

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)

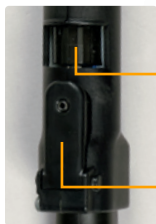
Net Weight (Gun Only)

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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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)

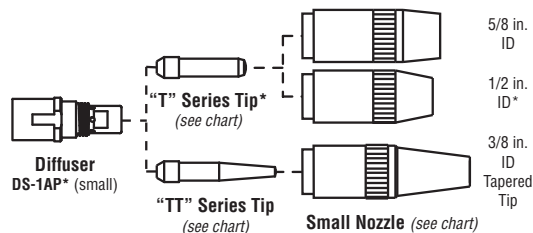
TT-030 .030 in. (0.8 mm)
TT-035 .035 in. (0.9 mm)
TT-045 .045 in. (1.2 mm)

Small Nozzles

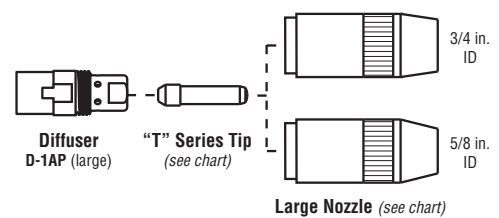
NST-3818B Brass, 3/8 in. ID, 1/8 in. recess
NS-1218B Brass, 1/2 in. ID, 1/8 in. recess
NS-1200B Brass, 1/2 in. ID, flush
NS-5818B Brass, 5/8 in. ID, 1/8 in. recess
NS-1218C* Copper, 1/2 in. ID, 1/8 in. recess

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

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

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
XR-Aluma-Pro™ Lite	300948	175-amp, air-cooled push-pull gun with 25 ft. (7.6 m) cable		
Recommended Power Sources				
Millermatic® 255 (See literature DC/12.8)	951766	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)	951767	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)	951926	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		
Recommended Wire Feeder				
XR-AlumaFeed® Suitcase® (See literature DC/34.0)	301567	Feeder only. Includes .035 and 3/64 in. drive rolls		
Accessories				
Leather Cable Cover	234110	25 ft. (7.6 m)		
Short Leather Gun Cover	234416	17 in. (432 mm)		

Date:

Total Quoted Price:

Distributed by:

