

# XR-Aluma-Pro™ Lite

## Gooseneck-Style Push-Pull Gun

MIG Gun for Aluminum Welding 

### Quick Specs

#### 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)

#### Net Weight (Gun Only)

2.0 lb. (0.9 kg)

**Lightweight gooseneck-style gun features rear trigger that allows access to hard-to-reach welds.**

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 settings** ensure 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.

**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.



The XR-Aluma-Pro™ Lite is designed to be used with **Millermatic® 255, Multimatic® 255 and Millermatic® 355** power sources or **XR-AlumaFeed® Suitcase®** feeder 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 2).

**Centerfire™ consumables** provide superior gas coverage and arc performance. **Also compatible with Miller FasTip™ consumables.** Order gas diffuser, contact tip and nozzle from Standard Centerfire Consumables section (see page 2) or Optional FasTip Consumables section (see page 3).



Guns are warrantied for one year, parts and labor.



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#### MillerWelds.com



# Specifications (Subject to change without notice.)



Welding Current Rating	Wire Feed Speed	Wire Diameter Capacity	Dimensions	Net Weight (Gun only)
175 A at 60% duty cycle	70–900 ipm (1.8–23 m/min.) dependent on power source or control box used	.030–.047 in. (0.8–1.2 mm) aluminum wire	H: 4 in. (102 mm) W: 1.9 in (48 mm) D: 15 in. (381 mm)	2.0 lb. (0.9 kg)

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

## Standard Replacement Consumables

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)	254756	227439	227408	258541	258726	M-1440
.035 in. (0.9 mm)				258542		
.040 in. (1.0 mm)					258727	
3/64 in. (1.2 mm)						

\*Long head tube liners must be cut to fit.

## Standard Centerfire™ Consumables

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

**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)

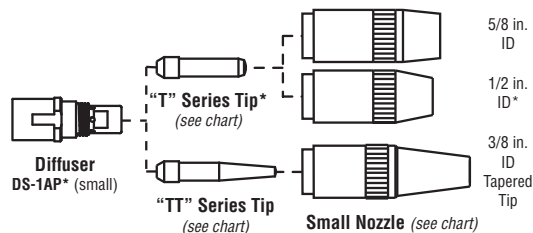
TT-030 .030 in. (0.8 mm)  
TT-035 .035 in. (0.9 mm)  
TT-045 .045 in. (1.2 mm)

**Small Nozzles**

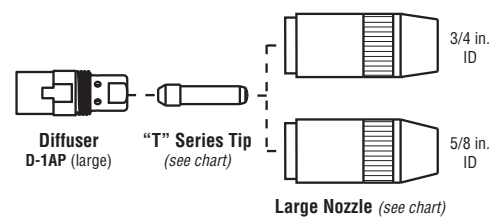
NST-3818B Brass, 3/8 in. ID, 1/8 in. recess  
NS-1218B Brass, 1/2 in. ID, 1/8 in. recess  
NS-1200B Brass, 1/2 in. ID, flush  
NS-5818B Brass, 5/8 in. ID, 1/8 in. recess  
NS-1218C\* Copper, 1/2 in. ID, 1/8 in. recess

**Large Nozzles**

N-5818B Brass, 5/8 in. ID, 1/8 in. recess  
N-5814B Brass, 5/8 in. ID, 1/4 in. recess  
N-3418B Brass, 3/4 in. ID, 1/8 in. recess  
N-3414B Brass, 3/4 in. ID, 1/4 in. recess  
N-5814C Copper, 5/8 in. ID, 1/4 in. recess  
N-3414C Copper, 3/4 in. ID, 1/4 in. recess



Standard Small Nozzle Configuration



Optional Large Nozzle Configuration

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

## Optional FasTip™ Consumables

### Gas Diffusers (XR-Aluma-Pro™ Lite specific)



**206195** 1/8 in. tip recess (standard)  
For heavy-duty FasTip contact tips.

**210664** 1/4 in. tip recess  
For heavy-duty FasTip contact tips.

**206196** Flush tip  
For heavy-duty FasTip contact tips.

### FasTip Contact Tips (25 per package)



#### Heavy-Duty (Aluminum Wire)

**206186** .030 in. (0.8 mm)

**206187** .035 in. (0.9 mm)

**206188** .040 in. (1.0 mm)

**206189** 3/64 in. (1.2 mm)

**206191** 1/16 in. (1.6 mm)

#### Tapered (Aluminum Wire)

**209026** .035 in. (0.9 mm)

**209027** .045 in. (1.2 mm)

**209029** .052 in. (1.3 mm)

**206030** 1/16 in. (1.6 mm)

### Nozzles

#### Screw-On Brass

**199610** 1/2 in. orifice, tapered

**199611** 3/4 in. orifice, straight

**199612** 3/4 in. orifice, straight HD

**199613** 5/8 in. orifice, tapered

**199614** 5/8 in. orifice, tapered HD

#### Screw-On Copper

**199615** 1/2 in. orifice, tapered

**199616** 3/4 in. orifice, straight

**199617** 3/4 in. orifice, straight HD

**198855** 5/8 in. orifice, tapered

**199618** 5/8 in. orifice, tapered HD

**207313** 5/8 in. orifice, tapered 15/16 OD

**209035** 3/8 in. orifice, tapered

**209036** 1/2 in. orifice, tapered

*\*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 2).*

## Replacement and Optional Head Tubes

### Replacement Head Tube 254477

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:

[tregaskiss.com/wp-content/uploads/2020/12/SpSh\\_Necks.pdf](http://tregaskiss.com/wp-content/uploads/2020/12/SpSh_Necks.pdf)

[tregaskiss.com/wp-content/uploads/2020/07/SP\\_FN\\_flex\\_necks.pdf](http://tregaskiss.com/wp-content/uploads/2020/07/SP_FN_flex_necks.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 (see page 2). Long head tube liners are 14 inches long and must be cut to fit.*

To locate the nearest Bernard distributor, visit: [tregaskiss.com/where-to-buy](http://tregaskiss.com/where-to-buy)

## Genuine Miller® Accessories

### Leather Cable Cover

**234110** 25 ft. (7.6 m)

Protects gun hose and cable assembly from wear and abrasion. Features a full-length hook-and-loop seam.

### Short Leather Gun Cover 234416

Optional cover is 17 inches (432 mm).

## Recommended Power Sources and Wire Feeder



### Millermatic® 255 with EZ-Latch™ Running Gear 951766

Easy-to-use machine to increase efficiency and productivity for light manufacturing and fabrication users. All-in-one welder connects to 208- or 240-volt input power and welds up to 1/2-inch aluminum, stainless and mild steel. Features 7-inch color LCD screen, Auto-Set™ Elite and pulsed MIG capabilities. Package includes running gear, MIG gun and accessories. See literature DC/12.8 for details.



### Multimatic® 255 with EZ-Latch™ Running Gear 951767

Built for professionals in the MRO and light manufacturing/fabrication segments who want a smaller, versatile multiprocess welder with intuitive setup to increase efficiencies and productivity. All-in-one welder connects to any North American input power and welds up to 1/2-inch aluminum, stainless and mild steel. Features 7-inch color LCD screen, Auto-Set™ Elite and pulsed MIG capabilities. Package includes running gear, MIG gun and accessories. See literature DC/12.9 for details.



### Millermatic® 355 with EZ-Latch™ Running Gear 951926

Easy-to-use machine to increase efficiency and productivity for manufacturing and fabrication users. All-in-one welder connects to any North American input power and welds up to 1/2-inch aluminum, stainless and mild steel. Features 7-inch color LCD screen, Auto-Set™ Elite, electronic parameter chart, trigger program select and pulsed MIG capabilities. Package includes running gear, MIG gun and accessories. See literature DC/12.95 for details.



### XR-AlumaFeed® SuitCase® 301567

Impact-resistant and flame-retardant suitcase-style feeder. Features Profile Pulse™ and trigger schedule select, as well as full synergic pulsed MIG welding (when used with MPa power sources only). Other Miller® 14-pin power sources may be used, but feature operation may be limited. Includes .035 and 3/64 in. drive rolls. See literature DC/34.0 for details.

## Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>XR-Aluma-Pro™ Lite</b>	<b>300948</b>	175-amp, air-cooled push-pull gun with 25 ft. (7.6 m) cable		
<b>Recommended Power Sources</b>				
Millermatic® 255 (See literature DC/12.8)	<b>951766</b>	Auto-Line™ 208–240 V, 50/60 Hz. Includes EZ-Latch™ single cylinder running gear, MDX™-250 MIG gun and accessories		
Multimatic® 255 (See literature DC/12.9)	<b>951767</b>	Auto-Line™ 208–575 V, 50/60 Hz. Includes EZ-Latch™ single cylinder running gear, MDX™-250 MIG gun and accessories		
Millermatic® 355 (See literature DC/12.95)	<b>951926</b>	3- or 1-phase, 208/240/460/575 V, 50/60 Hz. Includes EZ-Latch™ single cylinder running gear, 300-amp Bernard® BTB MIG gun and accessories		
<b>Recommended Wire Feeder</b>				
XR-AlumaFeed® Suitcase® (See literature DC/34.0)	<b>301567</b>	Feeder only. Includes .035 and 3/64 in. drive rolls		
<b>Accessories</b>				
Leather Cable Cover	<b>234110</b>	25 ft. (7.6 m)		
Short Leather Gun Cover	<b>234416</b>	17 in. (432 mm)		

Date:

Total Quoted Price:

Distributed by:

