



XR™ Push-Pull Guns

XR-Aluma-Pro and XR-Pistol guns work in conjunction with an XR Control, XR-AlumaFeed or select Millermatic machines to provide the best solution for push-pull applications.



Threaded quick-change 360-degree rotatable head tubes are available in different bends and lengths for even those hard-to-reach welds. Over 30 different styles to fit your application and welder's preference.

Wire tension settings (except XR-Pistol). 4000- or 5000-specific tension settings ensure the very best wire feeding performance and arc consistency.

Heavy-duty construction. All internal components are designed to provide long lasting performance and feeding precision.

XR-Aluma-Pro™ Lite See literature M/1.75

Lightest weight gooseneck-style gun features rear trigger that allows access to hard-to-reach welds.

XR-Aluma-Pro™ See literature M/1.71

Robust professional-grade gun has the highest duty cycle rating in its class.

Easy access to drive assembly and removable toolless head tube reduce service time by allowing a means of changing drive rolls and head tube, or performing routine maintenance, without disassembly of gun.



XR™-Pistol See literature M/1.73

Reliable, cost-effective gun for light- to medium-industrial applications.

XR™-Pistol-Pro See literature M/1.74

Exceptional aluminum welding results for heavy-industrial applications.

Most durable motor and drive design improves feedability and arc consistency while helping reduce downtime and maintenance costs.

Easy access to drive assembly and removable toolless head tube reduce service time by allowing a means of changing drive rolls and head tube, or performing routine maintenance, without disassembly of gun.

Industrial ● XR-Aluma-Pro Lite
Heavy industrial ● XR-Aluma-Pro and all Pistol models

CC CV Use with CC/CV, DC power sources.

Processes

- MIG (GMAW) with aluminum wire (capable of other wires with optional solid wire kits)
- Pulsed MIG (GMAW-P) with pulsing power source

Suggested feeders/controls

- XR-AlumaFeed® SuitCase®

Suggested power sources

- Millermatic® 255 (XR-Aluma-Pro Lite, XR-Aluma-Pro and XR-Pistol-Pro guns only)
- Millermatic® 355 (XR-Aluma-Pro Lite, XR-Aluma-Pro and XR-Pistol-Pro guns only)
- Multimatic® 255 (XR-Aluma-Pro Lite, XR-Aluma-Pro and XR-Pistol-Pro guns only)

These power sources require an XR-AlumaFeed SuitCase

- AlumaPower™ MPa
- Deltaweld® 350/500 (14-pin receptacle models only)
- XMT® Series
- Trailblazer® Series

Most popular accessories

- Solid Wire Liner Kit 198377

*Dependent on control box or Millermatic used. **Requires wire kit (230708) to run 1.6 mm (1/16 in.) wire.

Model	Cable Length				Welding Current Rating	Wire Feed Speed*	Wire Type and Diameter Capacity	Dimensions	Gun Only Net Weight
	4.6 m (15 ft.)	7.6 m (25 ft.)	9 m (30 ft.)	10.6 m (35 ft.)					
XR-Aluma-Pro Lite (Air-cooled)	—	300948	—	—	175 A at 60% duty cycle	1.8–23 m/min. (70–900 ipm)	Aluminum 0.8–1.2 mm (.030–.047 in.)	H: 102 mm (4 in.) W: 48 mm (1.9 in.) L: 381 mm (15 in.)	0.9 kg (2.0 lb.)
XR-Aluma-Pro (Air-cooled)	301568	301569	—	301570	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.) W: 64 mm (2.5 in.) L: 432 mm (17 in.)	1.1 kg (2.5 lb.)
XR-Aluma-Pro (Water-cooled)	301571, CE	301572, CE	—	301573, CE	400 A at 100% duty cycle				1.3 kg (2.9 lb.)
XR-Pistol (Air-cooled)	198127, CE	—	198128, CE	—	200 A at 100% duty cycle	1.8–22.2 m/min. (70–875 ipm)	Aluminum 0.8–1.6 mm (.030–1/16 in.)	H: 187 mm (7.375 in.) W: 48 mm (1.875 in.) L: 270 mm (10.625 in.)	1 kg (2.2 lb.)
XR-Pistol (Water-cooled)	198129, CE	—	198130, CE	—	400 A at 100% duty cycle				1.1 kg (2.4 lb.)
XR-Pistol-Pro (Air-cooled)	300782	300783	—	300784	200 A at 100% duty cycle	1.8–23 m/min. (70–900 ipm)	Aluminum** 0.8–1.6 mm (.030–1/16 in.)		1 kg (2.2 lb.)
XR-Pistol-Pro (Water-cooled)	300786	300787	—	300788	400 A at 100% duty cycle				1.1 kg (2.4 lb.)