

# 22A

## 24 Volt, Constant-Speed Wire Feeder

Index No. M/11.0  
Issued Dec. 1999



### Processes



MIG (GMAW)  
Welding



Flux Cored (FCAW) Welding  
(Gas- and Self-shielded)

**TRUE BLUE**  
3YR. WARRANTY



Simple to use but with all the features needed for the industrial manufacturing and fabricating markets. Built with the strength and flexibility to handle strenuous work loads, the 22A delivers proven reliability and economy.

This wire feeder is ideal for most high-duty-cycle applications requiring day-in day-out trouble-free operation.

### Applications

- Light-duty fab shops
- Trailer manufacturers
- Furniture manufacturers
- Automotive products
- Educational institutions

### Features

#### Increased wire-feed-speed range

### Benefits

The 22A wire-feed-speed range is 75–750! This offers a wider operating range than the competition.

#### Trigger hold control

Allow operator to make long extended welds without having to hold gun trigger.

#### Gear-driven drive rolls

Offers smooth, positive and accurate wire feed with long, uninterrupted service life.

#### On-board burnback and motor ramp control

Unmatched starting and stopping performance on a variety of power sources. This helps to ensure positive arc starting performance.

#### 16 gauge sheet metal housing

Robust in rough service applications. Less prone to damage.

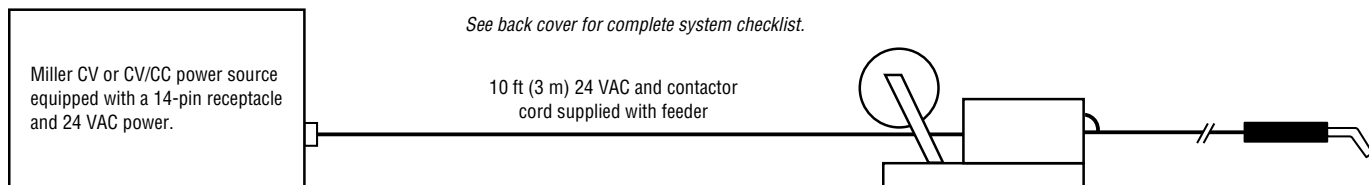
#### Optional presettable voltage and wire feed speed

Allows voltage and wire feed speed to be preset and monitored. Does not require a volt sense lead.

#### Miller's True Blue® Warranty

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

### Typical Installation



Note: For power sources only supplying 115 VAC power the R-115 (#193 164) model is recommended.

### Specifications (Subject to change without notice.)

Industrial (Use with CV Power Sources.)

Input Power	Electrode Wire Diameter Capacity	Wire Speed	Dimensions	Net Weight
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)

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

### Ordering Information See back page.



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**International Headquarters**  
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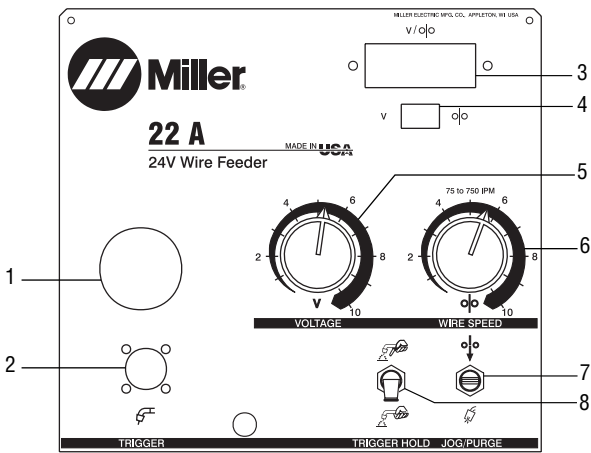
**Web Site**  
[www.MillerWelds.com](http://www.MillerWelds.com)



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



**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)
.023/.025 in (0.6 mm)	#087 131	—	—	—
.030 in (0.8 mm)	#079 594	—	—	—
.035 in (0.9 mm)	#079 595	#044 749	#079 606	—
.040 in (1.0 mm)	#161 189	—	—	—
.045 in (1.1/1.2 mm)	#079 596	#079 599*	#079 607	#083 318
.052 in (1.3/1.4 mm)	#079 597	#079 600	#079 608	#083 317
1/16 in (1.6 mm)	#079 598	#079 601	#079 609	#079 614
.068/.072 in (1.8 mm)	—	—	#089 984	—
5/64 in (2.0 mm)	—	#079 602	#079 610	#079 615

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

**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.

Options

**Skill Level Index**  
The bracketed entry to the right of the stock number of field-installed options contains a letter and number. The letter indicates the skill level required to install the option. The number indicates the approximate time required for installation (see legend).

**A – Easy.** No previous experience needed.

**B – Average.** Requires removal of service panels. Mechanical ability is helpful.

**C – Difficult.** May require the use of an ohmmeter and/or splicing of electrical wires. Repair or replacement of component parts is more difficult.

**D – Technical.** May require the use of an ohmmeter and the ability to read a circuit diagram. Repair or replacement of component parts is complex.

**Example:**  
[ B: 30 ] Skill Level: B, Time: 30 minutes

**Digital Display V/WFS #186 498 Field [ B: 30 ]**  
Dual-function, back-lit LCD digital meter with selector switch. The digital meter allows the wire feed speed to be preset in inches per minute or meters per minute. The voltage function, if used with a current manufactured Miller electronically controlled constant voltage power source, allows the arc voltage to be preset and monitored on the digital display. When used with voltage control #194 211.

**Voltage Control #194 211 Field [ A: 15 ]**  
Installs in front panel of the feeder to allow remote voltage control of most Miller electrically controlled CV or CC/CV power sources.  
*Note: The field kit voltage control includes a 10 ft (3 m) cord that replaces the standard cord supplied with the feeder.*

**Run-In Control #193 391 Field [ A: 25 ]**  
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.

**Preflow/Postflow and Spot Control #186 496 Field [ A: 25 ]**  
Installs inside feeder under an easy access hinged cover. Provides up to 5 seconds of spot weld time and has adjustable timers (0.25 to 5 seconds) for controlling gas flow prior to arc initiation and after completion of weld.



## Accessories



### Blue Runner #043 965

Simple, convenient, and easy-to-assemble running gear for the XMT-304 and Invision 354MP. Designed for factory floor MIG applications using the 22A or S-60 Series wire feeders.



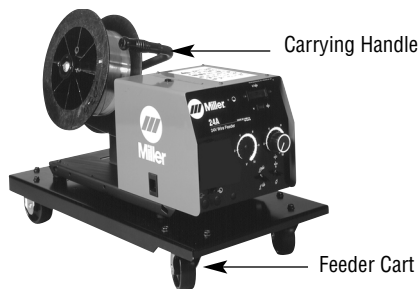
### Carrying Cart #056 301 [A: 30]

A utility cart for the wire feeder and other miscellaneous welding supplies. Height: 34 in (863 mm) Lower tray height: 9 in (228 mm) Shipped disassembled.



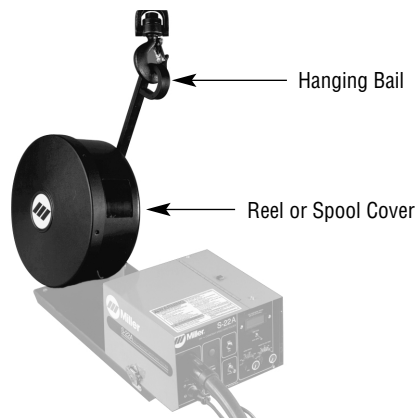
### Feeder Cart #142 382 [A: 20]

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



### Carrying Handle #193 762

For lifting and moving feeder. (Cannot be used with wire reel assembly #108 008.)



### Hanging Bail #058 435 [A: 05]

Suspends feeder over the work area.

### Reel Cover #058 256 [A: 05]

For 60 lb (27.2 kg) coil.

### Spool Cover #057 607 [A: 05]

For 12 in (304 mm) spool.



### Wire Reel Assembly #108 008 [A: 05]

For 60 lb (27.2 kg) coil of wire. (Cannot be used with carrying handle #193 762.)

### Turntable Assembly #146 236 [B: 20]

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

### Spool Adapter #047 141 [A: 05]

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



### PSA-2 Control #141 604 [A: 10]

Required when using the 22A wire feeder with power sources having only 115 VAC available. The PSA-2 control can be conveniently mounted on the wire feeder or positioned at the power source. The control is equipped with a 14-pin receptacle for direct connection of the wire feeder control cord. A short cord with a 4-pin Amp plug is hard wired to the control. A 10 ft (3 m) interconnecting cord with a 4-pin Amp for connection to the PSA-2 and Hubbell connectors for older-style Miller CV power sources is included. The PSA-2 control can also be used with competitive power sources requiring a contact closure for contactor control.

### Extension Cords

#122 973 25 ft (7.6 m)

#122 974 50 ft (15 m)

#122 975 75 ft (23 m)

These extension cords can be added to the standard 10 ft cord to extend feeder farther from the power source.

### 2/0 MIG Welding Accessory Kit #173 856

25 ft (7.6 m). Includes gas hose, weld cable and ground cable with clamp.

### M-25 and M-40 Guns

See Lit. Index No. M/10.0.

### GW-500 Gun

See Lit. Index No. M/13.4.

# System Checklist and Quotation Sheet

Equipment and Options	Stock No.	Description	Qty.	Price
<b>22A</b>	<b>#193 066</b>	With run-in control		
	<b>#193 066-01-1</b>	With digital display and voltage control		
	<b>#193 066-02-2</b>			
Drive Roll Kit		See table on page 2		
Digital Display Meter	<b>#186 498</b>	Field		
Voltage Control	<b>#194 211</b>	Field		
Run-In Control	<b>#193 391</b>	Field		
Preflow/Postflow and Spot Control	<b>#186 496</b>	Field		
<b>Power Sources</b>				
Regency 250 Package		See Lit. Index No. DC/12.6		
CP-302		See Lit. Index No. DC/13.0		
CP-252TS		See Lit. Index No. DC/13.0		
Deltaweld 302		See Lit. Index No. DC/16.2		
Shopmaster		See Lit. Index No. AD/2.3		
XMT-304 CC/CV		See Lit. Index No. DC/18.8		
Invision 354 MP		See Lit. Index No. DC/23		
<b>Accessories</b>				
Blue Runner	<b>#043 965</b>			
Carrying Cart	<b>#056 301</b>			
Feeder Cart	<b>#142 382</b>			
Carrying Handle	<b>#193 762</b>			
Hanging Bail	<b>#058 435</b>			
Reel Cover	<b>#058 256</b>	For 60 lb coil		
Spool Cover	<b>#057 607</b>	For 12 in spool		
Wire Reel Assembly	<b>#108 008</b>			
Turntable Assembly	<b>#146 236</b>			
Spool Adapter	<b>#047 141</b>	For 14 lb spool of Lincoln self-shielding wire		
PSA-2 Control	<b>#141 604</b>			
Extension Cords	<b>#122 973</b>	25 ft		
	<b>#122 974</b>	50 ft		
	<b>#122 975</b>	75 ft		
2/0 MIG Accessory Kit	<b>#173 856</b>			
Interconnecting Cable	<b>#043 695</b>	10 ft		
	<b>#043 696</b>	25 ft		
	<b>#043 697</b>	75 ft		
M-25 and M-40 MIG Guns		See Lit. Index No. M/10.0		
GW-500 MIG Gun		See Lit. Index No. M/13.4		
<b>Miscellaneous</b>				
Primary Power Cable				
Secondary Weld Cable				
Ground Cable with Work Clamp				
Gas Cylinder				
Gas Hose with Fittings				
Regulator/Flowmeter				
Welding Wire				
Helmet				
Welding Gloves				
<b>Date:</b>		<b>Total Quoted Price:</b>		

Distributed by:

