

# Gooseneck-Style Guns

## XR-Aluma-Pro™ Lite Gun

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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.

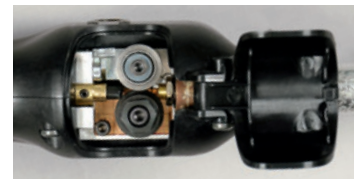
**Trigger mounted at the back of the gun** allows operator to easily access hard-to-reach weldments.

**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!**



**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).

**TRUE BLUE**  
WARRANTY

Guns are warranted for 1 year, parts and labor.



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MillerWelds.com



## 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

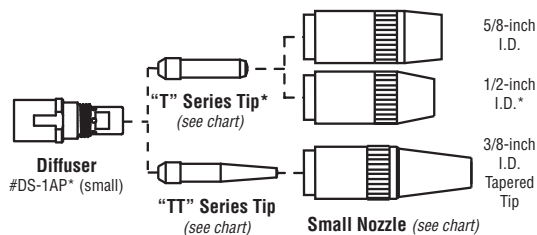
**N-3414B** Brass, 3/4-in. I.D., 1/4-in. tip recess

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

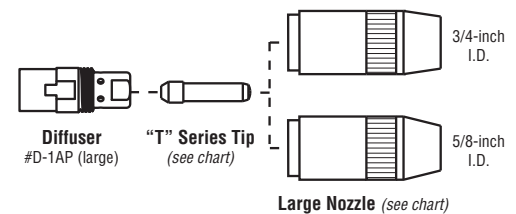
**N-5818B** Brass, 5/8-in. I.D., 1/8-in. tip recess

**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](http://bernardwelds.com/files/SpSh_Necks.pdf)

[bernardwelds.com/files/SpSh\\_FlexNeck.pdf](http://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](http://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
<b>XR-Aluma-Pro™ Lite</b>	<b>#300 948</b>	175-amp, air-cooled push-pull gun with 25-ft. (7.6 m) cable		
<b>Machines and Wire Feeders</b>				
Millermatic® 350P Aluminum/ XR-Aluma-Pro Lite System (See Lit. Index No. DC/12.56)	<b>#951 454</b>	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)	<b>#907 300</b>	200(208)/230/460 V. Standard power supply with constant-speed motor		
Millermatic® 252 (See Lit. Index No. DC/12.49)	<b>#907 321</b> <b>#907 322</b>	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)	<b>#300 601</b>	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)	<b>#300 687</b>	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)	<b>#300 509</b>	Advanced model includes .035- and 3/64-in. drive rolls, and adds Profile Pulse™, synergic control, trigger schedule select, lock capabilities and flowmeter		
<b>Accessories</b>				
Leather Cable Cover	<b>#234 110</b>	25 ft. (7.6 m)		
Short Leather Gun Cover	<b>#234 416</b>	17 in. (432 mm)		

Date:

Total Quoted Price:

Distributed by:

