

XMT[®] 400 ArcReach[®] Systems

**Multiprocess
Welding System**



Quick Specs

Heavy Industrial Applications

Construction
Shipbuilding
Power generation plants
Rental fleets
Maintenance repair
operations (MRO)
Fabrication

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
RMD[®]*
Stick (SMAW)
TIG (GTAW)
Flux-cored (FCAW)
Air carbon arc cutting and gouging (CAC-A)
Rated: 5/16-inch
Induction heating**

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)

ArcReach[®] Remote voltage control without
a control cord

*Available with ArcReach Smart Feeder only.

**Available with ArcReach Heater only.

The next step in a legacy so reliable, you can stake your reputation on it.

Simplify your fleet with the new XMT 400 ArcReach — tackle more jobs with one machine.

The streamlined user interface allows your crew to dial in exactly what they need with several specialized features and settings, including ArcReach, Auto-Line[™] and dedicated weld processes.

ArcReach technology allows you to take full control where it matters — process and parameter changes all happen at the point of use — improving jobsite efficiency, weld quality, and safety.



Ideal for:

- Structural
- General construction
- Ship
- Rental fleets



**More Jobsite
Productivity and
Efficiency**



**Built To
Work Harder**



**Empower
Your Welders**

ArcReach[®]

Remote voltage control at the wire feeder or remote without needing a control cord. See page 2 for more information.



Power source is warranted for three years, parts and labor.



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XMT® 400 ArcReach® Systems Benefits



More Jobsite Productivity and Efficiency

AR ArcReach® capabilities eliminate the time spent tracing weld cables hundreds of feet back to the power source because weld operators can make adjustments at the ArcReach wire feeder or remote.

AR Cable Length Compensation (CLC™) setting means output is automatically adjusted at the power source to account for voltage drop due to long weld cables, ensuring the operator's preferred weld parameters.

Regulated metal deposition (RMD®) and pulsed MIG are fully supported, enabling operators to use these advanced processes in the field for faster, more efficient welds.

Jobsite mobility is made easy with the smallest and lightest machine in its amperage class.

True multiprocess system provides conventional stick, TIG, FCAW, and MIG welding as well as the advanced technologies of RMD and pulse.

Fleet compatibility. ArcReach-equipped power sources and wire feeders work with non-ArcReach equipment; however, the complete ArcReach benefit is only realized with the ArcReach system.

AR = ArcReach feature



Built To Work Harder

Extensively field-proven XMT 400 ArcReach welders and ArcReach feeders and remotes deliver the performance you need with ruggedly constructed internal components and Wind Tunnel Technology™.

AR No more expenses related to maintaining or replacing easily damaged control cords because the weld cables are used to communicate weld parameters between the wire feeder and power source.

AUTO-LINE™ 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.

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.

Universal connector system quickly and easily allows the machine to be configured to either Tweco®, Dinse-, or Cam-Lok-style receptacles. Extra receptacles and wrench are sold separately as Universal Connector Kits (see page 8).



Empower Your Welders

AR More control for weld operators with quick, easy adjustments at the wire feeder/remote.

AR Weld operators can Adjust While Welding (AWW™) to change weld parameters while the arc is on.

AR Inadvertent parameter changes by other jobsite workers can be easily avoided because connecting an ArcReach accessory from the power source automatically locks out the power source's panel controls.

AR Return to a previous weld process faster because the power source is restored to the previously used weld process and parameter settings once the ArcReach accessory is removed.

AR Decrease the chance of an incorrect weld process being used because Auto-Process Select™ automatically sets the power source to the correct weld process based on the polarity applied to the weld accessory.

Process selector switch reduces the number of control setup combinations without reducing any features.

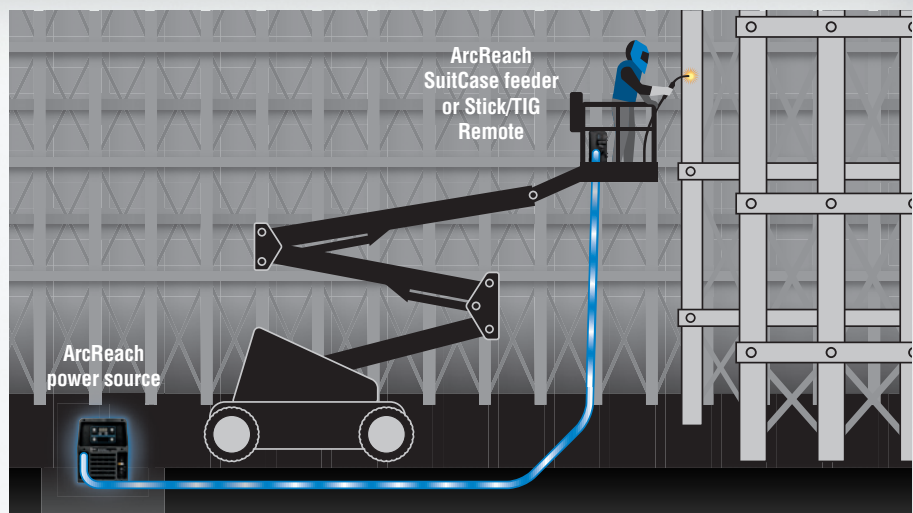
Adaptive Hot Start™ helps promote a fast positive arc ignition helping minimize defects.

Infinite arc control available in the stick and wire modes for easier fine tuning of tough-to-weld materials and out-of-position applications.

ArcReach®

Remote control of the power source without a cord.

ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or remote and power source. This technology eliminates the need for control cords, and their associated problems and costs.



XMT® 400 ArcReach® Pulse Programs

Built-in pulse programs for fabrication applications that have benefits for standard steels, high-strength steels and aluminum. See Owner's Manual for more information.

Note: Non-synergic only — no synergic or process control functionality with MPa feeders.

Wire Types — diameter in inches (mm)		Gas Types
Steel	.035 (0.9) STL	ARGN CO ₂ (argon/carbon dioxide) 80 ARGN CO ₂ (argon/carbon dioxide) ARGN OXY (argon/oxygen)
	.045 (1.2) STL	
Steel 100S	.035 (0.9) STL, .045 (1.2) STL	100S C5 (95 argon/5 carbon dioxide)
Metal Core	.045 (1.2) MCOR, .052 (1.4) MCOR	ARGN CO ₂ (argon/carbon dioxide)
Stainless Steel	.035 (0.9) SSTL	TRI MIX (tri-gas mixture) ARGN OXY (argon/oxygen) ARGN CO ₂ (argon/carbon dioxide)
	.045 (1.2) SSTL	
Aluminum	.035 (0.9) AL4X (4000 Series)	ARGN (argon)
	.040 (1.0) AL4X (4000 Series)	
	3/64 (1.2) AL4X (4000 Series)	ARGN (argon)
	1/16 (1.6) AL4X (4000 Series)	
	.035 (0.9) AL49 (4943)	ARGN (argon)
	.040 (1.0) AL49 (4943)	
Aluminum	.035 (0.9) AL5X (5000 Series)	ARGN (argon) HE AR25 (helium/argon)
	.040 (1.0) AL5X (5000 Series)	
	3/64 (1.2) AL5X (5000 Series)	ARGN (argon)
	1/16 (1.6) AL5X (5000 Series)	
	.035 (0.9) NI	ARGN HE (argon/helium) ARGN (argon)
	.045 (1.2) NI	
Copper Nickel	.035 (0.9) CUNI, .045 (1.2) CUNI	HE ARGN (helium/argon)
Silicon Bronze	.035 (0.9) SIBR, .045 (1.2) SIBR	ARGN (argon)
Titanium	.035 (0.9) TI-5, .045 (1.2) TI-5	ARGN HE25 (75 argon/25 helium)
	.035 (0.9) TI-5, .045 (1.2) TI-5	ARGN HE50 (50 argon/50 helium)

XMT® 400 ArcReach® Specifications (Subject to change without notice.)



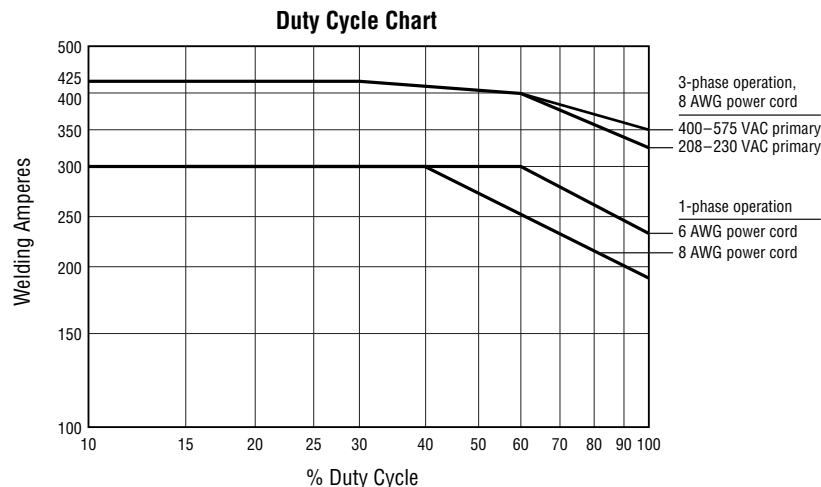
Input Power	Voltage Range in CV Mode	Amperage Range in CC Mode	Rated Output	Amps Input at Rated Load Output, 60 Hz							Max. Open-Circuit Voltage	Dimensions	Net Weight
				208 V	230 V	400 V	460 V	575 V	KVA	KW			
Three-phase	10–38 V	5–425 A	400 A at 36 VDC, 60% duty cycle	47.4	42.4	24.4	21.4	18.0	17.1	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.

XMT® 400 ArcReach® Performance Data



XMT® 400 ArcReach® Features



LED process indicator. Front panel process selections are illuminated with an LED that identifies the active process. This enables the selected weld process to be seen at a distance from the power source. Includes carbon arc gouging mode for enhanced arc stability and control, and two stick modes (EXX10 and EXX18) designed to reduce spatter and enhance arc starts.

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

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

ArcReach Stick/TIG Remote

Portable and lightweight, the ArcReach® Stick/TIG Remote paired with an XMT 400 ArcReach power source allows you to change weld settings at your work area, saving a trip to the power supply. No extra control cord to purchase, maintain, string or unstring — saving time and money.

Remote in use indicator provides convenient feedback indicating an ArcReach® wire feeder is controlling the power source. While under ArcReach control, process and voltage/ amperage adjustments are locked out, preventing accidental changes by personnel other than the welding operator.

ArcReach® SuitCase® 8 and 12 Features

Setting the standard for performance. Heavy-duty drive motor with tachometer control provides wire feed speed that is accurate and consistent from the start of the weld to the finish and from one weld to the next, which provides consistent arc quality. Wide voltage range for small and large wires with no contactor chatter or arc outages.

Set volts and wire feed speed remotely. The simple interface on the feeder allows operators to adjust parameters at the point of use with no control cords.

Durable design reduces downtime. Impact-resistant case and the elimination of feeder control cords provides a solid solution to last in harsh environments.



Easy process changeover. Simply connect the ArcReach SuitCase feeder to your weld lead and you are ready to go. The power source automatically switches settings to run conventional wire processes.

Easy solution for traditional wire process. Add the flux-cored capability of the XMT® 400 ArcReach® for fill and cap passes for increased productivity.

Weld with large diameter (3/32 in.) wire. The ArcReach SuitCase 12 Heavy Duty model is specifically designed for applications using 3/32-inch wire.

ArcReach SuitCase Specifications (Subject to change without notice.)



(Use with CC or CV, DC power sources.)

Model	Input Power	Input Welding Circuit Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Max. Spool Size Capacity	Dimensions	Net Weight
8	Operates on open-circuit voltage and arc voltage: 14–48 VDC/ 110 max. OCV	330 A at 60% duty cycle	50–780 ipm (1.3–19.8 m/min.) dependent on arc voltage	Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–5/64 in. (0.8–2.0 mm)	8 in. (203 mm) 14 lb. (6.4 kg)	H: 12.75 in. (324 mm) W: 7.25 in. (184 mm) D: 18 in. (457 mm)	28 lb. (13 kg)
12		425 A at 60% duty cycle		Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–5/64 in. (0.8–2.0 mm)			
12 Heavy Duty		450 A at 60% duty cycle	30–400 ipm (1.76–10.2 m/min.) dependent on arc voltage	Flux-cored: .030–3/32 in. (0.8–2.4 mm)	12 in. (305 mm) 45 lb. (20 kg)	H: 15.5 in. (394 mm) W: 9 in. (229 mm) D: 21 in. (533 mm)	35 lb. (15.9 kg)

ArcReach® 16 Features

Setting the standard for performance. Heavy-duty drive motor with tachometer control provides wire feed speed that is accurate and consistent from the start of the weld to the finish and from one weld to the next, providing consistent arc quality. Wide voltage range for small and large wires with no contactor chatter or arc outages.

Set volts and wire feed speed remotely. The simple interface on the feeder allows operators to adjust parameters at the point of use with no control cords.

Easy process changeover. Simply connect the ArcReach 16 wire feeder to your weld lead and you are ready to go. Switch between welding and gouging with a push of a button with no need to swap leads or disconnect the wire feeder with isolated outputs.



Durable design reduces downtime. The elimination of feeder control cords and field assembly IP23 rating provides a solid solution to last in harsh environments.

Integrated gouging stud on wire feeder. Isolated gouging stud allows easy connection for gouging at point of use, eliminating the need to disconnect the wire feeder and to swap leads.

Weld with up to 60-pound spools and large diameter (3/32 in.) wire to minimize downtime and maximize productivity.

Easy mobility in the shop and on-site. The ArcReach 16 wire feeder preassembled options include a shop cart and a field roller (shown) for your mobility needs.

ArcReach® 16 Specifications (Subject to change without notice.)

CC CV **DC** (Use with CC or CV, DC power sources.)

Input Power	Input Welding Circuit Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Max. Spool Size Capacity	Dimensions (H x W x D)	Net Weight
Operates on open-circuit voltage and arc voltage: 12–110 VDC	450 A at 100% duty cycle 500 A at 60% duty cycle CAC-A 600 A at 40% duty cycle	50–780 ipm (1.3–19.8 m/min.) dependent on arc voltage	Solid wire .035–5/64 in. (0.9–1.9 mm) Flux-cored .045–3/32 in. (1.1–2.4 mm)	18 in. (457 mm) 60 lb. (27.2 kg)	Base feeder 15.3 x 16.7 x 32.8 in. (388 x 424 x 833 mm) Shop cart 20 x 24.9 x 36.3 in. (508 x 632 x 922 mm) Field roller 28.2 x 19.9 x 42.7 in. (716 x 505 x 1,084 mm)	Base feeder 101 lb. (45.8 kg) Shop cart 120 lb. (54.4 kg) Field roller 123 lb. (55.7 kg)

ArcReach® Smart Feeder Features

ArcReach Smart Feeder delivers excellent RMD® and pulsed MIG welding up to 200 feet away from the power source with no control cords — twice the distance previously possible. RMD and pulsed MIG processes also help reduce weld failures and eliminate backing gas on some stainless and chrome-moly applications.

Easy process changeover. Simply connect the ArcReach Smart Feeder to your leads and you are ready to go. All controls automatically shift to the ArcReach Smart Feeder.



Synergic processes. RMD and pulsed MIG welding permits procedures with one wire and one gas to eliminate process switch-over time.

Durable design reduces downtime. Impact-resistant case and the elimination of feeder control cords provide a solid solution to last in harsh environments.

ArcReach Smart Feeder Specifications (Subject to change without notice.)

CC CV **DC** (Use with ArcReach-equipped power sources.)

Input Power*	Input Welding Circuit Rating	Wire Feed Speed	Wire Diameter Capacity	Max. Spool Size Capacity	Dimensions	Net Weight
XMT 400 ArcReach connected to three-phase power or an ArcReach-equipped engine drive	275 A at 60% duty cycle	50–500 ipm (1.3–12.7 m/min.) dependent on arc voltage	.035–.045 in. (0.9–1.1 mm)	12 in. (305 mm), 33 lb. (15 kg)	H: 18 in. (457 mm) W: 13 in. (330 mm) D: 21.5 in. (546 mm)	50 lb. (23 kg)

*XMT 400 ArcReach must be connected to three-phase power when using the ArcReach Smart Feeder. Using single-phase may cause the feeder to unpredictably interrupt welding. Smart Feeder Software version 1.17 or higher required. Visit MillerWelds.com to download the latest software.

ArcReach® Heater Features

Take charge of your field preheat and bakeout applications up to 600 degrees Fahrenheit (315°C).

As part of the ArcReach technology platform, the heater is an accessory for select ArcReach welding power sources. The induction heating tools (air-cooled cables or air-cooled quick wraps) connect to the ArcReach Heater, which is powered by select on-site welding power sources.

Learn more at MillerWelds.com/induction



Air-cooled cable



Air-cooled quick wrap

ArcReach Heater systems allow economical, insourced weld preheating and bakeout

With ArcReach Heater systems you can:

- Eliminate the costly overruns common with heating contractors
- Eliminate delays due to transitions between heating and welding crews
- Run your own schedule without depending on third-party contractors
- Use existing on-site welding equipment up to 200 feet away as the heating power source
- Lower preheating and bakeout costs
- Automatically and accurately document joint temperatures
- Eliminate safety concerns caused by traditional resistance and open-flame heating

The ArcReach Heater air-cooled induction heating system is specifically designed for preheating and bakeout applications up to 600 degrees Fahrenheit (315°C), without the need for a cooler and coolant. Preheat and bakeout programs can be manually entered or loaded via USB drive. Heating data is automatically recorded and can be used in quality control and documentation needs.



The air-cooled cables and quick wraps are manufactured from durable high-temperature materials, and designed to withstand the tough conditions in both industrial and construction applications.

Induction benefits

- Reduce injury**
Increase safety by removing open flames from your jobsite.
- Reduce labor**
Perform other tasks while heating is happening.
- Reduce inefficiencies**
Customer's weld team can be their heating team.
- Reduce time to heat**
In many cases your overall cycle can be up to four times faster than flame or resistance heating.

ArcReach Heater Specifications (Subject to change without notice.)

Input Power	Ambient Temperature Range		Rated Output	Dimensions	Net Weight
	Storage	Usage			
Operates on open-circuit voltage: 50–70 V	-4–131°F (-20–55°C)	14–104°F (-10–40°C)	7.8 kW at 100% duty cycle	H: 18.6 in (472 mm) W: 11.2 in (285 mm) D: 26.7 in (678 mm)	43 lb. (20 kg) CSA 50.5 lb. (23.4 kg) CE

 Certified by Canadian Standards Association to both the Canadian and U.S. Standards.
 Manufactured and certified in accordance with IEC-60974-1, -10.

XMT 400 ArcReach® Packages

MIG/Flux-Cored System

951000113

MIG/flux-cored system includes XMT 400 ArcReach power source, ArcReach® SuitCase 12 feeder with drive rolls and Bernard® BTB Gun 300 A with AccuLock™ consumables.

- No feeder control cords
- Eliminates trips back to power source
- Total remote control
- Automatically changes to CV output when feeder is connected



Stick/TIG System

951000114

Stick/TIG system includes XMT 400 ArcReach power source and ArcReach® Stick/TIG Remote

- Remotely change process
- Set actual amperage



RMD®/Pulse System

951000112

RMD/pulse system includes XMT 400 ArcReach power source, ArcReach® Smart Feeder with drive rolls and Bernard® PipeWorx 300-15 MIG gun.

- Offers traditional MIG and flux-cored processes, as well as advanced RMD and pulse programs
- Weld up to 200 feet away from the power source with no special cables
- Save welding parameters for later use on SD memory card
- Complete remote control at the weld joint



Ordering Information Most popular models ◀

XMT® 400 ArcReach® Packages	Stock No.	Description	Qty.	Price
XMT 400 ArcReach MIG/Flux-Cored System	951000113 ◀	208–575 V, Tweco®-style receptacles, includes XMT 400 ArcReach power source, ArcReach SuitCase 12 feeder with drive rolls and Bernard BTB Gun 300 A with AccuLock™ consumables		
XMT 400 ArcReach Stick/TIG System	951000114	208–575 V, Tweco-style receptacles, includes XMT 400 ArcReach power source and ArcReach Stick/TIG Remote		
XMT 400 ArcReach RMD®/Pulse System	951000112	208–575 V, Tweco-style receptacles, includes XMT 400 ArcReach power source, ArcReach Smart Feeder with drive rolls and Bernard PipeWorx 300-15 MIG gun		
XMT 400 ArcReach Racks				
XMT 400 ArcReach 4-Pack Rack	907882	Fused 460/575 V, 50/60 Hz, Tweco-style receptacles. See Multioperator Racks literature DC/19.0 for more information		
XMT 400 ArcReach 6-Pack Rack	907883	Fused 460/575 V, 50/60 Hz, Tweco-style receptacles. See Multioperator Racks literature DC/19.0 for more information		
System Components				
XMT 400 ArcReach Power Source	907865 ◀	208–575 V, 50/60 Hz, Tweco-style receptacles		
ArcReach® SuitCase® 12 MIG/FCAW Feeder with Tweco-style Receptacles	951729001	With drive rolls and Bernard BTB Gun 300 A with AccuLock™ consumables		
	951730	With drive rolls and Bernard S-Gun™ with Quik Tip™ consumables		
	951731	With drive rolls and Bernard Dura-Flux™ gun with Centerfire™ consumables		
	951732	With drive rolls and Bernard PipeWorx 300-15 MIG gun with Centerfire™ consumables		
ArcReach® SuitCase® 8 MIG/FCAW Feeder with Tweco-style Receptacles	951726001	With drive rolls and Bernard BTB Gun 300 A with AccuLock™ consumables		
	951727	With drive rolls and Bernard S-Gun™ with Quik Tip™ consumables		
	951728	With drive rolls and Bernard Dura-Flux™ gun with Centerfire™ consumables		
ArcReach® 16 MIG/FCAW/CAC-A Feeder	301619	Base feeder only		
	301664	With shop cart		
	951000065	With shop cart, drive rolls and Bernard® BTB Gun 500 A with AccuLock™ consumables		
	301663	With field roller		
	951000066	With field roller, drive rolls and Bernard® IronPro™ flux-cored gun with AccuLock™ consumables		
ArcReach® Smart Feeder MIG/FCAW/RMD®/Pulse Feeder	951733	Tweco-style receptacles, with drive rolls and Bernard® PipeWorx 300-15 MIG gun		
	300935	Tweco-style receptacles		
	300935001	Dinse-style receptacles		
ArcReach® Stick/TIG Remote	301325	Tweco-style connectors		
ArcReach® Heater		See literature IN/16.0		
Accessories				
14-Pin Feeders		See literature M/3.0 for 20 Series, M/11.0 for 70 Series, and M/6.5 for SuitCase® 12RC		
Spoolmatic® Spool Guns		See literature M/1.73		
Bernard® IronPro™ (FCAW)	GL4515MLNM	15 ft. (4.6 m), AccuLock™ consumables, 5/64 and 3/32 in. tips, 12 in. 30° neck		
Bernard® PipeWorx 300-15 MIG Gun	195400	15 ft. (4.6 m), 300 A air-cooled MIG gun designed for use with ArcReach smart systems		
Gas Valve Kit	297047	For XMT 400 ArcReach power source		
ArcReach® Feeder Gas Flow Meter Kit	301306	For ArcReach SuitCase 8/12 feeders and ArcReach Smart Feeder		
Cable Connectors and Adapters <i>All XMT 400 models ship with Tweco-style receptacles that can be swapped out for those listed below.</i>				
Universal Connector Kits	301611	Includes Tweco-style receptacles, wrench and electrical joint compound		
	301595	Includes Dinse-style receptacles, wrench and electrical joint compound		
	301637	Includes Cam-Lok-style receptacles, wrench and electrical joint compound		

Date:

Total Quoted Price:

Distributed by:

