicator
- 7. Arc Length Indicator
- 8. Left Adjust Knob
- 9. Start On Indicator
- 10. Setup Indicator
- 11. Setup Button
- 12. Start Button
- 13. Right Display
- 14. Schedule B Indicator
- 15. Advanced Trigger Indicator
- 16. Wire Speed Indicator
- 17. Amps Indicator
- 18. Right Adjust Knob
- 19. Crater On Indicator
- 20. Crater Button
- 21. Jog/Purge Switch

## Power Source Compatibility for XR-AlumaFeed Wire Feeders

| Power Source                | Pulse Capable       | Synergic Pulsed MIG | Profile Pulse Capability | Electronic Inductance/SharpArc | Compatibility |
|-----------------------------|---------------------|---------------------|--------------------------|--------------------------------|---------------|
| AlumaPower™ 350 MPa         | Yes (Aluminum only) | Yes (Aluminum only) | Yes                      | Yes                            | Optimized     |
| Invision™ 352 MPa           | Yes                 | Yes                 | Yes                      | Yes                            | Best          |
| XMT® 350 MPa                | Yes                 | Yes                 | Yes                      | Yes                            | Best          |
| XMT® 350 CC/CV              | Yes (with Optima)   | No                  | No                       | Yes                            | Better        |
| XMT® 304 CC/CV              | Yes (with Optima)   | No                  | No                       | Yes                            | Better        |
| Invision™ 456P              | Yes (with Optima)   | No                  | No                       | Yes                            | Better        |
| Invision™ 456MP             | Yes                 | No                  | No                       | Yes                            | Better        |
| Invision™ 354P              | Yes (with Optima)   | No                  | No                       | Yes                            | Better        |
| Invision™ 354MP             | Yes                 | No                  | No                       | Yes                            | Better        |
| Deltaweld® (after KF790532) | No                  | No                  | No                       | No                             | Good          |

Note: Power sources not included in this list are not recommended. For specific information, please contact your local Miller distributor.



# XR-Aluma-Pro™ Specifications (Subject to change without notice.)

| Model                             | Welding Output Range with 100% Argon and Peak Amperages                  | Electrode Wire Diameter Capacity   | Wire Speed   | Dimensions   | Net Weight (Torch only) |
|-----------------------------------|--|--|--|--|-------------------------|
| XR-Aluma-Pro A Gun (Air-Cooled)   | 300 A at 100% Duty Cycle with 15, 25, or 35 ft (4.6, 7.6, or 10.6 m) gun | .030–1/16 in (0.8–1.6 mm) aluminum wire<br>Wire kit #230 708 required to run 1/16 in (1.6 mm) wire | 70–900 IPM (1.8–23 m/min)<br>(Dependent on feeder used.) | H: 5 in (127 mm)<br>W: 2-1/2 in (64 mm)<br>D: 17 in (432 mm) | 2.5 lb (1.1 kg)         |
| XR-Aluma-Pro W Gun (Water-Cooled) | 400 A at 100% Duty Cycle with 15, 25, or 35 ft (4.6, 7.6, or 10.6 m) gun | .030–1/16 in (0.8–1.6 mm) aluminum wire<br>Wire kit #230 708 required to run 1/16 in (1.6 mm) wire | 70–900 IPM (1.8–23 m/min)                                | H: 5 in (127 mm)<br>W: 2-1/2 in (64 mm)<br>D: 17 in (432 mm) | 2.9 lb (1.3 kg)         |

A=Air-Cooled W=Water-Cooled



Certified to both the Canadian and U.S. Standards for welding equipment.

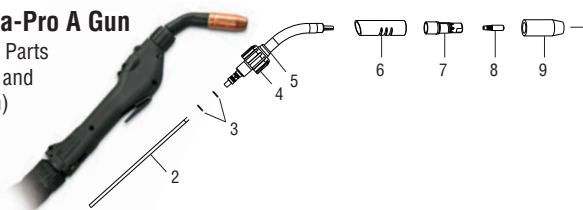


Conforms to European standards.

## XR-Aluma-Pro Parts Breakdown

### XR-Aluma-Pro A Gun

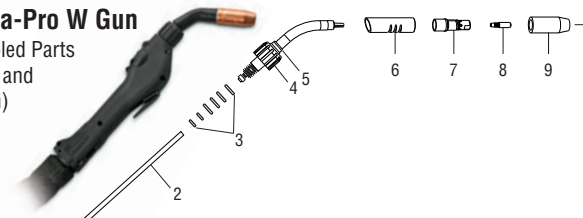
(Air-Cooled Parts Breakdown and Gun Shown)



- |  |           |           |
|--|-----------|-----------|
| 1. Air-Cooled Assembly                   |           |           |
| Short Head Tube, 4 in                    | #231 519  |           |
| Long Head Tube, 6 in                     | #231 518* |           |
| 2. Head Tube Liner (See chart below)     |           |           |
| 3. Head Tube O-Rings                     | #230 969  |           |
| 4. Lock Nut                              | #227 168  |           |
| 5. Insulator Ring Rear                   | #227 416  |           |
| 6. Outer Insulating Jacket               |           |           |
| Short                                    | #227 159  |           |
| Long                                     | #229 673  |           |
| 7. Gas Diffuser                          | #229 670  |           |
| 8. FasTip™ Contact Tip (See chart below) |           |           |
| 9. Nozzle                                | #198 855  |           |
|  |           | *Optional |

### XR-Aluma-Pro W Gun

(Water-Cooled Parts Breakdown and Gun Shown)



- |  |          |  |
|--|----------|--|
| 1. Water-Cooled Assembly                 |          |  |
| Long Barrel, 6 in                        | #231 517 |  |
| 2. Head Tube Liner (See chart below)     |          |  |
| 3. Head Tube O-Rings                     | #230 970 |  |
| 4. Lock Nut                              | #229 889 |  |
| 5. Insulator Ring Rear                   | #227 416 |  |
| 6. Outer Insulating Jacket               | #230 420 |  |
| 7. Gas Diffuser                          | #229 670 |  |
| 8. FasTip™ Contact Tip (See chart below) |          |  |
| 9. Nozzle                                | #199 618 |  |

**Important: A wider selection of Miller and Centerfire™ Series consumables are available — see Gooseneck-Style Guns spec sheet (Lit. Index No. M/1.71).**

## XR-Aluma-Pro Standard Consumables (Order from Miller Service Parts.)

| Aluminum Wire Size | FasTip Contact Tip (Qty. 25) | Drive Rolls | Idler Rolls | Inlet Guides | Air-Cooled Head Tube Liner Short Barrel 4 in (102 mm) | Air- and Water-Cooled Head Tube Liner Long Barrel 6 in (152 mm) | Cable Liners            |
|--------------------|------------------------------|-------------|-------------|--------------|---|---|-------------------------|
| .030 in (0.8 mm)   | #206 186 .041 in ID          | #227 434    | #230 439    | #227 408     | #227 161  | #229 674  | #229 887 15 ft (4.6 m)  |
| .035 in (0.9 mm)   | #206 187 .047 in ID          | #227 434    | #230 439    | #227 408     | #227 161  | #229 674  | #229 891 25 ft (7.6 m)  |
| .040 in (1.0 mm)   | #206 188 .053 in ID          | #227 434    | #230 439    | #227 408     | #227 161  | #229 674  | #232 321 35 ft (10.6 m) |
| 3/64 in (1.2 mm)   | #206 189 .061 in ID          | #227 434    | #230 439    | #227 408     | #230 239  | #229 431  |                         |
| 1/16 in (1.6 mm)   | #206 191 .071 in ID          | #227 434    | #230 710    | #230 711     | #230 239  | #229 431  |                         |

## XR-Aluma-Pro Genuine Miller Accessories

### Replacement Leather Cable Cover

#234 109 15 ft (4.6 m)

#234 110 25 ft (7.6 m)

#234 111 35 ft (10.6 m)

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

### Replacement Short Leather Gun Cover

#234 416

Cover is 17 in (432 mm).

### 1/16 Inch (1.6 mm) Wire Kit #230 708

Specially designed for 1/16 in wire. Includes idler roll, head tube liner and inlet guide.

Required when running 1/16 in wires. (Not included with standard Aluma-Pro Gun.)

### Short Head Tube Assembly #231 519

4-inch (102 mm) barrel includes liner.

(standard barrel)

### Long Air-Cooled Head Tube Assembly #231 518

6-inch (152 mm) barrel includes liner.

(optional barrel)

### Phosphorous Bronze Liner (Optional)

#233 999 Long Head Tube (air or water)

#233 998 Short Head Tube (air only)

### Hardwire Liner Kit for Steel and Stainless

#198 377 For 15, 25, or 35 ft guns

(4.6, 7.6 or 10.6 m)

Kit consists of gun head tube liner and feed cable liner. Recommend using .030–.045 in mild steel, or stainless steel electrode wire.

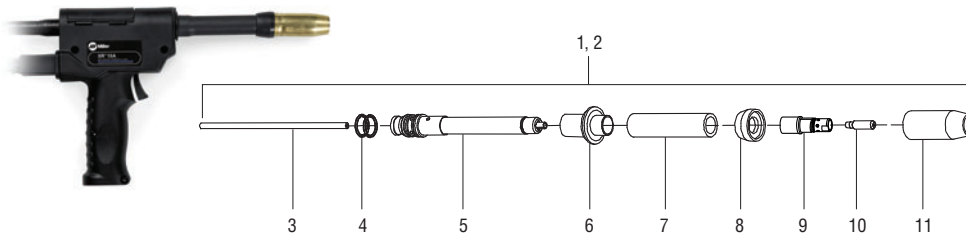
.052 and 1/16 in wires not recommended.

## XR™-Pistol Grip Specifications (Subject to change without notice.)

| Model           | Welding Output Rating                               | Electrode Wire Diameter Capacity           | Wire Speed                     | Dimensions   | Net Weight with Cable Assembly                               |
|-----------------|---|--|--------------------------------|--|--|
| XR-A Pistol Gun | 200 A at 100% Duty Cycle<br>250 A at 60% Duty Cycle | .030–.062 in (0.8–1.6 mm)<br>aluminum wire | 70–875 IPM<br>(1.8–22.2 m/min) | H: 7-3/8 in (187 mm)<br>W: 1-7/8 in (48 mm)<br>D: 10-5/8 in (270 mm) | 15 ft Cable: 13 lb (5.9 kg)<br>30 ft Cable: 21 lb (9.5 kg)   |
| XR-W Pistol Gun | 400 A at 100% Duty Cycle                            | .030–.062 in (0.8–1.6 mm)<br>aluminum wire | 70–875 IPM<br>(1.8–22.2 m/min) | H: 7-3/8 in (187 mm)<br>W: 1-7/8 in (48 mm)<br>D: 10-5/8 in (270 mm) | 15 ft Cable: 14 lb (6.4 kg)<br>30 ft Cable: 21.5 lb (9.8 kg) |

A=Air-Cooled W=Water-Cooled  Certified to both the Canadian and U.S. Standards for welding equipment.  Conforms to European standards.

## XR-Pistol Grip Parts Breakdown (Air-Cooled shown.)



- |                            |                     |
|----------------------------|---------------------|
| 1. Air-Cooled Assembly     | <b>Kit #231 523</b> |
| 2. Water-Cooled Assembly*  | <b>Kit #231 524</b> |
| 3. Head Tube Liner         | <b>#212 156</b>     |
| 4. O-Ring .614 ID          | <b>#134 800</b>     |
| 5. Head Tube (Air-cooled)  | <b>#221 087</b>     |
| Head Tube (Water-cooled)*  | <b>#221 519</b>     |
| 6. Barrel Pistol Insulator | <b>#219 795</b>     |
| 7. Outer Insulating Jacket | <b>#219 794</b>     |
| 8. Nozzle Insulator        | <b>#232 284</b>     |
| 9. Diffuser                | <b>#227 749</b>     |
| 10. Contact Tip            | (See chart below)   |
| 11. Nozzle                 | <b>#199 613</b>     |

\*Order water-cooled parts from Miller Service Parts.

**Important: A wider selection of Miller and Centerfire™ Series consumables are available — see Pistol Grip Guns spec sheet (Lit. Index No. M/1.73).**

## XR-Pistol Grip Standard Consumables (Air-Cooled Only) (Order from Miller Service Parts.)

| Aluminum Wire Size | FasTip Contact Tip (Qty. 25) | Drive Rolls     | All-Wire Dual Groove Drive Rolls | Head Tube Liner |
|--------------------|------------------------------|-----------------|----------------------------------|-----------------|
| .030 in (0.8 mm)   | <b>#206 186</b> .041 in ID   | <b>#183 357</b> | <b>#136 135</b>                  | <b>#212 156</b> |
| .035 in (0.9 mm)   | <b>#206 187</b> .047 in ID   | <b>#183 357</b> | <b>#136 135</b>                  | <b>#212 156</b> |
| .040 in (1.0 mm)   | <b>#206 188</b> .053 in ID   | <b>#183 357</b> | <b>#136 135</b>                  | <b>#212 156</b> |
| 3/64 in (1.2 mm)   | <b>#206 189</b> .061 in ID   | <b>#183 358</b> | <b>#136 135</b>                  | <b>#212 156</b> |
| 1/16 in (1.6 mm)   | <b>#206 191</b> .071 in ID   | <b>#183 358</b> | <b>#136 135</b>                  | <b>#212 156</b> |

| Cable Liners                             |
|--|
| <b>#191 065</b> 15 or 30 ft (4.6 or 9 m) |

# AlumaPower™ 350 MPa Power Source

**Auto-Line™** Power Management Technology allows for any input voltage hook-up (208–575 V) with no manual linking required, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

**Fan-On-Demand™** cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through machine.

**Large, dual digital meters** are easy to view and are presettable to ease setting weld output.

**Inverter arc control technology** provides greater puddle control for outstanding MIG and Pulsed MIG weld performance.

**Line voltage compensation** keeps welding output constant even if input power varies by +/-10%. XMT 350 models further expand line voltage compensation on 460 VAC to an amazing +37%, -59%.

**Lightweight, aerospace-grade aluminum case** offers protection and the benefit of reduced weight.

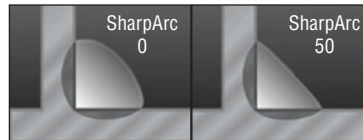
**Ultra-tough, polycarbonate-blended cover for control panel** protects front controls from damage.

**Easy setup** for MIG and Pulsed MIG applications.



**SharpArc™** controls the arc in Pulsed MIG mode and gives control over the arc cone shape, puddle fluidity, and bead profile. If a gas is used other than Ar 100% (Argon), SharpArc™ can be adjusted to help customize your arc to the gas being used.

**Weld Cross Section**



## Additional Features

**Exceptional electrical efficiency.**  
At 400 A, efficiency is 87.24%!

**350 A of welding output at 60% duty cycle with superior low-end aluminum welding performance.**

**Power factor of .95** enables smaller fuses/breakers and primary wiring. Primary amperage draw at rated output is 25% less than the competition.

**Built-in synergic or standard Pulsed MIG capabilities.** See the list below of built-in Pulsed MIG (GMAW-P) aluminum programs.

| Wire Type    | Gas Type        |
|--------------|-----------------|
| .035 AL 4043 | Ar 100% (Argon) |
| .040 AL 4043 | Ar 100% (Argon) |
| 3/64 AL 4043 | Ar 100% (Argon) |
| 1/16 AL 4043 | Ar 100% (Argon) |
| .035 AL 5356 | Ar 100% (Argon) |
| .040 AL 5356 | Ar 100% (Argon) |
| 3/64 AL 5356 | Ar 100% (Argon) |
| 1/16 AL 5356 | Ar 100% (Argon) |

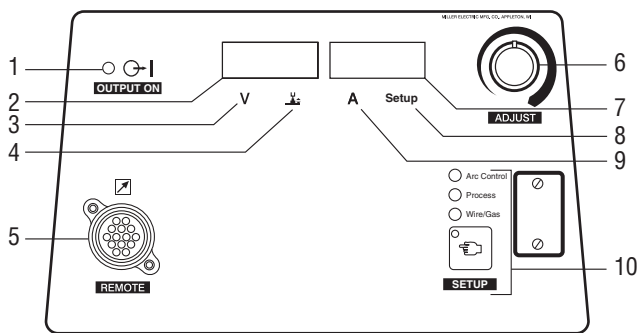
## AlumaPower 350 MPa Specifications (Subject to change without notice.)



| Input Power  | Rated Output at 60% Duty Cycle | Voltage Range in CV Mode | Amperage Range in CC Mode | Max. Open-Circuit Voltage | Amps Input at Rated Load Output, 60 Hz, |       |       |       |       |      |      |   | Dimensions         | Weight |
|--------------|--------------------------------|--------------------------|---------------------------|---------------------------|---|-------|-------|-------|-------|------|------|---|--------------------|--------|
|              |                                |                          |                           |                           | 208 V                                   | 230 V | 400 V | 460 V | 575 V | KVA  | KW   |   |                    |        |
| Three-Phase  | 350 A at 34 VDC                | 10–38 V                  | 5–425 A                   | 75 VDC                    | 40.4                                    | 36.1  | 20.6  | 17.8  | 14.1  | 14.2 | 13.6 | H: 17 in (432 mm)<br>W: 12-1/2 in (318 mm)<br>D: 24 in (610 mm) | 80 lb<br>(36.3 kg) |        |
| Single-Phase | 300 A at 32 VDC                | 10–38 V                  | 5–425 A                   | 75 VDC                    | 60.8                                    | 54.6  | 29.7  | 24.5  | 19.9  | 11.7 | 11.2 |   |                    |        |

Certified to both the Canadian and U.S. Standards for welding equipment.

## AlumaPower™ 350 MPa Control Panel



- Output ON Indicator Light
- Left Display
- Voltage Indicator
- Arc Length Indicator
- Wire Feeder Receptacle
- Adjustment Control
- Right Display
- Setup Indicator
- Amperage Indicator
- Setup Indicator Lights
  - Arc Control Indicator
  - Process Indicator
  - Wire/Gas Type Indicator
  - Setup Button

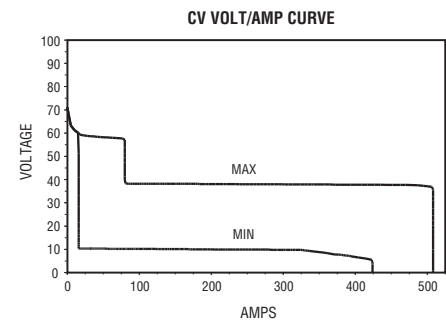
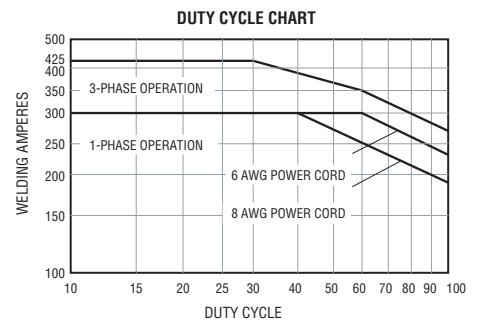
### MPa M (MIG), P (Pulse), a (Advanced Arc Control)

Advanced arc control enables an improved pulse welding arc. The operator has more control over puddle and bead characteristics using SharpArc™. In addition, the unit provides a more robust and stable arc at very low arc length, reducing heat input, and providing the ability to weld on a wider range of material thickness.

#### What are some benefits of Synergic-Pulsed MIG?

- Easier to set up
- No more changing wire speed, and then having to go back to the power source to reset the welding output.

## Performance Data



## AlumaPower™ 350 MPa Genuine Miller Accessories



**Industrial MIG 4/0 Kit with Dinse Connector #300 405**

This useful pulse-ready MIG kit can be purchased separately. Includes Smith® flowmeter/regulator with 10 ft (3 m) gas hose, 10 ft (3 m) 4/0 feeder weld cable with Dinse connector on one end and a lug on the other, 15 ft (4.6 m) work cable with Dinse connector on one end and 600-amp C-clamp on the other.

### Remote Control Extension Kits

- #043 725 25 ft (7.6 m)
- #043 726 50 ft (15 m)
- #043 727 75 ft (23 m)

Fully-loaded 14-pin extension cords for remote controls or 24 V and 115 V feeders.

## International-Style Connectors

*Note: AlumaPower 350 power sources are equipped with International-style connectors for secondary connections. (Power source is shipped with two 50-mm male International-style plugs for use with #1 or #2 AWG size cable.)*



**International/Tweco® Adapter #042 465**  
**International/Cam-Lok Adapter #042 466**

One-piece adapter with International-style male plug (to power source) on one end and female receptacle (Tweco or Cam-Lok for weld cable connection) on other end.

### International-Style Connector Kit

- #042 418 50 mm
- Accepts #4 or #1/0 AWG cable size. Required if male plugs shipped with power source must be replaced, or if additional plugs are needed.

**#042 533** 70 mm  
Accepts #1/0 or #2/0 AWG cable size. Required if #1/0 or #2/0 AWG size cable is to be used.

Kit includes one International-style male plug which attaches to the work and/or weld cables and plugs into the International-style receptacles on the power source.

### Extension Kit for International-Style Cable Connectors

- #042 419 50 mm  
Accepts #4 or #1/0 AWG size cable.
- #042 534 70 mm  
Accepts #1/0 or #2/0 AWG size cable.

Used to adapt or extend weld and/or work cables. Kit includes one male International-style plug and one in-line female International-style receptacle.

## AlumaFeed™ System Genuine Miller Accessories



**MIGRunner™ Cart #195 445**  
Small footprint and easily maneuverable, with cylinder rack low enough that you do not have to lift bottles.



**Universal Carrying Cart and Cylinder Rack #042 934**  
Holds power source, and gas cylinder up to 56 in (142.2 cm)

high measuring 6 to 9 in (15.2 to 22.8 cm) in diameter.

## Water Coolant Systems

For more information, see the Miller Coolant Systems literature sheet, Index No. AY/7.2.



**Coolmate™ 3 #043 007** 115 VAC  
**#043 008** 230 VAC

For use with water-cooled torches rated up to 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

**Coolmate™ V3 #043 009** 115 VAC  
For use with water-cooled torches rated up to 500 amps. Vertical design conveniently mounts to Miller cylinder rack in place of one cylinder.

**Coolmate™ 4 #042 288** 115 VAC  
For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

**Coolant #043 809**  
Sold in cases of four 1-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37°F (-38°C) or boiling to 227°F (108°C). Also contains a compound that resists algae growth.

## MIGRunner™ Packages



MIGRunner with 25 ft (7.6 m) air-cooled XR-Aluma-Pro gun shown.

### AlumaFeed MIGRunner (Auto-Line™ 208–575 VAC)

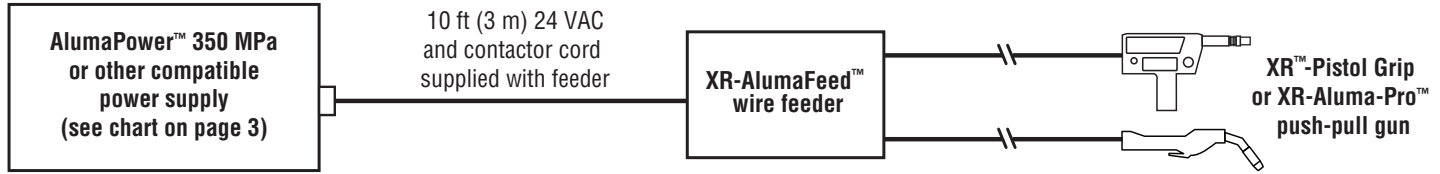
- #951 151 with 25 ft (7.6 m) air-cooled XR-Aluma-Pro gun
- #951 152 with 25 ft (7.6 m) water-cooled XR-Aluma-Pro gun
- #951 153 with 30 ft (9 m) air-cooled XR-Pistol Grip gun
- #951 154 with 30 ft (9 m) water-cooled XR-Pistol Grip gun

Packages include:

- AlumaPower 350 MPa power source (water-cooled packages have 115 V auxiliary power)
- XR-AlumaFeed wire feeder
- Air- or water-cooled XR-Aluma-Pro (gooseneck-style) or XR-Pistol Grip push-pull gun
- MIGRunner Cart
- Industrial MIG 4/0 MIG kit with Dinse connector
- Gun and feeder drive rolls and consumables to run .035–3/64 in (0.9–1.2 mm) wire (1/16 in consumables and water coolant system not included, order separately)

# Typical Installations

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



# Ordering Information

| Power Source and Options   | Stock No.  | Description   | Qty. | Price |
|--|--|---|------|-------|
| <b>AlumaFeed™ Synergic Aluminum Welding Systems</b><br>(Includes AlumaPower™ 350 MPa power source, XR-AlumaFeed™ wire feeder, gooseneck or pistol grip push-pull gun (air- or water-cooled), plus gun and feeder drive rolls and consumables to run .035–3/64 in (0.9–1.2 mm) wire. 1/16 inch drive rolls and consumables and water coolant system not included — order separately below.) | #951 162   | With 10 ft (3 m) air-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 158   | With 15 ft (4.6 m) air-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 159   | With 15 ft (4.6 m) water-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 147   | With 25 ft (7.6 m) air-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 148   | With 25 ft (7.6 m) water-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 160   | With 35 ft (10.7 m) air-cooled XR-Aluma-Pro™ gun  |      |       |
|  | #951 161   | With 35 ft (10.7 m) water-cooled XR-Aluma-Pro™ gun  |      |       |
|  | #951 163   | With 15 ft (4.6 m) air-cooled XR-Pistol Grip gun  |      |       |
|  | #951 164   | With 15 ft (4.6 m) water-cooled XR-Pistol Grip gun  |      |       |
|  | #951 149   | With 30 ft (9 m) air-cooled XR-Pistol Grip gun  |      |       |
| #951 150   | With 30 ft (9 m) water-cooled XR-Pistol Grip gun |   |      |       |
| <b>AlumaFeed™ MIGRunner™ Packages</b><br>(Includes the same as above plus MIGRunner Cart and Industrial MIG 4/0 Kit with Dinse Connector. Water-cooled packages have 115 V auxiliary power.)   | #951 151   | With 25 ft (7.6 m) air-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 152   | With 25 ft (7.6 m) water-cooled XR-Aluma-Pro™ gun   |      |       |
|  | #951 153   | With 30 ft (9 m) air-cooled XR-Pistol Grip gun  |      |       |
|  | #951 154   | With 30 ft (9 m) water-cooled XR-Pistol Grip gun  |      |       |
| <b>AlumaPower™ 350 MPa Power Source</b>  | #907 420   | Power source only. 208–575 VAC with Auto-Line™  |      |       |
|  | #907 420-00-1                                    | Power source only. 208–575 VAC with Auto-Line™ and Auxiliary Power  |      |       |
| <b>XR-AlumaFeed™ Wire Feeder</b>   | #300 509   | Feeder only. Full synergic operation when used with MPa power sources only. Other Miller 14-pin power sources may be used, but feature operation may be limited. Call your Miller distributor for more information. |      |       |
| <b>Gun Accessories</b>   |  |   |      |       |
| XR-Aluma-Pro™ 1/16 Inch (1.6 mm) Wire Kit  | #230 708   | Required along with 1/16 in Drive Roll Kit below to run 1/16 in wire  |      |       |
| Replacement Cable Covers   |  | See page 4  |      |       |
| Tube Assemblies and Liners   |  | See page 4  |      |       |
| <b>Feeder and Power Supply Accessories</b>   |  |   |      |       |
| XR-AlumaFeed™ 1/16 Inch (1.6 mm) Drive Roll Kit  | #195 591   | Required along with 1/16 in Wire Kit above to run 1/16 in wire<br><i>Order from Miller Service Parts</i>  |      |       |
| Industrial MIG 4/0 Kit with Dinse Connector  | #300 405   |   |      |       |
| Remote Control Extension Kits  | #043 725   | 25 ft (7.6 m)   |      |       |
|  | #043 726   | 50 ft (15 m)  |      |       |
|  | #043 727   | 75 ft (23 m)  |      |       |
| International-Style Connectors   |  | See page 7  |      |       |
| <b>System Accessories</b>  |  |   |      |       |
| MIGRunner™ Cart  | #195 445   |   |      |       |
| Universal Carrying Cart and Cylinder Rack  | #042 934   |   |      |       |
| Water Coolant Systems  |  | See above. See Lit. Index No. AY/7.2  |      |       |

Date:

Total Quoted Price:



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