

# XMT® 400

## QUICK SPECS

### Industrial Applications

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

### Processes

MIG (GMAW)  
Flux-cored (FCAW)  
Stick (SMAW)  
TIG (GTAW)  
Air carbon arc cutting and gouging (CAC-A)  
Rated: 8 mm 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** 34.0 kg

**Scalable Solutions with Intellex™ — Intellex Ex-S and Intellex Elite unlock the full suite of advanced processes in a multiprocess machine.**

### Dedicated wire feeder options

- Intellex Elite and Intellex Ex-S feeders add additional weld programs, intuitive display with on-demand graphics and more control.
- The Intellex Ex-S delivers outstanding performance in the field: with its fully enclosed wire spool, rugged construction, and compact form factor, it ensures maximum reliability wherever the job takes you.

### Easy to use

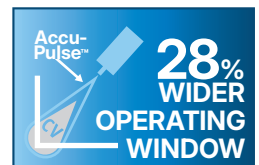
EZ-Set simplifies parameter setup based on material thickness, removing complexity.



### Pulse capable

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

**NEW!**



**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.



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# 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



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™ Elite feeder features

**Accu-Mate™ connection** (for Miller® power lin) aligns the gun perfectly in the drive-roll carrier — preventing the gun from being pulled loose and providing consistent wire feeding. A Euro-connector is included in the delivery.

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

**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.

- Full color LCD display
- Weld sequence control
- Trigger select
- Trigger dual schedule
- Memory slots
- Locks and Limits
- Remote voltage
- Arc control
- Insight Centerpoint Premium compatible
- EZ-Set
- Out-of-Box programs
- Auto thread and auto purge
- XR plus push-pull gun compatible



**Soft keys** to easily navigate menus

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

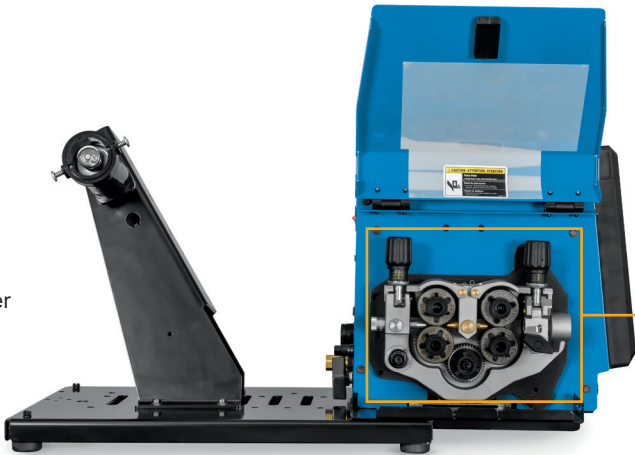
**Arc control** to fine tune welding arc

**Memory buttons** for quick program recall

**Trigger connections** for standard MIG gun and XR-Aluma-Pro™ Plus

## Intellx™ Elite feeder Drive mechanism

- Rotatable drive
- Wire jog and purge
- Optional spool cover available
- Optional feeder swivel
- Optional running gear for feeder



**Heavy duty** drive system  
**Four** drive rolls

# Intellix™ Ex-S

Extended working range at the jobsite, reduced handling effort, and a wire feeder designed to withstand demanding industrial environments and continuous daily operation.

## IC – STRAIN RELIEF

A robust solution to last the toughest environments with a quick closure bar to attach and disconnect the IC within seconds. The robust fixture takes away all stress from the connections to prevent them from breaking. All connections are quick connects to enable an attachment of the IC without any tools.

## HANDLING FLEXIBILITY

The wire feeder is delivered with two incorporated handles (top certified for crane) and a third lifting point for optimal portability. Standard rails on the bottom of the feeder enable safe transport through any environment. If the feeder needs to be completely mobile, a wheel kit can be added.

## REACH

The lightweight design of the wire feeder enables a large work area. Easy to move from one spot to another using the 30m IC cables.

## GAS FLOW METER

Built in optional gas flow meter.

## WIRE PROTECTION

The fully enclosed wire feeder protects the wire from any external impacts.

## SIZE

With less than 400mm the new wire feeder Ex-S defines the word compact new. It is designed to reach the most difficult areas.

## DURABILITY

The new fully enclosed Ex-S can tackle the toughest environments and has been designed for and is designed for adverse conditions. Protective stripes have been incorporated into the design of the side panels to protect the feeder when lying on the side.

## PORTABILITY FIRST

Smallest fully enclosed solution in its class, optimized for field use. Innovative strain relief for IC cables.

## EASE OF USE & SERVICEABILITY

Quick service access, quick connections, angled UI, and integrated front/top/rear handles.



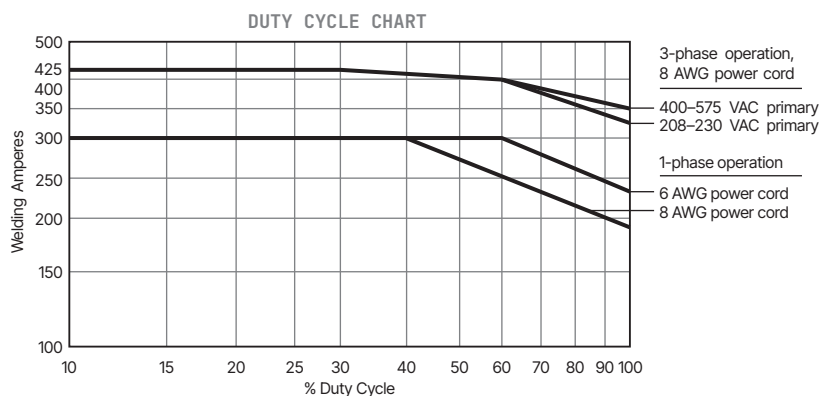
**WEIGHT:** 12,7 kg  
**SIZE:** 249 × 608 × 394 mm  
**DRIVE MECHANISM:** 4 driven  
**IP RATING:** IP 23

# 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.



## 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, 60HZ |      |      |      |      |      |      | MAX. OPEN-CIRCUIT VOLTAGE | DIMENSIONS                          | NET WEIGHT |
|--------------|--------------------------|---------------------------|---------------------------------|---------------------------------------|------|------|------|------|------|------|---------------------------|-------------------------------------|------------|
|              |                          |                           |                                 | 208V                                  | 230V | 400V | 460V | 575V | 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<br>25/12 VDC*      | H: 438 mm<br>W: 324 mm<br>D: 514 mm | 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.

# Genuine Miller® Accessories

## Remote Controls



### ArcConnect Control/Motor Cables

|                  |        |
|------------------|--------|
| <b>280471005</b> | 1.5 m  |
| <b>280471009</b> | 2.7 m  |
| <b>280471015</b> | 4.6 m  |
| <b>280471025</b> | 7.6 m  |
| <b>280471050</b> | 15.2 m |
| <b>280471075</b> | 22.9 m |
| <b>280471100</b> | 30.5 m |
| <b>280471150</b> | 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)

|               |        |
|---------------|--------|
| <b>300461</b> | 7.6 m  |
| <b>300462</b> | 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 Intellix™ Elite feeders.* Required for high-deposition MIG (HD MIG) process when using Bernard® BTB gun with AccuLock consumables.



### Wireless Remote Foot Control 301580

For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 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 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

|                  |             |
|------------------|-------------|
| <b>242211020</b> | 6 m cord    |
| <b>242211100</b> | 30.5 m cord |

Miniature hand control for remote current and contactor control. Dimensions: 102 × 102 × 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 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 8 m cord and 14-pin plug.

### Extension Cables for Remote Controls and 24 VAC Wire Feeders

|                  |        |
|------------------|--------|
| <b>242208025</b> | 7.6 m  |
| <b>242208050</b> | 15 m   |
| <b>242208080</b> | 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

|               |                                |
|---------------|--------------------------------|
| <b>042418</b> | Accepts #4 to #1/0 AWG cable   |
| <b>042533</b> | 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

|               |                               |
|---------------|-------------------------------|
| <b>134460</b> | Male Dinse-style plug         |
| <b>136600</b> | Female Dinse-style receptacle |

Used to adapt or extend weld and/or work cables. Accepts #1/0 to #2/0 AWG cable.

## Additional Feeders



### 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.

# Ordering Information

| POWER SOURCE AND OPTIONS            | STOCK NO.                                                                                                                                                                                                      | DESCRIPTION                                                                                                                                                                                                                                                                                                                                                                                                                                              | QTY. | PRICE |
|-------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|-------|
| <b>XMT® 400</b>                     | <b>907865002</b>                                                                                                                                                                                               | With Auto-Line™ and Dinse-style receptacles and <b>CE</b>                                                                                                                                                                                                                                                                                                                                                                                                |      |       |
| <b>Wire Feeders</b>                 |                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                          |      |       |
| Intellx™ Elite                      | <b>301705</b>                                                                                                                                                                                                  | Intellx™ Elite                                                                                                                                                                                                                                                                                                                                                                                                                                           |      |       |
| Intellx™ Ex-S                       | <b>3800000006</b>                                                                                                                                                                                              | Intellx™ Ex-S                                                                                                                                                                                                                                                                                                                                                                                                                                            |      |       |
| Intellx™ Ex-S                       | <b>3800000009</b>                                                                                                                                                                                              | Intellx™ Ex-S with gas regulator                                                                                                                                                                                                                                                                                                                                                                                                                         |      |       |
| ST - 24WD                           | <b>3800000004</b>                                                                                                                                                                                              | Wire feeder new generation                                                                                                                                                                                                                                                                                                                                                                                                                               |      |       |
| S-74 MPa Plus                       | <b>300577</b>                                                                                                                                                                                                  | Single-wire synergic feeder. See literature WFM/30.0                                                                                                                                                                                                                                                                                                                                                                                                     |      |       |
| D-74 MPa Plus                       | <b>300578</b>                                                                                                                                                                                                  | Dual-wire synergic feeder. See literature WFM/30.0                                                                                                                                                                                                                                                                                                                                                                                                       |      |       |
| <b>Interconnection cables</b>       |                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                          |      |       |
| Air-Cooled Interconnecting Cables   | <b>058019028</b><br><b>058019044</b><br><b>058019039</b>                                                                                                                                                       | 3 m<br>5 m<br>10 m<br>70 mmq weld cable, control cable,<br>gas hose for ST-24/ST-44                                                                                                                                                                                                                                                                                                                                                                      |      |       |
| Water-Cooled Interconnecting Cables | <b>058019032</b><br><b>058019033</b><br><b>058019046</b>                                                                                                                                                       | 3 m<br>5 m<br>10 m<br>70 mmq weld cable, control cable,<br>gas and water hose for ST-24/ST-44                                                                                                                                                                                                                                                                                                                                                            |      |       |
|                                     | <b>058019174</b><br><b>058019175</b><br><b>058019176</b>                                                                                                                                                       | 3 m<br>5 m<br>10 m<br>70 mmq weld cable, control cable,<br>gas and water hose for MPa Plus feeders                                                                                                                                                                                                                                                                                                                                                       |      |       |
| IC XMT - Ex-S                       | <b>7400000057</b><br><b>7400000058</b><br><b>7400000059</b><br><b>7400000060</b><br><b>7400000061</b><br><b>7400000062</b><br><b>7400000063</b><br><b>7400000064</b><br><b>7400000065</b><br><b>7400000066</b> | 3 m<br>5 m<br>8 m<br>15 m<br>23 m<br>3 m<br>5 m<br>8 m<br>15 m<br>23 m<br>Air cooled, XMT 400 Intellx Ex-S<br>Air cooled, XMT 400 Intellx Ex-S<br>Air cooled, XMT 400 Intellx Ex-S<br>Air cooled, XMT 400 Intellx Ex-S<br>Air cooled, XMT 400 Intellx Ex-S<br>Water cooled, XMT 400 Intellx Ex-S<br>Water cooled, XMT 400 Intellx Ex-S<br>Water cooled, XMT 400 Intellx Ex-S<br>Water cooled, XMT 400 Intellx Ex-S<br>Water cooled, XMT 400 Intellx Ex-S |      |       |
| <b>Accessories</b>                  |                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                          |      |       |
| Running Gear 1                      | <b>7600000001</b>                                                                                                                                                                                              | Single gas cylinder (optional dual gas cylinder available) for water cooled configurations                                                                                                                                                                                                                                                                                                                                                               |      |       |
| Field Runner                        | <b>7600000022</b>                                                                                                                                                                                              | For air cooled configurations                                                                                                                                                                                                                                                                                                                                                                                                                            |      |       |
| Attachment XMT                      | <b>7600000023</b>                                                                                                                                                                                              | For use when a water cooler is needed                                                                                                                                                                                                                                                                                                                                                                                                                    |      |       |
| Water cooler                        | <b>058042005</b>                                                                                                                                                                                               | 1 kW of cooling, 5 l tank capacity                                                                                                                                                                                                                                                                                                                                                                                                                       |      |       |
| Coolant 3.8 l                       | <b>043810</b>                                                                                                                                                                                                  | 2 canisters required to fill the tank                                                                                                                                                                                                                                                                                                                                                                                                                    |      |       |
| Feeder rotation support             | <b>156012180</b>                                                                                                                                                                                               | Needed for XMT 400 with running gear 1 and cooler setup                                                                                                                                                                                                                                                                                                                                                                                                  |      |       |
| Swivel-Plate Ex-S                   | <b>7600000024</b>                                                                                                                                                                                              | Tool-less switching between stationary and mobile use                                                                                                                                                                                                                                                                                                                                                                                                    |      |       |
| ArcConnect Control/Motor Cables     |                                                                                                                                                                                                                | See page 6 for available lengths                                                                                                                                                                                                                                                                                                                                                                                                                         |      |       |
| Work Sense Leads (volt sense)       |                                                                                                                                                                                                                | See page 6 for available lengths                                                                                                                                                                                                                                                                                                                                                                                                                         |      |       |
| Wheel Kit Ex-S                      | <b>7600000017</b>                                                                                                                                                                                              | For smooth and stable movement on various surfaces                                                                                                                                                                                                                                                                                                                                                                                                       |      |       |
| AccuLock™ Nozzle                    | <b>N-A3412C</b>                                                                                                                                                                                                | Required for high-deposition MIG (HD MIG) process when using Bernard® BTB gun with AccuLock consumables                                                                                                                                                                                                                                                                                                                                                  |      |       |
| <b>Remote Controls</b>              |                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                          |      |       |
| Wireless Remote Foot Control        | <b>301580</b>                                                                                                                                                                                                  | Foot control with wireless 27.4 m (90 ft.) operating range                                                                                                                                                                                                                                                                                                                                                                                               |      |       |
| Wireless Remote Hand Control        | <b>301582</b>                                                                                                                                                                                                  | Hand control with wireless 91.4 m (300 ft.) operating range                                                                                                                                                                                                                                                                                                                                                                                              |      |       |
| RFCS-14 HD                          | <b>301589</b>                                                                                                                                                                                                  | Foot control with 6 m (20 ft.) cord and 14-pin plug                                                                                                                                                                                                                                                                                                                                                                                                      |      |       |
| RHC-14                              | <b>242211020</b><br><b>242211100</b>                                                                                                                                                                           | Hand control with 6 m (20 ft.) cord Hand control with 30.5 m (100 ft.) cord                                                                                                                                                                                                                                                                                                                                                                              |      |       |
| RCC-14                              | <b>151086</b>                                                                                                                                                                                                  | Fingertip control                                                                                                                                                                                                                                                                                                                                                                                                                                        |      |       |
| RCCS-14                             | <b>043688</b>                                                                                                                                                                                                  | Fingertip control                                                                                                                                                                                                                                                                                                                                                                                                                                        |      |       |

DATE :

TOTAL QUOTED PRICE :

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