



74 MPa Plus See literature M/3.0

Feeders for heavy-duty industrial applications with features for weld control and programs, plus push-pull aluminum capabilities. Optimized with AlumaPower™ MPa or XMT® MPa power sources.

Available in dual-wire models which allow two different wire types to be available on one feeder, avoiding downtime from changing spools and drive rolls.

Toolless rotatable drive assembly allows operator to rotate the drive housing, allowing a straight path for wire flow.

Accu-Mate™ properly seats the MIG gun power pin for best feeding performance.

High-torque permanent-magnet motor, sealed ball bearing gear drive and solid-state speed and brake control are maintenance free for long life.

Digital meters ensure accuracy when presetting and reading actual voltage, amperage and wire feed speed.

Remote voltage control allows you to set both voltage and wire feed speed at the feeder, saving time and increasing weld quality.

Adjustable run-in control for improved arc starts.

Dual schedule control allows the operator to switch between two preconfigured welding parameters without readjusting the machine, saving time and enhancing quality.

Trigger schedule select saves time when switching between two weld settings by simply tapping gun trigger.

Trigger program select provides the ability to access any of the four active programs.

Sequence control gives the operator the ability to adjust all of the welding parameters: preflow, run-in, weld time, crater, burnback and postflow.

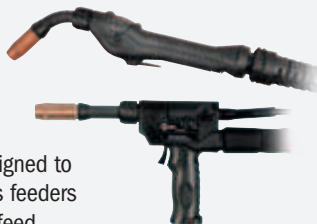
Locks and limits for restricting or limiting operator adjustments, such as voltage and wire feed speed parameters.

Four weld program memories allow operators to recall up to four previously used processes and their weld settings.

Push-pull capability provides consistent, versatile and dependable aluminum wire feeding over greater distances.

Recommended aluminum solution.

XR Plus guns (gooseneck and pistol grip) are designed to work with MPa Plus feeders to coordinate wire feed speed of the gun and the feeder. This provides optimized aluminum feeding and welding performance. See chart below for gun models and stock numbers.



Additional features when used with AlumaPower MPa or XMT MPa power sources

Synergic pulsed MIG. As wire speed increases/decreases, pulse parameters also increase/decrease to match the right amount of power needed, reducing the need to make additional adjustments.

Profile Pulse™ provides TIG appearance with MIG simplicity and productivity. Achieve “stacked dimes” without gun manipulation. Profile Pulse frequency can be changed to increase or decrease the spacing between the ripple pattern to achieve the desired weld appearance.



Heavy industrial

Use with CV, DC power sources.

Processes

- MIG (GMAW) ▪ Flux-cored (FCAW)
- Pulsed MIG (GMAW-P) with MPa Plus feeder and MPa power source

Suggested power sources

- AlumaPower™ MPa
- XMT® Series

Suggested guns

- Bernard® Guns
- XR-Aluma-Pro™ Plus and XR™-Pistol Plus (see chart below)

Most popular accessories

- Feeder Cart 142382
- Extension Cables
- Spool Adapter 047141
- Turntable Assembly 146236
- Wire Straightener
- Field Kits for 20 Series Basic 301513 Digital meter and remote voltage control
- 301515 Run-in control
- Hanging Bail 058435
- Spool Covers 057607 For 20 Series and 74 MPa Plus single-wire models and left side of dual-wire models
- 090389 For right side of 74 MPa Plus dual-wire models
- Wire Reel Assembly 108008
- Remote configurations are available – see literature M/3.0

*Requires wire kit (230708) to run 1.6 mm (1/16 in.) wire.

Model	Stock Number	Input Power	Wire Feed Speed	Wire Type and Diameter Capacity	Maximum Spool Size Capacity	Dimensions	Net Weight	
20 Series	Basic 301499, CE Digital 301499001, CE	24 VAC, 3.5 A, 50/60 Hz	1.9–19 m/min. (75–750 ipm)	0.6–2.0 mm (.023–5/64 in.)	27 kg (60 lb.) coil with optional wire reel assembly (108008)	H: 406 mm (16 in.) W: 314 mm (12.375 in.) D: 708 mm (27.875 in.)	21 kg (46 lb.)	
74 MPa Plus	300577 S-74 MPa Plus single-wire feeder, CE	24 VAC, 10 A, 50/60 Hz	1.3–19.8 m/min. (50–780 ipm)	Solid wire 0.6–2.0 mm (.023–5/64 in.) Aluminum* 0.9–1.6 mm (.035–1/16 in.)	27 kg (60 lb.) coil with optional wire reel assembly (108008)	H: 356 mm (14 in.) W: 318 mm (12.5 in.) D: 711 mm (28 in.)	21.2 kg (48 lb.)	
	300578 D-74 MPa Plus dual-wire feeder, CE					H: 356 mm (14 in.) W: 533 mm (21 in.) D: 889 mm (35 in.)	39.5 kg (87 lb.)	
Optional Push-Pull Gun (For MPa Plus feeders only)	4.6 m (15 ft.)	Cable Length 7.6 m (25 ft.) 10.6 m (35 ft.)		Welding Current Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Dimensions	Net Weight
XR-Aluma-Pro Plus (Air-cooled)	301575	301574	—	300 A at 100% duty cycle	1.8–23 m/min. (70–900 ipm)	Aluminum* 0.8–1.6 mm (.030–1/16 in.)	H: 127 mm (5 in.)	1.1 kg (2.5 lb.)
XR-Aluma-Pro Plus (Water-cooled)	301576, CE	301577, CE	—	400 A at 100% duty cycle			W: 64 mm (2.5 in.) L: 432 mm (17 in.)	1.3 kg (2.9 lb.)
XR-Pistol Plus (Air-cooled)	300753	300754	—	200 A at 100% duty cycle	1.8–23 m/min. (70–900 ipm)	Aluminum* 0.8–1.6 mm (.030–1/16 in.)	H: 187 mm (7.375 in.) W: 48 mm (1.875 in.)	1 kg (2.2 lb.)
XR-Pistol Plus (Water-cooled)	—	300757	—	400 A at 100% duty cycle			L: 270 mm (10.625 in.)	1.1 kg (2.4 lb.)