

# XR™ Control

Issued April 2005 • Index No. M/1.7

**Push-Pull  
Wire Feed System** 

## Quick Specs



### Heavy Industrial Applications

Emergency Vehicles    Recreational Vehicles  
Shipbuilding            Tool Boxes  
Trucks and Trailers    Heat Exchangers  
Railcars                  Sign Manufacturers  
Fabrication

### Processes

MIG (GMAW) Welding

### Input Power

24 VAC, 50/60 or  
100 Hz

**Rated Output** Air: 250 A at 100% Duty Cycle  
Water: 400 A at 100% Duty Cycle  
Python: 200 A at 100% Duty Cycle

**Wire Speed** 70–875 IPM (1.8–22.2 m/min)

**Weight** 38 lb (17.2 kg)

## The Power of Blue.®

Unique **solid-state control** permits XR systems to work with most CC, CV, or CC/CV, DC welding power sources.

**Digital display** indicates wire feed speed or weld voltage. Allows you to switch between wire feed speed and voltage display.

**Push-pull design** feeder motor provides continuous push force to the wire while the gun motor controls wire feed speed at the arc, together providing accurate and positive wire feed speed over long distances (15, 30, and 50 ft).

**Master/gun wire feed speed control** improves resolution by limiting speed range available at the gun, making it easier to fine-tune arc conditions.

**Unique arc starting control** can be adjusted to tune arc starting, reducing wire stubbing or arc flaring which can result in burnbacks to the contact tip.

**Gear-driven, smooth groove drive rolls** reduce deformation of the wire and provide positive feeding performance by having both rolls driving the wire, helping to reduce burnbacks and enhancing arc starts.

**Replaceable feed cable liner** 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 by allowing a simple means of changing drive rolls and head tube or performing routine maintenance without disassembly of gun.



Control shown with optional voltage control, gas flowmeter, and dual schedule control.

### A Complete System Consists of the Following:

- Control
- Gun
- Fastip™/Drive Roll Kit

*(Kits must be ordered separately and consist of gun drive rolls, control box drive rolls and five FasTip™ contact tips. XR-A Python® gun contains control box drive rolls only.)*

*See back page for more information on 3-step process used to order and assemble a complete system.*

Python® is a registered trademark of MK Products, Irvine, CA USA



Wire feeder is warranted for 3 years, parts and labor.  
Guns are warranted for 1 year.

**Trigger hold** reduces fatigue by allowing operator to weld without holding trigger.

**Wire jog control** allows wire to be threaded through gun cable without energizing weld output.

**Preflow/Postflow factory preset times:** 0.5 second preflow, 3.5 second postflow (unit arrives with default setting: preflow off, postflow on).

**Patented quick-change, single-turn contact tip** provides excellent performance and ease of replacement.

**New barrels are Roughneck and Bernard Centerfire compatible.** (See page 6 for optional consumables.)



Select from an XR-Pistol gun, an XR-Edge gooseneck-style gun or an XR-A Python gooseneck-style gun. All feature a quick-connect to the XR-Control. The XR-Pistol and XR-Edge are available in air- and water-cooled versions with 15 or 30 ft cable lengths. A 50 ft cable is also available for the XR-Edge. The XR-A Python is only available as an air-cooled version with 25 ft cable length.



The XR-Edge and XR-A Python guns also feature a toolless 360° rotating head tube that reduces operator fatigue by providing a simple means of positioning gun comfortably for various welding positions.

MADE IN USA  
APPLETON, WI



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



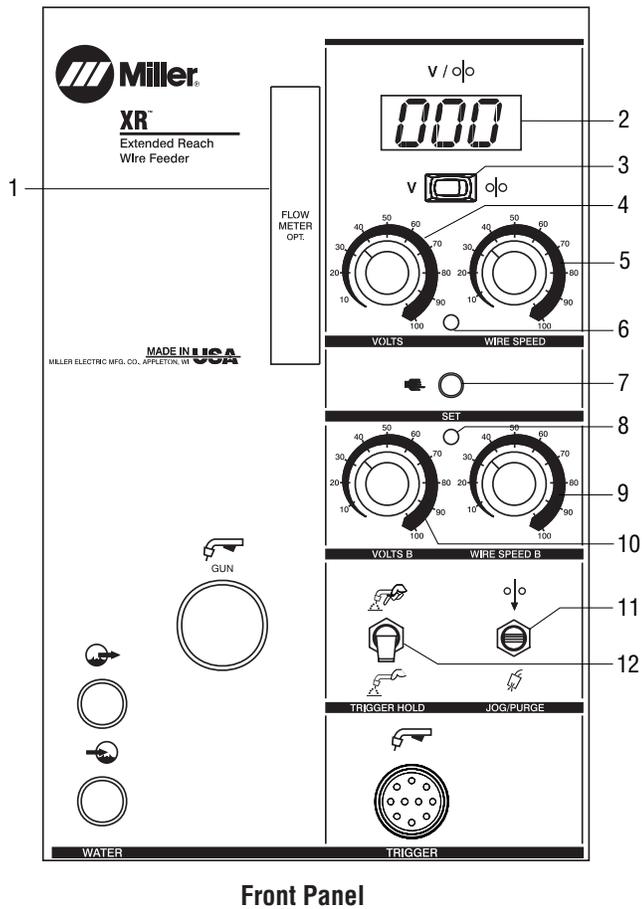
(Use with CC/CV, DC Power Sources.)

Input Power	Wire Speed	Maximum Spool Size Capacity	Dimensions	Net Weight
24 VAC, 50/60 or 100 Hz	70–875 IPM (1.8–22.2 m/min)	12 in (305 mm)	H: 16 in (406 mm) W: 9-1/4 in (235 mm) D: 21-1/4 in (540 mm)	38 lb (17.2 kg)

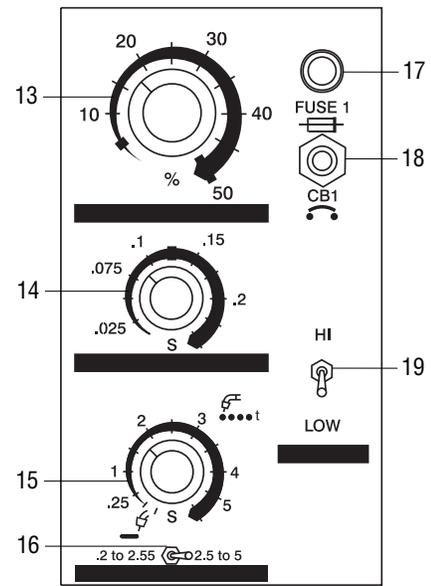
Certified to both the Canadian and U.S. Standards for welding equipment.

Conforms to European standards.

## XR-Control Panel



Front Panel



Side Panel

- 1. Gas Flowmeter\*
- 2. Voltage/Wire Speed Meter
- 3. Voltage/Wire Speed Switch
- 4. Voltage Control\*
- 5. Wire Speed Control
- 6. Schedule A Indicator LED\*
- 7. Press To Set Push Button\*
- 8. Schedule B Indicator LED\*
- 9. Wire Speed B Control\*
- 10. Remote Volts B Control\*
- 11. Wire Jog/Gas Purge Switch
- 12. Trigger Hold Switch
- 13. Run-In Speed Control
- 14. Burnback Time Control\*
- 15. Continuous/Spot Time Control\*
- 16. Spot Time Range Switch\*
- 17. Fuse F1
- 18. Circuit Breaker CB1
- 19. Motor Torque Switch

\* Optional

## XR-Control Genuine Miller Options

\*Factory option available only in XR-Control packages  
— see Ordering Information on page 8.



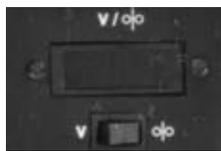
**Voltage Control\***  
**#194 027** Field  
Allows voltage adjustment at the current XR Control when used with Miller electrically controlled, constant-voltage DC power sources that have a 14-pin receptacle.



**Dual Schedule Control\*** **#193 276** Field  
Allows two different welding conditions (voltage and wire feed speed) to be used on the same wire. This is ideal

when different heat settings are required or when the need arises to change conditions while welding, i.e. different material thickness, out of position welding, etc. Is also ideal for use as a start control or crater fill control.

*Note: The Digital Display is required to use the Dual Schedule. Only for use with Miller CV or CC/CV power sources. Dual Schedule Switch required.*



**Digital Display V/WFS**  
**#193 274** Field  
For XR Control prior to serial #LC122752.

*Note: Voltage Sense Lead (#209 867) required for voltage display when used with non-solid-state Miller and competitive power sources.*

Allows wire feed speed to be preset and displayed. Will also monitor voltage while welding. If used with current manufactured Miller CV or CC/CV power sources (excluding CPs) and the optional voltage control or dual schedule control is used, the arc voltage can also be preset on the digital display. Includes back-lit LCD digital display that is easy to read in virtually any lighting condition. A selector switch allows the display to switch between wire feed speed and voltage.

### Dual Schedule Switch

**DSS-30 #193 271** Field  
For 15 ft (4.6 m) and 30 ft (9 m) guns

**DSS-50 #193 272** Field  
For 50 ft (15.2 m) gun

Required to operate the dual schedule control. A two position slide switch that can be positioned at the XR-Edge gun to remotely select schedule A or B conditions.



**Gas Flowmeter\***  
**#193 278** Field  
**#197 793** Field w/CE  
Monitors and adjust gas flow at the XR Control.

*Note: Gas pressure must be controlled at the primary gas supply with the use of a regulator.*



**Spot Weld/Burnback Control #193 279** Field  
Provides up to 5 seconds of spot weld time and 0 (zero) to 0.25 seconds of burnback time.

## XR-Control Genuine Miller Accessories



**Optima™ MIG (GMAW) Pulse Control #043 389**  
For Invision and XMT 304 CC/CV. A multipurpose, microprocessor-based pulse control for synergic MIG (wire welding or GMAW), manual MIG pulsing or standard MIG

welding. Use this control with all above power sources and any Miller wire feeder. Includes 25 ft (7.6 m) cord with 14-pin plug.



**PSA-2 Control #141 604**  
Required when using the XR Control with power sources having only 115 VAC available. Mounts at power source and includes a 10 ft (3 m) 115 VAC cord and

contactor cord with Hubbell connectors. A simple modification in the PSA-2 control also allows it to be used with competitive

constant voltage power sources requiring a contact closure for contactor control. The PSA-2 includes a 14-pin receptacle for direct connection of the standard interconnecting cord and optional extension cords. Bracket included for side mounting to the power source.

*Note: When using the PSA-2 control, the optional Remote Voltage Control is not functional.*

### Extension Cords

**#122 973** 25 ft (7.6 m)

**#122 974** 50 ft (15.2 m)

**#122 975** 75 ft (22.9 m)

Provides 14-pin, 24 VAC, contactor and voltage control. Can be added to the standard 10 ft (3 m) feeder cord to extend feeder farther from power source.

## Water Coolant Systems



**Coolmate™ 3 #043 007** 115 VAC  
**Coolmate™ 3 #043 008** 230 VAC  
**Coolmate™ V3 #043 009** 115 VAC  
**Coolmate™ 4 #042 288** 115 VAC

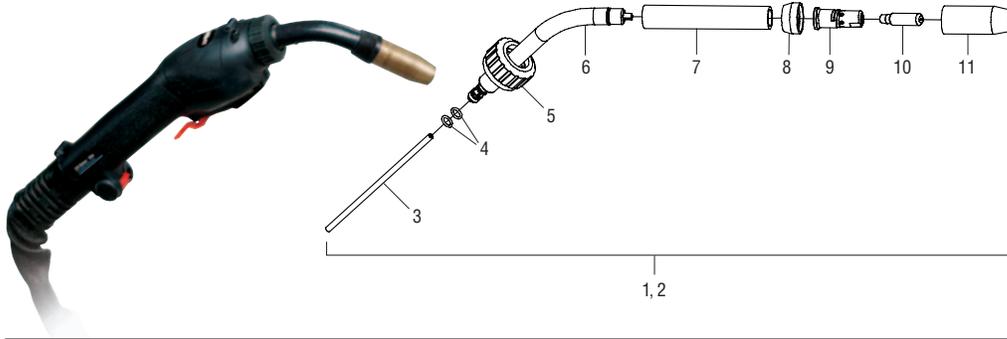
For use with water-cooled guns. Refer to Lit. Index No. AY/7.2 for additional coolant system information.

### Coolant #043 809

Sold in cases of four 1-gallon recyclable plastic bottles.

# XR Guns

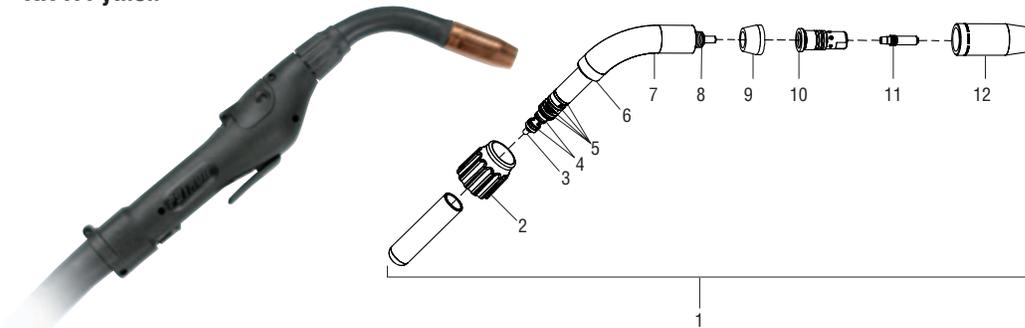
## XR-Edge (Air-Cooled Parts Breakdown and Gun Shown)



- 1. Air-Cooled Assembly **Kit #221 456**
- 2. Water-Cooled Assembly\* **Kit #221 457**
- 3. Head Tube Liner **#212 523**
- 4. Head Tube O-Ring **#191 191**
- 5. Lock Nut **#185 111**
- 6. Head Tube (Air-cooled) **#220 102**
- 7. Outer Insulating Jacket **#220 103**
- 8. Nozzle Insulator **#198 856**
- 9. Gas Diffuser **#206 195**
- 10. FasTip™ Contact Tip (See chart on pg 5)
- 11. Nozzle (See page 6)

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

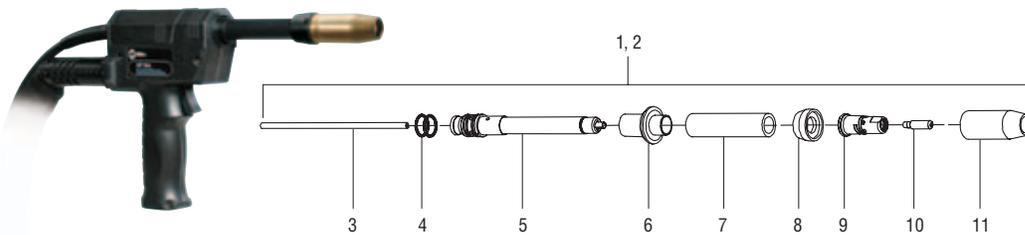
## XR-A Python



- 1. Air-Cooled Assembly **Kit #215 687**
- 2. Taper Lock Barrel **#220 725**
- 3. Liner **#215 689\***
- 4. Liner O-Ring **#215 694**
- 5. Head Tube O-Ring **#215 693**
- 6. Retaining Ring **#220 726**
- 7. Insulator **#220 727**
- 8. Barrel Bend **#215 694**
- 9. Nozzle Insulator **#198 856**
- 10. Diffuser **#206 195\***
- 11. FasTip™ Contact Tip\* (See chart on pg 5)
- 12. Copper Nozzle, 5 in orifice **#198 855\***

\*Recommended replacement parts.

## XR-Pistol (Air-Cooled Parts Breakdown and Gun Shown)



- 1. Air-Cooled Assembly **Kit #219 793**
- 2. Water-Cooled Assembly\* **Kit #221 518**
- 3. Head Tube Liner **#212 156**
- 4. O-Ring .614 ID **#134 800**
- 5. Head Tube (Air-cooled) **#219 796**
- 6. Barrel Pistol Insulator **#219 795**
- 7. Outer Insulating Jacket **#219 794**
- 8. Nozzle Insulator **#198 856**
- 9. Diffuser **#206 195**
- 10. Contact Tip (See consumables)
- 11. Nozzle (See optional consumables)

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

## XR Gun Specifications (Subject to change without notice.)

Model	Welding Output Range	Electrode Wire Diameter Capacity	Wire Speed	Dimensions	Net Weight
XR-A Edge Gun	Air: 250 A at 100% Duty Cycle	.030–.062 in (0.8–1.6 mm) aluminum wire	70–875 IPM (1.8–22.2 m/min)	H: 5 in (127 mm) W: 2-1/2 in (64 mm) D: 17 in (432 mm)	2.5 lb (1.1 kg)
XR-W Edge Gun	Water: 400 A at 100% Duty Cycle				
XR-A Python Gun	Air: 200 A at 100% Duty Cycle	.030–.062 in (0.8–1.6 mm) aluminum wire	70–875 IPM (1.8–22.2 m/min)	H: 5 in (127 mm) W: 2-1/2 in (64 mm) D: 16 in (406 mm)	2.5 lb (1.1 kg)
XR-A Pistol Gun	Air: 250 A at 100% Duty Cycle	.030–.062 in (0.8–1.6 mm) aluminum wire	70–875 IPM (1.8–22.2 m/min)	H: 7-3/8 in (187 mm) W: 1-7/8 in (48 mm) D: 10-5/8 in (270 mm)	2.4 lb (1.1 kg)
XR-W Pistol Gun	Water: 400 A at 100% Duty Cycle				

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

Python gun is not a CSA approved product.

Note: See back page for ordering XR-Edge FasTip™/Drive Roll Kits (one required), XR-A Python Drive Roll Kits (one required), and XR-Pistol FasTip™/Drive Roll Kits (one required).

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

Wire Size	FasTip Contact Tip	Standard XR-Edge Drive Rolls	Optional Isolated XR-Edge Drive Rolls	XR-Pistol Drive Rolls	XR-Pistol All-Wire Dual Groove Drive Rolls
.030 in (0.8 mm)	#206 186 .041 in ID	#194 114	#198 434	#183 357	#136 135
.035 in (0.9 mm)	#206 187 .047 in ID	#194 115	#198 435	#183 357	#136 135
.040 in (1.0 mm)	#206 188 .053 in ID	#196 302	#198 436	#183 357	#136 135
.047 in (1.2 mm)	#206 189 .061 in ID	#194 116	#198 437	#183 358	#136 135
.062 in (1.6 mm)	#206 190 .071 in ID	#194 117	#198 438	#183 358	#136 135

Head Tube Liners
#212 156 XR-Pistol
#212 523 XR-Edge

Cable Liners
#191 065 15 ft (4.6 m) or 30 ft (9.1 ft)
#191 066 50 ft (15.2 m)

XR-Control Drive Rolls
#194 118 .030 in (0.8 mm)
#194 118 .035 in (0.9 mm)
#196 301 .040 in (1.0 mm)
#194 119 .047 in (1.2 mm)
#195 591 .062 in (1.6 mm)

Note: These are replacement consumables. See back page for initial setup kits.

## XR-A Python Standard Replacement Consumables (Air-Cooled Only) (Order from Miller Service Parts.)

Wire Size	FasTip Contact Tip	Standard Knurled .030/.062 in Drive Roll	Optional Insulated Groove Drive Rolls*	Head Tube Liner	Cable Liner
.030 in (0.8 mm)	#206 186 .041 in ID	#215 672	#215 677	#215 689	#220 010 25 ft (7.62 m)
.035 in (0.9 mm)	#206 187 .047 in ID	#215 672	#215 678		
.040 in (1.0 mm)	#206 188 .053 in ID	#215 672	—		
.045/.047 in (1.2 mm)	#206 189 .061 in ID	#215 672	#215 681		
.062 in (1.6 mm)	#206 190 .071 in ID	#215 672	#215 684		

\*Kits include insulated drive roll and idler roll assembly.

Note: These are replacement consumables. See back page for initial setup kits.

## Genuine Miller XR Gun Optional Consumables (Order from Miller Service Parts.)

### Nozzles

- #176 238\* Spot Flat
- #176 240\* Spot Inside Corner
- #176 242\* Spot Outside Corner
- #199 610 Screw-on brass, 1/2 in orifice
- #199 611 Screw-on brass, 3/4 in orifice straight
- #199 612 Screw-on brass, 3/4 in orifice straight heavy-duty
- #199 613 Screw-on brass, 5/8 in orifice
- #199 614 Screw-on brass, 5/8 in orifice heavy-duty
- #199 615 Screw-on copper, 1/2 in orifice
- #199 616 Screw-on copper, 3/4 in orifice
- #199 617 Screw-on copper, 3/4 in orifice heavy-duty
- #198 855 Screw-on copper, 5/8 in orifice
- #199 618 Screw-on copper, 5/8 in orifice heavy-duty
- #207 313 Screw-on copper, 5/8 in orifice 15/16 O.D.

#209 035\*\* Screw-on copper, 3/8 in orifice tapered

#209 036\*\* Screw-on copper, 1/2 in orifice tapered

\*Requires Diffuser #209 099, used with any heavy-duty FasTip™ contact tip.

\*\*Requires Diffuser #206 195, #206 196, or #210 664. Used with any tapered FasTip™ contact tip.

### FasTip™ Contact Tips (25 per package)

#### Heavy-Duty

- #206 186 .030/.035 in (0.8/0.9 mm) aluminum wire
- #206 187 .040/.035 in (0.9/1.0 mm) aluminum wire
- #206 188 .040/.045 in (1.0/1.2 mm) aluminum wire
- #206 189 .052 in (1.3 mm) or 3/64 in (1.2 mm) aluminum wire
- #206 190 1/16 in (1.6 mm)
- #206 191 .068 in (1.7 mm) or 1/16 in (1.6 mm) aluminum wire

#### Tapered

- #209 026 .030/.035 in (0.8/0.9 mm) aluminum wire
- #209 027 .035/.045 in (0.9/1.2 mm) aluminum wire
- #209 028 3/64 in (1.2 mm)
- #209 029 .052 in (1.3 mm)
- #209 030 1/16 in (1.6 mm)

#### Gas Diffusers

- #206 195 Standard 1/8 in tip recess for heavy-duty FasTip contact tips.
- #210 664 1/4 in tip recess for heavy-duty FasTip contact tips.
- #206 196 Flush tip for heavy-duty FasTip contact tips.

## Centerfire® Series Optional Consumables (Order from Miller Service Parts.)

### T Series Contact Tips 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)  
**T-052** .052 in (1.4 mm)  
**T-062** 1/16 in (1.6 mm)  
**T-078** 5/64 in (2.0 mm)  
**T-094** 3/32 in (2.4 mm)  
**T-109** 7/64 in (2.8 mm)  
**T-125** 1/8 in (3.2 mm)

### TT Series Contact Tips 2 in (50.8 mm)

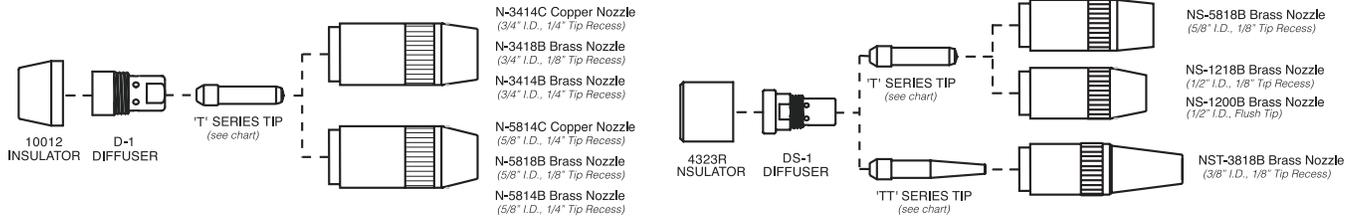
**TT-030** .030 in (0.8 mm)  
**TT-035** .035 in (0.9 mm)  
**TT-045** .045 in (1.2 mm)  
**TT-052** .052 in (1.4 mm)  
**TT-062** 1/16 in (1.6 mm)

**Insulator** 10012  
 4323R

**Diffuser** D-1  
 DS-1

### 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  
**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



## XR Gun Genuine Miller Accessories

### Cable Cover

**#118 677** 15 ft **#118 678** 30 ft  
 50 ft cable cover is not available. Protects gun hose and cable assembly from wear and abrasion. Features a full length zipper.

### Hardwire Liner Kits for Steel and Stainless

**#198 377** For 15 or 30 ft guns  
 For XR-Pistol and XR-Edge guns. Kits consist of gun head tube liner and feed cable liner. Recommend using .030–.045 in mild steel, flux cored, or stainless steel electrode wire.



**10 in Flex Head-A #222 735**  
 10 in (254 mm). For .030–1/16 in (0.8–1.6 mm) wire. Used in place of the standard straight barrel. Flexible head tube bends 60 degrees in any direction for easier joint access and improved operator comfort. Supplied with liners. Uses FasTip™ contact tips.



**10 in Head Tube-A #222 461**  
 Ideal when a longer reach is required.

### Replacement Liners for Air-Cooled Barrels (Order from Miller Service Parts.)

**For 6 in Curved Barrel #212 411** .030–1/16 in (0.8–1.6 mm) wire  
**For 10 in Head Tube #212 401** .030–1/16 in (0.8–1.6 mm) wire  
**For Flex Head #222 853** .030–.035 in (0.8–0.9 mm) wire  
**#222 854** .047–.062 in (1.2–1.6 mm) wire

### 50 Degree Curved Nozzle Kit-A #147 174

Attaches to old-style gun barrel assembly for access to confined weld joint areas. Used with .030–1/16 in (0.8–1.6 mm) wire. Kit includes two of each size contact tips to accommodate all wire sizes, Nozzle Adapter Kit (#193 794) and curved nozzle. Uses standard straight barrel head tube liner. *Note: Kit only works with old-style colleted multi-piece barrel #193 142 and can be ordered through Miller Service Parts. Kit will not work with new Roughneck-style one piece front end.*

### Replacement Contact Tips for Curved Nozzle (Order from Miller Service Parts.)

**#148 155** .030 and .035 in (0.8 and 0.9 mm) wire  
**#148 154** .047 (1.2 mm) wire  
**#148 156** 1/16 in (1.6 mm) wire

### XR-Pistol Gun Barrels (Water-Cooled)



**50 Degree Curved Barrel-W #222 464**  
 6 in (152 mm). Used with .030–1/16 in (0.8–1.6 mm) wire. Kits supplied with liner that accommodates all wire sizes.

### Replacement Liners for Water-Cooled Barrels (Order from Miller Service Parts.)

**For 6 in Curved Barrel #212 411** .030–1/16 in (0.8–1.6 mm) wire  
**For 10 in Straight Barrel #212 401** .030–1/16 in (0.8–1.6 mm) wire



**10 in Straight Barrel-W #222 463**  
 Used with .030–1/16 in (0.8–1.6 mm) wire. Kits supplied with liner that accommodates all wire sizes.



**1 lb (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 in (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. (Canister accommodates 4 in [102 mm] spools of wire.)

### XR-Pistol Gun Barrels (Air-Cooled)



**50 Degree Curved Barrel-A #222 462**  
 6 in (152 mm). Used with .030–1/16 in (0.8–1.6 mm) wire. Kits supplied with liner that accommodates all wire sizes.

# XMT Packages

**New!** XMT® 350 CC/CV XR™-Edge  
PULSERunner™ #951 033

**New!** XMT® 350 CC/CV Python®  
MIGRunner™ #907 235

**New!** XMT® 350 XR™-Edge  
MIGRunner™ #907 234

### Comes Complete With:

- XMT 350 CC/CV power source
- XR-Control
- 30 ft (9 m) XR-A Edge gun (air-cooled)
- Consumables
- .035 and .047 in drive roll kit
- Regulator/flow gauge with gas hose
- MIGRunner Cart with cylinder rack
- Bottom tray will hold optional Coolmate 3 (sold separately)
- Optima Pulse control (PULSERunner #951 033 only)

### Comes Complete With:

- XMT 350 CC/CV power source
- XR-Control
- 25 ft (7.6 m) Python® gun (air-cooled)
- Consumables (.035 and 3/64 in contact tips)
- Regulator/flow gauge with gas hose
- MIGRunner Cart with cylinder rack
- Bottom tray will hold optional Coolmate 3 (sold separately)

*Python® is a registered trademark of MK Products, Irvine, CA USA*

### Comes Complete With:

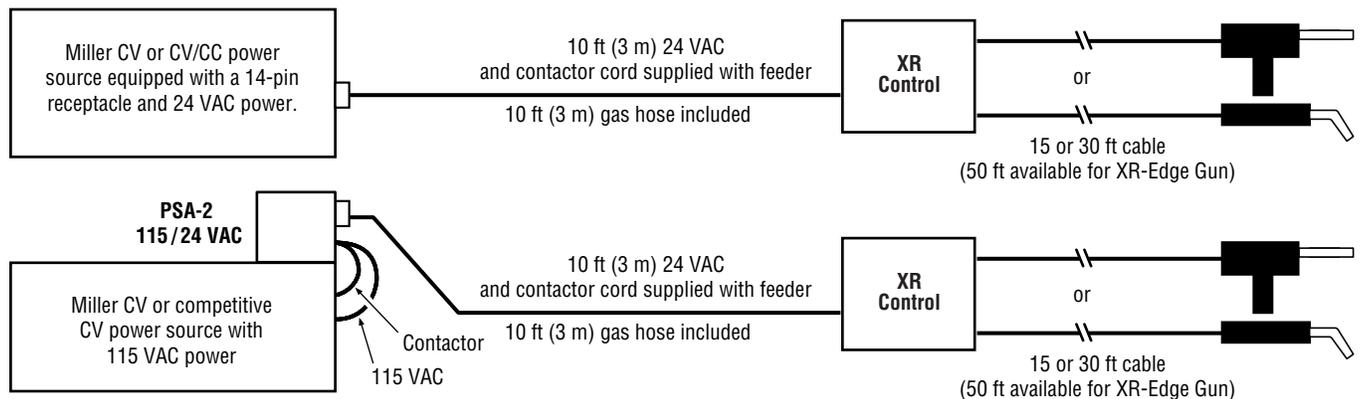
- XMT 350 CC/CV power source
- XR-Control
- 30 ft (9 m) XR-A Edge gun (air-cooled)
- Consumables
- .035 and .047 in drive roll kit
- Regulator/flow gauge with gas hose
- MIGRunner Cart with cylinder rack
- Bottom tray will hold optional Coolmate 3 (sold separately)



**Optima™  
Pulse Control**  
(comes with  
PULSERunner  
#951 033)



# Typical Installations



# Ordering Information (Use the 3-step process below to assemble a complete system.)

## How to Assemble a System

- 1** Pick a Control  
Standard or with Options



- 2** Pick a Gun Style  
Gooseneck or Pistol (15, 30 or 50 ft Cable, Air- or Water-Cooled) or Python Gooseneck (25 ft Cable, Air-Cooled)



- 3** Pick a FasTip™/Drive Roll Kit  
.030, .035, .040, .047 or .062 in (Kits consist of gun drive rolls, control box drive rolls and five FasTip contact tips.) Python kit contains control box drive roll only.

Equipment	Stock No.	Description	Qty.	Price
<b>Important: The XR-Control and specific type and length gun must be ordered separately. Also order proper FasTip™/Drive Roll Kit below for the size wire being used.</b>				
<b>XR™-Control</b>	<b>#181 538</b> <b>#181 538-01-1</b> <b>#181 538-03-3</b> <b>#181 538-04-2</b>	Standard model w/digital display Standard model w/digital display & w/CE W/digital display, voltage control & gas flow meter W/digital display, voltage control & gas flow mtr w/CE		
<b>XMT® 350 XR™-Edge Packages</b>	<b>#951 033</b> <b>#907 234</b>	<b>PULSERunner™</b> See pg 7 for package description <b>MIGRunner™</b> See pg 7 for package description		
<b>XMT® 350 XR™-A Python® MIGRunner™ Package</b>	<b>#907 235</b>	See page 7 for package description		
XR-A Edge Gun (Air-Cooled)	<b>#181 534</b> <b>#181 535</b> <b>#181 537</b>	15 ft (4.6 m) cable 30 ft (9 m) cable 50 ft (15.2 m) cable	<i>All XR-Edge guns have CE approval.</i>	
XR-W Edge Gun (Water-Cooled)	<b>#181 531</b> <b>#181 532</b> <b>#181 533</b>	15 ft (4.6 m) cable 30 ft (9 m) cable 50 ft (15.2 m) cable		
XR-A Pistol Gun (Air-Cooled)	<b>#198 127</b> <b>#198 128</b>	15 ft (4.6 m) cable 30 ft (9 m) cable		
XR-W Pistol Gun (Water-Cooled)	<b>#198 129</b> <b>#198 130</b>	15 ft (4.6 m) cable 30 ft (9 m) cable		
XR-A Python Gun (Air-Cooled)	<b>#195 373</b>	25 ft (7.62 m) cable		
XR-Edge Gun FasTip™/Drive Roll Kits (One required—See page 5 for Isolated Drive Rolls)	<b>#195 208</b> <b>#195 207</b> <b>#195 206</b> <b>#195 205</b> <b>#195 204</b>	.030 in (0.8 mm) .035 in (0.9 mm) .040 in (1.0 mm) .047 in (1.2 mm) .062 in (1.6 mm)		
XR-Pistol Gun FasTip™/Drive Roll Kits (One Required)	<b>#195 213</b> <b>#195 212</b> <b>#195 211</b> <b>#195 210</b> <b>#195 209</b>	.030 in (0.8 mm) .035 in (0.9 mm) .040 in (1.0 mm) .047 in (1.2 mm) .062 in (1.6 mm)		
XR-A Python Control Box Drive Roll Kits (one required) <i>Note: Includes control box drive rolls only, contact tips must be ordered separately.</i>	<b>#194 118</b> <b>#194 118</b> <b>#196 301</b> <b>#194 119</b> <b>#195 591</b>	.030 in (0.8 mm) .035 in (0.9 mm) .040 in (1.0 mm) .047 in (1.2 mm) .062 in (1.6 mm)		

## Recommended Power Sources\*

Deltaweld® Series	Lit. Index No. DC/16.2
XMT® 350	Lit. Index No. DC/18.8
Invision™ 354 MP	Lit. Index No. DC/23
Trailblazer® 301 G	Lit. Index No. ED/4.77
Big Blue Air Pak™	Lit. Index No. ED/10.5
PipePro™	Lit. Index No. ED/10.6
Trailblazer® 301 D	Lit. Index No. ED/4.8
Millermatic® 350/350P	Lit. Index No. DC/12.51

\*Other power sources may be used.

**Important note:** The products and descriptions mentioned in this literature are for use with XR-Control systems with serial #KK309906 or higher. To confirm compatibility of any products listed here with older equipment, please contact the factory at 1-920-735-4505.

<b>Options</b>				
Voltage Control	<b>#194 027</b>	Field		
Dual Schedule Control	<b>#193 276</b>	Field		
Digital Display V/WFS	<b>#193 274</b>	Field. For XR-Control prior to serial #LC122752		
Remote Volt Sense Lead	<b>#209 867</b>	Field. Required for CC, competitive or non-solid-state Miller power sources		
Dual Schedule Switch	<b>#193 271</b> <b>#193 272</b>	Field. For 15 ft (4.6 m) and 30 ft (9 m) guns Field. For 50 ft (15.2 m) gun		
Gas Flowmeter	<b>#193 278</b> <b>#197 793</b>	Field Field w/CE		
Spot Weld/Burnback Control	<b>#193 279</b>	Field		
<b>Accessories</b>				
Optima MIG Pulse Control	<b>#043 389</b>			
PSA-2 Control	<b>#141 604</b>	For older power sources w/ 115 V feeder power		
Extension Cords		See XR-Control Accessories on page 3		
Water Coolant Systems		See Lit. Index No. AY/7.2		
Cable Cover	<b>#118 677</b> <b>#118 678</b>	15 ft (4.5 m) 30 ft (9 m)		
Spool Canister	<b>#132 230</b>			
XR-Pistol Gun Barrels		See page 6		

Date:

Total Quoted Price:

Distributed by:

