

# 22A and 24A

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**24 Volt Constant-Speed Wire Feeder** 

## Quick Specs

### Industrial Applications

Heavy- or Light-Duty  
Fabrication Shops  
Trailer Manufacturers  
Furniture Manufacturers  
Automotive Products  
Educational Institutions

### Processes

MIG (GMAW)  
Flux Cored (FCAW)  
Gas- and Self-Shielded

*For use with CV power sources*

**Input Power** 24 VAC, 7 A, 50/60 Hz

### Electrode Wire Diameter Capacity

**22A:** .023–5/64 (0.6–2.0 mm)  
**24A:** .023–3/32 (0.6–2.4 mm)

**Wire Speed** 75–750 IPM (1.9–19 m/min)

**Weight** **22A:** 36 lb (15.4 kg) **24A:** 40 lb (18 kg)

## The Power of Blue.®

**Wire feed speed range** is 75–750! This offers a wider operating range than the competition.

**Trigger hold control** allows operator to make long extended welds without having to hold gun trigger.

**Gear-driven drive rolls** offer smooth, positive and accurate wire feed with long, uninterrupted service life. 24A has four drive rolls for larger wire diameters.

**On-board burnback and motor ramp control** offers unmatched starting and stopping performance on a variety of power sources. This helps to ensure positive arc starting performance.



**16 gauge sheet metal housing** is robust in rough service applications and less prone to damage.

**Run-in standard on 24A** for better arc-starting performance on a variety of wires. Optional for 22A.

**Remote voltage control is standard on 24A.** Parameter adjustments can be made in weld cell or at a remote location. Optional for 22A.

Both include performance-matched Bernard® Q™-Gun, .035/.045 in drive roll and Centerfire™ contact tips.

## Specifications (Subject to change without notice.)

**CV**

Model	Input Power	Electrode Wire Diameter Capacity	Wire Speed	Dimensions	Net Weight
22A	24 VAC, 7 A, 50/60 Hz	.023–5/64 in (0.6–2.0 mm)	75–750 IPM (1.9–19 m/min)	H: 11 in (279 mm) W: 10-3/4 in (273 mm) D: 23-1/2 in (597 mm)	36 lb (15.4 kg)
24A		.023–3/32 in (0.6–2.4 mm)			40 lb (18 kg)

 Certified to both the Canadian and U.S. Standards for welding equipment.

**TRUE BLUE**  
3YR. WARRANTY

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

MADE IN **USA**  
APPLETON, WI **USA**



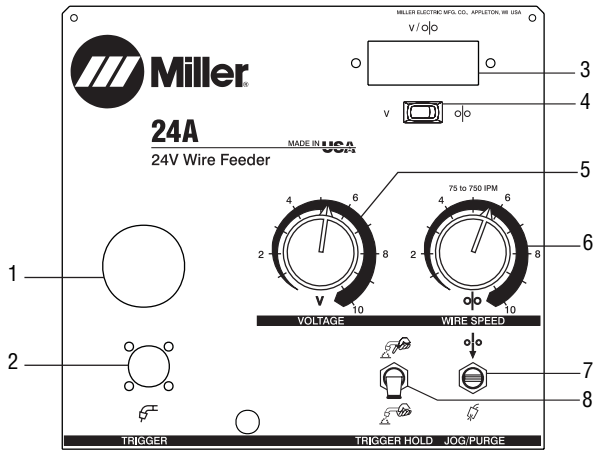
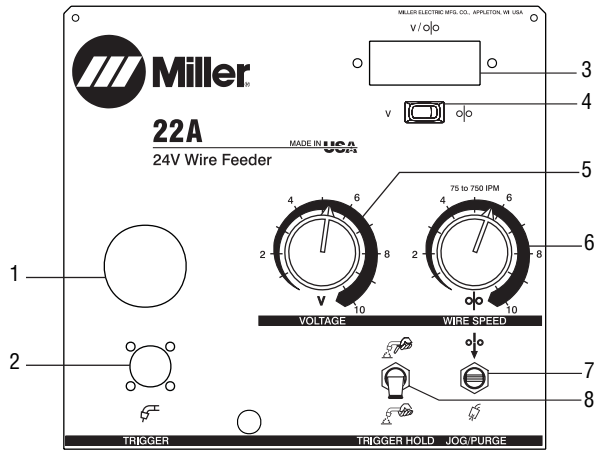
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# Control Panel



- 1. Gun Connection
- 2. Trigger Receptacle
- 3. Voltage/Wire Speed Meter\*
- 4. Meter Selection Switch\*
- 5. Remote Voltage Control\*\*

- 6. Wire Speed Control
  - 7. Jog/Purge
  - 8. Trigger Hold (On/Off)
- Power On/Off (on rear panel)

\*Optional

\*\*Optional on 22A, standard on 24A

## Drive Roll Kits (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)	
	22A 2-Roll Kit	24A 4-Roll Kit	22A 2-Roll Kit	24A 4-Roll Kit	22A 2-Roll Kit	24A 4-Roll Kit	22A 2-Roll Kit	24A 4-Roll Kit
.023/.025 in (0.6 mm)	#087 131	—	—	—	—	—	—	—
.030 in (0.8 mm)	#079 594	#046 780	—	—	—	—	—	—
.035 in (0.9 mm)	#079 595	#046 781	#044 749	#044 750	#079 606	#046 792	—	—
.040 in (1.0 mm)	#161 189	#161 190	—	—	—	—	—	—
.045 in (1.1/1.2 mm)	#079 596	#046 782	#079 599*	#046 785	#079 607	#046 793	#083 318	#083 319
.052 in (1.3/1.4 mm)	#079 597	#046 783	#079 600	#046 786	#079 608	#046 794	#083 317	#083 320
1/16 in (1.6 mm)	#079 598	#046 784	#079 601	#046 787	#079 609	#046 795	#079 614	#046 800
.068/.072 in (1.8 mm)	—	—	—	—	#089 984	#089 985	—	—
5/64 in (2.0 mm)	—	—	#079 602	#046 788	#079 610	#046 796	#079 615	#046 801
3/32 in (2.4 mm)	—	—	—	#046 789**	—	#046 797**	—	#046 802**

\*Accommodates .045 and .047 in (3/64 mm) wires.

\*\*3/32 in inlet guide (#194 264) is required when using 3/32 in drive rolls.

## Nylon Wire Guides for Feeding Aluminum Wire (Order from Miller Service Parts.)

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.