

XMT[®] 350 MPa

With ArcReach[™]

Multiprocess Welding Power Source 

Quick Specs

Heavy Industrial Applications

Construction
Shipbuilding
Fabrication
Repair shops
Rental fleets
Power generation plants

Processes

MIG (GMAW)/Pulsed MIG (GMAW-P)
Stick (SMAW)
TIG (GTAW)
Flux-cored (FCAW)
Air carbon arc cutting and gouging (CAC-A)
Rated: 1/4-inch carbons
Capable: 5/16-inch carbons

Input Power Auto-Line[™], 208–575 V
Requires 3- or 1-phase power

Output Range 10–38 V, 15–425 A

Net Weight 80 lb. (36.3 kg)

Aux. Power (optional) 120 V, 10 amps

ArcReach Remote voltage control without a control cable

Portability and excellent arc performance make the XMT 350 MPa with ArcReach the most popular in the industry.

With multiprocess capabilities and features like Auto-Line, the XMT 350 MPa with ArcReach is versatile for portable applications around any jobsite.



Input power management for portability



Lightweight and portable



Best multiprocess capabilities



ArcReach[™] — remote control without a cord



Power source is warranted for three years, parts and labor. Original main power rectified parts are warranted for five years.



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Features



For portability and reliability, Auto-Line allows for any input voltage hookup (208–575 V, single- or three-phase) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable input power.

Auto Remote Sense™ enables unit to automatically use remote control if connected to remote control receptacle.

Tweco-style weld disconnects provide high-quality weld cable connections. Note Tweco cable connectors are not supplied with the unit and must be order separately.

14-pin receptacle has the flexibility to be used with spool guns, feeders, and remote controls.

Optional 115-volt auxiliary power provides 10 amps of circuit-breaker-protected power for coolant systems, etc.

Insight Core™

Optional Welding Intelligence™ system. XMT CC/CV and MPa models are Insight capable to monitor weld voltage, amperage, and arc-time and percentage.

Multiprocess weld quality

High-quality performance in all welding processes.

Adaptive Hot Start™ makes starting stick electrodes easy without creating an inclusion.

Infinite arc control available in the stick and wire modes for easier fine tuning of tough-to-weld materials and out-of-position applications.

Lift-Arc™ provides arc starting that minimizes contamination of the electrode and without the use of high-frequency.

Reliability

Wind Tunnel Technology™ Internal air flow that protects electrical components and PC boards from dirt, dust debris... greatly improving reliability.

Fan-On-Demand™ cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through machine.

Lightweight aerospace-grade aluminum case offers protection with the benefit of reduced weight.

Welder-friendly control panel

Process selector switch reduces the number of control setup combinations without reducing any features.

Large, dual digital meters are easy to view and are presettable to ease setting weld output.

Ultra-tough polycarbonate-blended cover protects front controls from damage.

Setup indicator lights

- Arc control indicator
- Wire type indicator
- Gas type indicator
- Setup button

Portability

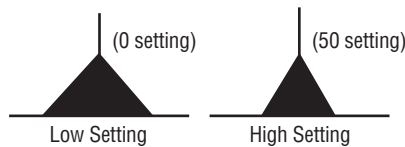
Jobsite mobility is made easy with a small, compact design and Auto-Line technology.

Pulsed MIG Programs

Built-in pulse programs for fabrication applications that have benefits for standard and high-strength steels.

Advanced arc control enables an improved pulse welding arc. The operator has more control over puddle and bead characteristics using SharpArc. In addition, the unit provides a more robust and stable arc at very low arc length, reducing heat input, and providing the ability to weld on a wider range of material thickness.

SharpArc® controls the arc in pulsed MIG mode and gives total control over the arc cone shape, puddle fluidity and bead profile. If a gas is used other than what is listed in the chart above, SharpArc can be adjusted to help customize your arc to the gas being used. Lower SharpArc™ settings widen the arc cone, increase puddle fluidity and flattens the weld bead.

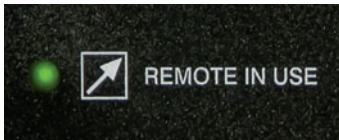


Built-in pulsed MIG programs provide reduced heat affected zone, weld in all positions, great for thick-to-thin metal, good gap filling ability and faster travel speeds and deposition. See the table below for the wide range of pulsed MIG (GMAW-P) welding applications the XMT MPa models can handle.

Wire Types — diameter in inches (mm)		Gas Types*
Steel	.035 (0.9) STL, .045 (1.2) STL	90 ARGN CO ₂ (argon/carbon dioxide)
Steel 100S	.035 (0.9) STL, .045 (1.2) STL	100S C5 (95 argon/5 carbon dioxide)
Metal Core	.045 (1.2) MCOR, .052 (1.4) MCOR	90 ARGN CO ₂ (argon/carbon dioxide)
Inconel	.035 (0.9) INCO, .045 (1.2) INCO	ARGN (argon)

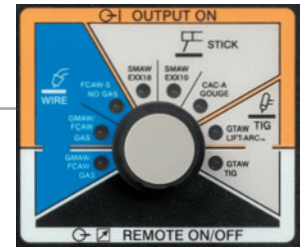
*Note: Other normal gas mixtures can be used by adjusting arc length and SharpArc. Use the program closest to your gas mixture, and wire type and size.

ArcReach™ Features and Advantages



Remote in use indicator provides convenient feedback indicating an ArcReach wire feeder is controlling the power source. While under ArcReach control, process and voltage/amperage adjustments are locked out, preventing accidental changes by personnel other than the welding operator.

Auto-Bind automatically establishes an exclusive communication between the power source and the wire feeder, using the existing weld cables upon system power up.



LED process indicator. Front panel process selections are illuminated with an LED that identifies the active process. This enables the selected weld process to be seen at a distance from the power source.

Includes new carbon arc gouging mode for enhanced arc stability and control, and two new stick modes (EXX10 and EXX18) designed to reduce spatter and enhance arc starts.

Fleet compatibility. ArcReach-equipped power sources and wire feeders work with non-ArcReach equipment; however, the complete ArcReach benefit is only realized with the ArcReach system.

ArcReach provides remote voltage control at the wire feeder without needing a control cord.



Increased productivity

More arc-on time and reduced exposure to workplace hazards for operators can be realized using ArcReach because less time is spent going back to the welding power supply to set process and arc voltage.

Auto-Process Select.™ System automatically changes to MIG/FCAW (with gas) if electrode positive polarity is detected or FCAW (no gas) if electrode negative polarity is detected, when ArcReach communication is established between the feeder and the XMT — reducing the need to access the power supply.

Automatic return to panel settings. System automatically returns to XMT setting when ArcReach communication is terminated. For example, if the XMT is set to gouging at 350 amps and an ArcReach feeder is connected, the XMT will go to a MIG/FCAW process. If the feeder is disconnected, the XMT will go back to its previous setting (gouging at 350 amps).

Less operator fatigue by not needing to move or reposition both heavy secondary weld leads bundled with control cords on the jobsite. Control cables are not used.



Improved weld quality

Remote override of XMT. When an ArcReach feeder is connected to an XMT the feeder has full control and the XMT controls are disabled. While under ArcReach control, process and voltage/amperage adjustments are locked out, preventing accidental changes by personnel other than the welding operator.

Operator can precisely set arc voltage at the feeder and monitor the actual arc voltage and current delivered to the weld using the digital meters on the feeder. This removes guesswork when it comes to adhering to weld procedures.

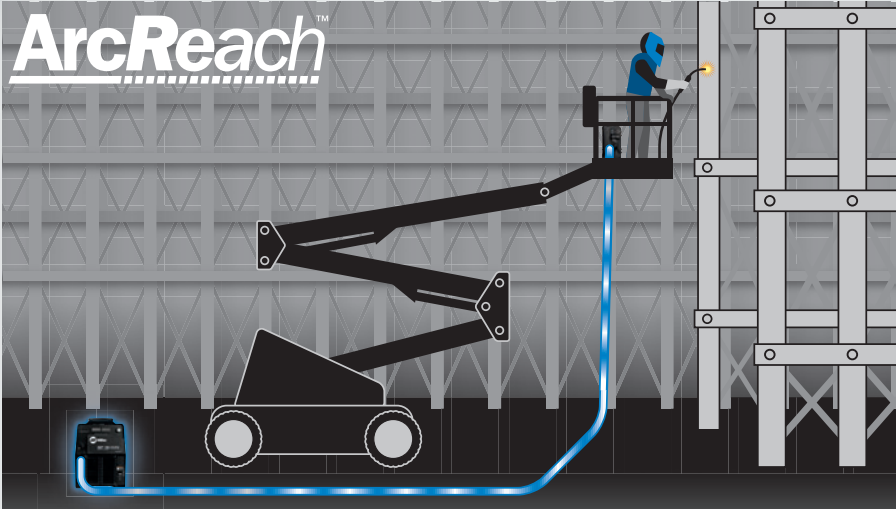


Reduced maintenance

Save time by no longer needing to troubleshoot welding system problems that result from damaged control cords.

Eliminate costly control cord repairs because control cords are not used.

ArcReach™



Remote control of the power source without a cord

ArcReach technology uses the existing weld cable to communicate welding control information between the feeder and power source. This technology eliminates the need for control cords, and their associated problems and costs.

Specifications (Subject to change without notice.)

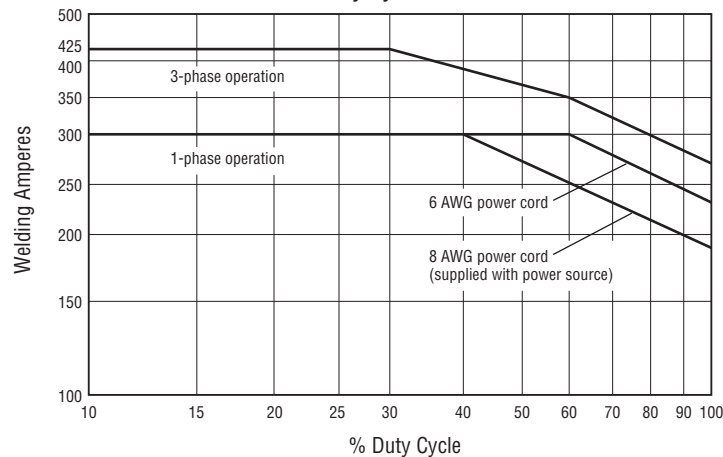


Input Power	Voltage Range in CV Mode	Amperage Range in CC Mode	Rated Output	Amps Input at Rated Load Output, 60 Hz						Max. Open-Circuit Voltage	Dimensions	Net Weight	
				208 V	230 V	400 V	460 V	575 V	KVA	KW			
Three-phase	10–38 V	5–425 A	350 A at 34 VDC, 60% duty cycle	40.4	36.1	20.6	17.8	14.1	14.2	13.6	75 VDC	H: 17 in. (432 mm) W: 12.5 in. (318 mm) D: 24 in. (610 mm)	80 lb. (36.3 kg)
Single-phase	10–38 V	5–425 A	300 A at 32 VDC, 60% duty cycle	60.8	54.6	29.7	24.5	19.9	11.7	11.2			

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Performance Data

Duty Cycle Chart





MIGRunner™ Cart 195445
Easily maneuverable, with cylinder rack low enough that you do not have to lift bottles.



Running Gear Cylinder Rack 300408
For dual feeders. Easily maneuverable, with cylinder rack low enough that you do not have to lift bottles. Has gun cable hangers and a consumable drawer in front.



Protective Cover 195478
Mildew and water resistant, odor-free cover protects your machine's finish.

Remote Controls



Wireless Remote Foot Control 300429
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.



Wireless Remote Hand Control 300430
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.



RFCS-14 Foot Control 043554
Foot current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.



RHC-14 Hand Control*
242211020 20-foot (6 m) cord
242211100 100-foot (30.5 m) cord
Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 82 mm). Includes cord and 14-pin plug.
**For additional lengths visit MillerWelds.com/equiptoweld.*



RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Allows complete current and contactor control at operator's fingertips. Includes 26.5-foot (8 m) cord and 14-pin plug.



RCCS-14 Remote Contactor and Current Control 043688
North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Great for applications that require a finer amperage control. Includes 26.5-foot (8 m) cord and 14-pin plug.

Extension Cables for Remote Controls and 24 VAC Wire Feeders*

242208025 25 ft. (7.6 m)

242208050 50 ft. (15 m)

242208080 80 ft. (24.3 m)

14-pin plug to 14-pin socket. Not for use with XR-AlumaFeed or 70 Series MPa feeder.

**For additional lengths visit MillerWelds.com/equiptoweld.*

Wire Feeders/Guns



SuitCase® X-TREME™ 8VS ArcReach

- 951588** With Bernard™ S-Gun™
- 951584** With Bernard™ BTB Gun 300 A

SuitCase® X-TREME™ 12VS ArcReach

- 951589** With Bernard™ S-Gun™
- 951581** With Bernard™ BTB Gun 300 A

Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source provides remote control of the power source without a cord — saving time and money. See literature M/6.42.



SuitCase® 12RC Wire Feeder **951580**

Lightweight and flexible enough to run a variety of wires up to .062-inch diameter. Holds up to a 12-inch spool of wire. Operates using 14-pin control receptacle. Includes remote voltage control, drive roll kit and Bernard™ BTB Gun 300 A. See literature M/6.5.



70 Series Wire Feeders

- S-74 MPa Plus** **951291** single feeder
- D-74 MPa Plus** **951292** dual feeder

Order XR-Aluma-Pro Plus gun and U-grooved drive rolls separately to match your aluminum needs. Above models are optimized for XMT 350 MPa and have push-pull capability.

- S-74S** **951196** single feeder
- S-74D** **951198** single feeder
- D-74S** **951203** dual feeder
- D-74D** **951204** dual feeder

70 Series feeders feature Posifeed™ wire drive assembly and handle a variety of wires. Each includes a 15-foot Bernard™ BTB Gun 400 A (two for dual feeders) and .035/.045-inch V-grooved drive rolls. See literature M/3.0.

Extension Cables*

- 247831025** 25 ft. (7.6 m)
- 247831050** 50 ft. (15.2 m)
- 247831080** 80 ft. (24.4 m)

Eleven conductors to support contactor control and remote voltage control on all Miller electronic CV 14-pin power sources. Additional functions supported when using MPa power sources include synergic pulsed MIG, remote process select and side select capabilities.

**For additional lengths visit MillerWelds.com/equiptoweld.*

Stick/TIG Remote



ArcReach Stick/TIG Remote **301325**

When paired with an ArcReach power source, provides remote control of the power source without a cord — saving time and money. See literature AY/14.5.

Welding Intelligence™



Insight Core™ 14-pin Module **301072**

Easy-to-install module brings Insight Core capabilities to your existing fleet. This simplified, Internet-based weld data solution collects, transmits and presents actionable information to any Web-connected device. Insight Core can help you increase productivity, improve weld quality and manage costs.

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
XMT® 350 MPa with ArcReach™	907366023	208–575 V with Auto-Line™		
	907366024	208–575 V with Auto-Line™ and auxiliary power		
Gas Valve Kit	195286	For XMT 350		
Accessories				
MIGRunner™ Cart	195445			
Running Gear Cylinder Rack	300408	For dual feeders		
Protective Cover	195478			
Remote Controls				
Wireless Remote Foot Control	300429	Foot control with wireless 90 ft. (27.4 m) operating range		
Wireless Remote Hand Control	300430	Hand control with wireless 300 ft. (91.4 m) operating range		
RFCS-14	043554	Foot control		
RHC-14	242211020 242211100	Hand control with 20 ft. (6 m) cord Hand control with 100 ft. (30.5 m) cord		
RCC-14	151086	Fingertip control (east/west)		
RCCS-14	043688	Fingertip control (north/south)		
Extension Cables		See page 5		
Wire Feeders/Guns				
SuitCase® X-TREME 8VS ArcReach™	951588	With Bernard™ S-Gun™		
	951584	With Bernard™ BTB Gun 300 A		
SuitCase® X-TREME™ 12VS ArcReach™	951589	With Bernard™ S-Gun™		
	951581	With Bernard™ BTB Gun 300 A		
SuitCase® 12RC	951580	See literature M/6.5		
70 Series MPa Plus	951291	S-74 MPa (single-wire). Works synergically with MPa power sources		
	951292	D-74 MPa (dual-wire). Works synergically with MPa power sources		
70 Series	951196	S-74S		
	951198	S-74D		
	951203	D-74S		
	951204	D-74D		
Extension Cables (for MPa Plus feeders)		See page 6		
Bernard™ BTB MIG Guns		See Bernard literature SP-BTB		
Stick/TIG Remote				
ArcReach™ Stick/TIG Remote	301325	Point-of-use control for stick or TIG welding and gouging with XMT 350 MPa ArcReach		
Welding Intelligence				
		See page 6		

Date:

Total Quoted Price:

Distributed by:

