



PM-285556A

2020-07

**Processes**



MIG (GMAW) Welding

**Description**



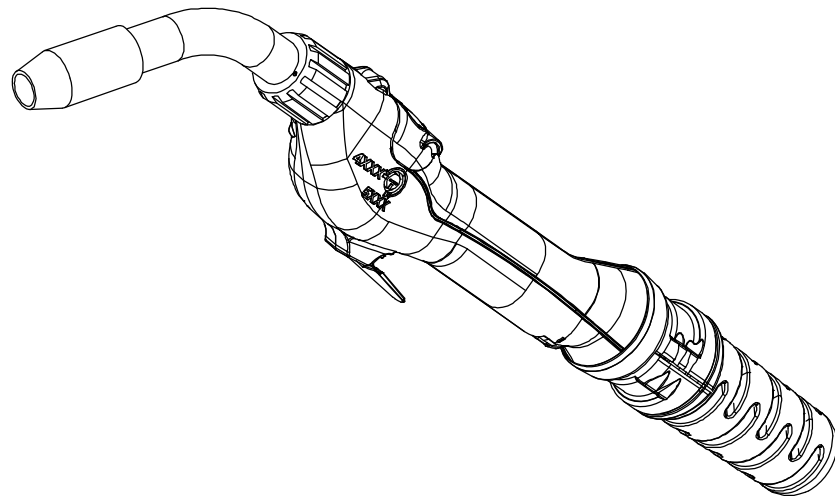
Semi-Automatic, Air/Water-Cooled, MIG (GMAW) Welding Gun

# XR-Aluma-Pro<sup>TM</sup>

## (Air And Water-Cooled Guns)

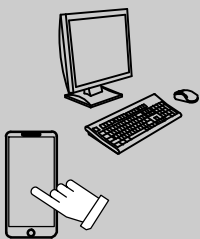
### CE And Non-CE Models

#### Eff w/Serial No. NA190084T And Following



300 Ampere (Air) Push-Pull Welding Gun  
400 Ampere (Water) Push-Pull Welding Gun


# PARTS MANUAL



For product information,  
Owner's Manual translations,  
and more, visit

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# SECTION 1 – PARTS LIST EFF W/SERIAL NO. NA190084T AND FOLLOWING

 Hardware is common and not available unless listed.

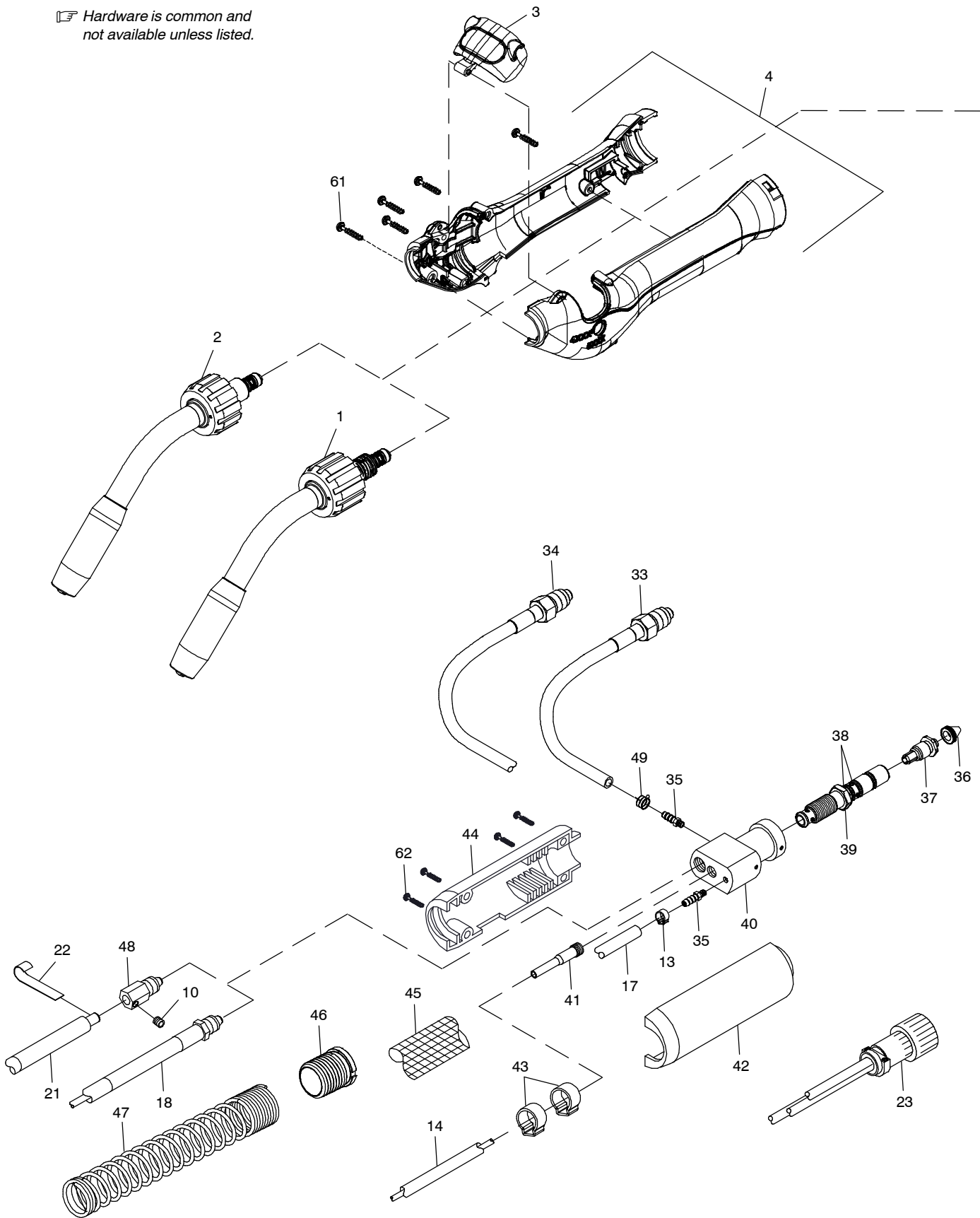
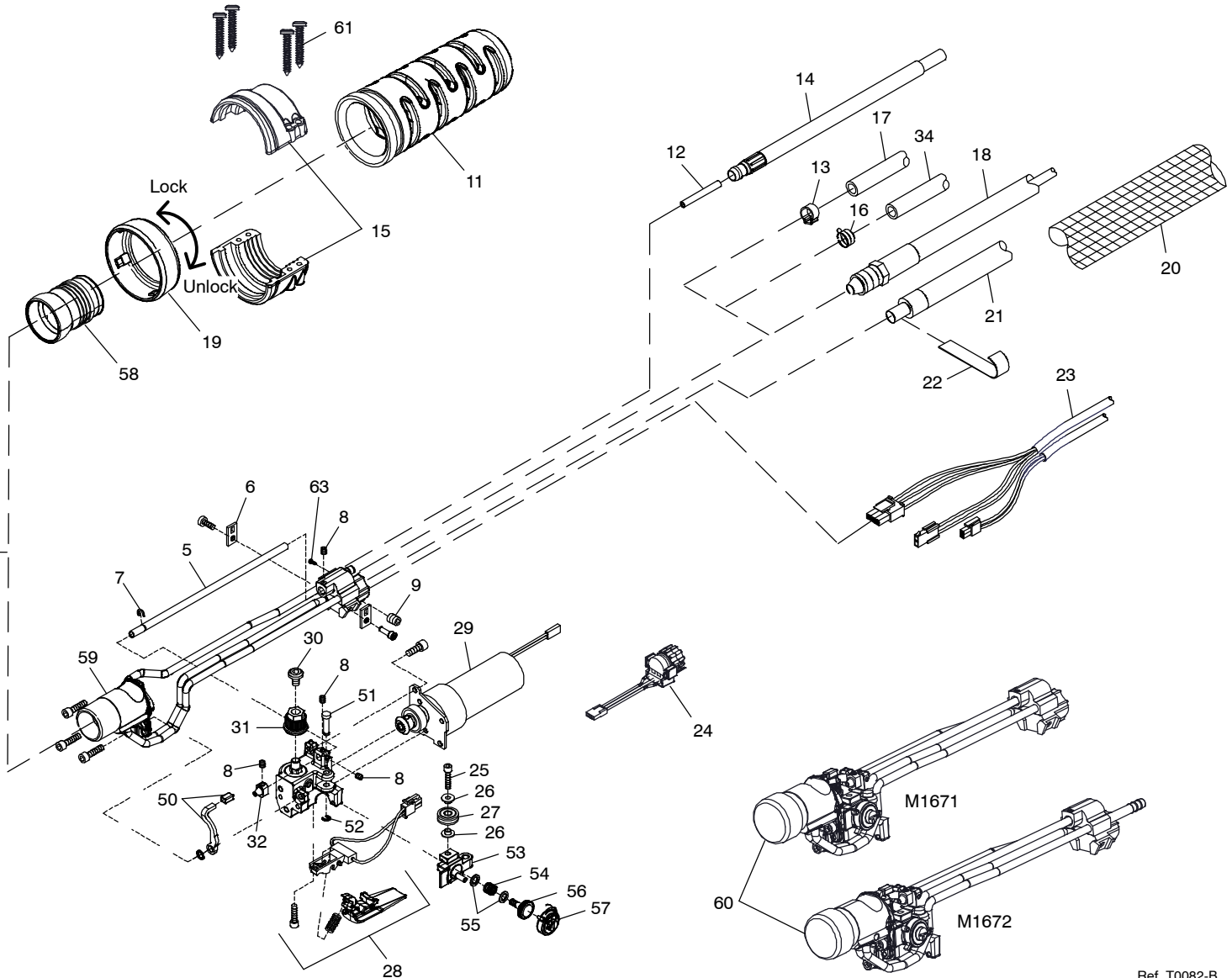


Figure 1-1. Exploded View Of XR-Aluma-Pro Gun

# Eff w/Serial No. NA190084T And Following



Ref. T0082-B

Item No.	Part No.	Description	Quantity
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**Figure 1-1. Exploded View Of XR-Aluma-Pro Gun**

...	1	231517 .. Kit, Head Tube Assy (Water) Long	1
...	2	231519 .. Kit, Head Tube Assy (Air) Short	1
...	2	231518 .. Kit, Head Tube Assy (Air) Long	1
...	3	227403 .. Cover, W/Spring Plunger (Includes)	1
...		187316 .. Label, Pinch Wordless	1
...	4	M1637 .. Handle Assembly, Left/Right	1
...	5	M1646 .. Tube, Liner Stainless	1
...	6	254701 .. Clamp, Cable Stl	2
...	7	M1476 .. Clip, C, Retaining 0.1875 Dia Shaft	1
...	8	135126 .. Screw, Set # 6-32x .12 Cup Pt Sch Stl Pln	4
...	9	237515 .. Screw, Set 250-20X .37 Conept Sch Stl W/Nyl Patch	1
...	10	M1500 .. Screw, Set 312-18X .31 Conept Sch Stl Pln Nylok	1
...	11	M1640 .. Strain Relief	1
...	12	229887 .. Liner, Replacement 15 Ft	1
...	12	229891 .. Liner, Replacement 25 Ft	1
...	12	232321 .. Liner, Replacement 35 Ft	1
...	13	357-2 .. Clamp, Oetiker	2

# Eff w/Serial No. NA190084T And Following

Item No.	Part No.	Description	Quantity
<b>Figure 1-1. Exploded View Of XR-Aluma-Pro Gun (Continued)</b>			
14	M1658	Kit, Conduit Monocoil 15 Ft	1
14	M1659	Kit, Conduit Monocoil 25 Ft	1
14	M1660	Kit, Conduit Monocoil 35 Ft	1
15	M1645	Clasp, Top/Bottom Assembly	1
16	237864	Clamp, Hose .375 - .450 Clp Dia Slftrng Green W/Shortened Middle Tab	2
17	M1720	Hose, Gas-Hytrel 15 Ft	1
17	M1721	Hose, Gas-Hytrel 25 Ft	1
17	M1722	Hose, Gas-Hytrel 35 Ft	1
18	191052	Cable, Power/Water Out 15 Ft	1
18	228696	Cable, Power/Water Out 25 Ft	1
18	232055	Cable, Power/Water Out 35 Ft	1
19	M1639	Rear, Ring	1
20	M1681	Kit, Cable Cover CSM W/Velcro 15 Ft	1
20	M1682	Kit, Cable Cover CSM W/Velcro 25 Ft	1
20	M1683	Kit, Cable Cover CSM W/Velcro 35 Ft	1
21	M1531	Cable, Power 15 Ft (Air)	1
21	M1532	Cable, Power 25 Ft (Air)	1
21	M1533	Cable, Power 35 Ft (Air)	1
22	235225	Strip, Cop .010 X 1.500 X .750	2
23	M1661	Cable, Control 15 Ft	1
23	M1662	Cable, Control 25 Ft	1
23	M1663	Cable, Control 35 Ft	1
24	M1641	Potentiometer Assy	1
25	231443	Screw, 006-32x .44 Soc Hd-Hex Gr8 Pld Lkg Patch	1
26	134624	Washer, Shldr.140id 0.187odx.094t .375odx.031t Nyl	2
27	227439	Drive Roll Assy, Idler .645 Od	1
28	245081	Trigger Assy	1
29	234782	Drive Motor Assy, Replacement	1
30	226588	Screw, 010-32x .37 Btn Hd-Soc Sst Lkg Patch	1
31	227434	Drive Roll, Knurled	1
32	227408	Guide, Inlet	1
33	196177	Hose, Water Out 10 in.	1
34	191072	Hose, Water In 15 Ft	1
34	229892	Hose, Water In 25 Ft	1
34	232056	Hose, Water In 35 Ft	1
35	202513	Ftg, Hose Brs Barbed M 3/16 Tbg X .250-20 (Water)	2
35	202513	Ftg, Hose Brs Barbed M 3/16 Tbg X .250-20 (Air)	2
36	229853	Guide, Cone Outlet Nylon	1
37	229852	Guide, Collet Outlet .030-1/16	1
38	079974	O-Ring, .500 Id X .103 Cs Rbr	2
39	193896	Pin, Power Assembly	1
40	187029	Connector, Power/Gas	1
41	203539	Fitting, Liner Double Wound Adapter	1
42	189811	Housing, Power Pin Lh	1
43	149332	Clamp, Hose .405 - .485 Clp Dia Slftrng Olive Dra	2
44	189812	Housing, Power Pin Rh	1
45	227449	Jacket, Cable 3 Ft 4 in. (Power Pin)	1
46	203560	Strain Relief, Spring Retainer	1
47	203562	Spring, Strain Relief	1
48	M1501	Ftg, Connection Power Weld	1
49	089120	Clamp, Hose .375 - .450 Clp Dia Slftrng Green	1
50	227405	Lever, Pressure Arm	1
51	227420	Pin, Pressure Arm	1
52	191088	Ring, Rtnng Ext .125 Shaft X .015 Thk E Style	1
53	227435	Arm, Pressure (Machined)	1
54	227421	Spring, Cprsn .360 Od X .059 Wire X .440 Free	1
55	229850	Washer, Pressure Arm Precision	2
56	229849	Shaft, Pressure Arm Brs	1
57	229851	Nut, Pressure Arm Plastic	1

# Eff w/Serial No. NA190084T And Following


Item No.	Part No.	Description	Quantity
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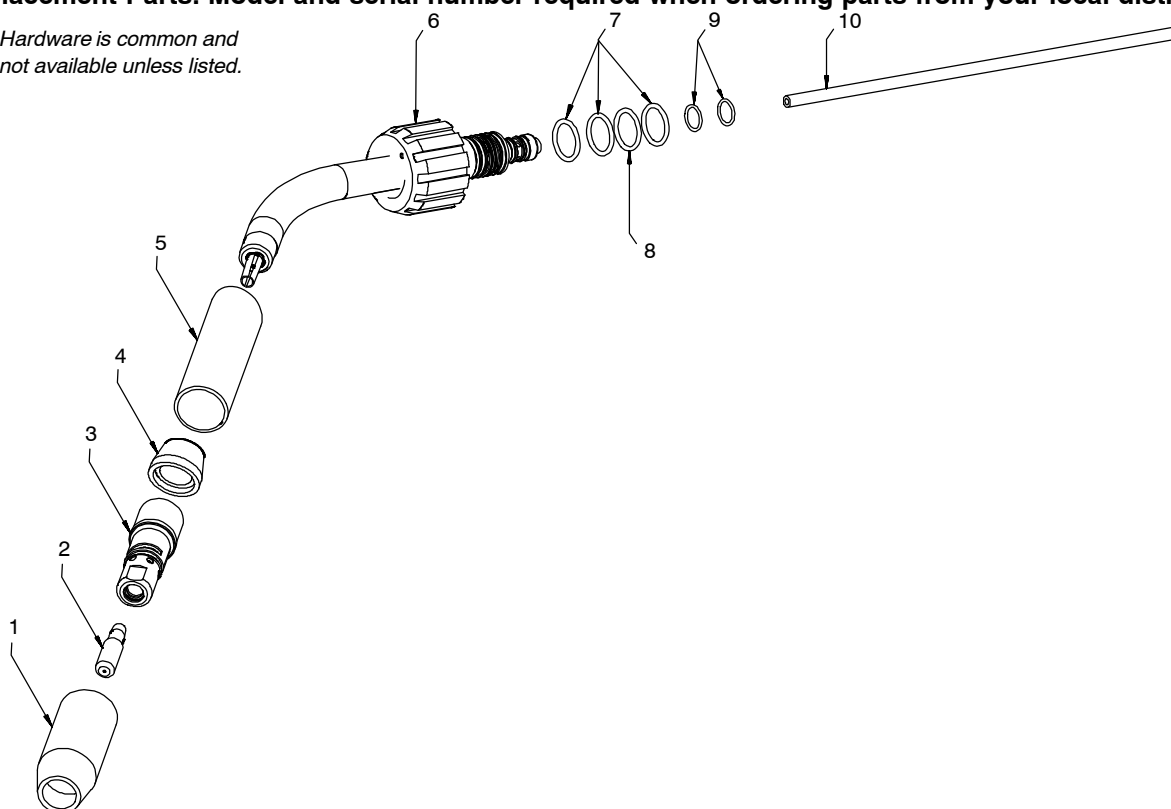
**Figure 1-1. Exploded View Of XR-Aluma-Pro Gun (Continued)**

... 58	M1638	.. Ball, Swivel	1
... 59	M1647	.. Brazed Assembly (Air)	1
... 59	M1654	.. Brazed Assembly (Water)	1
... 60	++M1671	.. Drive Assy, Replacement Air	1
... 60	++M1672	.. Drive Assy, Replacement Water	1
... 61	217934	.. Screw, K40x 20 Pan Hd-Trx Stl Pld Pt Thread Forming	9
... 62	145217	.. Screw, K40x 12 Pan Hd-Phl Stl Pld Pt Thread Forming	4
... 63	227413	.. Screw, 006-32x .37 Soc Hd-Hex Gr8 Pld Lkg Patch	1

++ Drive assemblies include drive housing, pressure arm, pressure arm pin, pressure arm lever, power block assy, drive shaft assy, pressure arm shaft, tube liner, O-ring, set screws, and springs.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

 Hardware is common and not available unless listed.



T0087-A

**Figure 1-2. (Water) Head Tube Assembly Of XR-Aluma-Pro Gun**

Item No.	Part No.	Description	Quantity
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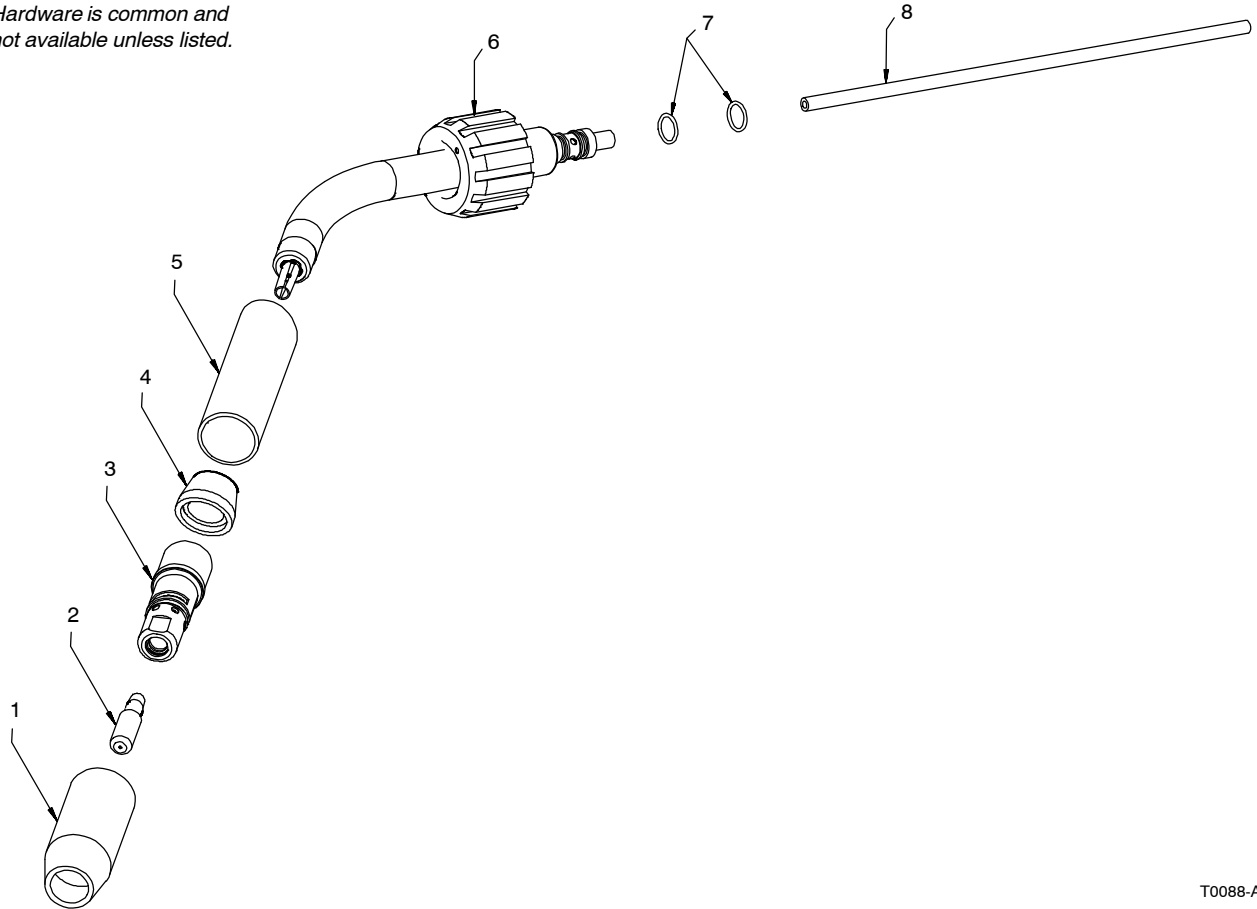
**Figure 1-2. (Water) Head Tube Assembly Of XR-Aluma-Pro Gun (Figure 1-1 Item 1)**

...	231517	.. Kit, Head Tube Assy Water AlumaPro (Long) (Includes)	1
... 1	199618	... Nozzle, Copper 5/8 in. Orifice Tapered Heavy Duty	1
... 2	206189	... Tip, Fastip .312 Od .052 And 3/64al Wires	1
... 3	229670	... Diffuser, .281/.312 Od Fastip 1/8 Tip Rec AlumaPro	1
... 4	232284	... Insulator, Nozzle Collared	1
... 5	M1679	... Insulator, Outer Water Long Fastip	1
... 6	229889	... Nut, Headtube Rotation Water	1
...	230970	.. Kit, Replacement O-Rings Head Tube Water (Includes)	1
... 7	194261	... O-Ring, .551 Id X .070 Cs 70 Duro Buna-n	3
... 8	210771	... O-Ring, 14.99mm Id X 1.27mm Cs 70 Duro Buna-n	1
... 9	191191	... O-Ring, .312 Id X .070 Cs 70 Duro Buna-n	2
... 10	229431	... Liner, Teflon .047-.062 Wire X 8.250 (Fastip)	1

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# Eff w/Serial No. NA190084T And Following

☞ Hardware is common and not available unless listed.



T0088-A

**Figure 1-3. (Air) Head Tube Assembly Of XR-Aluma-Pro Gun**

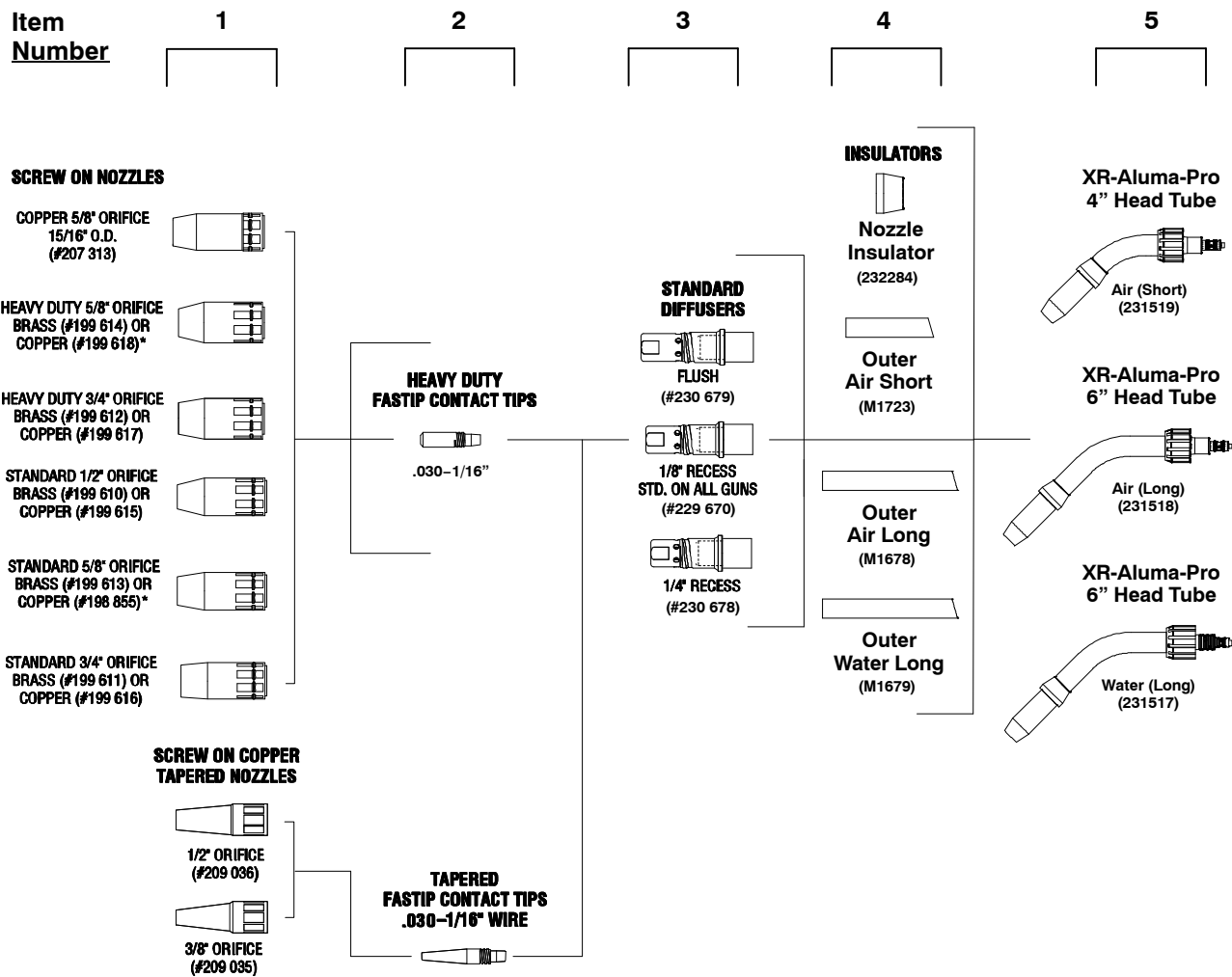
Item No.	Part No.	Description	Quantity
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**Figure 1-3. (Air) Head Tube Assembly Of XR-Aluma-Pro Gun (Figure 1-1 Item 2)**

.....	231518	.. Kit, Head Tube Assy Air (Long) (Includes)	1
.....	231519	.. Kit, Head Tube Assy Air (Short) (Includes)	1
... 1	198855	.... Nozzle, Copper 5/8 in. Orifice Tapered	1
... 2	206189	.... Tip, Fastip .312 Od .052 And 3/64al Wires	1
... 3	229670	.... Diffuser, .281/.312 Od Fastip 1/8 Tip Rec AlumaPro	1
... 4	232284	.... Insulator, Nozzle Collared	1
... 5	M1678	.... Insulator, Outer Air (Long)	1
... 5	M1723	.... Insulator, Outer Air (Short)	1
... 6	227168	.... Nut, Headtube Rotation	1
.....	230969	.. Kit, Replacement O-Rings Head Tube Air (Includes)	1
... 7	191191	.... O-Ring, .312 Id X .070 Cs 70 Duro Buna-n	2
... 8	229431	.... Liner, Teflon .047-.062 Wire X Long (Fastip)	1
... 8	230239	.... Liner, Teflon .047-.062 Wire X Short (Fastip)	1

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

# Eff w/Serial No. NA190084T And Following



Ref. 803909-A / T0089-A

Figure 1-4. Consumables Flowchart

Item No.	Part No.	Description	Quantity
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Figure 1-4. Consumables Flowchart

Table 1-1. Nozzles

...	1	◆199610	.. Nozzle, Screw On Brass 1/2 in. Orifice	1
...	1	◆199611	.. Nozzle, Screw On Brass 3/4 in. Orifice Straight	1
...	1	◆199612	.. Nozzle, Screw On Brass 3/4 in. Orifice Straight Heavy Duty	1
...	1	◆199613	.. Nozzle, Screw On Brass 5/8 in. Orifice	1
...	1	◆199614	.. Nozzle, Screw On Brass 5/8 in. Orifice Heavy Duty	1
...	1	◆199615	.. Nozzle, Screw On Copper 1/2 in. Orifice	1
...	1	◆199616	.. Nozzle, Screw On Copper 3/4 in. Orifice	1
...	1	◆199617	.. Nozzle, Screw On Copper 3/4 in. Orifice Heavy Duty	1
...	1	198855	.. Nozzle, Screw On Copper 5/8 in. Orifice	1
...	1	199618	.. Nozzle, Screw On Copper 5/8 in. Orifice Heavy Duty	1
...	1	◆207313	.. Nozzle, Screw On Copper 5/8 in. Orifice 15/16 OD	1
...	1	◆209035	.. Nozzle, Screw On Copper 3/8 in. Orifice Tapered (Requires Diffuser 229 670, 230 678, 230 679 Used With Any Tapered FasTip™ Contact Tip)	1
...	1	◆209036	.. Nozzle, Screw On Copper 1/2 in. Orifice Tapered (Requires Diffuser 229 670, 230 678, 230 679 Used With Any Tapered FasTip™ Contact Tip)	1

# Eff w/Serial No. NA190084T And Following

**Table 1-2. Heavy Duty FasTip™ Contact Tips\***

...	2	...	◆206185	..	.030 in. (0.8 mm)	.....	1
...	2	...	◆206186	..	.035 in. (0.9 mm)	.....	1
...	2	...	206187	..	.040 in. (1.0 mm) or .035 in. (0.9 mm) Aluminum Wire	.....	1
...	2	...	◆206188	..	.045 in. (1.2 mm)	.....	1
...	2	...	206189	..	.052 in. (1.3 mm) or 3/64 in. (1.2 mm) Aluminum Wire	.....	1
...	2	...	◆206190	..	1/16 in. (1.6 mm)	.....	1
...	2	...	◆206191	..	.068 in. (1.7 mm) or 1/16 in. (1.6 mm) Aluminum Wire	.....	1

**Table 1-3. Tapered FasTip™ Contact Tips\***

...	2	...	◆209025	..	.030 in. (0.8 mm)	.....	1
...	2	...	◆209026	..	.035 in. (0.9 mm)	.....	1
...	2	...	◆209027	..	.045 in. (1.2 mm)	.....	1
...	2	...	◆209028	..	3/64 in. (1.2 mm)	.....	1
...	2	...	◆209029	..	.052 in. (1.3 mm)	.....	1
...	2	...	◆209030	..	1/16 in. (1.6 mm)	.....	1

**Table 1-4. Gas Diffusers**

...	3	...	229670	..	1/8 in. Tip Recess – For Heavy Duty FasTip Contact Tips (Standard On All Guns)	.....	1
...	3	...	◆230678	..	1/4 in. Tip Recess – For Heavy Duty FasTip Contact Tips	.....	1
...	3	...	◆230679	..	Flush Tip – For Heavy Duty FasTip Contact Tips	.....	1

**Table 1-5. Insulators**

...	4	...	232284	..	Insulator, Nozzle Collared	.....	1
...	4	...	M1723	..	Insulator, Outer Air Short (4 in.)	.....	1
...	4	...	M1678	..	Insulator, Outer Air Long (6 in.)	.....	1
...	4	...	M1679	..	Insulator, Outer Water Long FasTip (6 in.)	.....	1

**Table 1-6. Head Tube Assemblies**

...	5	...	231517	..	Kit, Head Tube Assy Water (Long)	.....	1
...	5	...	231518	..	Kit, Head Tube Assy Air (Long)	.....	1
...	5	...	231519	..	Kit, Head Tube Assy Air (Short)	.....	1

**Table 1-7. FasTip Head Tube Liners (Not Shown)**

.....	229674	..	Liner, Teflon .030-.035 Wire X Long (Fastip)	.....	1
.....	227161	..	Liner, Teflon .030-.035 Wire X Short (Fastip)	.....	1
.....	229431	..	Liner, Teflon .047-.062 Wire X Long (Fastip)	.....	1
.....	230239	..	Liner, Teflon .047-.062 Wire X Short (Fastip)	.....	1
.....	233998	..	Liner, Phos Bronze .030-1/16 Wire (Short Aluma-Pro)	.....	1
.....	233999	..	Liner, Phos Bronze .030-1/16 Wire (Long Aluma-Pro)	.....	1

**Table 1-8. Wire Kit (Not Shown)**

.....	◆230708	..	Kit, Idler Roll 1/16 (.062)	.....	1
.....	◆198377	..	Hardwire Liner Kit, 30W For Steel&Stainless	.....	1

**NOTE:**

◆OPTIONAL

\*All contact tips are packaged in bags of 25.

BE SURE TO PROVIDE MODEL WHEN ORDERING REPLACEMENT PARTS.

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