

XR™-Pistol-Pro

Pistol-Grip Push-Pull Gun

MIG Gun for Aluminum Welding 

Quick Specs

Heavy Industrial Applications

Emergency Vehicles Shipbuilding
 Recreational Vehicles Tool Boxes
 Trucks and Trailers Railcars
 Boat/Yacht Building Fabrication
 Sign Manufacturers

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

Air-Cooled: 200 A
 Water-Cooled: 400 A

Net Weight (Gun Only)

Air-Cooled: 2.2 lb. (1 kg)
 Water-Cooled: 2.4 lb. (1.1 kg)



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



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

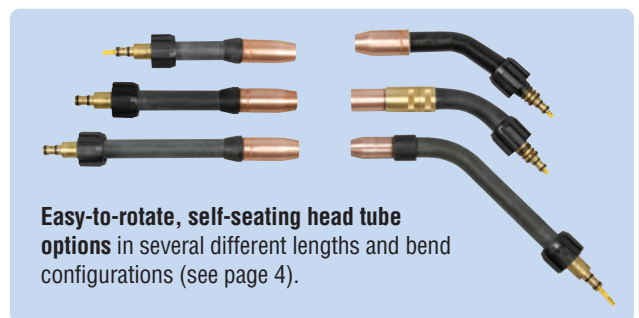
The XR-Pistol-Pro gun is available in air- or water-cooled versions with 15-, 25- or 35-foot (4.6, 7.6 or 10.6 m) cable lengths.



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

Easy access to drive assembly and removable toolless head tube reduces service time by allowing a simple means of changing drive rolls and head tube or performing routine maintenance without disassembly of gun.

Improved motor and drive design for better feedability and arc consistency over longer distances while helping reduce downtime and maintenance costs associated with complex drive systems.



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



Guns are warranted for 1 year, parts and labor.



Miller Electric Mfg. Co.
 An ITW Company
 1635 West Spencer Street
 P.O. Box 1079
 Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
 Phone: 866-931-9730
 FAX: 800-637-2315
 International Phone: 920-735-4554
 International FAX: 920-735-4125

MillerWelds.com
  



Specifications (Subject to change without notice.)



Model	Welding Current Rating	Wire Feed Speed	Wire Diameter Capacity	Dimensions	Net Weight (Gun only)
XR™-Pistol-Pro (air-cooled)	200 A at 100% duty cycle 250 A at 60% duty cycle	70–900 IPM (1.8–23 m/min.) dependent on control box or Millermatic used	.030–1/16 in. (0.8–1.6 mm) aluminum wire Wire kit #230 708 required to run 1/16-in. (1.6 mm) wire.	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-Pro (water-cooled)	400 A at 100% duty cycle				2.4 lb. (1.1 kg)

Standard Replacement Consumables (Order from Miller Service Parts.)

Aluminum Wire Size	FasTip Contact Tip (Qty. 25)	Drive Rolls	Idler Rolls	Head Tube Liner 4 in. (102 mm)	Cable Liners
.030 in. (0.8 mm)	#206 186 .041-in. ID	#227 434	#227 439	M1272	M1115 15 ft. (4.6 m)
.035 in. (0.9 mm)	#206 187 .047-in. ID	#227 434	#227 439	M1272	#248 359 25 ft. (7.6 m)
.040 in. (1.0 mm)	#206 188 .053-in. ID	#227 434	#227 439	M1272	#248 375 35 ft. (10.6 m)
3/64 in. (1.2 mm)	#206 189 .061-in. ID	#227 434	#227 439	M1273	
1/16 in. (1.6 mm)	#206 191 .071-in. ID	#227 434	#230 710	M1273	

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

Gas Diffusers



#229 670 Standard
1/8-inch tip recess for heavy-duty FasTip™ contact tips.

#230 678
1/4-inch tip recess for heavy-duty FasTip™ contact tips.

#230 679
Flush tip for heavy-duty FasTip™ contact tips.

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)
#206 030 1/16 in. (1.6 mm)

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

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

Insulator 10012
4323R

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

XR™-Pistol-Pro Diffuser Conversion Kits for .035–1/16 in aluminum

#230 669 For D-1AP diffuser

#230 670 For DS-1AP diffuser

Diffuser kits must be used to convert to Centerfire™ Series consumables. Kit includes diffuser and head tube liners.

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

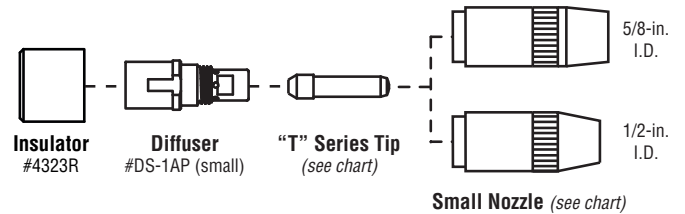
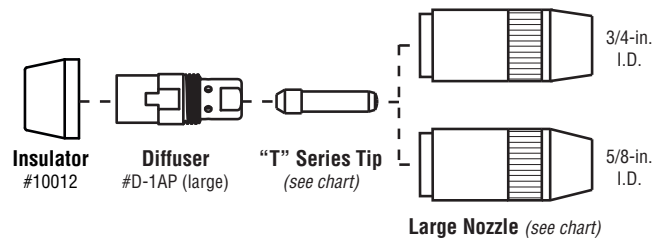
Small Nozzles

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 (Order from Miller Service Parts.)



45 Degree/4 Inch
 #255 037 Air-Cooled
 #255 338 Water-Cooled



180 Degree/4 Inch
 (standard on XR™-Pistol Pro)
 #255 716 Air-Cooled
 #255 717 Water-Cooled



45 Degree/6 Inch with Centerfire™
 #246 205 Water-Cooled
 (standard on XR-Aluma-Pro™ Plus)
60 Degree/6 Inch with Centerfire™
 #246 301 Air-Cooled



45 Degree/6 Inch
 #255 040 Air-Cooled
 #231 517 Water-Cooled
 (standard on XR-Aluma-Pro™)



180 Degree/6 Inch
 #258 476 Air-Cooled
 #258 477 Water-Cooled



180 Degree/4 Inch with Centerfire™
 (standard on XR™-Pistol Plus)
 #258 474 Air-Cooled
 #258 475 Water-Cooled



60 Degree/4 Inch
 #231 519 Air-Cooled
 (standard on XR-Aluma-Pro™)
 #255 038 Water-Cooled



180 Degree/8 Inch
 #255 042 Air-Cooled
 #255 043 Water-Cooled

Heavy-Duty Head Tube Assemblies

For high-duty-cycle applications.



60 Degree/6 Inch
 #231 518 Air-Cooled
 #255 041 Water-Cooled



45 Degree/10 Inch Tight Access
 #258 295 Air-Cooled
 For hard-to-reach welds where a smaller nozzle and longer reach is needed.



45 Degree/6 Inch Heavy-Duty
 #262 206 Air-Cooled
 #258 293 Water-Cooled

60 Degree/6 Inch Heavy-Duty
 #262 207 Air-Cooled
 #258 294 Water-Cooled



Flex Neck/10 Inch
 #267 517 Air-Cooled
 Ideal for hard-to-reach welds.



180 Degree/6 Inch Heavy-Duty
 #262 208 Air-Cooled
 #259 535 Water-Cooled

Liners for Optional Head Tube Assemblies (Order from Miller Service Parts.)

Fastip™ Liners (4-inch assemblies)

For XR™-Pistol-Pro

M1272 .030–.040 in. (0.8–1.0 mm)

M1273 3/64 and 1/16 in. (1.2 and 1.6 mm)

For XR-Aluma-Pro™

#227 161 .030–.040 in. (0.8–1.0 mm)

#230 239 3/64 and 1/16 in. (1.2 and 1.6 mm)

Fastip Liners (6-inch assemblies)

For XR-Pistol-Pro

M1430 .030–.040 in. (0.8–1.0 mm)

M1365 3/64 and 1/16 in. (1.2 and 1.6 mm)

For XR-Aluma-Pro

#229 674 .030–.040 in. (0.8–1.0 mm)

#229 431 3/64 and 1/16 in. (1.2 and 1.6 mm)

Fastip Liners (8-inch assemblies)

For XR-Pistol-Pro

M1337 .030–.040 in. (0.8–1.0 mm)

M1338 3/64 and 1/16 in. (1.2 and 1.6 mm)

For XR-Aluma-Pro

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)

For XR-Pistol-Pro

M1427 .030–.040 in. (0.8–1.0 mm)

M1421 3/64 and 1/16 in. (1.2 and 1.6 mm)

For XR-Aluma-Pro

M1428 .030–.040 in. (0.8–1.0 mm)

M1429 3/64 and 1/16 in. (1.2 and 1.6 mm)

Fastip Liners (6-inch heavy-duty water-cooled assemblies)

For XR-Pistol-Pro

M1423 .030–.040 in. (0.8–1.0 mm)

M1424 3/64 and 1/16 in. (1.2 and 1.6 mm)

For XR-Aluma-Pro

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 (heavy-duty water-cooled assemblies)

For XR-Pistol-Pro

M1437 .030–1/16 in. (0.8–1.6 mm)
(6-inch)

For XR-Aluma-Pro

M1436 .030–1/16 in. (0.8–1.6 mm)
(6-inch)



Universal Teflon® Liner Kit

#262 707 .030–.040 in. (0.8–1.0 mm)

black liners

#262 705 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 #258 863

Genuine Miller® Accessories

XR-AlumaFeed™ Remote Connector Kit

#300 898 Field

Required for use with remote option guns.

Leather Cable Cover

#241 159 15 ft. (4.6 m)

#248 355 25 ft. (7.6 m)

#248 377 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.



One-Pound (0.5 kg) Spool Canister

#132 230

Ideal for use with XR guns if a small job arises requiring a different wire size and/or wire type that does not justify a 12-inch (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. Canister accommodates 4-inch (102 mm) spools of wire.



50-Degree Curved Nozzle Kit-A #264 064

(Order from Miller Service Parts.)

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

(Order from Miller Service Parts.)

#148 155 .030- and .035-in.
(0.8 and 0.9 mm) wire

#148 154 .047-in. (1.2 mm) wire

#148 156 1/16-in. (1.6 mm) wire

50-Degree Curved Nozzle Insulator Kit

#264 066

(Order from Miller Service Parts.)

Sleeve goes over center of curved nozzle to protect operator from heat. For use with 50-Degree Curved Nozzle Kit-A.

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

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-Pistol-Pro gun.

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 a gun head tube liner (M1461 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

M1461 4-inch

M1462 6-inch

For use with Hardwire Liner Kit above when used in XR-Pistol-Pro gun.

Wire Feeders and System Packages



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.



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.

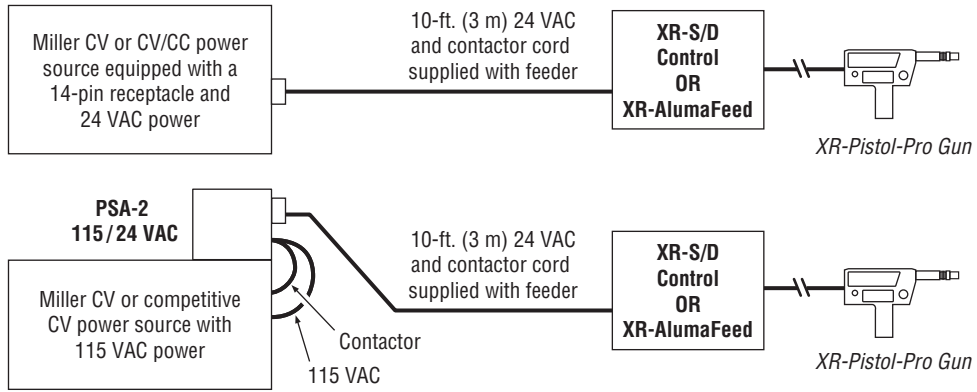


Millermatic® 350P Aluminum/ XR™-Pistol-Pro System (Air-Cooled) #951 453 200(208)/230/460 V

Includes Millermatic 350P Aluminum, 25-foot XR-Pistol-Pro push-pull gun, .035- and 3/64-inch FasTip™ contact tips, and .035- and 3/64-inch reversible U-groove drive rolls. (MIG gun not included.)

Typical Installations

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



XR™-Pistol-Pro Gun Hook-Up Recommendations

CV Power Supply	Control
Millermatic® 252, 350P, 350P Aluminum	Direct Hook-Up
AlumaPower™ 350 MPa, 450 MPa Deltaweld® Series Dimension™ Series Invision™ Series XMT® Series (except VS model) Big Blue® 300, 350 PipePro® Trailblazer® 275, 325, 302 Air Pak™	XR™-S/D Control or XR-AlumaFeed™

Note: XR-Pistol-Pro guns are not compatible with 74MPa Plus feeders.

Ordering Information

XR-Pistol-Pro guns require the following:

- XR-S/D Control OR
XR-AlumaFeed (See at right.)
- Recommended Miller 14-pin power source (See list below.)
OR
- Millermatic 252, 350P, or 350P Aluminum
(See Lit. Index No. DC/12.49, DC/12.51 or DC/12.56.)

Important notes:

XR-Pistol-Pro guns with remotes are not compatible with XR-S/D Control and Millermatic models.

XR-Pistol-Pro guns are not compatible with 74MPa Plus feeders.

XR-Control must be serial #KK309906 or higher to be used with products and descriptions mentioned in this literature. To confirm a product's compatibility with older equipment, please contact the factory at 1-920-735-4505.

Recommended Power Sources

- AlumaPower™ MPa
See literature no. DC/34
(For synergic use with AlumaFeed™)
- Deltaweld® Series
See literature no. DC/16.2
- XMT® 350/450
See literature no. DC/18.83
- Invision™ MPa
See literature no. DC/23.5
- Trailblazer® 275/325
See literature no. ED/4.75
- Big Blue® 800 Duo Air Pak™
See literature no. ED/13.0

Note: Other power sources may be used.

Equipment	Stock No.	Description	Qty.	Price
XR™-Pistol-Pro Gun (Air-Cooled)	#300 782	15-ft. (4.6 m) cable		
	#300 783	25-ft. (7.6 m) cable		
	#300 784	35-ft. (10.6 m) cable		
XR™-Pistol-Pro Gun (Water-Cooled)	#300 786	15-ft. (4.6 m) cable		
	#300 787	25-ft. (7.6 m) cable		
	#300 788	35-ft. (10.6 m) cable		
XR™-Pistol-Pro Gun with Remote (Air-Cooled)	#300 782 001	15-ft. (4.6 m) cable		
	#300 783 001	25-ft. (7.6 m) cable		
	#300 784 001	35-ft. (10.6 m) cable		
XR™-Pistol-Pro Gun with Remote (Water-Cooled)	#300 786 001	15-ft. (4.6 m) cable		
	#300 787 001	25-ft. (7.6 m) cable		
	#300 788 001	35-ft. (10.6 m) cable		
Wire Feeders and System Packages				
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		
XR-AlumaFeed™ w/Remote Connector (See Lit. Index No. DC/34)	#300 509 001			
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		
Millermatic® 350P Aluminum/ XR-Pistol-Pro System (Air-Cooled) (See Lit. Index No. DC/12.56)	#951 453	200(208)/230/460 V. True torque motor push-pull system. Note: The Millermatic® 350P Aluminum is compatible only with push-pull guns — not standard MIG guns		
Consumables and Accessories				
Consumables		See pages 2–3		
Optional Head Tube Assemblies		See page 4		
Liners for Opt. Head Tube Assemblies		See page 5		
XR-AlumaFeed Remote Connector Kit	#300 898	Field. Required for use with remote option guns		
Leather Cable Cover	#241 159	15 ft. (4.6 m)		
	#248 355	25 ft. (7.6 m)		
	#248 377	35 ft. (10.6 m)		
One-Pound Spool Canister	#132 230			
50-Degree Curved Nozzle Kit-A	#264 064			
Replacement Contact Tips for Curved Nozzle		See page 5		
50-Degree Curved Nozzle Insulator Kit	#264 066	For use with 50-Degree Curved Nozzle Kit-A		
1/16-Inch (1.6 mm) Wire Kit	#230 708	Required when running 1/16-inch wire		
Hardwire Liner Kit for Steel and Stainless	#198 377			
Phosphorous Bronze Liners		See page 5		
Coolant Systems		See Lit. Index No. AY/7.2		

Remote guns **ONLY** work with XR-AlumaFeed wire feeder with remote option (#300 509 001), or with XR-AlumaFeed with remote kit (#300 898) installed.

Date:

Total Quoted Price:

Distributed by:

