

XR™-Pistol-Pro

Pistol-Grip Push-Pull Gun

MIG Gun for Aluminum Welding 

Quick Specs

Heavy Industrial Applications

Emergency vehicles
Recreational vehicles
Trucks and trailers
Boat/yacht building
Sign manufacturers

Shipbuilding
Tool boxes
Railcars
Fabrication

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 Control, XR-AlumaFeed® or Millermatic® 350P Aluminum as part of a push-pull system.

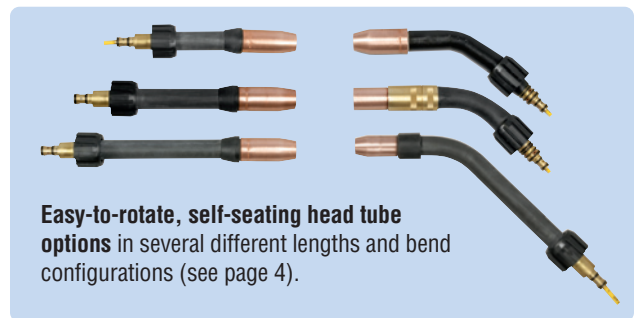
The XR-Pistol-Pro gun is available in air- or water-cooled versions with 15-, 25- or 35-foot (4.6, 7.6 or 10.6 m) cable lengths.



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 one year, parts and labor.



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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 230708 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

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)	206186 .041 in. ID	227434	227439	M1272	M1115 15 ft. (4.6 m)
.035 in. (0.9 mm)	206187 .047 in. ID	227434	227439	M1272	248359 25 ft. (7.6 m)
.040 in. (1.0 mm)	206188 .053 in. ID	227434	227439	M1272	248375 35 ft. (10.6 m)
3/64 in. (1.2 mm)	206189 .061 in. ID	227434	227439	M1273	
1/16 in. (1.6 mm)	206191 .071 in. ID	227434	230710	M1273	

Standard Consumables – FasTip™ Series

Gas Diffusers



229670 1/8 in. tip recess (Standard)
For heavy-duty FasTip contact tips.

230678 1/4 in. tip recess
For heavy-duty FasTip contact tips.

230679 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 .030 in. (0.8 mm)

209027 .035 in. (0.9 mm)

209029 3/64 in. (1.2 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 O.D.

209035 3/8 in. orifice, tapered

209036 1/2 in. orifice, tapered

Optional Consumables – Centerfire™ Series

Insulator 10012
4323R

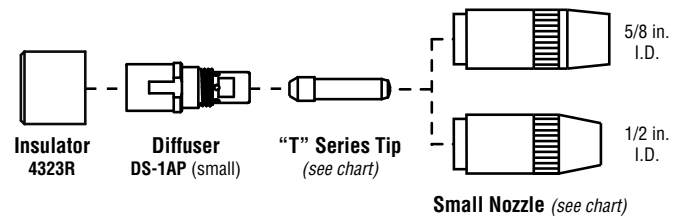
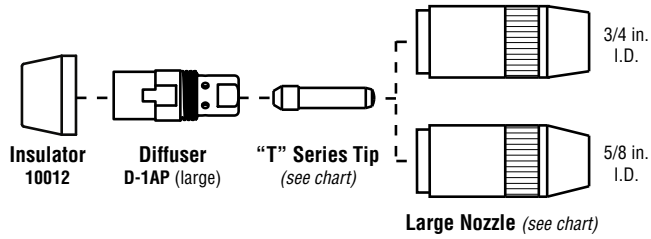
Diffuser D-1AP (large)
DS-1AP (small)

XR-Aluma-Pro™ Diffuser Conversion Kits for .035–1/16 inch aluminum
230669 For D-1AP diffuser
230670 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



45 Degree/4 Inch
255037 Air-cooled
255338 Water-cooled



180 Degree/4 Inch
 (standard on XR™-Pistol Pro)
255716 Air-cooled
255717 Water-cooled



45 Degree/6 Inch with Centerfire™
246205 Water-cooled
 (standard on XR-Aluma-Pro™ Plus)



45 Degree/6 Inch
255040 Air-cooled
231517 Water-cooled
 (standard on XR-Aluma-Pro™)



180 Degree/6 Inch
258476 Air-cooled
258477 Water-cooled

60 Degree/6 Inch with Centerfire™
246301 Air-cooled



60 Degree/4 Inch
231519 Air-cooled
 (standard on XR-Aluma-Pro™)
255038 Water-cooled



180 Degree/8 Inch
255042 Air-cooled
255043 Water-cooled



180 Degree/4 Inch with Centerfire™
 (standard on XR™-Pistol Plus)
258474 Air-cooled
258475 Water-cooled



60 Degree/6 Inch
231518 Air-cooled
255 041 Water-cooled



45 Degree/10 Inch Tight Access
258295 Air-cooled
 For hard-to-reach welds where a smaller nozzle and longer reach is needed.

Heavy-Duty Head Tube Assemblies

For high-duty-cycle applications.



45 Degree/6 Inch Heavy-Duty
262206 Air-cooled
258293 Water-cooled



60 Degree/6 Inch Heavy-Duty
262207 Air-cooled
258294 Water-cooled



Flex Neck/10 Inch
267517 Air-cooled
 Ideal for hard-to-reach welds.



180 Degree/6 Inch Heavy-Duty
262208 Air-cooled
259535 Water-cooled

Liners for Optional Head Tube Assemblies

Fastip™ Liners (4-inch assemblies)

M1272 .030–.040 in. (0.8–1.0 mm)

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

Fastip Liners (6-inch assemblies)

M1430 .030–.040 in. (0.8–1.0 mm)

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

Fastip Liners (8-inch assemblies)

M1337 .030–.040 in. (0.8–1.0 mm)

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

Bernard® Quik Tip™ Tight-Access Liners (10-inch assemblies)

M1427 .030–.040 in. (0.8–1.0 mm)

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

Fastip Liners

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

M1423 .030–.040 in. (0.8–1.0 mm)

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

Phosphorous Bronze Liners

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

M1437 .030–.040 in. (0.8–1.0 mm)



Universal Teflon® Liner Kit

262707 .030–.040 in. (0.8–1.0 mm)

black liners

262705 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 258863

Genuine Miller® Accessories

Leather Cable Cover

241159 15 ft. (4.6 m)

248355 25 ft. (7.6 m)

248377 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 132230

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 264064

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

148155 .030 and .035 in. (0.8 and 0.9 mm) wire

148154 .047 in. (1.2 mm) wire

148156 1/16 in. (1.6 mm) wire

50-Degree Curved Nozzle Insulator Kit 264066

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

1/16-inch (1.6 mm) Wire Kit 230708

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 198377

For 15, 25, or 35 ft. (4.6, 7.6 or 10.6 m) guns. Kit consists of 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 300509

Advanced push-pull wire feeder designed for high-volume, high-production aluminum MIG welding where quality and consistency is a high priority. See literature DC/34.0.



XR™-S Control 300601

The XR-S Control offers unsurpassed performance and reliability for feeding aluminum and other difficult-to-feed wire types. Model includes .035-inch and factory-installed 3/64-inch drive rolls. See literature M/1.7.



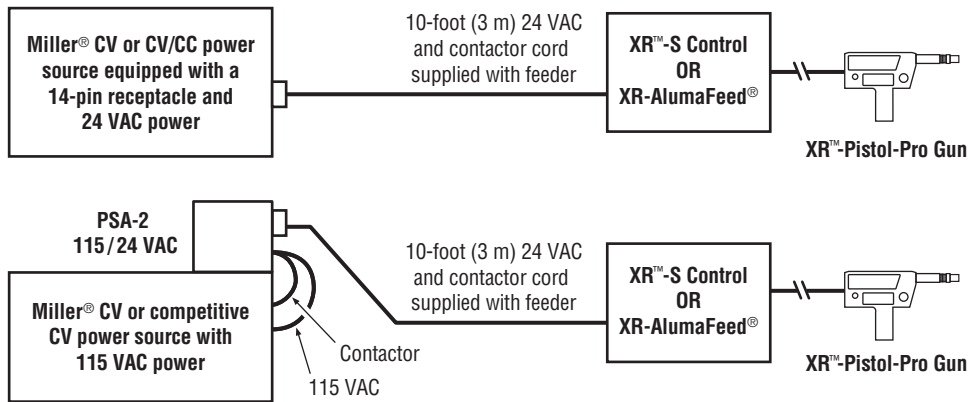
Millermatic® 350P Aluminum/ XR™-Pistol-Pro System

951453 200(208)/230/460 V

Includes Millermatic 350P Aluminum, 25-foot (7.6 m) XR™-Pistol-Pro air-cooled push-pull gun, .035- and 3/64-inch FasTip™ contact tips, and .035- and 3/64-inch reversible U-groove drive rolls. (Standard 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, 255, 350P, 350P Aluminum Multimatic® 255	Direct Hook-Up
AlumaPower™ 350 MPa, 450 MPa Deltaweld® Series Dimension™ Series Invision™ Series XMT® Series (except VS model) Trailblazer® 325, 302 Air Pak™ Big Blue® Series (with 14-pin receptacle)	XR™-S 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 Control or XR-AlumaFeed (See at right.)
- Recommended Miller® 14-pin power source (See list below.)
OR
- Millermatic 252, 255, 350P, 350P Aluminum, or Multimatic 255 (See literature DC/12.49, DC/12.8, DC/12.51, DC/12.56, or DC/12.9.)

Important notes:

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

XR-Control must be serial number 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 DC/34.0
(For synergic use with AlumaFeed®)

Deltaweld® Series
See literature DC/16.2

XMT® 350 Series
See literature DC/18.93

XMT® 450 Series
See literature DC/18.94

Invision™ MPa
See literature DC/23.6

Trailblazer® Series
See literature ED/4.75

Big Blue® 800 Series
See literature ED/14.0

Note: Other power sources may be used.

Equipment	Stock No.	Description	Qty.	Price
XR™-Pistol-Pro Gun (Air-Cooled)	300782	15 ft. (4.6 m) cable		
	300783	25 ft. (7.6 m) cable		
	300784	35 ft. (10.6 m) cable		
XR™-Pistol-Pro Gun (Water-Cooled)	300786	15 ft. (4.6 m) cable		
	300787	25 ft. (7.6 m) cable		
	300788	35 ft. (10.6 m) cable		
XR-AlumaFeed® (See literature DC/34.0)	300509	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 literature DC/34.0)	300509001			
XR™-S Control (See literature M/1.7)	300601	Standard model includes .035 and 3/64 in. drive rolls, wire feed speed digital display, jog/purge, run-in control, and trigger hold		
Millermatic® 350P Aluminum/ XR-Pistol-Pro System (Air-Cooled) (See literature DC/12.56)	951453	200(208)/230/460 V. True torque motor push-pull system. Note: The Millermatic 350P Aluminum is only compatible 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		
Leather Cable Cover	241159 248355 248377	15 ft. (4.6 m) 25 ft. (7.6 m) 35 ft. (10.6 m)		
One-Pound Spool Canister	132230			
50-Degree Curved Nozzle Kit-A	264064			
Replacement Contact Tips for Curved Nozzle		See page 5		
50-Degree Curved Nozzle Insulator Kit	264066	For use with 50-Degree Curved Nozzle Kit-A		
1/16-Inch (1.6 mm) Wire Kit	230708	Required when running 1/16-inch wire		
Hardwire Liner Kit for Steel and Stainless	198377			
Phosphorous Bronze Liners		See page 5		
Coolant Systems		See literature AY/7.2		

Date:

Total Quoted Price:

Distributed by:

