

R-115

115-Volt Replacement Wire Feeder



Quick Specs

Industrial Applications

Heavy Manufacturing
Metal Fabrication
Construction
Light Manufacturing

Processes

MIG (GMAW)
Flux Cored (FCAW)
Gas- and Self-Shielded
For use with CV Power Sources

Input Power 115 VAC, 2 A, 50/60 Hz

Wire Diameter Capacity .030–5/64 in. (0.8–2.0 mm)

Wire Speed 75–750 IPM (1.9–19 m/min.)

Net Weight 40 lb. (18 kg)

Universal, constant-speed, semi-automatic wire feeder offers easy connection to Miller and competitive power sources that only supply 115 VAC power.



Industrial four-drive-roll system offers exceptional feed performance and reliability.

Quick-change drive rolls are easy to change — no tools required.

Wire feed speed range is 75–750 IPM and covers a wide variety of wire sizes (.030–3/32 in.).

Gas solenoid accommodates self-shielded and gas-shielded wires.

Motor ramp and burnback control aids in starting and stopping performance to match power source characteristics.

Heavy-duty industrial design features 16-gauge sheet metal enclosure for durability in harsh environments.

Trigger hold reduces fatigue by allowing operator to make long welds without holding trigger.



Feeder **includes** 15-foot (4.6 m) Bernard™ Q400 MIG gun, .035/.045-inch drive rolls and Centerfire™ contact tips!

Universal 115 V feeder adapts to a wide variety of older Miller and competitive power sources (see optional cords on page 3):

- Standard Miller 14-pin
- Older-style Miller with hubble connectors
- Hobart
- Lincoln
- L-Tec
- Airco

Convenient terminal block easily adapts to existing feeder interconnecting cords.

Optional interconnecting cords are quick and easy to install to a variety of power sources. See pages 2 and 3 for drive roll kits and power source interconnecting cords.

Optional run-in control, a separate wire feed speed adjustment to control wire speed prior to arc initiation.



Wire feeder is warranted for 3 years, parts and labor.



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Specifications (Subject to change without notice.)



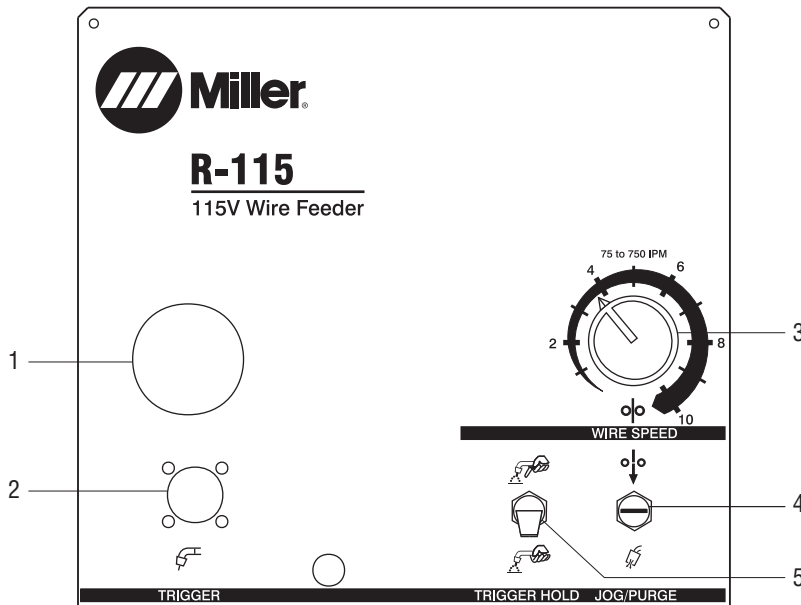
(Use with CV, DC Power Sources.)

Input Power	Wire Feed Speed	Wire Diameter Capacity	Maximum Spool Size Capacity	Dimensions	Net Weight
115 VAC, 2 A, 50/60 Hz	75–750 IPM (1.9–19 m/min.)	.030–5/64 in. (0.8–2.0 mm)	60 lb. (27 kg) with optional wire reel assembly #108 008	H: 11 in. (279 mm) W: 10.75 in. (273 mm) D: 23.5 in. (597 mm)	40 lb. (18 kg)



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

Control Panel



1. Gun Connection
 2. Trigger Receptacle
 3. Wire Speed Control
 4. Jog/Purge
 5. Trigger Hold
- Power On/Off (on rear panel)

Drive Roll Kits and Guides (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include the necessary guides and feature an anti-wear sleeve for inlet guide.

Wire size	"V" groove for hard wire 	"U" groove for soft wire or soft-shelled cored wires 	"V" knurled for hard-shelled cored wires 	"U" cogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types) 
.030 in. (0.8 mm)	#046 780	—	—	—
.035 in. (0.9 mm)	#046 781	#044 750	#046 792	—
.040 in. (1.0 mm)	#161 190	—	—	—
.045 in. (1.1/1.2 mm)	#046 782	#046 785	#046 793	#083 319
.052 in. (1.3/1.4 mm)	#046 783	#046 786	#046 794	#083 320
1/16 in. (1.6 mm)	#046 784	#046 787	#046 795	#046 800
.068/.072 in. (1.8 mm)	—	—	#089 985	—
5/64 in. (2.0 mm)	—	#046 788	#046 796	#046 801

Nylon Wire Guides for Feeding Aluminum Wire

Wire Size	Inlet Guide
.035–.047 in. (1.2 mm)	#151 203
1/16 in. (1.6 mm)	#151 205

Note: "U" groove drive rolls are recommended when feeding aluminum wire.

Genuine Miller® Options and Accessories

Run-In Control #193 391 Field

A separate wire feed speed adjustment to control wire speed prior to arc initiation. This control may be beneficial to aid arc starting with certain types of power sources.



Feeder Cart #142 382

A low-profile, creeper cart which allows the operator to easily move the feeder around the work area. Shipped disassembled.

Turntable Assembly #146 236

Allows rotation of the feeder as operator changes work positions. This reduces strain and bending on gun cable.

Hanging Bail (Electrically Isolated) #058 435

Used for suspending feeder over work area.



Spool Cover #057 607

For 12-inch (305 mm) spool.

Spool Adapter #047 141

For use with 14-pound (6.4 kg) spool of Lincoln self-shielding wire.



Wire Reel Assembly #108 008

For 60-pound (27 kg) coil of wire.

Reel Cover #195 412

For 60-pound (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.

Feeder to Power Source Interconnecting Cords *(Cords are 10 feet (3 m) in length unless noted.)*

Select interconnecting cord from list below for the type of power source being used. Cords shown reflect connection at the power source.



#194 842

Miller power source with 14-pin connector. 12-foot (3.7 m) cord.



#193 384

Lincoln power source with 14-pin connector.



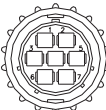
#193 381

Hobart power source with 19-pin plug.



#193 382

L-Tech power source with 19-pin connector.



#193 379

L-Tech power source with 7-pin connector.



#193 387

Old-style Miller and Airco power source with two- and three-prong (Hubbell-style) twistlock connectors.



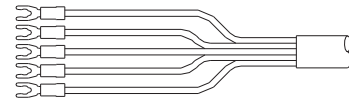
#193 386

Airco power source with straight-blade 115 volt wall-type plug and two-prong twistlock.



#193 383

Hobart power source with 115-volt wall-type plug and 5-pin plug.



#193 385

Lincoln power source with five-wire terminal strip connection.

Typical Installation

Old Miller or competitive
CV or CV/CC power source
with 115 VAC power supply



To wire feeder terminal block

Note: Optional hubble cord shown.



Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
R-115 Wire Feeder	#951 328			
Run-In Control	#193 391	Field		
Accessories				
Drive Roll Kits		See page 2		
Feeder Cart	#142 382			
Turntable Assembly	#146 236			
Hanging Bail	#058 435			
Spool Cover	#057 607			
Spool Adapter	#047 141			
Wire Reel Assembly	#108 008			
Reel Cover	#195 412			
Interconnecting Cords		See page 3		
Miscellaneous				
Primary Power Cable				
Secondary Weld Cable				
Work Cable with Work Clamp				
Gas Cylinder				
Gas Hose with Fittings				
Flowmeter Regulator				
Welding Wire				
Helmet				
Welding Gloves				

Date:

Total Quoted Price:

Distributed by:



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