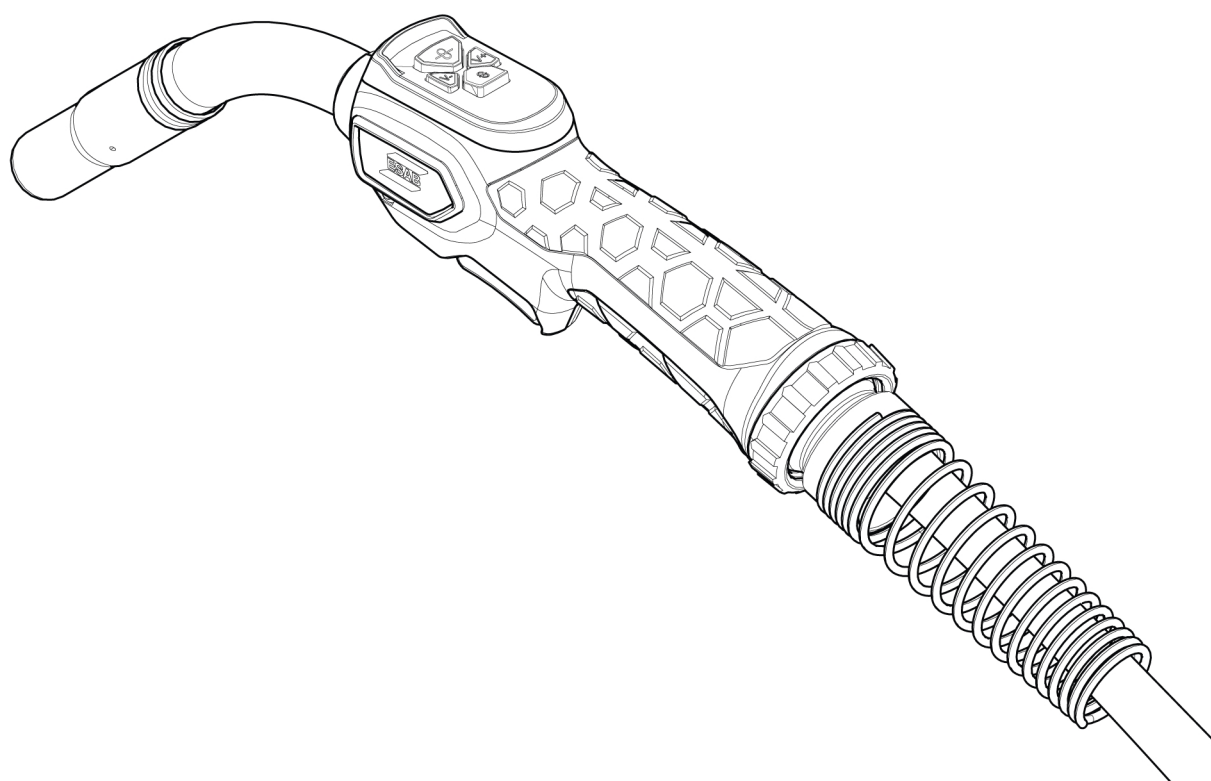


# ***Exeor MIG 315 R4***



## **Instruction manual**



## EU DECLARATION OF CONFORMITY

**According to:**

The Low Voltage Directive 2014/35/EU  
The RoHS Directive 2011/65/EU

**Type of equipment**

MIG/MAG welding torch

**Type designation**

Gas cooled variants: Exeor MIG 315 R4 Torch 3 m,  
Exeor MIG 315 R4 Torch 4 m  
Exeor MIG 315 R4 Torch 5 m

**Brand name or trademark**

ESAB

**Manufacturer or his authorized representative established within the EEA**

ESAB AB  
Lindholmsallén 9, Box 8004, SE-402 77 Göteborg, Sweden  
Phone: +46 31 50 90 00, [www.esab.com](http://www.esab.com)

The following EN standards and regulations in force within the EEA has been used in the design:

|                     |                                         |
|---------------------|-----------------------------------------|
| EN IEC 60974-7:2019 | Arc welding equipment - Part 7: Torches |
|---------------------|-----------------------------------------|

**Additional Information:**

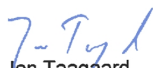
Restrictive use, Class A equipment, intended for use in locations other than residential.

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorized representative established within the EEA, that the equipment in question complies with the safety and environmental requirements stated above.

Place/Date

Signature

Göteborg  
2023-06-01

  
Jan Taagaard  
Global Product Manager





## UK DECLARATION OF CONFORMITY

### According to:

- Electric Equipment (Safety) Reg. 2016
- Electromagnetic Compatibility Reg. 2016
- The Restriction of Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012

### Type of equipment

MIG/MAG welding torch

### Type designation

Gas cooled variants: Exeor MIG 315 R4 Torch 3 m,  
Exeor MIG 315 R4 Torch 4 m  
Exeor MIG 315 R4 Torch 5 m

### Brand name or trademark

ESAB

### Manufacturer or his authorised representative established within United Kingdom

ESAB Group (UK) Ltd,  
322 High Holborn, London, WC1V 7PB, United Kingdom  
[www.esab.co.uk](http://www.esab.co.uk)

The following British Standards and Instruments in force within the United Kingdom has been used in the design:

|                          |                                         |
|--------------------------|-----------------------------------------|
| - BS EN IEC 60974-7:2019 | Arc welding equipment - Part 7: Torches |
|--------------------------|-----------------------------------------|

### Additional Information:

Restrictive use, Class A equipment, intended for use in locations other than residential.

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the UK, that the equipment in question complies with the safety and environmental requirements stated above.

### Signatures

David Todd  
Commercial Director,  
ESAB Group UK & Ireland  
London, 2023-06-05

UK  
CA

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# 1 SAFETY

## 1.1 Meaning of symbols

As used throughout this manual: Means Attention! Be Alert!



### **DANGER!**

Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.



### **WARNING!**

Means potential hazards which could result in personal injury or loss of life.



### **CAUTION!**

Means hazards which could result in minor personal injury.



### **WARNING!**

Before use, read and understand the instruction manual and follow all labels, employer's safety practices and Safety Data Sheets (SDSs).



## 1.2 Safety precautions

Users of ESAB equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
  - no unauthorised person is stationed within the working area of the equipment when it is started up
  - no-one is unprotected when the arc is struck or work is started with the equipment
3. The workplace must:
  - be suitable for the purpose
  - be free from drafts
4. Personal safety equipment:
  - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves
  - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns
5. General precautions:
  - Make sure the return cable is connected securely
  - Work on high voltage equipment **may only be carried out by a qualified electrician**
  - Appropriate fire extinguishing equipment must be clearly marked and close at hand
  - Lubrication and maintenance must **not** be carried out on the equipment during operation

**WARNING!**

Arc welding and cutting can be injurious to yourself and others. Take precautions when welding and cutting.

**ELECTRIC SHOCK - Can kill**

- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing
- Insulate yourself from work and ground.
- Ensure your working position is safe

**ELECTRIC AND MAGNETIC FIELDS - Can be dangerous to health**

- Welders having pacemakers should consult their physician before welding. EMF may interfere with some pacemakers.
- Exposure to EMF may have other health effects which are unknown.
- Welders should use the following procedures to minimize exposure to EMF:
  - Route the electrode and work cables together on the same side of your body. Secure them with tape when possible. Do not place your body between the torch and work cables. Never coil the torch or work cable around your body. Keep welding power source and cables as far away from your body as possible.
  - Connect the work cable to the workpiece as close as possible to the area being welded.

**FUMES AND GASES - Can be dangerous to health**

- Keep your head out of the fumes
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area

**ARC RAYS - Can injure eyes and burn skin**

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing
- Protect bystanders with suitable screens or curtains

**NOISE - Excessive noise can damage hearing**

Protect your ears. Use earmuffs or other hearing protection.

**MOVING PARTS - Can cause injuries**

- Keep all doors, panels and covers closed and securely in place. Have only qualified people remove covers for maintenance and troubleshooting as necessary. Reinstall panels or covers and close doors when service is finished and before starting engine.



- Stop engine before installing or connecting unit.
- Keep hands, hair, loose clothing and tools away from moving parts.

**FIRE HAZARD**

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby
- Do not use on closed containers.

**MALFUNCTION - Call for expert assistance in the event of malfunction.**

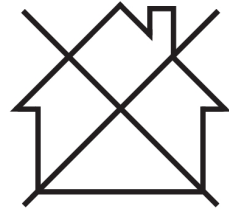
**PROTECT YOURSELF AND OTHERS!**

**CAUTION!**

This product is solely intended for arc welding.

**CAUTION!**

Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility of class A equipment in those locations, due to conducted as well as radiated disturbances.

**NOTE!****Dispose of electronic equipment at the recycling facility!**

In observance of European Directive 2012/19/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

As the person responsible for the equipment, it is your responsibility to obtain information on approved collection stations.

For further information contact the nearest ESAB dealer.



**ESAB has an assortment of welding accessories and personal protection equipment for purchase. For ordering information contact your local ESAB dealer or visit us on our website.**

## 2 INTRODUCTION

---

The **Exeor 315 R4** welding torches intended for shielded- arc welding, using inert gas (MIG) or active gas (MAG) for industrial and commercial use by suitably trained employees. The torches are intended to use only with Rustler power sources and are only available in manual versions.

### 2.1 Shipment and packaging

The components are carefully checked and packaged, however damage may occur during shipping.

#### **Checking procedure on receipt of goods**

Check that the shipment is correct by referring to the shipping note.

#### **In case of damage**

Check the package and components for damage (visual inspection).

#### **In case of complaints**

If the package and/or components have been damaged during shipment

- Contact with the last carrier immediately.
- Keep the packaging (for possible inspection by the carrier or supplier, or for returning the goods).

#### **Storage in an enclosed space**

Ambient temperature for shipment and storage: -20 to +55 °C

Relative air humidity: up to 90% at a temperature of 20 °C

## 3 TECHNICAL DATA

| Welding torch                            | Exeor MIG 315 R4 |
|------------------------------------------|------------------|
| Type of cooling                          | Air              |
| <b>Permitted load</b> at 60% duty cycle* |                  |
| Carbon dioxide CO <sub>2</sub>           | 315 A            |
| Mixed gas, Ar/CO <sub>2</sub> M21        | 285 A            |
| <b>Recommended gas flow</b>              | 8-15 l/min       |
| <b>Wire diameter</b>                     | 0.8-1.2 mm       |
| <b>Operating teperature*</b>             | -10 °C to 40 °C  |

\* The capacity may be reduced up to 30 when pulse welding.

### Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld or cut at a certain load without overloading. The duty cycle is valid for 40 °C / 104 °F, or below.

| General torch data with reference to IEC/EN 60 974-7 |                                                                                     |
|------------------------------------------------------|-------------------------------------------------------------------------------------|
| Type of guidance:                                    | Manual                                                                              |
| Wire type:                                           | Standard round wire                                                                 |
| Voltage rating:                                      | The control circuit and trigger switch are rated for a voltage of 42 V, maximum 1 A |

## 4 OPERATION

General safety regulations for handling the equipment can be found in the "SAFETY" chapter of this manual. Read it through before you start using the equipment!



### CAUTION!

This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.



### DANGER!

In the event of an emergency, the power source must be switched off immediately. For further action in such circumstances, refer to the instruction manual of the power source for more information.

The welding torch can be used in any welding position.

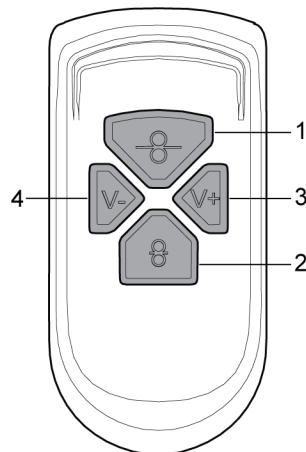
Contact with hot items might cause damage to the torch and the cable assembly.

Do not drag the power source using the torch.

Do not pull the cable assembly over sharp edges.

Do not bend the cable assembly sharply.

### 4.1 Connections and control devices



- |                                           |                                   |
|-------------------------------------------|-----------------------------------|
| 1. The button to increase wire feed speed | 3. The button to increase voltage |
| 2. The button to decrease wire feed speed | 4. The button to decrease voltage |

### 4.2 Fitting the liner

Fit the correct wire guide liner for the application, as needed to suit the wire type and diameter. See Section 5.3 "Steel liner / Plastic liner", page 12.



### NOTE!

For information on how to install new liners and about correct assembly procedure, see Section 5 "MAINTENANCE", page 12.

Steel liner = for steel wires

Plastic liner = for aluminium, copper, nickel and stainless steel wires

## 4.3 Equipping the torch

The torch must be equipped according to the wire diameter and wire material. Choose the right liner, contact tip, tip adaptor, gas nozzle and gas diffuser (as applicable). A detailed overview of the suitable parts is found in the spare parts list for the torch.

Tighten the tip adaptor and the contact tip with an adequate tool.

Make sure, that all required parts shown in the spare parts list, e.g. insulators, are installed. Welding without these items might cause immediate destruction of the torch.

## 4.4 Fitting the central adaptor to the equipment

- 1) Check that the wire guide liner is fitted correctly.
- 2) Insert the central plug into the socket on the wire feed unit and secure it by tightening the adaptor nut firmly by hand.

## 4.5 Setting the level of shielding gas

Set the quantity of gas required on the gas regulator. The type and quantity of gas to be used depend on the welding task to be performed.

## 4.6 Checklist

Check the cable assembly before connecting it to the wire feed unit to confirm the wire liner is suitable for the wire diameter and type.

Check the front end consumable parts on the swan neck, whether the correct contact tip etc. is being used for the wire diameter and type.

## 4.7 Changing wire

When changing the wire, ensure that the end of the wire is deburred.

Insert the wire into the wire feeding unit in accordance with the operating instructions.

When inserting the wire, press the wire jog button on the wire feed unit.

## 4.8 Starting and stopping the welding process

The wire feeder and the welding process will be started by depressing the torch trigger. Depending on the configuration of the welding machine, the welding process will be stopped by releasing the trigger or by depressing the trigger a second time. Refer to the instruction manual for the power source for more information.



### **DANGER!**

The torch head might reach very high temperatures during operation, there is a risk of severe burns. Let it cool down under observation, there is risk of fire. Do not place the hot torch on or near heat-sensitive objects.

When leaving the workplace the system must be secured against unintended operation, preferably by switching off the power source.

## 5 MAINTENANCE

**NOTE!**

Regular maintenance is important for safe and reliable operation.

Cleaning and replacement of the welding torch's wear parts should take place at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean with low pressure compressed air regularly and clean the contact tip.

**WARNING!**

Before carrying out cleaning, servicing and repair work, the following shutdown procedure must be followed.

1. Switch off the power supply.
2. Close off the gas supply.

Make sure that the power supply and gas remain turned off all the time while servicing the equipment.

### 5.1 Cable assembly

Check the torch and cable assembly for damages prior to use. Damages must be repaired by qualified personnel before further use of the product.

### 5.2 Cleaning the wire feed

Disconnect the torch cable assembly from the equipment and lay it out straight.

Unscrew the retention nut and pull out the wire guide liner. Remove other parts from the swan neck.

Blow low pressure compressed air through the wire conduit from both ends in order to remove wire shavings.

Insert the liner into the wire conduit and secure the wire guide liner with the retention nut.

**NOTE!**

New liners must be cut to the correct length.

### 5.3 Steel liner / Plastic liner

If a wire feeding problem cannot be solved by exchanging the contact tip and cleaning the wire guide channel, the liner should be replaced.

Liner and welding wire should be inserted while the cable assembly is laid out straight.

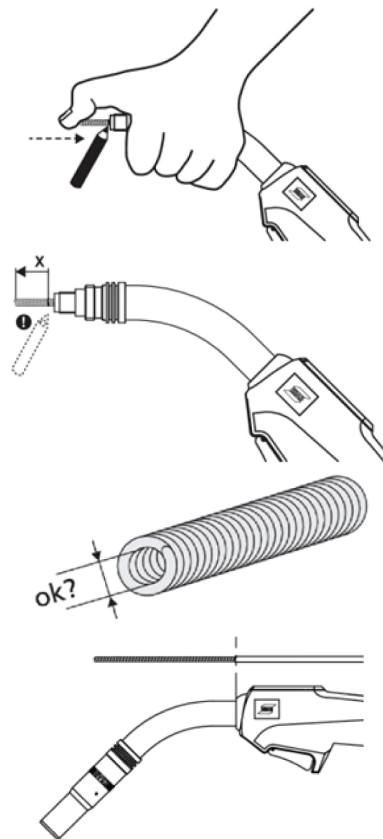
**Installing a steel liner**

1. Remove the sleeve nut from the central connector, remove the gas nozzle, contact tip and tip holder from the torch.
2. Insert the liner through the central connector and lock it with the sleeve nut.
3. Gently push back the front part of the liner into the torch as far as it will go, do not apply force. Mark the end of the torch neck on the liner.
4. Cut the liner to the correct length using a projectile "X" measured from the marking as shown in the figure.

Remove the liner from the torch and carefully smoothen its front end. If needed, grind down burred edges. Make sure the inner hole is completely open.

For insulated liners, remove the insulation at the front end so that the remaining insulation ends approximately at the front end of the torch handle.

Reinstall the liner and lock it with the sleeve nut. Install all equipment parts on the torch neck.

**Cutting length**

| Welding torch    | Projectile "X" |
|------------------|----------------|
| Exeor MIG 315 R4 | 16 mm          |

**Installing a plastic liner**

1. Remove the sleeve nut from the central connector, remove the gas nozzle, contact tip and tip holder from the torch.
2. Insert the liner through the central connector and lock it with the sleeve nut.
3. Gently push back the front part of the liner into the torch as far as it will go, do not apply force. Mark the end of the torch neck on the liner.
4. Cut the liner to the correct length using a projectile "X" measured from the marking as shown in the figure.

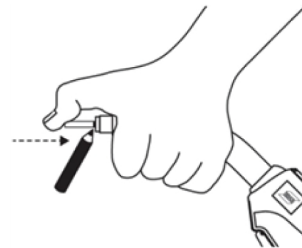
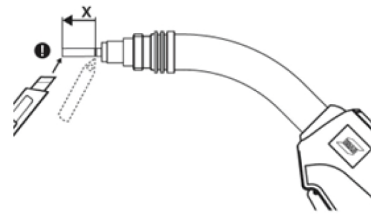
Slightly chamfer the liner front end after the liner has been cut to the correct length

**NOTE!**

If the liner has a bronze front end, first cut the plastic liner to a suitable length and let the bronze liner stick out approximately 40-50 mm from the torch neck. Attach the bronze liner to the front of the plastic liner and only then cut this liner assembly to the precise length.

If it is difficult to insert the liner into the torch, make a clean cut at the front end of the liner and chamfer the edges (e.g. with a pencil sharpener).

Install all equipment parts on the torch neck.

**Cutting length**

| Welding torch    | Projectile "X" |
|------------------|----------------|
| Exeor MIG 315 R4 | 13 mm          |

**5.4 Cleaning the swan neck**

- Clean the inside of the gas nozzle regularly to remove welding spatter and spray with ESAB® anti-spatter agent.
- Check the consumables for visible damage and replace if necessary.

## 6 TROUBLESHOOTING

If the measures described below are not successful, consult your dealer or the manufacturer.

Read the operating instructions for the welding components, e.g. power source and wire feed unit.

| Type of fault                  | Possible cause                                                                                                                                                                                                                                                                                                                 | Corrective action                                                                                                                                                                                                                                                                                                                                                           |
|--------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Torch becomes too hot          | <ul style="list-style-type: none"> <li>• Contact tip / tip holder not tight enough</li> <li>• Torch overstrained</li> <li>• Cable assembly defective</li> </ul>                                                                                                                                                                | <ul style="list-style-type: none"> <li>• Check and tighten hand-tight</li> <li>• Observe technical data, if needed, choose a different type</li> <li>• Check cables, tubes and connections</li> </ul>                                                                                                                                                                       |
| Wire feeding problems          | <ul style="list-style-type: none"> <li>• Contact tip is worn</li> <li>• Liner is worn/dirty</li> <li>• Consumables used are not suitable for the wire diameter or material</li> <li>• Wire feeder not set-up properly</li> <li>• Cable assembly is bent or laid in a small diameter</li> <li>• Wire is contaminated</li> </ul> | <ul style="list-style-type: none"> <li>• Exchange contact tip</li> <li>• Check the liner, blow through in both directions. Exchange if needed</li> <li>• Check with spare part list</li> <li>• Check the wire feeding rolls, the contact pressure and the spool brake</li> <li>• Check the cable assembly and lay it out straight</li> <li>• Use a cleaning felt</li> </ul> |
| Porous welds                   | <ul style="list-style-type: none"> <li>• Gas swirl caused by spatter adherence</li> <li>• Too small or extremely high gas flow in the torch</li> <li>• Gas supply defective</li> <li>• Air draft at the workplace</li> <li>• Moisture or contamination on the wire or on the workpiece</li> </ul>                              | <ul style="list-style-type: none"> <li>• Clean the torch head, use gas diffuser/spatter protection</li> <li>• Check flow rate with measurement tool</li> <li>• Check for possible leakage</li> <li>• Install shielding</li> <li>• Check the wire and the work piece, use less or different anti-spatter liquid</li> </ul>                                                   |
| Variable arc                   | <ul style="list-style-type: none"> <li>• Contact tip is worn</li> <li>• Wrong welding parameters</li> </ul>                                                                                                                                                                                                                    | <ul style="list-style-type: none"> <li>• Exchange contact tip</li> <li>• Correct the welding parameters</li> </ul>                                                                                                                                                                                                                                                          |
| Welding process does not start | <ul style="list-style-type: none"> <li>• Control cable is broken or the trigger is defective</li> </ul>                                                                                                                                                                                                                        | <ul style="list-style-type: none"> <li>• Check and repair the trigger connections, clean the trigger switch or exchange it</li> </ul>                                                                                                                                                                                                                                       |

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## 7 ORDERING SPARE PARTS

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**CAUTION!**

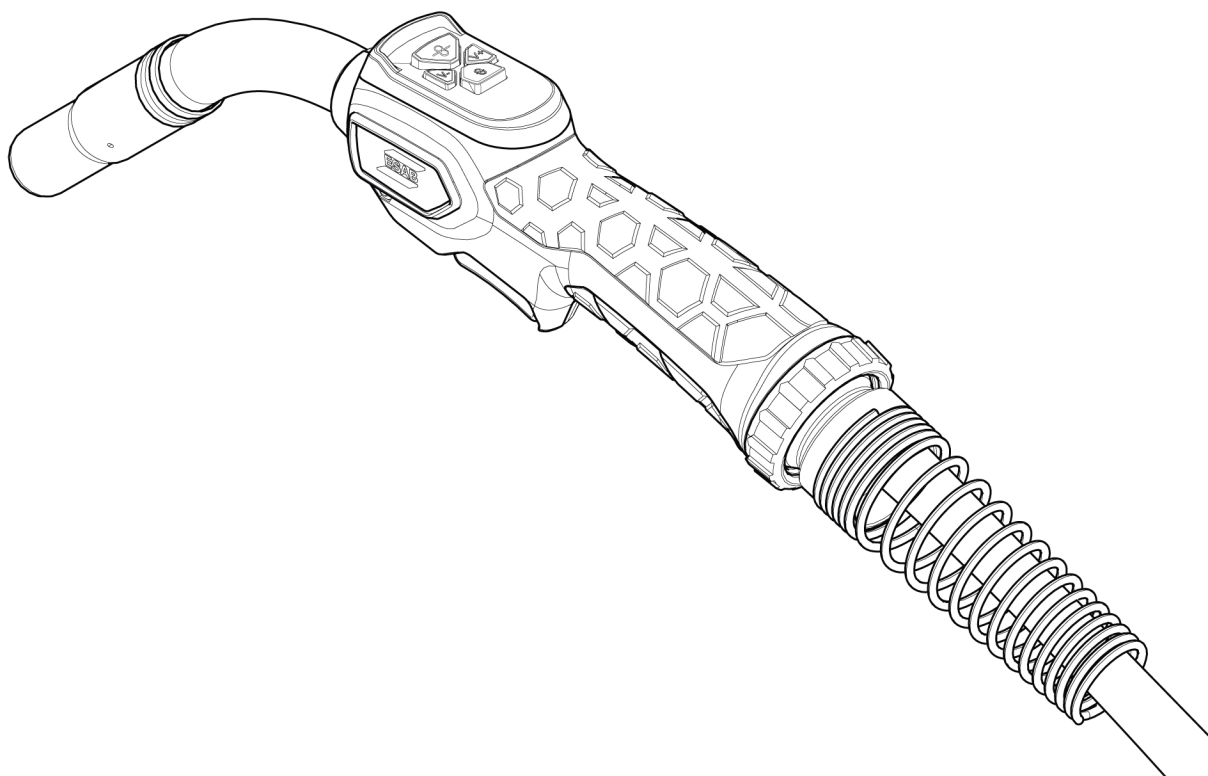
Repair and electrical work should be performed by an authorised ESAB service technician.  
Use only ESAB original spare and wear parts.

The Exeor MIG 315 R4 is designed and tested in accordance with the international and European standards **IEC/EN 60974-7**. On completion of service or repair work, it is the responsibility of the person(s) performing the work to ensure that the product still complies with the requirements of the above standards.

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see [esab.com](https://www.esab.com). When ordering, please state product type, serial number, designation and spare part number in accordance with the spare parts list. This facilitates dispatch and ensures correct delivery.

## APPENDIX

### ORDERING NUMBERS

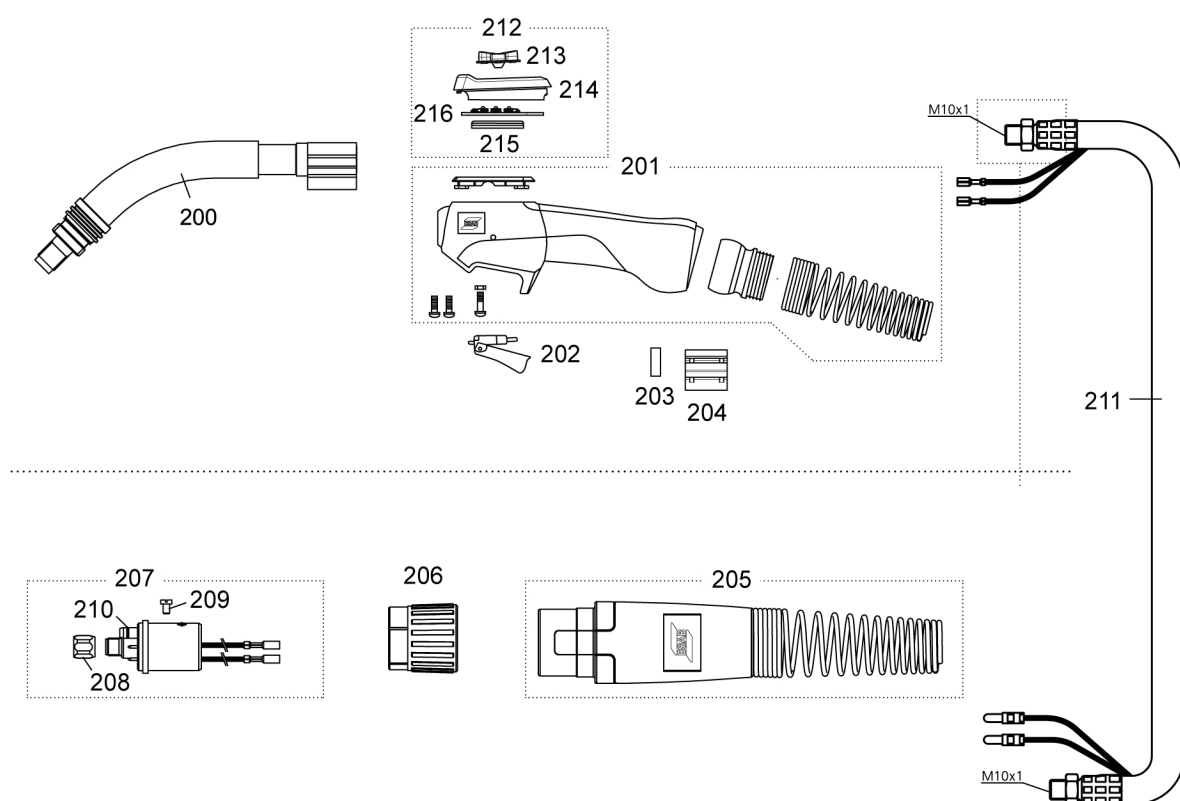


| Ordering number | Denomination     | Type               | Notes                  |
|-----------------|------------------|--------------------|------------------------|
| 0700 026 150    | Exeor MIG 315 R4 | Welding torch, 3 m | Euro-Central connector |
| 0700 026 151    | Exeor MIG 315 R4 | Welding torch, 4 m | Euro-Central connector |
| 0700 026 152    | Exeor MIG 315 R4 | Welding torch, 5 m | Euro-Central connector |

Technical documentation is available on the Internet at: [www.esab.com](http://www.esab.com)

## SPARE PARTS LIST

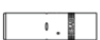
| Item | Ordering number | Denomination           | Notes               |
|------|-----------------|------------------------|---------------------|
| 200  | 0700 025 001    | Torch neck             |                     |
| 201  | 0700 026 102    | Handle complete        |                     |
| 202  | B01P 600 237    | Trigger                | Yellow, 2-poles     |
| 203  | 130P 002 009    | Insulating sleeve      |                     |
| 204  | 600P 002 018    | PVC body               |                     |
| 205  | 0700 025 907    | Cable support complete | Large, G            |
| 206  | 0700 025 951    | Adaptor nut            |                     |
| 207  | 0700 200 101    | Central connector      | G, includes 208-210 |
| 208  | 0700 200 098    | Liner locking nut      |                     |
| 209  | 0700 025 952    | Cylinder head screw    | M4×6                |
| 210  | 0700 025 953    | O-ring                 | 4.0×1.0 mm          |
| 211  | 0700 025 964    | Coaxial cable          | 3 m                 |
|      | 0700 025 965    | Coaxial cable          | 4 m                 |
|      | 0700 025 966    | Coaxial cable          | 5 m                 |
| 212  | 0700 026 118    | Remote modul it        | Includes 213-216    |
| 213  |                 | Push button            |                     |
| 214  |                 | Module housing         |                     |
| 215  |                 | Bottom cover           |                     |
| 216  |                 | Torch PCBA             |                     |

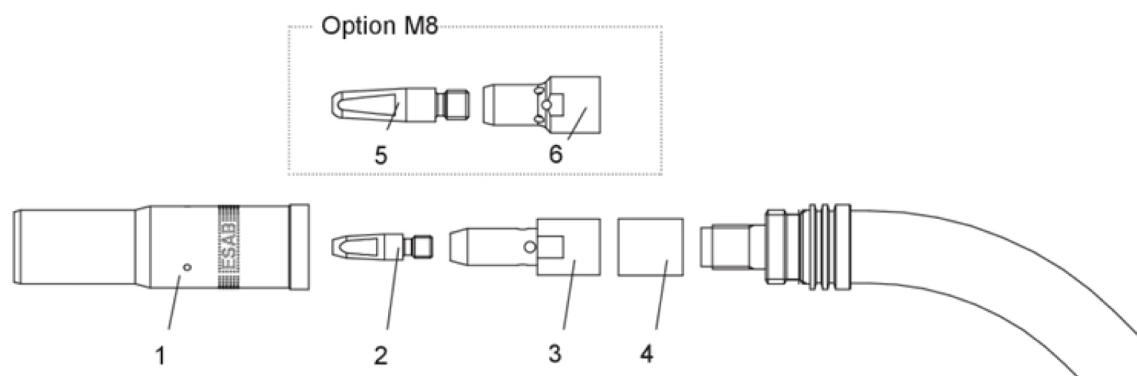


## WEAR PARTS

### Exeor MIG 315 R4

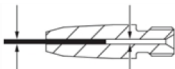
Bold = standard delivery. For contact tip, see contact tips table.

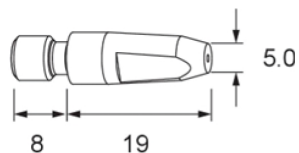
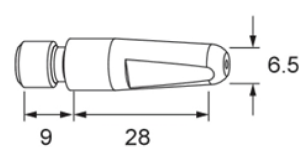
| Ordering number     | Denomination       | Notes           | Ø            | Length         |                                                                                     |
|---------------------|--------------------|-----------------|--------------|----------------|-------------------------------------------------------------------------------------|
| <b>0458 464 882</b> | <b>Gas nozzle</b>  | <b>Standard</b> | <b>16 mm</b> | <b>80 mm</b>   |  |
| 0458 465 882        | Gas nozzle         | Conical         | 14 mm        | 80 mm          |  |
| 0458 470 882        | Gas nozzle         | Straight        | 19 mm        | 80 mm          |  |
| <b>0366 394 001</b> | <b>Tip adaptor</b> | <b>M6</b>       |              | <b>40.6 mm</b> |  |
| 0460 819 001        | Tip adaptor        |                 |              | 31.6 mm        |  |
| 0700 025 851        | Tip adaptor        |                 |              | 31.6 mm        |                                                                                     |
| 0366 397 002        | Insulation bushing |                 |              |                |  |



