

# PipeWorx 400 Welding System

See literature PWS/2.0

Optimized for pipe fabrication shops.

PipeWorx 400 welding system shown with PipeWorx accessory kit for dual-wire feeder. Filler metal and shielding gas sold separately.



### Simple process setup

- The front panel was designed by welders for welders
- Requires just a few basic steps to set up a new weld process, resulting in less training time and minimizing errors from incorrect setups
- Memory feature stores four programs for each selection: stick, DC TIG, and MIG (left and right side of feeder) – eliminates the need to remember parameters

### True multiprocess machine

- Weld processes are optimized to deliver superior arc performance and stability, specifically for root, fill, and cap passes on pipe
- RMD® and pulsed MIG increase quality and productivity

### Quick process changeover

- Simply push a process selection button to choose a welding process
- Reduces setup time and the risk of weld reworks due to incorrect cable connections
- PipeWorx “Quick Select” technology automatically selects the welding process, the correct polarity, cable outputs, gas solenoid, and user-programmed welding parameters

### Single-system design

- One machine designed to perform all of your pipe welding needs
- Simplified and optimized specifically for pipe welding

Heavy industrial

### Processes

- Stick (SMAW) ▪ DC TIG (GTAW)
- MIG (GMAW) ▪ Flux-cored (FCAW)
- RMD ▪ Pulsed MIG (GMAW-P)
- Air carbon arc cutting and gouging (CAC-A)

### PipeWorx welding system comes complete with

- PipeWorx 400 power source with cable hangers (907382 **OR** 907384)
- Dual-wire feeder with drive rolls (300366)
- Two Bernard® PipeWorx 300-15 MIG guns (195400)
- Running gear with gas cylinder rack and handles (300368)
- Cable kit with 25 ft. (7.6 m) work sense lead (300367)

### Most popular accessories

- Bernard® PipeWorx Guns  
195399 15 ft. (4.6 m), 250-15  
195400 15 ft. (4.6 m), 300-15
- PipeWorx Accessories Kit for Dual-wire Feeder 300568  
Includes 25 ft. (7.6 m) work cable with EG500 clamp, two flowmeter regulators and two 5 ft. (1.5 m) gas hoses
- Composite Cable Kit  
300454 25 ft. (7.6 m)  
300456 50 ft. (15.2 m)
- PipeWorx Cooler 300370
- Foot Control Bracket 300676
- RFCS-14 HD 194744 (pg 124)
- RPBS-14 300666 (pg 124)

Visit [MillerWelds.com](http://MillerWelds.com) or your distributor for other Miller® options and accessories.

## Advanced Technologies of PipeWorx System

### Regulated Metal Deposition (RMD®)

- Higher quality root pass
- Calm stable arc
- Less spatter
- More tolerant of hi-lo conditions
- Reduced training requirements
- Less chance of cold lap or lack of fusion; reduces rework
- Can eliminate the need for a hot pass
- Can eliminate backing/purge gas in some stainless applications



RMD carbon steel

### Pulsed MIG

- Less heat input than traditional spray pulse transfer
- Shorter arc length
- Narrower arc cone
- Improved fusion and fill at the toes of the weld resulting in:
  - Faster travel speeds
  - Higher deposition rates
- Less training time required because pulsed MIG:
  - Virtually eliminates arc wander
  - Is easier to control the puddle
  - Compensates for tip-to-work variations automatically
- When used with RMD, it is possible to use one wire and one gas for all passes



Pulsed MIG stainless

\*Dimensions and weight are for power source only.

Model/Stock Number Most Popular System	Welding Mode/ Process	Amperage/ Voltage Ranges	Rated Output at 100% Duty Cycle	Amps Input at Rated Output, 60 Hz, 3-Phase			KVA			KW			Max. Open- Circuit Voltage	Dimensions*	Net Weight*
				230 V	460 V	575 V	230 V	460 V	575 V	230 V	460 V	575 V			
PipeWorx 400 Welding System (951381) 230/460 V (951382) 575 V	CC: Stick	40-400 A	400 A at 36 VDC	43.9	26.6	22.4	17.5	21.2	22.3	16.1	16.3	16.4	90 VDC	H: 28.5 in. (724 mm) W: 19.5 in. (495 mm) D: 31.75 in. (806 mm)	225 lb. (102 kg)
	CC/DC: TIG	10-350 A	350 A at 24 VDC	29.3	18.2	13.5	11.8	14.5	13.4	10.7	10.6	10			
PipeWorx 400 Power Source only (907382) 230/460 V (907384) 575 V	CV: MIG/flux-cored	10-44 V	400 A at 34 VDC	42.9	24	20.5	17.3	19.2	20.5	16	15.8	16.2			
Model/Stock Number	Input Power	Input Welding Circuit Rating	Wire Feed Speed	Wire Diameter Capacity			Maximum Spool Size Capacity			Dimensions			Net Weight		
PipeWorx Dual-wire Feeder only (300366)	24 VAC, 11 A	100 V, 750 A at 100% duty cycle	50-780 ipm (1.3-19.8 m/min.)	.035-.062 in. (0.9-1.6 mm)			60 lb. (27 kg)			H: 14 in. (356 mm) W: 19 in. (483 mm) D: 29 in. (737 mm)			90 lb. (41 kg)		