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XMT® 400 Systems

Multiprocess Welding System

QUICK SPECS

Industrial Applications

General manufacturing
General fabrication
Transportation
Sheet metal fabrication
Light-gauge tube and sheet
Power generation plants
Pipe fabrication
Education
Repair shops
Construction
Rental fleets

Processes

MIG (GMAW)
Flux-cored (FCAW)
Stick (SMAW)
TIG (GTAW)
Air carbon arc cutting and gouging (CAC-A)
Rated: 5/16-inch carbons
Accu-Pulse® (GMAW-P)*
Versa-Pulse™ (GMAW-P)**
High-deposition MIG (GMAW)**
RMD® (Regulated Metal Disposition)**

Input Power

Auto-Line™, 208–575 V
Requires 3- or 1-phase power

Output Range 10–38 V, 15–425 A

Net Weight 75 lb. (34.0 kg)

**With Intellx™ Pro and Intellx™ Elite feeders.*
***With Intellx™ Elite feeders.*

Scalable Solutions with Intellx™—Intellx Pro enables Accu-Pulse® while Intellx Elite unlocks the full suite of advanced processes in a multiprocess machine.

Dedicated wire feeder options

- Intellx Basic feeder with arc control means welders can produce better welds with minimal parameter adjustments.
- Intellx Pro feeder adds EZ-Set, Accu-Pulse, memory buttons and steel and stainless weld programs.
- Intellx Elite feeder adds additional weld programs, intuitive display with on-demand graphics and more control.

Easy to use

EZ-Set simplifies parameter setup based on material thickness, removing complexity.

Pulse capable

Accu-Pulse offers a more forgiving arc and compensates for variations in operator technique, providing a wider operating window.

NEW!

XMT 400 MIGRunner™ with single-wire Intellx™ Pro feeder shown.

TRUE BLUE® 3YR. WARRANTY

Power source is warranted for three years, parts and labor.
Original main power rectifier parts are warranted for five years.
Gun warranted for 90 days, parts and labor.

Miller®

Miller Electric Mfg. LLC
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
Phone: 866-931-9730
International Phone: 920-735-4554

MillerWelds.com

Certified System ISO 9001 Quality

XMT® 400 Features

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.

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

Portability

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

Reliability

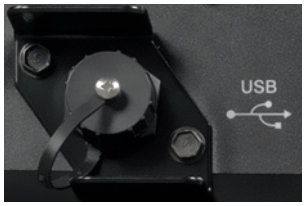
Wind Tunnel Technology™. Internal air flow that protects electrical components and PC boards from dirt, dust and debris... greatly improving reliability.

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.

Dinse-style weld disconnects provide high-quality weld cable connections.

Updatable



USB port on back panel allows XMT 400 to be easily updated in the field.

Versatility

AUTO-LINE™ TECHNOLOGY

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.

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

ArcConnect™ is a next generation communication that utilizes high speed signals to improve weld performance and allow point-of-use controls to be located at the feeder.

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.

Optional gas valve kit for TIG applications (see page 8).

Intellx™ Feeders Features

Balanced-pressure drive-roll design and tensioners feed wire in its truest and straightest form for consistent feedability, resulting in better welding performance.

Accu-Mate™ connection aligns the gun perfectly in the drive-roll carrier — preventing the gun from being pulled loose and providing consistent wire feeding.

Drive rolls and guides are common with other Miller® industrial feeders (use existing, not new parts).

Note: For Intellx feeder drive roll kits and guides, see Deltaweld literature DC/16.5 or DC/16.7.

Inlet guide and intermediate guide installation is toolless.

Rotatable drive assembly allows operator to rotate the drive, eliminating severe bends in the wire feed path. This extends gun-liner life and aids in feeding difficult wires.

Intellx Pro single-wire feeder

Memory buttons for quick program recall

Display and controls for volts/arc length, wire feed speed, and EZ-Set (if selected)

Arc control to fine tune the welding arc

LCD setup screen for easy selection of welding processes

Jog and purge button

Trigger hold, trigger select, preflow and postflow buttons

Intellx Elite single-wire feeder

Soft keys to easily navigate menus

Full-color LCD screen to simplify the setup and operation of a fully featured feeder

Arc control to fine tune welding arc

Memory buttons for quick program recall

Trigger connections for standard MIG gun and XR-Aluma-Pro™ Plus and XR™-Pistol Plus push-pull guns

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

Intellx™ Feeders Comparison

FEATURE	INTELLX BASIC FEEDER	INTELLX PRO FEEDER	INTELLX ELITE FEEDER
Digital meters	■	■	Full color LCD
Remote voltage	■	■	■
Wire feed speed	■	■	■
Arc control	■	■	■
Trigger hold	■	■	■
Wire jog and purge	■	■	■
Wire feed speed feedback	■	■	■
Four drive rolls	■	■	■
Dual-wire models	■	■	■
Rotatable drive	■	■	■
Up to 60 lb. spool	■	■	■
MIG process	■	■	■
EZ-Set MIG		■	■
EZ-Set Accu-Pulse®		■	■
Trigger select		■	■
Preflow and postflow		■	■
Memory slots		2	8
Out-of-box programs (steel/stainless)		■	■
Out-of-box programs (aluminum/nickel/copper nickel/silicon bronze/titanium)			■
EZ-Set Versa-Pulse™, high-deposition MIG and RMD®			■
XR™ Plus push-pull gun compatible			■
Profile Pulse™			■
Weld sequence control			■
Trigger dual schedule			■
Dual schedule switch support			■
Parameter limits			■
Memory lockouts			■
System lock			■
Wire retract			■
Auto thread and auto purge			■
Cloning and custom weld library			■

Processes

- MIG
- EZ-Set MIG (Intellx Pro and Intellx Elite)
- EZ-Set Accu-Pulse® (Intellx Pro and Intellx Elite)
- EZ-Set Versa-Pulse™ (Intellx Elite)
- EZ-Set High-deposition MIG (Intellx Elite)
- EZ-Set RMD® (Intellx Elite)

Intellx Pro and Intellx Elite Feeder Programs

- Different wire sizes
- Different gas types
- Flux-cored
- Metal-cored
- Steel
- Stainless steel

Additional Intellx Elite Feeder Programs

- Aluminum
- Nickel
- Copper nickel
- Silicon bronze
- Titanium

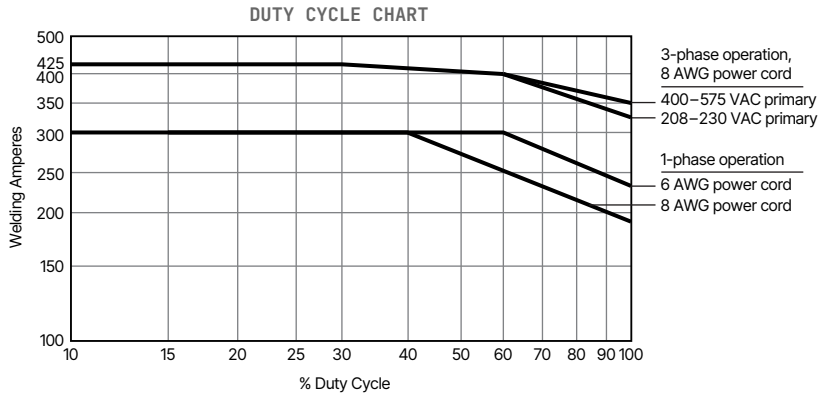
XMT® 400 Processes and Performance Data

BEST FOR	STANDARD SPRAY	HD MIG**	ACCU-PULSE*	VERSA-PULSE**	SHORT CIRCUIT	RMD**
Deposition	A	A	A	B	D	D
Gap filling	D	D	B	B	A	A
Low heat input	D	C	B	A	A	A
Out-of-position welds			A	B	B	B
Low spatter	A	A	A	B	C	B
Thick metals	A	A	A	C	D	D
Thin metals			B	A	A	A
Increased travel speed	A	A	A	A	B	C

HOT → COLD

Ratings A, B, C, and D *are relative values. An "A" rating indicates a best fit between your performance needs and process. A "blank" rating indicates that the process is not recommended for that application.*

**With Intellx™ Pro and Intellx™ Elite feeders. **With Intellx™ Elite feeders.*



MIG
- Lower spatter than traditional MIG welders
- Better arc performance with silicon bronze and coated materials

Accu-Pulse®*
- The most popular process for majority of industrial welding applications
- Most adaptive arc on 16 gauge (1.6 mm) and thicker
- Designed for all weld positions

Versa-Pulse™**
- Fast, low-heat, low-spatter process — for materials 1/4 inch (6.35 mm) and thinner
- Great for gap filling
- Shortest arc length / lowest pulse voltage for lower heat and lower spatter at higher speeds

High-deposition MIG (HD MIG)**
- Higher deposition rates than standard spray transfer on thicker materials
- Designed for welding applications in which spray transfer is preferred

RMD®**
- Lowest heat process, best for gap handling
- Limited travel speed

XMT® 400 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 208 V	230 V	400 V	460 V	575 V	KVA	KW	MAX. OPEN-CIRCUIT VOLTAGE	DIMENSIONS	NET WEIGHT
Three-phase	10–38 V	5–425 A	400 A at 36 VDC, 60% duty cycle	47.4	42.4	24.4	21.4	18.0	17.1	16.0	91 VDC 25/12 VDC*	H: 17.25 in. (438 mm) W: 12.75 in. (324 mm) D: 20.25 in. (514 mm)	75 lb. (34.0 kg)
Single-phase	10–38 V	5–425 A	300 A at 32 VDC, 60% duty cycle	59.9	52.1	27.1	23.5	19.9	11.5	10.8			

**When Voltage Reduction Device is active. See Owner's Manual for details.*

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

Intellx™ Feeder Specifications (Subject to change without notice.)

INPUT POWER	WELDING POWER SOURCE	INPUT WELDING CIRCUIT RATING	WIRE FEED SPEED	WIRE DIAMETER CAPACITY	MAXIMUM SPOOL SIZE CAPACITY	DIMENSIONS (H x W x D)	NET WEIGHT
50 VDC	XMT 400	600 A at 113 VDC, 60% duty cycle	50–780 ipm (1.3–19.8 m/min.)	.023–5/64 in. (0.6–2.0 mm) Elite model only: Aluminum: .035–1/16 in. (0.9–1.6 mm)	18 in. (457 mm) 60 lb. (27 kg)	Single-wire: 16.25 x 12.38 x 27.88 in. (413 x 314 x 708 mm) Dual-wire: 14 x 18 x 34.5 in. (356 x 457 x 876 mm)	Single-wire: 44.8 lb. (20.3 kg) Dual-wire: 77 lb. (34.9 kg)

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

Genuine Miller® Accessories

MIGRunner™ Cart
195445 For single feeders
Small footprint and easily maneuverable, with dual-cylinder rack low enough that you do not have to lift bottles. Durable ergonomic handles are designed for comfort.

Note: Not compatible with dual wire feeders.

Running Gear Cylinder Rack
300408 For single or dual feeders
Holds two large gas cylinders and has gun cable hangers and a consumable drawer in front. A convenient handle allows the cart to be pulled easily through doorways. Power source and single or dual feeders can be mounted to cart and secured.

MIG kit 300405 shown.

Industrial MIG 4/0 Kit with Dinse Connectors
300405 For single feeders
300956 For dual feeders
Consists of flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable, and 15-foot (4.6 m) work cable with 600-amp C-clamp. Dual kit comes with two flowmeter regulators and gas hoses.

ArcConnect Control/Motor Cables
280471005 5 ft. (1.5 m)
280471009 9 ft. (2.7 m)
280471015 15 ft. (4.6 m)
280471025 25 ft. (7.6 m)
280471050 50 ft. (15.2 m)
280471075 75 ft. (22.9 m)
280471100 100 ft. (30.5 m)
280471150 150 ft. (45.7 m)
Connects power source directly to feeder or remote operator interface.

Note: Cables cannot be joined together to create longer lengths and extension cables are not available.

Work Sense Leads (volt sense)
300461 25 ft. (7.6 m)
300462 50 ft. (15.2 m)
When connected from the back of the wire feeder to the workpiece, the work sense lead provides accurate voltage feedback on the wire feeder display, and compensates for any voltage drop from the weld cables.

AccuLock™ Nozzle N-A3412C
ONLY for use with Intellx™ Elite feeders. Required for high-deposition MIG (HD MIG) process when using Bernard® BTB gun with AccuLock consumables.

Remote Controls

Wireless Remote Foot Control 301580
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

RFCS-14 HD Foot Control 301589
Heavy-duty foot pedal current and contactor control provides increased stability and durability from larger base and heavier cord. Includes 20-foot (6 m) cord with plug.

Wireless Remote Hand Control 301582
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

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.

RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. 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. 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.

Cable Connectors and Adapters

Dinse-Style Connectors
042418 Accepts #4 to #1/0 AWG cable
042533 Accepts #1/0 to #2/0 AWG cable
Kits include one Dinse-style male plug which attaches to the work and/or weld cables and plugs into the Dinse-style receptacles on the power source.

Extension Kit for Dinse-Style Cable Connectors 042419
Accepts #4 to #1/0 AWG cable. Used to adapt or extend weld and/or work cables. Kit includes one male Dinse-style plug and one in-line female Dinse-style receptacle.

Extensions for Dinse-Style Cable Connectors
134460 Male Dinse-style plug
136600 Female Dinse-style receptacle
Used to adapt or extend weld and/or work cables. Accepts #1/0 to #2/0 AWG cable.

Universal Connector Kits
301595 Dinse-style
301611 Tweco®-style
301637 Cam-Lok-style
Universal connector kits allow the machine to be quickly configured to either Tweco-, Dinse- or Cam-Lok-style receptacles.

Genuine Miller® Accessories

Guns and Additional Feeders

Spoolmatic® 30A
130831
One-pound, air-cooled spool gun that extends the weld process range by adding a handy portable system for small wire MIG. Rated at 200 amps at 100% duty cycle. Includes 30-foot (9.1 m) cable assembly. Requires WC-24 Weld Control **137549** for use with 14-pin receptacles, order separately.

WC-24 Weld Control
137549
Required to use Spoolmatic 30A spool gun. Designed for use with Miller CV power sources with 14-pin receptacles and supplying 24 VAC.

XR-Aluma-Pro™ Plus Push-Pull Guns
Air-Cooled
301575 15 ft. (4.6 m)
301574 25 ft. (7.6 m)
301739 35 ft. (10.7 m)
Water-Cooled
301576 15 ft. (4.6 m)
301577 25 ft. (7.6 m)
301740 35 ft. (10.7 m)
ONLY for use with Intellx™ Elite and 74 MPa Plus feeders. See literature M/1.77.

XR™-Pistol Plus Push-Pull Guns
Air-Cooled
300753 15 ft. (4.6 m)
300754 25 ft. (7.6 m)
Water-Cooled
300757 25 ft. (7.6 m)
ONLY for use with Intellx™ Elite and 74 MPa Plus feeders. See literature M/1.77.

20 Series and 74 MPa Plus Feeders
See literature M/3.0 for 20 Series feeders, and M/11.0 for 74 MPa Plus feeders.

Typical XMT® 400 System Installations

Single-wire feeder installation

Stationary

XMT 400
907881

+

Industrial MIG 4/0 kit with Dinse connectors
300405

+

ArcConnect control/ motor cable (one required, see page 6)

+

Single-wire Intellx™ feeder with Bernard® BTB MIG gun**
(use with XR™ Plus push-pull gun **REQUIRES** Intellx Elite feeder)

Intellx
951783001

or

Intellx Pro
951784001

or

Intellx Elite
951785001

***Intellx™ feeders with Bernard® guns **include** .035/.045 in. V-groove drive rolls and .035 and .045 in. AccuLock™ contact tips.*

Dual-wire feeder installation

Stationary

XMT 400
907881

or

MIGRunner™

XMT 400 907881 plus running gear cylinder rack 300408

+

Industrial MIG 4/0 kit with Dinse connectors
300956

+

ArcConnect control/ motor cable (one required, see page 6)

+

Dual-wire Intellx™ feeder with Bernard® BTB MIG gun**
(use with XR™ Plus push-pull gun **REQUIRES** Intellx Elite feeder)

Intellx
951815001

or

Intellx Pro
951816001

or

Intellx Elite
951942001

Ordering Information (Most popular models ◀)

POWER SOURCE AND OPTIONS	STOCK NO.	DESCRIPTION	QTY.	PRICE
XMT® 400	**907881** ◀ **907881001** **907881002**	208 – 575 V with Auto-Line™ and Dinse-style receptacles 208 – 575 V with Auto-Line™ and Tweco-style receptacles 230 – 460 V with Auto-Line™ and Dinse-style receptacles and **CE**		
XMT® 400 MIGRunner™	**907915** ◀	Power source 907881 with MIGRunner™ cart, 10 ft. 4/0 work cable with clamp, 6 ft. 4/0 weld cable for wire feeder to power source, 5 ft. ArcConnect cable, and flowmeter regulator with 3 ft. gas hose		
XMT® 400 MIGRunner™ Packages	**951971** **951000212** ◀ **951972**	Power source 907881 with Intellx Basic feeder Power source 907881 with Intellx Pro feeder Power source 907881 with Intellx Elite feeder All MIGRunner packages also include MIGRunner cart, Bernard® BTB Gun 400 A with .035 and .045 in. AccuLock™ contact tips, .035/.045 in. V-groove drive rolls, 10 ft. 4/0 work cable with clamp, 6 ft. 4/0 weld cable for wire feeder to power source, 5 ft. ArcConnect cable, and flowmeter regulator with 3 ft. gas hose		
Wire Feeders				
Intellx™ Basic Bench-Style Wire Feeders	**951783001** **951815001**	Single-wire feeder with Bernard® BTB Gun 400 A Dual-wire feeder with two Bernard® BTB Gun 400 A		
Intellx™ Pro Bench-Style Wire Feeders	**951784001** **951816001**	Single-wire feeder with Bernard® BTB Gun 400 A Dual-wire feeder with two Bernard® BTB Gun 400 A		
Intellx™ Elite Bench-Style Wire Feeders	**951941001** **951942001**	Single-wire feeder with Bernard® BTB Gun 400 A Dual-wire feeder with two Bernard® BTB Gun 400 A		
20 Series		See literature M/3.0		
74 MPa Plus		See literature M/11.0		
Accessories				
MIGRunner™ Cart	**195445**	For single feeders		
Running Gear Cylinder Rack	**300408**	For dual feeders		
Industrial MIG 4/0 Kit with Dinse Connectors	**300405** **300956**	For single feeders For dual feeders		
ArcConnect Control/Motor Cables		See page 6 for available lengths		
Work Sense Leads (volt sense)		See page 6 for available lengths		
AccuLock™ Nozzle	**N-A3412C**	Required for high-deposition MIG (HD MIG) process when using Bernard® BTB gun with AccuLock consumables		
Gas Valve Kit	**297047**	For XMT 400 power source for TIG applications		
Remote Controls				
Wireless Remote Foot Control	**301580**	Foot control with wireless 90 ft. (27.4 m) operating range		
Wireless Remote Hand Control	**301582**	Hand control with wireless 300 ft. (91.4 m) operating range		
RFCS-14 HD	**301589**	Foot control with 20 ft. (6 m) cord and 14-pin plug		
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		
RCCS-14	**043688**	Fingertip control		
Extension Cables (8-conductor)		See page 6		
Cable Connectors and Adapters		See page 6		
Guns				
Spoolmatic® 30A Spool Gun	**130831**	Requires WC-24 for use with 14-pin receptacles		
WC-24 Weld Control	**137549**	Required for use with Spoolmatic 30A and power sources with 14-pin		
XR™ Plus Push-Pull Guns		ONLY for use with Intellx Elite or 74 MPa Plus wire feeders. See page 7		

*Intellx™ feeders with Bernard® guns **include** .035/.045 in. V-groove drive rolls and .035 and .045 in. AccuLock™ contact tips.*

DATE:

TOTAL QUOTED PRICE:

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