- |                       |                       |
|-----------------------|-----------------------|
| 1. Gas nozzle         | 4. Insulation bushing |
| 2. Contact tip, M6×27 | 5. Contact tip, M8×37 |
| 3. Tip adaptor, M6    | 6. Tip adaptor, M8    |

### Contact tips

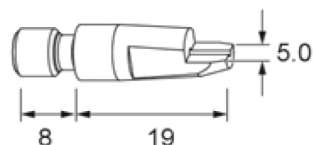
| Rustler torch | Gas/wire Ø      |        |  |
|---------------|-----------------|--------|---------------------------------------------------------------------------------------|
|               | Co <sub>2</sub> | Mix/Ar |                                                                                       |
| <b>M6</b>     |                 |        | <b>M6</b>                                                                             |
| 0468 500 001  | 0.6             | -      | W0.6 / 0.8                                                                            |
| 0468 500 002  | -               | 0.6    | W0.8 / 0.9                                                                            |
| 0468 500 003  | 0.8             | -      | W0.8 / 1.0                                                                            |
| 0468 500 004  | 0.9             | 0.8    | W0.9 / 1.1                                                                            |
| 0468 500 005  | 1.0             | 0.9    | W1.0 / 1.2                                                                            |
| 0468 500 006  | 1.2             | -      | W1.2 / 1.4                                                                            |
| 0468 500 007  | 1.2             | 1.0    | W1.2/1.5                                                                              |
| 0468 500 008  | 1.4             | 1.2    | W1.4/1.7                                                                              |

**M6×27****M8×37**

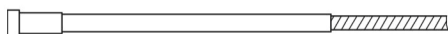
| Rustler torch | Gas/wire Ø      |        |          |
|---------------|-----------------|--------|----------|
| M6            | Co <sub>2</sub> | Mix/Ar | M6       |
| 0468 500 003  | 0.8             | -      | W0.8/1.0 |
| 0468 500 004  | 0.9             | 0.8    | W0.9/1.1 |
| 0468 500 005  | 1.0             | 0.9    | W1.0/1.2 |
| 0468 500 006  | 1.2             | -      | W1.2/1.4 |
| 0468 500 007  | 1.2             | 1.0    | W1.2/1.5 |
| 0468 500 008  | 1.4             | 1.2    | W1.4/1.7 |

**Contact tips M6**

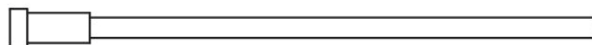
| Rustler torch | Gas/wire Ø      |        |            |
|---------------|-----------------|--------|------------|
| M6            | Co <sub>2</sub> | Mix/Ar | M6         |
| 0468 500 002  | -               | 0.6    | W0.8 / 0.9 |
| 0468 500 003  | 0.8             | -      | W0.8 / 1.0 |
| 0468 500 004  | 0.9             | 0.8    | W0.9 / 1.1 |
| 0468 500 005  | 1.0             | 0.9    | W1.0 / 1.2 |

**Nib M6****Steel liner**

Bold = standard delivery



| Ordering numbers | Ø         | Length | Notes |
|------------------|-----------|--------|-------|
| 0700 200 085     | 0.8 - 1.0 | 3.0 m  | Blue  |
| 0700 200 086     | 0.8 - 1.0 | 4.0 m  | Blue  |
| 0700 025 800     | 0.8 - 1.0 | 5.0 m  | Blue  |
| 0700 200 087     | 1.0 - 1.2 | 3.0 m  | Red   |
| 0700 200 088     | 1.0 - 1.2 | 4.0 m  | Red   |
| 0700 025 801     | 1.0 - 1.2 | 5.0 m  | Red   |

**PTFE liner**

| Ordering numbers | Ø         | Length | Notes |
|------------------|-----------|--------|-------|
| 0700 200 089     | 0.8 - 1.0 | 3.0 m  | Blue  |
| 0700 200 090     | 0.8 - 1.0 | 4.0 m  | Blue  |
| 0700 025 811     | 0.8 - 1.0 | 5.0 m  | Blue  |
| 0700 200 091     | 1.0 - 1.2 | 3.0 m  | Red   |
| 0700 200 092     | 1.0 - 1.2 | 4.0 m  | Red   |
| 0700 025 812     | 1.0 - 1.2 | 5.0 m  | Red   |

**PA liner with bronze front end**

| Ordering numbers | Ø         | Length | Notes      |
|------------------|-----------|--------|------------|
| 0700 025 816     | 0.8 - 1.0 | 3.0 m  | Anthracite |
| 0700 025 817     | 0.8 - 1.0 | 4.0 m  | Anthracite |
| 0700 025 818     | 0.8 - 1.0 | 5.0 m  | Anthracite |



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