

# STANDARD WELDING AND PLASMA CUTTING EQUIPMENT

8TH EDITION









# WELDING AND CUTTING TECHNOLOGY



For over 100 years now ESAB has been one of the leading and most innovative companies in welding and cutting technology. We are continuously working on the optimization and development of welding and cutting processes so that customers and partners can profit from technical progress.

We do of course pay great attention to the quality of our products, which are manufactured and sold worldwide. The experience of our staff, our service and our technical support are available to our partners. A wide network of branches, area representatives and trading partners allow us to be close to our customers - worldwide.

Ever since the foundation of the company back in 1904, satisfying the needs and demands of our customers has always been our main focus. The company was founded by Oscar Kjellberg, a Swedish engineer and the inventor of the coated welding electrode. His invention, which revolutionised the manufacture of boilers and ships, is still a core product in the ESAB range.

Today, in parallel with the development of modern filler metals ESAB has developed welding units that are perfectly matched for just about any process.



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## KEY TO PACKAGE CONTENT


The coloured circles shown in the ordering information indicates the package content.


### Complete Package

Origo™ Tig 3000i AC/DC TA24 + MMA welding cables   
+ CoolMidi 1800 + torch TXH™ 251w + 4-wheels trolley **0459 795 882**

### Ordering Information

Origo Tig 3000i, TA24

Origo™ Tig 3000i, TA24 AC/DC  **0459 735 880**

CoolMidi 1800 cooling unit  **0459 840 880**

Two-wheels trolley **0459 366 890**

Four-wheels trolley  **0460 060 880**

## READY TO USE (RTU) PACKAGES

Within Europe ESAB can also offer RTU packages. RTU is a complete equipment package consisting of standard components built to order or stocked in ESAB's factory. All parts will be pre-fitted, packed and delivered together. Saving time for the customer. For details on how to order RTUs please contact your local ESAB representative.





Manual metal arc welding is often called manual electric welding, stick, GMAW or MMA welding. It is the oldest and most versatile form of arc welding. The electric arc is set up between a coated welding electrode and the work piece. The metallic core of the coated welding electrode melts in the arc and becomes the molten weld pool drop by drop.

A portion of the coating stabilizes the arc and provides the required gas protection. The rest of the coating forms a slag that protects the weld pool and the cooling seam from the atmosphere. This slag must be removed after each welding pass.

There are hundreds of different types of electrodes. The strength and toughness of the weld seam can be determined very precisely by their alloying elements.

MMA welding is mostly used on steel based materials. Despite its comparatively low deposition rates the process has unbeatable advantages when welding outdoors and in hard to reach places



## ArcPlus™ II

NO MORE SPATTER WITH ARCPLUS™

ArcPlus™ allows welding without spatter even with difficult electrodes. The restriking of the arc has been greatly improved, especially with basic electrodes.

Through ArcPlus™ II the welding current that is required for a stable process is also less than that required by conventional units.



## LiveTig™

TIG welding with manual metal arc or MAG units often fails due to the arc striking method.

LiveTig™ provides a reliable striking procedure for the TIG welding process, which is gentle on the electrodes.

# RENEGADE ES 300i

## POWERFUL AND PORTABLE

Renegade ES 300i is an inverter based MMA/Stick and LiveTIG machine with extreme power to weight ratio. The compact format makes it easy to carry and bring to any jobsite. Combined with high duty cycle and the ability to run the machine on long mains and welding cable makes this a superior welding machine for both on-and off site applications.

The machine has an automatic input voltage sensor and can operate with any input voltage between 230V and 480V 3-phase.

For professional MMA welding with electrodes up to 6 mm with a high duty cycle of 300 A at 40%. Ideal for operation in high ambient temperatures.

- Extreme power to weight ratio
- Automatically adjusts to optimal start and stop
- Designed for extreme conditions including up to +55°C ambient temperature
- Voltage booster provide additional arc voltage for superior cellulosic weld performance
- Professional welding applications
- 3 memory settings
- Rugged composite casing for durability
- IP 23 designed casework suitable for outdoor site work
- For installation and production
- For repair and maintenance



## MOBILE SOLUTIONS FOR PROFESSIONAL WELDING

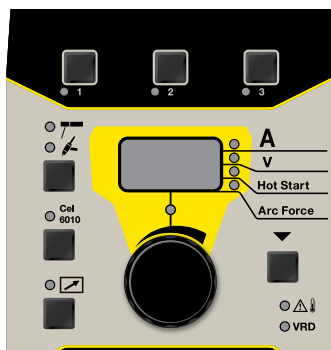


| Technical data*               | Renegade ES 300i          |
|-------------------------------|---------------------------|
| Mains Supply, 3 ph 50/60HZ, V | 230-480, +/-10%           |
| Fuse, slow A                  | 10 (20 at 230V)           |
| Rated kVA                     | 11,3                      |
| Setting range MMA, A          | 5-300                     |
| Setting range TIG, A          | 5-300                     |
| Open circuit voltage, V       | 48                        |
| Open circuit voltage VRD, V   | 32                        |
| Idle Power, W                 | 120                       |
| Efficiency at max. current %  | 89                        |
| Power factor at max current   | 0.96                      |
| Enclosure class               | IP23                      |
| Dimensions, LxWxH, mm         | 460x200x320               |
| Weight, kg                    | 15,5                      |
| Mains cable, Ø mm2            | 3m 4x2,5 (4x4 with 230 V) |
| Supply plug                   | CEE 16 A                  |
| Operating Temperature, °C     | -10 - +40                 |
| Application class             | S                         |
| Approvals                     | CE                        |

| Maximum output at 40°C    | MMA    | TIG    |
|---------------------------|--------|--------|
| 60% duty cycle, A/V, 3ph  | 300/32 | 300/22 |
| 100% duty cycle, A/V, 3ph | 200/28 | 200/18 |

\*Technical data is subject to change.





## CONTROL PANEL A35

- Selection of electrode type, basic - rutile or cellulosic
- MMA welding and TIG welding with LiveTig™ striking
- Hot Start and Arc Force can be set
- 3 memory slots
- Digital V/A-meter to display set or measured values

## Ordering information

|   |              |
|---|--------------|
| Renegade ES 300i incl 3 m mains cable and plug  | 0445 100 880 |
| Renegade ES 300i, incl. 3 m mains cable, shoulder strap, 5 m weld and return cable and electrode holder Handy 300 | 0445 250 880 |

## Accessories

|  |              |
|--|--------------|
| Shoulder strap   | 0445 197 880 |
| Electrode holder kit, Handy 300, OKC 50, 3 m             | 0700 006 902 |
| Electrode holder kit, Handy 300, OKC 50, 5 m             | 0700 006 888 |
| Return cable kit, OKC 50, 3 m                            | 0700 006 903 |
| Return cable kit, OKC 50, 5 m                            | 0700 006 889 |
| OKC 50 male contact, pack of 4 pcs                       | 0160 360 881 |
| ER 1 Remote Control incl. 5 m cable and 6-pin connector  | 0445 536 881 |
| ER 1 Remote Control incl. 10 m cable and 6-pin connector | 0445 536 882 |
| ER 1 Remote Control incl. 25 m cable and 6-pin connector | 0445 536 883 |
| ER 1F Foot Control incl. 5 m cable and 6-pin connector   | 0445 550 881 |
| ER 1F Foot Control incl. 10 m cable and 6-pin connector  | 0445 550 882 |
| 5 m replacement cable with 6-pin conn. for ER 1          | 0445 280 880 |
| 10 m replacement cable with 6-pin conn. for ER 1         | 0445 280 881 |
| 25 m replacement cable with 6-pin conn. for ER 1         | 0445 280 882 |
| 5 m replacement cable with 6-pin conn. for ER 1F         | 0445 254 880 |
| 10 m replacement cable with 6-pin conn. for ER 1F        | 0445 254 881 |
| ER 1 incl. 5 m cable and 4-pin connector                 | 0445 536 880 |
| 5 m replacement cable with 4-pin conn. for ER 1          | 0445 450 880 |



## REMOTE CONTROLLER ER 1

With digital display for accurate reading of welding amperage and other settings.



TIG torches at page 102

# CADDY® ARC 151i AND 201i

## DEVELOPED FOR DURABILITY

The Caddy's are equipped with large OKC 50 welding current connections to withstand heavy loads. Due to the compact design and a polymer casing that is impervious to impacts, these devices are light and easy to transport. The large cooling unit and the carefully thought out design ensure a long working life and allow use even under rough working conditions.

The new inbuilt ArcPlus™ II function further improves the welding arc and ensures that there is less spatter and better restriking of the arc.

The Caddy® has been designed in such a way that all the main components in the machine are kept clean and free of dust. Caddy® complies with the requirements of insulation type IP 23 and is thus suitable for use outdoors. The long-lived construction and the excellent welding properties of the machines ensure reliable use on a day to day basis.

Power Factor Correction - PFC. Caddy® Arc is equipped with automated power factor correction (PFC), which minimizes disturbing feedback effects in the mains supply network. Furthermore, the devices are less sensitive to fluctuations in the mains power supply and thus allow operation from generators.

Caddy Arc has a large action radius through the ability to use mains intermediate cables of Ø 2.5 mm<sup>2</sup> and up to 100 m in lengths without power losses, also improved compatibility with generators through PFC - Power Factor Correction.



- Four different control panels to choose from
- IP 23 designed casework suitable for outdoor site work
- Robust housing that is impervious to impacts
- Thermal overload protection
- For installation and production
- For repair and maintenance



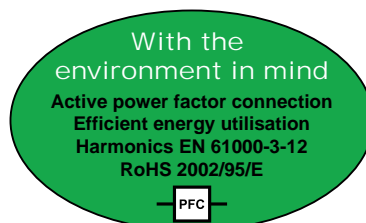
### CONTROL PANEL A31

- For Caddy® Arc 151i
- Single button operation
- TIG (scratch start)
- Hot Start (preset)
- Arc Force (preset)



### CONTROL PANEL A33

- For Caddy® Arc 151i and 201i
- TIG with LiveTig™ striking
- Hot Start (adjustable)
- Arc Force (adjustable)
- ArcPlus™ II controller
- Digital display
- Drop welding
- Remotely controllable
- Parameter storage (2x)





# CADDY® ARC 251i



## CONTROL PANEL A32

- For Caddy® Arc 251i
- TIG with LiveTig™ striking
- Hot Start (adjustable, background menu)
- Arc Force (adjustable, background menu)
- ArcPlus™ II controller
- Digital display
- Drop welding
- Remote controllable



## CONTROL PANEL A34

- For Caddy® Arc 251i
- Selection of electrode type Basic - rutile - cellulose
- TIG with LiveTig™ striking
- Hot Start (adjustable)
- Arc Force (adjustable)
- ArcPlus™ II controller
- Digital display
- Drop welding
- Remote controllable
- Parameter storage (2x)



Trolleys page 74

| Technical data                 | Caddy® Arc 151i | Caddy® Arc 201i | Caddy® Arc 251i |
|--------------------------------|-----------------|-----------------|-----------------|
| Mains supply, V / ph           | 230 / 1         | 230 / 1         | 400 / 3         |
| Fuse, slow, A                  | 16              | 16              | 10              |
| Setting range MMA (A31), A     | 8 - 150         | -               | -               |
| Setting range MMA (A33), A     | 4 - 150         | 4 - 170         | -               |
| Setting range MMA (A32/A34), A | -               | -               | 4 - 250         |
| Setting range TIG (A33), A     | 4 - 150         | 4 - 220         | -               |
| Setting range TIG, A           | -               | -               | 3 - 250         |
| Open circuit voltage (A31), V  | 58 - 72         | -               | -               |
| Open circuit voltage (A33), V  | 55 - 60         | 55 - 60         | -               |
| Open circuit voltage, V        | -               | -               | 65              |
| Power factor                   | 0,99            | 0,99            | 0,94            |
| Efficiency, %                  | 80              | 81              | 83              |
| Dimensions, LxWxH, mm          | 418 x 188 x 208 |                 |                 |
| Weight, kg                     | 7,9             | 8,3             | 10,5            |
| Enclosure class                | IP 23           |                 |                 |
| Application class              | S               |                 |                 |

## Maximum output at 40°C, MMA

|                    |     |     |     |
|--------------------|-----|-----|-----|
| 25% duty cycle, A  | 150 | 170 | -   |
| 30% duty cycle, A  | -   | -   | 250 |
| 60% duty cycle, A  | 100 | 130 | 190 |
| 100% duty cycle, A | 90  | 110 | 150 |

## Maximum output at 40°C, TIG

|                    |     |     |     |
|--------------------|-----|-----|-----|
| 20% duty cycle, A  | -   | 220 | -   |
| 25% duty cycle, A  | 150 | -   | -   |
| 30% duty cycle, A  | -   | -   | 250 |
| 60% duty cycle, A  | 120 | 150 | 190 |
| 100% duty cycle, A | 110 | 140 | 150 |

## Ordering information

|                      |              |
|----------------------|--------------|
| Caddy® Arc 151i, A31 | 0460 445 881 |
| Caddy® Arc 151i, A33 | 0460 445 883 |
| Caddy® Arc 201i, A33 | 0460 445 884 |
| Caddy® Arc 251i, A32 | 0460 300 880 |
| Caddy® Arc 251i, A34 | 0460 300 881 |

## Accessories Caddy® Arc

|   |              |
|---|--------------|
| Shoulder strap                                  | 0460 265 003 |
| Two-wheels trolley (for 5-10 liters gas bottle) | 0459 366 885 |
| TIG torch TXH™ 151V, 4m                         | 0700 300 539 |
| TIG torch TXH™ 151V, 8m                         | 0700 300 545 |
| TIG torch TXH™ 201V, 4m                         | 0700 300 553 |
| TIG torch TXH™ 201V, 8m                         | 0700 300 556 |

## Caddy® Arc 151i /201i

|   |              |
|---|--------------|
| Welding cable 200A, 25 mm <sup>2</sup> , OKC 50, 3m | 0700 006 900 |
| Return cable 200A, 25 mm <sup>2</sup> , OKC 50, 3m  | 0700 006 901 |
| Welding cable 200A, 25 mm <sup>2</sup> , OKC 50, 5m | 0700 006 884 |
| Return cable 200A, 25 mm <sup>2</sup> , OKC 50, 5m  | 0700 006 885 |
| Confort 200   | 0700 006 004 |
| Handy 200   | 0700 006 003 |
| ESAB 200  | 0333 249 001 |
| Handy 300   | 0700 006 016 |

## Caddy® Arc 251i

|   |              |
|---|--------------|
| Welding cable 300A, 35 mm <sup>2</sup> , OKC 50, 3m | 0700 006 902 |
| Return cable 300A, 35 mm <sup>2</sup> , OKC 50, 3m  | 0700 006 903 |
| Welding cable 300A, 35 mm <sup>2</sup> , OKC 50, 5m | 0700 006 888 |
| Return cable 300A, 35 mm <sup>2</sup> , OKC 50, 5m  | 0700 006 889 |
| Handy 300   | 0700 006 016 |

## Delivery includes:

3 m MMA welding and return cable kit, 3 m mains cable with plug.

# BUDDY™ ARC 145 AND 180

## PORTABLE SOLUTIONS FOR PROFESSIONAL WELDING

The Buddy™ family is a series of robust and durable power source for the professional welders. The machines provides state-of-the-art welding performance and reliability through use of the latest high grade IGBT technology.

### Designed for durability

The internal electronics are cooled by a highly efficient fan for added reliability and monitored by a thermal protection system. The machine has been equipped with three heat sinks which further extending the life time of the product. The casing has been designed to withstand harsh environments and is rated to IP 23S standard. The machine incorporates both a shoulder strap and a robust carry handle.

Buddy™ Arc provides a smooth DC (Direct Current) welding power which allows you to weld most metals such as alloyed and non alloyed steel, stainless steel and cast iron. Buddy™ Arc can weld most electrodes from Ø1.6 -3.2 mm.

### TIG welding with Buddy™ Arc 180

The Buddy™ Arc 180 can easily perform TIG-welding using a "Live Tig" start. Equip the power source with the optional Tig-Torch which has an in-built gas valve, a gas regulator and a bottle of gas and you are ready to weld mild steel or stainless steel with or without filler material.

### Ideal applications

- Plant Fabrication & Maintenance
- Site Maintenance/Repair
- Civil Construction
- General Fabrication
- Agriculture



Buddy™ Arc 145 is very easy to use and features only one knob for the setting of the weld current.



Buddy™ Arc 180 features one knob for the setting of the weld current. A switch on the front panel provides easy selection of the MMA or TIG process. The arc force and hot start settings are adjusted automatically according to the set welding current giving excellent arc starts and welding performance across the amperage range of the machine.







Buddy™ Arc 145



Buddy™ Arc 180

- Superior arc characteristics
- Generator compliant
- Easy to use
- Practical & robust design
- Can be used with extended mains cable

| Technical data*                        | Buddy™ Arc 145 | Buddy™ Arc 180 |
|--|----------------|----------------|
| Mains supply, V / ph Hz                | 230 / 1, 50/60 | 230 / 1, 50/60 |
| Fuse, slow, A                          | 16             | 16             |
| Setting range MMA / TIG , A            | 10 - 145       | 5 - 180        |
| Phase current I <sub>1eff</sub> MMA, A | 10,8           | 16,0           |
| Phase current I <sub>1eff</sub> TIG, A | -              | 12,5           |
| Dimensions, LxWxH, mm                  | 280x120x220    | 310x140x230    |
| Weight, kg                             | 3,6            | 6,0            |
| Enclosure class                        | IP 23S         | IP 23S         |
| Application class                      | S              | S              |

| Maximum output at 40°C MMA |         |          |
|----------------------------|---------|----------|
| 60% duty cycle, A/V, 3ph   | 70/22,8 | 125/25,0 |
| 100% duty cycle, A/V, 3ph  | 55/22,2 | 100/24,0 |

| Maximum output at 40°C TIG |   |          |
|----------------------------|---|----------|
| 60% duty cycle, A/V, 3ph   | - | 130/15,2 |
| 100% duty cycle, A/V, 3ph  | - | 100/14,0 |

\*Technical data is subject to change.

#### Ordering information

|                            |                     |
|----------------------------|---------------------|
| Buddy™ Arc 145 CE          | <b>0700 300 884</b> |
| Buddy™ Arc 180 CE c/w Plug | <b>0700 300 680</b> |
| Buddy™ Tig 160 CE c/w Plug | <b>0700 300 681</b> |

#### Package includes:

|  |                     |
|--|---------------------|
| 3m Welding cable and return cable kits.    |                     |
| TIG Torch ET 17v 4 m (Buddy™ Tig 160 Only) | <b>0700 300 861</b> |

# ORIGO™ ARC 410c, 650c AND 810c



## HIGH-POWER DC RECTIFIERS

In the Origo™ Arc C range the most modern power control technology and robust basic technology has found a perfect match. Stability and durability characterize these construction site welding power sources.

The welder benefits from Hot Start for optimal striking of the electrode or from Arc Force for perfect regulation of the process in all situations. Anti Stick prevents the electrodes from sticking to the workpiece at the start of the weld.

On large construction sites, in shipyards or when laying pipelines, many already put their trust in the legendary reliability of the Origo™ Arc welding units.

- Extremely well suited for difficult to run cellulosic
- Superlative welding characteristics - optimal quality
- Large setting range - versatile in use
- Mains voltage compensation - constant welding parameters and stable control
- Stepless current setting - can be controlled remotely and exact setting options
- HotStart, ArcForce and Anti Stick
- Optimally suited for gouging
- Suitable for special mains voltages
- Offshore versions with added protection for the toughest applications outdoors
- Available in stationary or mobile wheeled variants
- MIG/MAG welding with MobileFeed 301 AVS



| Technical data          | Origo™ Arc 410c           |
|-------------------------|---------------------------|
| Mains supply, V / ph    | 230 / 400 - 415 / 500 / 3 |
| Fuse, slow, A           | 63 / 25 / 20              |
| Setting range MMA, A    | 20 - 400                  |
| Open circuit voltage, V | 53 - 70                   |
| Dimensions, LxWxH, mm   | 1310 x 800 x 780          |
| Weight, kg              | 157                       |
| Enclosure class         | IP 23                     |
| Application class       | S                         |

| Maximum output at 40°C, MMA |          |
|-----------------------------|----------|
| 35% duty cycle, A           | 400 / 36 |
| 60% duty cycle, A           | 310 / 33 |
| 100% duty cycle, A          | 240 / 30 |





## CONTROL PANEL A11

- Selection of the welding procedure, welding electrode, gouging or TIG welding with contact striking
- HotStart (adjustable)
- ArcForce (adjustable)



## CONTROL PANEL A12

- Selection of the welding procedure, welding electrode, gouging or TIG welding with contact striking
- Digital display
- HotStart (adjustable)
- ArcForce (adjustable)
- Suitable for cableless remote controller N02
- Remote controllable

### Ordering information

|                                 |              |
|---------------------------------|--------------|
| Origo™ Arc 410c, A11 Stationary | 0349 312 100 |
| Origo™ Arc 410c, A12 Offshore   | 0349 311 480 |
| Origo™ Arc 410c, A12 Stationary | 0349 311 490 |
| Origo™ Arc 650c, A12 Offshore   | 0349 311 500 |
| Origo™ Arc 650c, A12 Stationary | 0349 311 510 |
| Origo™ Arc 810c, A12 Offshore   | 0349 311 430 |

### Accessories Origo™ Arc 410c

|  |              |
|--|--------------|
| Welding cable, complete, 5m, 70mm <sup>2</sup> | 0700 006 894 |
| Return cable, complete, 5m, 70mm <sup>2</sup>  | 0700 006 895 |

### Accessories Origo™ Arc 650c and 810c

|  |              |
|--|--------------|
| Welding cable, complete, 5m, 95mm <sup>2</sup> | 0700 006 896 |
| Return cable, complete, 5m, 95mm <sup>2</sup>  | 0700 006 897 |

### Remote controller

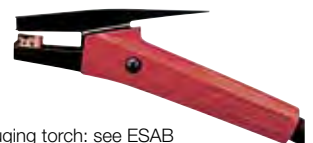
|                                |              |
|--------------------------------|--------------|
| N02 wireless remote controller | 0349 304 617 |
|--------------------------------|--------------|

## REMOTE CONTROLLER N02

The remote controller N02, controls the current through the welding current circuit, without a separate control cable. Set the desired current, place the remote controller on the work piece, press the electrode against the measuring point and wait a moment - all done!



Other remote controllers, page 68



Gouging torch: see ESAB accessories catalogue

| Origo™ Arc 650c           | Origo™ Arc 810c           |
|---------------------------|---------------------------|
| 230 / 400 - 415 / 500 / 3 | 230 / 400 - 415 / 500 / 3 |
| 80 / 50 / 35              | 100 / 63 / 50             |
| 20 - 650                  | 20 - 800                  |
| 53 - 70                   | 53 - 70                   |
| 1310 x 800 x 780          | 1310 x 800 x 780          |
| 223                       | 245                       |
| IP 23                     | IP 23                     |
| S                         | S                         |
| 650 / 44                  | 800 / 44                  |
| 490 / 40                  | 630 / 44                  |
| 400 / 36                  | 500 / 40                  |

# ORIGO™ MIG 4004i A44

## HIGH-PERFORMANCE INVERTERS

The Origo™ Mig 4004i A44 is the ideal partner for manual metal arc welding in your operation or on the construction site.

A powerful device for production welding, repair and maintenance or on site installation.

This 3rd generation inverter offers considerable improved efficiency and power factor is approximately 1.

The ESAB Arc Plus™ II controller ensures superlative welding properties and perfect restriking when using basic MMA electrodes.

With the Origo™ Mig 4004i A44 you can work with electrodes of up to 6 mm in diameter without any problems, for gouging you can use carbon electrodes up to a diameter of 8 mm.

Optionally, MIG/MAG welding in conjunction with the MobileFeed 301 AVS wire feed device is possible.

## OPTIMUM WELDING WITH MMA ELECTRODES



- Superlative welding properties - High deposition and high quality
- Standby function – energy saving system.
- Internal dust filter - reduces possible failures due to dust particle ingress
- TIG welding with ESAB LiveTig™ striking
- IP 23 protection - for work outdoors
- Can be controlled remotely, digital display
- Integrated handles

| Technical data             | Origo™ Mig 4004i |
|----------------------------|------------------|
| Mains supply, V / ph       | 380 - 440 / 3    |
| Fuse, slow, A              | 25               |
| Setting range, A           | 16 - 400         |
| Open circuit voltage, V    | 55               |
| Open circuit power, W      | 100              |
| Power factor               | 0,94             |
| Efficiency at max power, % | 88               |
| Dimensions, LxWxH, mm      | 610 x 250 x 445  |
| Weight, kg                 | 46               |
| Enclosure class            | IP 23            |
| Application class          | S                |

| Maximum output at 40°C |          |
|------------------------|----------|
| 60% duty cycle, A/V    | 400 / 36 |
| 100% duty cycle, A/V   | 300 / 32 |



## CONTROL PANEL A44

- Selection of electrode type, basic - rutile - cellulose
- MMA welding and TIG with LiveTig™ striking
- Hot Start and Arc Force can be set
- Stepless inductance
- Voltage Reduction Device
- Carbon arc gouging
- Two memories
- Digital display
- Drop welding and setting of TIG minimum current through a background menu
- Optional MIG/MAG welding with MobileFeed 300 AVS



MobileFeed 301 AVS

### Ordering information

|                             |              |
|-----------------------------|--------------|
| Origo™ Mig 4004, A44        | 0465 152 880 |
| Welding cable, complete, 5m | 0700 006 893 |
| MobileFeed 301 AVS          | 0558 102 207 |

### Delivery includes:

5 m mains cable and CEE plug. Return cable, complete, 5m.



TIG torches at page 102



Remote controller, page 68

Gouging torch: see ESAB accessories catalogue







ESAB

CE

400A1

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# MIG/MAG WELDING



MIG/MAG welding is one of the gas-shielded metal arc welding processes. The arc burns between a continuously fed and consumable wire electrode and the work piece. The arc and the weld pool are protected by an active or inert gas. The process can be used with most materials and there is a wide range of filler metals.

Compared to manual metal arc welding, MIG/MAG welding is far more productive. There is no need to change electrodes frequently and the net productivity is significantly greater. For every kilogram of rod electrodes

used, only around 65% actually goes into the welded material. With wire electrodes this value is already around 85 - 90%.

MIG/MAG welding is a very versatile process that allows high deposition rates to be attained in all positions. It is employed in almost all areas involving the welding of unalloyed and low-alloy steels, high-alloy steels, nickel-based materials and aluminium. MIG/MAG pulse welding is frequently used on high-alloy steels and aluminium. Filler wires are increasingly used, which have a whole series of advantages in addition to increased productivity.

## QSet™

The arc has been reinvented! This unique, intelligent system is so flexible: whether it involves construction steel under CO<sub>2</sub>, under a mixed gas, with stainless steel or aluminium, whether you weld with self-protecting cored wire without protective gas or cored wire with protective gas or carry out GMA brazing. QSet™ automatically adjust the arc to suit the combination of wire/gas being used and sets the perfect parameters for a stable short arc. Lightning-fast regulation ensures that the welding can be undertaken with the minimum of spatter.



## TrueArcVoltage™

Exact repeatability of welding parameters is particularly important for reproducing quality welds. ESAB units with True Arc Voltage™ measure the values directly at the Arc and not, as is usual, in the machine. You have the process firmly under control even when using extended cable lengths or torches.

## SuperPulse™

With SuperPulse™ various types of arc can be superimposed in a process: the advantages of pulse-welding combined with those of the short arc, the spray arc or of a pulse with another frequency. In this way the welding speed, application of heat, weld penetration behaviour and deposition rate are perfectly balanced. Cold arc, deep weld penetration, perfect fusion - everything under control.

## Swift Arc Transfer™

SAT™ is a high productivity MIG process using AristoRod™ non-copper coated wires with advanced surface characteristics at travel speeds well beyond the limits of normal spray arc welding. The advantage with AristoRod™ non-copper-coated wire over copper-coated wires is that it does not quickly contaminate the feed system with copper particles. SAT™ is developed for robotic, automated and mechanized welding.



# REBEL™ SERIES

## DUAL INPUT VOLTAGE MACHINES FOR MIG/MMA/LIFT TIG

The Rebel™ Series Welding Machines offer 120/230V flexibility and some of the most innovative welding technology available. A breakthrough design inspired by professional welders, the Rebel is a complete package to weld anything –mild steel, aluminium, stainless steel –and go anywhere.

True multi-process performance for best-in-class MIG, Flux-cored, MMA, including challenging electrodes, and Lift TIG welding with Rebel EMP 215ic.

Exclusive sMIG (“smart MIG“) feature continuously learns and adapts to the operator’s welding technique to provide a stable arc and superior, repeatable welds; increases productivity for the experienced welder, and reduces training time for novice welders.

Innovative user interface with a large TFT display to provide a clear view of the weld parameters and settings, also from a distance. The display is loaded with exclusive features: on-demand availability of the user’s manual, listing of spare parts –all in multiple languages.

Choose from 3 models:

- Rebel EMP 215ic for MIG/MMA/Lift TIG
- Rebel EM 215ic for MIG
- Rebel EMP 235ic for MIG/MMA/Lift TIG



Rebel™ EM 215ic

### Ordering information

|                  |              |
|------------------|--------------|
| Rebel™ EMP 215ic | 0700 300 985 |
| Rebel™ EM 215ic  | 0700 300 986 |

### Delivery includes

|  |
|--|
| <b>Rebel™ EMP 215ic</b>  |
| MXL 200 MIG torch, electrode and return cable kits, 200 mm spool OK Aristorod 12.50 0,8 mm wire, 4.5 m gas hose with quick connector, contact tips and drive rolls for 0,6 –1,0 mm wire. |
| <b>Rebel™ EM 215ic</b>   |
| MXL 200 MIG torch, return cable kits, 200 mm spool OK Aristorod 12.50 0.8 mm wire, 4.5 m gas hose with quick connector, contact tips and drive rolls (V-groove) for 0.6 –1.0 mm wire.    |

### Accessories

|   |              |
|---|--------------|
| TIG Torch ET17v, 4 m (8 pin connection) | 0700 300 869 |
| TIG Foot Control incl. 4,5 m cable      | W4 014 450   |
| PSF™ 305 3 m (for FCW 1.2 mm)           | 0458 401 880 |
| MXL™ 270 3m (for FCW 1.2 mm)            | 0700 200 004 |
| 2-wheel trolley                         | 0459 366 887 |





# REBEL™ EMP 235ic



## Ordering information

Rebel™ EMP 235ic for MIG/MMA/Lift TIG **0700 300 989**

## Accessories

TXH™ 202 TIG Torch 4 m **0700 300 857**

TIG Foot Control incl. 4,5 m cable **W4 014 450**

PSF™ 305 3 m (for FCW 1.2 mm) **0458 401 880**

MXL™ 270 3 m (for FCW 1.2 mm) **0700 200 004**

- More power and increased duty cycle
- For medium-duty jobs where a larger spool is more suitable
- Two gas inlets, one for MIG/MAG and one for TIG where both can be connected simultaneously
- Built in TIG gas solenoid valve on the front of the machine - no need for a manual valve on the TIG torch

| Technical data*                   | Rebel™<br>EMP 215ic   | Rebel™<br>EM 215ic  | Rebel™<br>EMP 235ic   |
|-----------------------------------|---|---|---|
| Primary Voltage                   | 115/230 VAC   | 115/230 VAC   | 115/230 VAC   |
| Supply Voltage Range              | 95 –270 VAC   | 95 –270 VAC   | 95 –270 VAC   |
| Number of Phases                  | 1   | 1   | 1   |
| Supply Frequency                  | 50/60 Hz  | 50/60 Hz  | 50/60 Hz  |
| Supply Plug                       | 230 V, Schuko 16A plug  | 230 V, Schuko 16A plug  | 230 V, Schuko 16A plug  |
| Rated kVA                         | 4.5 kVA (120 V), 7 kVA (230 V)                                  | 4.5 kVA (120 V), 7 kVA (230 V)                                  |   |
| Mains Cable                       | 3 m 3x2,5 mm <sup>2</sup> H07RN-F                               | 3 m 3x2,5 mm <sup>2</sup> H07RN-F                               | 3 m 3x2,5 mm <sup>2</sup> H07RN-F                               |
| Maximum Output                    | 240 A   | 240 A   | 270 A   |
| MIG Welding Output (230V)         |   |   |   |
| 25% Duty Cycle                    | 205 A / 24,3 V  | 205 A / 24,3 V  | 230 A / 25,5 V  |
| 40% Duty Cycle                    | 150 A / 21,5 V  | 150 A / 21,5 V  | 195 A / 23,8 V  |
| 60% Duty Cycle                    | 125 A / 20,3 V  | 125 A / 20,3 V  | 170 A / 22,5 V  |
| MMA Welding Output (230 V)        |   |   |   |
| 25% Duty Cycle                    | 180 A / 27,2 V  | -   | ( 40% ) 210 A / 28,4 V  |
| 60% Duty Cycle                    | 125 A / 25 V  | -   | 150 A / 26 V  |
| TIG Welding Output (230 V)        |   |   |   |
| 30% Duty Cycle                    | 180 A / 17,2 V  | -   | 235 A / 19,4 V  |
| 60% Duty Cycle                    | 125 A / 15 V  | -   | 200 A / 18 V  |
| Current Range                     | 5 –240 A (230 V), 5 –150 A (120 V)                              | 5 –240 A (230 V), 5 –150 A (120 V)                              |   |
| MIG Welding Voltage Range         | 10 – 26 V   | 10 – 26 V   | 14,8 – 30 V   |
| Wire Feed Speed Range             | 1,5 –12,1 m/min   | 1,5 –12,1 m/min   | 1,5 –17,5 m/min   |
| Nominal OCV Volt/DC               | 68 VDC  | 68 VDC  |   |
| Maximum Plate Thickness           | 9,5 mm  | 9,5 mm  | 12,7 mm   |
| Wire Diameter Range:              |   |   |   |
| Mild Steel                        | 0,6 –1,0 mm   | 0,6 –1,0 mm   | 0,6 –1,0 mm   |
| Stainless Steel                   | 0,8 –1,0 mm   | 0,8 –1,0 mm   | 0,8 –1,0 mm   |
| Aluminium                         | 0,8 –1,2 mm   | 0,8 –1,2 mm   | 0,8 –1,2 mm   |
| Flux Cored                        | 0,8 –1,2 mm   | 0,8 –1,2 mm   | 0,8 –1,2 mm   |
| Wire Spool Size                   | 100 mm, 200 mm  | 100 mm, 200 mm  | 100 mm, 200 mm, 300 mm  |
| Approvals                         | CSA: E60974-1-00<br>CE: IEC/EN 60974-1, 5, 7, 10, 12 & 13. RoHS | CSA: E60974-1-00<br>CE: IEC/EN 60974-1, 5, 7, 10, 12 & 13. RoHS | CSA: E60974-1-00<br>CE: IEC/EN 60974-1, 5, 7, 10, 12 & 13. RoHS |
| Protection Class                  | IP23S   | IP23S   | IP23S   |
| Power Source Dimensions, Lx W x H | 584 x 229 x 406 mm  | 584 x 229 x 406 mm  | 673 x 292 x 495 mm  |
| Power Source Weight               | 18 kg   | 18 kg   | 24 kg   |

\*Technical data is subject to change.

# CADDY® MIG C160i AND C200i

## EXPERIENCE A NEW LEVEL OF MOBILITY

Compact, light and powerful. Caddy® Mig C160i/ C200i welding inverter is a perfect companion for your travels. Sling the carrying strap over your shoulder and go on to the next job. This go-anywhere welding unit offers industrial welding capacity even in the most remote of locations. Whether you choose the Caddy® Mig C160i or the intelligent C200i, your new partner will exceed your expectations. From light metal structures, Auto-body repair, workshop or site maintenance and installation. To tough demanding agricultural and industrial applications, the Caddy MIG is robust, efficient, reliable and user-friendly.

Caddy MIG is powered by single -phase 230V and can be connected to either mains electrical power or power provided by a generator without any issue.

The simplest way to obtain excellent high grade welds: Just select the material thickness and start welding. Or even easier still, Caddy MIG 200 with QSet™.

## MORE POWER THAN EVER BEFORE

The energy-efficient PFC module (Power Factor Correction) smoothes out the current for effective operation. The result is up to 30% increase in welding power for the same fuse rating.



## CADDY® MIG

- Easy to use; Uses material thickness to preselect welding parameters
- Fine adjustment of heat input
- Weight under 12 kg (incl. torch, work piece cable and main cable)
- Single phase 230 Volt 50/60 Hz
- Generator-compatible
- Suitable for 100-200 mm spools
- High quality welding torch MXL™ 180
- Tool holder
- Roller holder for torch and cable
- Easy polarity change over when using self-shielding cored wire.



## CADDY® MIG C160i

- Optimized for construction steel, metal sheet thicknesses from 0.5 - 4.0 mm.
- Solid and cored wire, wire diameter 0.8 mm



## CADDY® MIG C200i

- Sheet metal thicknesses 0.5 - 6.0 mm
- Wire diameter 0.6 - 1.0 mm
- Construction steel & stainless steel
- Aluminium
- GMA brazing of galvanized metal sheets
- QSet™

### Welding wires in 200 mm spools

#### Caddy® Mig C160i/C200i

**Mild steels:** Solid wire OK Autrod 12.51, Ø 0,8mm  
Cored wire Coreshield 15, Ø 0,8mm

#### Caddy® Mig C200i

**Stainless steels:** OK Autrod 316LSi, Ø 0,8mm  
OK Autrod 308LSi, Ø 1,0mm, 18Cr 8Ni steels

**Aluminium:** OK Autrod 5183, Ø 1,0 mm

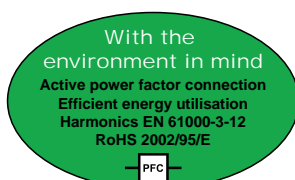
**GMA brazing:** OK Autrod 19.30, Ø 1,0 mm

### Ordering information for wires in 200 mm spools

|                  |              |                     |
|------------------|--------------|---------------------|
| OK Autrod 12.51  | Ø 0,8/5,0 kg | <b>1251 084 600</b> |
| Coreshield 15    | Ø 0,8/4,5 kg | <b>35UE 084 630</b> |
| OK Autrod 19.30  | Ø 1,0/5,0 kg | <b>1930 104 600</b> |
| OK Autrod 308LSi | Ø 0,8/5,0 kg | <b>1612 084 600</b> |
| OK Autrod 316LSi | Ø 0,8/5,0 kg | <b>1632 084 600</b> |
| OK Autrod 5183   | Ø 1,0/2,0 kg | <b>1816 104 62E</b> |

### Package includes

Welding torch with 3m cable, mains cable 3m with plug, protective gas hose 4,5m with clamp and quick connector, earth cable complete, carrying strap, consumables for 0.8 mm wire and instructions for use. 1 kg welding wire OK Autrod 12.51, 0.8 mm



| Technical data                       | Caddy® Mig C160i | Caddy® Mig C200i |
|--------------------------------------|------------------|------------------|
| Mains supply, V / ph                 | 230 / 1          |                  |
| Fuse, slow, A                        | 16               |                  |
| Auto-fuse (MCB) EN 60898-B, A        | 16               | 20               |
| Power requested from generator*, kVA | 5,5              | 6,5              |
| Setting range, A                     | 30 - 160         | 30 - 200         |
| Open circuit voltage, V              | 60               |                  |
| Open circuit power, W                | 15               |                  |
| Power factor                         | 0,99             |                  |
| Efficiency at max power, %           | 82               |                  |
| Wire feed speed, m/min               | 2 - 11           | 2 - 12           |
| Dimensions, LxWxH, mm                | 449 x 198 x 347  |                  |
| Weight, Kg                           | 11,4             | 11,5             |
| Enclosure class                      | IP23             |                  |
| Application class                    | S                |                  |

\* Generator with automatic voltage regulator

### Maximum output at 40°C

|                    |     |     |
|--------------------|-----|-----|
| 25% duty cycle, A  | --- | 180 |
| 35% duty cycle, A  | 150 | 150 |
| 100% duty cycle, A | 100 | 100 |

### Usable wire diameters, mm

|                    |     |           |
|--------------------|-----|-----------|
| Mild steels        | 0,8 | 0,6 - 1,0 |
| Stainless steels   | --- | 0,6 - 1,0 |
| Cored wires        | 0,8 | 0,8       |
| Aluminium          | --- | 1,0       |
| Brazing CuSi wires | --- | 0,8 - 1,0 |

### Ordering information

|                    |                     |
|--------------------|---------------------|
| Caddy® Mig C160i   | <b>0349 310 850</b> |
| Caddy® Mig C200i   | <b>0349 312 030</b> |
| Two-wheels trolley | <b>0459 366 887</b> |





# ORIGO™ MIG/MAG C170, C171, C200 C201, C250 AND C251

## COMPACT UNITS FOR LIGHT AND MEDIUM DUTY COMMERCIAL USE

- Power Smoothing Device™ - excellent welding properties for single-phase units
- Simple polarity changing - allows the use of solid wire and Flux-cored wire
- Also suitable for the welding of aluminium and GMAW brazing of galvanized metal sheets
- IP 23 - allows use outdoors
- Simple setting of the welding parameters
- MXL™ torches - proven by professionals to be reliable and durable.



| Technical data         | Origo™ Mig C170 | Origo™ Mag C171 | Origo™ Mig C200 | Origo™ Mag C201 | Origo™ Mig C250 | Origo™ Mag C251 |
|------------------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|
| Mains supply, V / ph   | 400 / 3         | 230 / 1         | 400 / 3         | 230 / 1         | 400 / 3         | 230 / 1         |
| Fuse, slow, A          | 10              | 16              | 10              | 20              | 16              | 35              |
| Setting range, A       | 30 - 170        | 30 - 170        | 30 - 200        | 30 - 200        | 40 - 280        | 40 - 250        |
| Burn-back time, sec    | 0,02 - 0,25     | 0,02 - 0,25     | 0,02 - 0,25     | 0,02 - 0,25     | 0,02 - 0,25     | 0 - 0,25        |
| Spot welding time, sec | 0,2 - 2,5       | 0,2 - 2,5       | 0,2 - 2,5       | 0,2 - 2,5       | 0,2 - 2,5       | 0,2 - 2,5       |
| Voltage steps          | 8               | 8               | 10              | 12              | 10              | 12              |
| Polarity change        | yes (optional)  | yes             | yes             | yes             | yes             | yes             |
| Dimensions, LxWxH, mm  | 860 x 420 x 730 | 860 x 420 x 730 | 860 x 420 x 730 | 860 x 420 x 730 | 860 x 420 x 730 | 860 x 420 x 730 |
| Weight, kg             | 63,5            | 59              | 72,5            | 68              | 82              | 94              |
| Spool type, Ømm/kg     | 300 / 18        | 300 / 18        | 300 / 18        | 300 / 18        | 300 / 18        | 300 / 18        |
| Enclosure class        | IP 23           | IP 23           | IP 23           | IP 23           | IP 23           | IP 23           |
| Application class      | S               | S               | S               | S               | S               | S               |

### Maximum output at 40°C

|                    |     |     |     |     |     |           |
|--------------------|-----|-----|-----|-----|-----|-----------|
| 20% duty cycle, A  | -   | 170 | -   | 200 | -   | 250       |
| 35% duty cycle, A  | 170 | -   | 200 | -   | 250 | 200 (30%) |
| 60% duty cycle, A  | 130 | 98  | 150 | 115 | 190 | 140       |
| 100% duty cycle, A | 100 | 76  | 120 | 90  | 150 | 110       |

### Usable wire diameters, mm

|                           |           |           |           |           |           |           |
|---------------------------|-----------|-----------|-----------|-----------|-----------|-----------|
| Mild and stainless steels | 0,6 - 0,8 | 0,6 - 0,8 | 0,6 - 1,0 | 0,6 - 0,8 | 0,6 - 1,2 | 0,6 - 1,2 |
| Cored wires               | 0,8       | 0,8       | 0,8 - 1,0 | 0,8       | 0,8 - 1,2 | 0,8 - 1,2 |
| Aluminium                 | 1,0       | 1,0       | 1,0       | 1,0       | 1,0 - 1,2 | 1,0 - 1,2 |
| Brazing CuSi wires        | 0,8 - 1,0 | 0,8 - 1,0 | 0,8 - 1,0 | 0,8 - 1,0 | 0,8 - 1,0 | 0,8 - 1,0 |

### Package includes

|                   |             |             |             |             |             |             |
|-------------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Welding torch     | MXL™        | MXL™        | MXL™        | MXL™        | MXL™        | MXL™        |
| Type/cable length | 200 / 3,0 m | 200 / 3,0 m | 200 / 3,0 m | 200 / 3,0 m | 270 / 3,0 m | 270 / 3,0 m |
| Connection        | Euro        | Euro        | Euro        | Euro        | Euro        | Euro        |

Mains cable 3m with plug, gas hose 1,5m with clamps and quick connector, earth cable complete, wear parts for 0,6-0,8mm wire (0,8-1,0mm for C250) pre-assembled, safety chain for gas bottle and wheels.

### Ordering information

|                     |                     |
|---------------------|---------------------|
| Origo™ Mag C171     | <b>0349 311 280</b> |
| Origo™ Mig C170 3ph | <b>0349 308 670</b> |
| Origo™ Mag C201     | <b>0349 311 290</b> |
| Origo™ Mig C200 3ph | <b>0349 308 290</b> |
| Origo™ Mag C251     | <b>0349 311 420</b> |
| Origo™ Mig C250 3ph | <b>0349 307 840</b> |

### Accessories

|  |                     |
|--|---------------------|
| Digital V/A instruments kit                        | <b>0349 302 598</b> |
| Transformer kit for CO2 preheater (42V – 50/60 Hz) | <b>0349 302 250</b> |
| Pressure reducer with flux-meter                   | <b>0760 030 300</b> |
| Polarity inversion kit (for Origo™ Mig C170)       | <b>0349 309 310</b> |

# MXL™ TORCHES

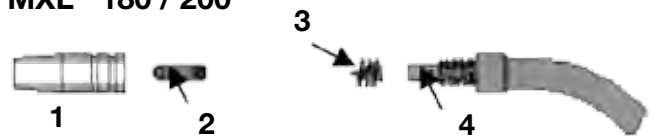


| Technical data                         | MXL™ 150V             | MXL™ 180  | MXL™ 200               | MXL™ 270  |
|--|-----------------------|-----------|------------------------|-----------|
|  | With fixed connection |           | With central connector |           |
| CO <sub>2</sub> , A / duty cycle, %    | 150 / 35              | 180 / 35  | 200 / 35               | 270 / 35  |
| Ar/CO <sub>2</sub> , A / duty cycle, % | 150 / 35              | 150 / 35  | 170 / 35               | 260 / 35  |
| Wire diameters, mm                     | 0,6 - 0,8             | 0,6 - 1,0 | 0,6 - 1,0              | 0,8 - 1,2 |

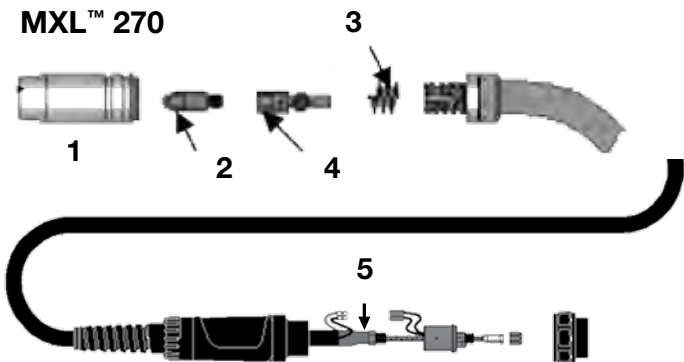
## Ordering information – torches and wear parts

|                                 |              |              |              |              |
|---------------------------------|--------------|--------------|--------------|--------------|
| Torch with 2,5m cable           | 0700 200 001 | -            | -            | -            |
| Torch with 3,0m cable           | -            | 0349 483 070 | 0700 200 002 | 0700 200 004 |
| Torch with 4,0m cable           | -            | -            | 0700 200 003 | 0700 200 005 |
| Swan neck                       | 0700 200 050 | 0700 200 051 | 0700 200 051 | 0700 200 052 |
| 1 - Gas nozzle standard Ø 12mm  | 0700 200 054 | 0700 200 054 | 0700 200 054 | -            |
| 1 - Gas nozzle standard Ø 15mm  | -            | -            | -            | 0700 200 055 |
| 1 - Gas nozzle straight Ø 16mm  | 0700 200 057 | 0700 200 057 | 0700 200 057 | -            |
| 1 - Gas nozzle straight Ø 18mm  | -            | -            | -            | 0700 200 058 |
| 1 - Gas nozzle conical Ø 9,5mm  | 0700 200 060 | 0700 200 060 | 0700 200 060 | -            |
| 1 - Gas nozzle conical Ø 11,5mm | -            | -            | -            | 0700 200 061 |
| 2 - Contact tip Cu W 0,6 M6     | 0700 200 063 | 0700 200 063 | 0700 200 063 | -            |
| 2 - Contact tip Cu W 0,8 M6     | 0700 200 064 | 0700 200 064 | 0700 200 064 | 0700 200 068 |
| 2 - Contact tip Cu W 0,9 M6     | 0700 200 065 | 0700 200 065 | 0700 200 065 | 0700 200 069 |
| 2 - Contact tip Cu W 1,0 M6     | 0700 200 066 | 0700 200 066 | 0700 200 066 | 0700 200 070 |
| 2 - Contact tip Cu W 1,2 M6     | -            | -            | -            | 0700 200 071 |
| 3 - Nozzle spring               | 0700 200 078 | 0700 200 078 | 0700 200 078 | 0700 200 079 |
| 4 - Tip adapter M6              | 0700 200 076 | 0700 200 072 | 0700 200 072 | 0700 200 073 |
| 5 - Steel liner W0,6-W0,8-2,5m  | 0700 200 099 | -            | -            | -            |
| 5 - Steel liner W0,6-W0,8-3,0m  | -            | 0700 200 085 | 0700 200 085 | 0700 200 085 |
| 5 - Steel liner W0,6-W0,8-4,0m  | -            | -            | 0700 200 086 | 0700 200 086 |
| 5 - Steel liner W0,9-W1,2-3,0m  | -            | 0700 200 087 | 0700 200 087 | 0700 200 087 |
| 5 - Steel liner W0,9-W1,2-4,0m  | -            | -            | 0700 200 088 | 0700 200 088 |
| 5 - PTFE liner W0,6-W0,8-3,0m   | -            | 0700 200 089 | 0700 200 089 | 0700 200 089 |
| 5 - PTFE liner W0,6-W0,8-4,0m   | -            | -            | 0700 200 090 | 0700 200 090 |
| 5 - PTFE liner W0,9-W1,2-3,0m   | -            | 0700 200 091 | 0700 200 091 | 0700 200 091 |
| 5 - PTFE liner W0,9-W1,2-4,0m   | -            | -            | 0700 200 092 | 0700 200 092 |

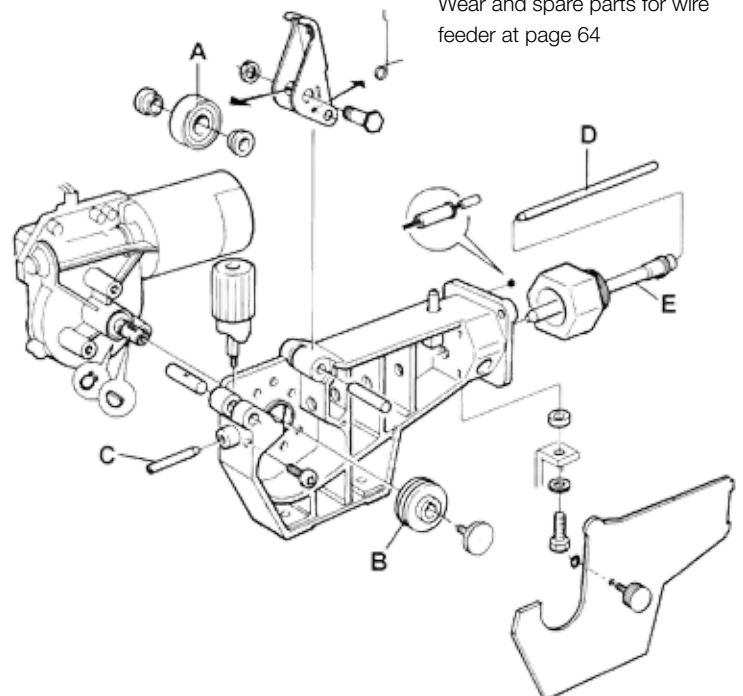
### MXL™ 180 / 200



### MXL™ 270



Wear and spare parts for wire feeder at page 64



Welding with aluminium wires. Use appropriate feeding rolls and torches with 3m cable.

# ORIGO™ MIG C280, C340, C420w PRO

COMPACT UNITS FOR PROFESSIONAL USE

ORIGO™ MIG C280 PRO



ORIGO™ MIG C340 PRO



ORIGO™ MIG C420w PRO



| Technical data         | Origo™<br>Mig C280 PRO | Origo™<br>Mig C280 PRO 4WD | Origo™<br>Mig C340 PRO |
|------------------------|------------------------|----------------------------|------------------------|
| Mains supply, V / ph   | 400 / 3                | 400 / 3                    | 400 / 3                |
| Fuse, slow, A          | 16                     | 16                         | 16                     |
| Setting range, A       | 30 - 280               | 30 - 280                   | 40 - 340               |
| Burn-back time, sec    | 0 - 0,25               | 0 - 0,25                   | 0 - 0,5                |
| Spot welding time, sec | 0,2 - 2,5              | 0,2 - 2,5                  | -                      |
| Voltage steps          | 10                     | 10                         | 40                     |
| Polarity change        | yes                    | yes                        | yes                    |
| Inductance outlets     | 2                      | 2                          | 2                      |
| 2/4 stroke control     | -                      | -                          | yes                    |
| Creep start            | -                      | -                          | yes                    |
| Dimensions, LxWxH, mm  | 840 x 425 x 830        | 840 x 425 x 830            | 840 x 425 x 830        |
| Weight, kg             | 97                     | 97                         | 120                    |
| Spool type, Ømm/kg     | 300 / 18               | 300 / 18                   | 300 / 18               |
| Feed rolls             | 2                      | 4                          | 2                      |
| Enclosure class        | IP 23                  | IP 23                      | IP 23                  |
| Application class      | S                      | S                          | S                      |

#### Maximum output at 40°C

|                                |            |            |            |
|--------------------------------|------------|------------|------------|
| Max current, A at duty cycle % | 280 / 30 % | 280 / 30 % | 340 / 30 % |
| 60% duty cycle, A              | 190        | 190        | 250        |
| 100% duty cycle, A             | 150        | 150        | 195        |

#### Usable wire diameters

|                           |           |           |           |
|---------------------------|-----------|-----------|-----------|
| Mild and stainless steels | 0,6 - 1,0 | 0,6 - 1,0 | 0,6 - 1,2 |
| Cored wires               | 0,9 - 1,2 | 0,9 - 1,2 | 0,9 - 1,2 |
| Aluminium                 | 1,0 - 1,2 | 1,0 - 1,2 | 1,0 - 1,2 |

#### Delivery includes

|                   |             |             |             |
|-------------------|-------------|-------------|-------------|
| Welding torch     | PSF™        | PSF™        | PSF™        |
| Type/cable length | 250 / 3,0 m | 250 / 4,5 m | 305 / 3,0 m |
| Connection        | Euro        | Euro        | Euro        |

Mains cable 5m with plug, gas hose 1,5m with clamps and quick connector, earth cable complete, wear parts for 0,8-1,0mm wire (C280), 1,0-1,2mm (C340-420), safety chain for gas bottle and wheels.



- Very good welding properties - stable arc and very finely matched voltage steps
- Also suitable for the welding of aluminium and GMA brazing of galvanized metal sheets
- Galvanized metal housing with optional air filter designed for use under rough conditions
- Two or three inductance connections - optimal arc dynamics
- 4-roll wire feed available - perfect wire conveying
- Professional ESAB PSF™ torches included
- Origo™ Mig C340 PRO and C420w PRO optionally with electric Push-Pull welding torch in 6 or 10 m length
- Simple polarity change - allows the use of solid wire and cored wire
- Origo™ Mig C420w PRO with ELP, ESAB LogicPump (forced switching over of the water cooling if required)

| Origo™<br>Mig C340 PRO 4WD | Origo™<br>Mig C420/C420w PRO |
|----------------------------|------------------------------|
| 400 / 3                    | 400 / 3                      |
| 16                         | 32                           |
| 40 - 340                   | 50 - 420                     |
| 0 - 0,5                    | 0 - 0,5                      |
| -                          | -                            |
| 40                         | 35                           |
| yes                        | yes                          |
| 2                          | 3                            |
| yes                        | yes                          |
| yes                        | yes                          |
| 840 x 425 x 830            | 935 x 640 x 800              |
| 120                        | 230                          |
| 300 / 18                   | 300 / 18                     |
| 4                          | 4                            |
| IP 23                      | IP 23                        |
| S                          | S                            |
| 340 / 30 %                 | 420 / 50 %                   |
| 250                        | 400                          |
| 195                        | 315                          |
| 0,6 - 1,2                  | 0,6 - 1,6                    |
| 0,9 - 1,2                  | 0,9 - 1,6                    |
| 1,0 - 1,2                  | 1,0 - 1,6                    |

|                             |                                  |
|-----------------------------|----------------------------------|
| PSF™<br>305 / 4,5 m<br>Euro | PSF™<br>405 / 410w 4,5 m<br>Euro |
|-----------------------------|----------------------------------|

### Ordering information

|                              |              |
|------------------------------|--------------|
| Origo™ Mig C280 PRO 2WD V/A  | 0349 312 510 |
| Origo™ Mig C280 PRO 4WD V/A  | 0349 312 520 |
| Origo™ Mig C340 PRO 2WD V/A  | 0349 312 550 |
| Origo™ Mig C340 PRO 4WD V/A  | 0349 310 830 |
| Origo™ Mig C420w PRO 4WD V/A | 0349 312 590 |
| Origo™ Mig C420 PRO 4WD V/A  | 0349 312 580 |

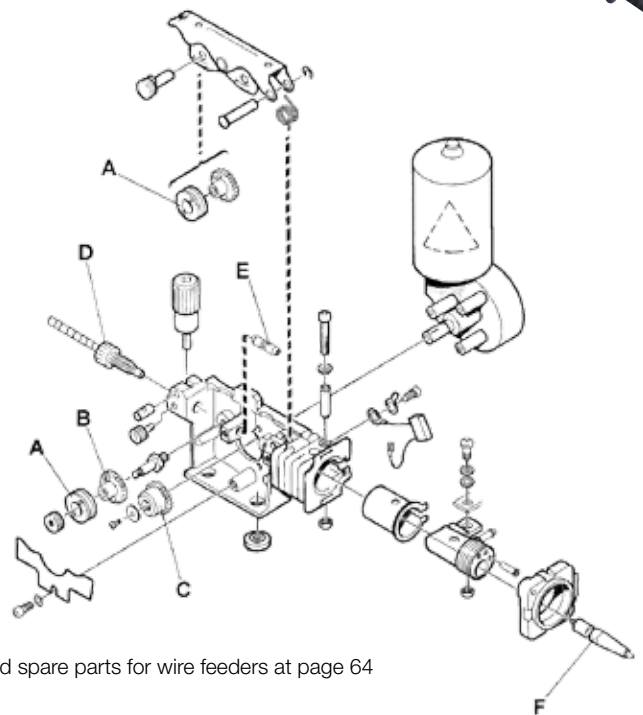
### Accessories

|  |              |
|--|--------------|
| Anti-dust filter C280-C340 (steel grid)  | 0349 302 599 |
| Anti-dust filter C420w (steel grid)      | 0349 302 252 |
| Transformer kit for preheater            | 0349 302 250 |
| Cable holder                             | 0349 303 362 |
| Water flow guard                         | 0349 302 251 |
| Pressure reducer with flux-meter         | 0760 030 300 |
| Connection kit MXH /Origo™ Mig C340 PRO  | 0349 308 980 |
| Connection kit MXH /Origo™ Mig C420w PRO | 0349 308 337 |

### Ordering information for special versions

|   |              |
|---|--------------|
| Multi-voltage types (230/415-500V, 50Hz, 230/440-460V, 60Hz, three-phase) |              |
| Origo™ Mig C280 PRO 2WD V/A   | 0349 312 530 |
| Origo™ Mig C280 PRO 4WD V/A   | 0349 312 540 |
| Origo™ Mig C340 PRO 2WD V/A   | 0349 312 560 |
| Origo™ Mig C340 PRO 4WD V/A   | 0349 312 570 |

Wear and spare parts for torches at page 60



Wear and spare parts for wire feeders at page 64

# ORIGO™ / ARISTO® MIG C3000i

## INVERTERS FOR FABRICATION AND INDUSTRY

- Inverters with first-class welding properties
- MMA welding with electrodes up to 6.0 mm diameter
- TrueArcVoltage™ guarantees the exact welding voltage
- Electronically-regulated motor for constant wire feed
- 4-roll wire feed mechanism
- Excellent GMA brazing of galvanized sheets
- Cooler optional, with ELP, ESAB LogicPump (forced switching over of the water cooling if required)
- Optionally with electric Push-Pull welding torch in 6 or in 10 m length
- Can be controlled remotely, digital display
- IP 23 - allows use outdoors



| Technical data        | Origo™ Mig C3000i |
|-----------------------|-------------------|
| Mains supply, V / ph  | 400 / 3           |
| Fuse, slow, A         | 16                |
| Setting range, A      | 16 - 300          |
| Current adjustment    | stepless          |
| Dimensions, LxWxH, mm | 652 x 412 x 423   |
| Weight, kg            | 40,5              |
| Spool type, Ømm/kg    | 300 / 18          |
| Feed rolls            | 4 rolls           |
| Enclosure class       | IP 23             |
| Application class     | S                 |

| Maximum output at 40°C |     |
|------------------------|-----|
| 35% duty cycle, A      | 300 |
| 60% duty cycle, A      | 240 |
| 100% duty cycle, A     | 200 |

| Usable wire diameters     |           |
|---------------------------|-----------|
| Mild and stainless steels | 0,6 - 1,2 |
| Cored wires               | 1,0 - 1,2 |
| Aluminium                 | 1,0 - 1,2 |

### Delivery includes

Mains cable 5m with plug, gas hose 2m with clamps and quick connector, earth cable complete, wear parts for 0,8-1,0mm wire.  
Origo™ Mig C3000i MA24 is supplied with PSF305 torch - 4,5m.

Remote controller  
at page 68





## CONTROL PANEL MA24

- Controller in the wire feed device for MIG/MAG and MMA electrode welding
- 35 preprogrammed synergic lines
- QSet™ Parameter automation
- 2 / 4 stroke torch switch actions
- Gas test and tension-free wire feed
- Gas pre- and post-flow can be set
- Creep start and end crater filling
- Continuous choke setting
- 3 memory slots, can be called up from the torch button
- Can be controlled remotely, digital display



## CONTROL PANEL U6

- MIG/MAG pulse-type welding
- QSet™ Parameter automation
- Preprogrammed synergic lines
- 2/4 -stroke torch controller
- End of weld crater filling
- Creep start, Hot Start and wire burn-back time that can be set
- Gas pre- and post-flow can be set
- Gas test and tension-free wire feed
- Professional MMA electrode welding
- 10 memory slots
- Multi-lingual menu guidance
- Limit value assignment, password protection

### Complete Package

Origo™ Mig C3000i MA24 + torch PSF™ 305 – 4,5 mt. .  
+ earth cable 4,5 mt. + two wheels trolley

**0459 795 887**

### Ordering information

|                                     |                     |
|-------------------------------------|---------------------|
| Origo™ Mig C3000i MA24 (with QSet™) | <b>0459 750 881</b> |
| Aristo® Mig C3000i U6               | <b>0459 750 882</b> |
| Two-wheels trolley                  | <b>0459 366 890</b> |
| Four-wheels trolley                 | <b>0460 060 880</b> |
| Cooling unit CoolMidi 1800          | <b>0459 840 880</b> |

### Welding torches

|                                 |                     |
|---------------------------------|---------------------|
| PSF™ 305, L=3,0m, self-cooled   | <b>0458 401 880</b> |
| PSF™ 305, L=4,5m, self-cooled   | <b>0458 401 881</b> |
| PSF™ 410w, L=3,0m, water cooled | <b>0458 400 882</b> |
| PSF™ 410w, L=4,5m, water cooled | <b>0458 400 883</b> |

Torches MXH™, electric Push-pull, page 59

### Accessories

|  |                     |
|--|---------------------|
| Connection kit for MXH™ torches, with remote control     | <b>0459 681 891</b> |
| Connection kit for MXH™ torches, with start-stop control | <b>0459 020 883</b> |
| Pressure reducer with flux-meter                         | <b>0760 030 300</b> |

Wear and spare parts for wire feeders at page 64



Origo™ Mig C3000i MA24  
Package, complete **0459 795 887**



# ORIGO™ MIG L305 AND L405

## RELIABLE AND SIMPLE TO USE MIG/MAG UNITS

- Low investment costs
- Robust, step-controlled MIG/MAG units
- 10 or 40 voltage steps
- Choice of 2- or 4-rolls wire feed mechanism
- Intermediate cables up to 10 m
- Galvanized sheet steel housing



### ORIGO™ FEED L302

- 2-roll feed
- Wire feed speed
- Wire burn-back time
- 2/4 cycle torch controller



### ORIGO™ FEED L304

- 4-roll wire feed
- Wire feed speed
- Wire burn-back time
- Spot-welding
- Creep start
- Voltage free inching of the wire
- Gas test
- 2/4 cycle torch controller



| Technical data                    | Origo™ Mig L305 | Origo™ Mig L405/L405w |
|-----------------------------------|-----------------|-----------------------|
| Mains supply, V / ph              | 400 / 3         |                       |
| Fuse, slow, A                     | 16              | 20                    |
| Setting range, A                  | 30 - 300        | 50 - 400              |
| Voltage steps                     | 10              | 40                    |
| Inductance outlets                | 2               |                       |
| Dimensions, LxWxH, mm             | 782 x 425 x 830 | 812 x 552 x 925       |
| Weight, kg (without cooling unit) | 89              | 142                   |
| Weight, kg (with cooling unit)    | -               | 156                   |
| Enclosure class                   | IP 23           |                       |
| Application class                 | S               |                       |

#### Maximum output at 40°C

|                                |          |          |
|--------------------------------|----------|----------|
| Max current, A at duty cycle % | 300 / 25 | 400 / 50 |
| 60% duty cycle, A              | 190      | 365      |
| 100% duty cycle, A             | 150      | 280      |

| Technical data                   | Origo™ Feed L302 | Origo™ Feed L304 |
|----------------------------------|------------------|------------------|
| Wire feed speed, m/min           | 1,5 - 22         |                  |
| Wire burn-back time, sec         | 0 - 0,7          |                  |
| Spot-welding time, sec           | -                | 0,2 - 5,0        |
| 2/4 cycle torch controller       | yes              |                  |
| Creep start                      | -                | yes              |
| No-current threading of the wire | -                | yes              |
| Gas test                         | -                | yes              |
| Dimensions, LxWxH, mm            | 569 x 259 x 355  |                  |
| Weight, kg                       | 12,6             | 13,2             |
| Spool type, Ø mm/kg              | 300 / 18         |                  |
| Feeding rolls                    | 2                | 4                |
| Enclosure class                  | IP 23            |                  |

#### Usable wire diameters, mm

|                           |           |           |
|---------------------------|-----------|-----------|
| Mild and stainless steels | 0,6 - 1,2 | 0,6 - 1,6 |
| Cored wires               | 0,8 - 1,2 | 0,8 - 1,6 |
| Aluminium                 | 1,0 - 1,2 | 1,0 - 1,6 |

## Ordering information

### Power sources

|                                |              |
|--------------------------------|--------------|
| Origo™ Mig L305                | 0349 309 700 |
| Origo™ Mig L405                | 0349 306 517 |
| Origo™ Mig L405w water cooling | 0349 306 563 |
| Origo™ Mig L405 V/A meter      | 0349 313 090 |

### Power source, multivoltage version

230/400-415/500V 50Hz: 2307440-460V 60Hz

|                 |              |
|-----------------|--------------|
| Origo Mig L405  | 0349 306 594 |
| Origo Mig L405w | 0349 306 595 |

### Wire feeders

|                         |              |
|-------------------------|--------------|
| Origo™ Feed L302, open  | 0459 495 782 |
| Origo™ Feed L304, open  | 0459 495 882 |
| Origo™ Feed L304w, open | 0459 495 892 |

### Connection cables

|                                      |              |
|--------------------------------------|--------------|
| Air/water connection cable - mt. 1,7 | 0459 532 880 |
| Connection cable, air - m. 5         | 0459 532 881 |
| Connection cable, air - m. 10        | 0459 532 882 |
| Connection cable, water - m. 5       | 0459 532 891 |
| Connection cable, water - m. 10      | 0459 532 892 |
| Connection cable, air - m. 15        | 0459 532 883 |
| Connection cable, water - m. 15      | 0459 532 893 |

### Welding torches

|                                    |              |
|------------------------------------|--------------|
| PSF™ 305, L = 3,0 m, self-cooled   | 0458 401 880 |
| PSF™ 305, L = 4,5 m, self-cooled   | 0458 401 881 |
| PSF™ 405, L = 3,0 m, self-cooled   | 0458 401 882 |
| PSF™ 405, L = 4,5 m, self-cooled   | 0458 401 883 |
| PSF™ 410w, L = 3,0 m, water cooled | 0458 400 882 |
| PSF™ 410w, L = 4,5 m, water cooled | 0458 400 883 |

## Accessories

|  |              |
|--|--------------|
| Digital instruments kit for Origo™ Mig L305                                      | 0349 302 598 |
| Digital instruments kit for Origo™ Mig L405                                      | 0349 302 451 |
| Transformer kit for CO2 preheater (42V – 50/60 Hz)                               | 0349 302 451 |
| Stabilizer (for counterbalance device - L305)                                    | 0349 302 451 |
| Stabilizer (for counterbalance device - L405)                                    | 0349 303 474 |
| Reinforcement for counterbalance device  | 0349 309 748 |
| Pressure reducer with flux-meter   | 0760 030 300 |
| Wheels kit for Origo™ Feed L302/304  | 0458 707 880 |
| Strain relief for welding torch  | 0457 341 881 |
| Lifting eye  | 0458 706 880 |
| Quick connector for MarathonPac  | F102 440 880 |
| Adapter for 5kg spool  | 0455 410 001 |
| Counterbalance device  | 0458 705 880 |
| Plastics spool cover   | 0458 674 880 |
| Turning piece  | 0458 703 880 |
| Complete hose kit, mt 1,7, to modify<br>0459 495 782/882 in water cooled version | 0459 564 880 |

## Suggested configurations

### Origo™ Mig L305 with Origo™ Feed L302

|                                      |              |
|--------------------------------------|--------------|
| Origo™ Mig L305                      | 0349 309 700 |
| Origo™ Feed L302, open               | 0459 495 782 |
| Air/water connection cable - mt. 1,7 | 0459 532 880 |
| PSF™ 305, L=3,0m, self-cooled        | 0458 401 880 |

### Origo™ Mig L405w with Origo™ Feed L304w water cooled

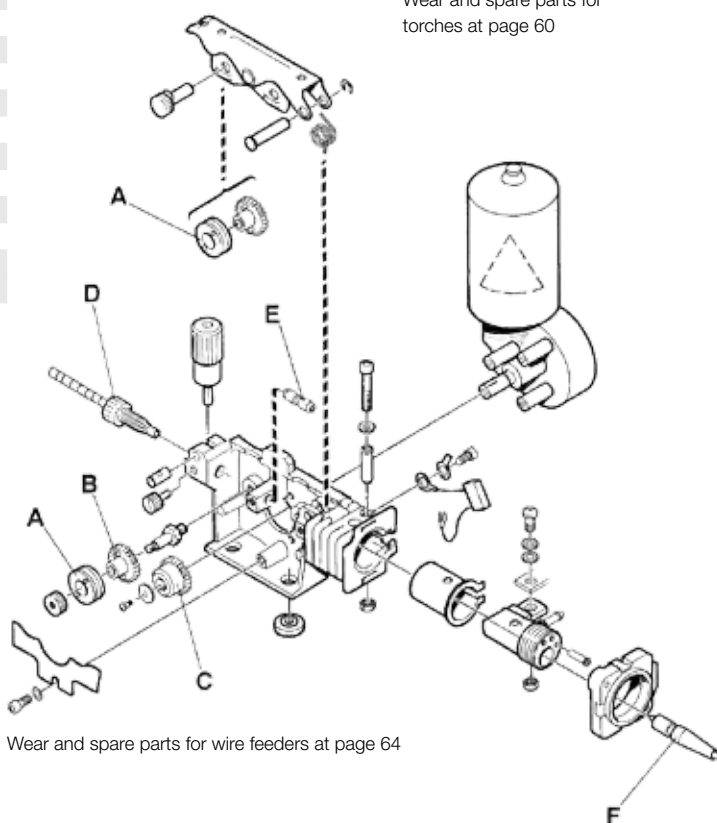
|                                     |              |
|-------------------------------------|--------------|
| Origo™ Mig L405w                    | 0349 306 563 |
| Origo™ Feed L304w, open             | 0459 495 892 |
| Air/water connection cable - m. 1,7 | 0459 532 880 |
| PSF™ 410w, L=3,0m, water cooled     | 0458 400 882 |

## Delivery includes

Trolley with gas bottle shelf and safety chain, wire feeder pivot, 5m mains cable and 5m earth cable



Wear and spare parts for torches at page 60



Wear and spare parts for wire feeders at page 64

# ORIGO™ MIG 320, 410 AND 510

## VERSATILE, SIMPLE AND POWERFUL

- Robust, step-controlled MIG/MAG units for the upper capacity range
- 40 voltage steps
- Intermediate cables up to 35 metres
- Electronically regulated motors for constant wire feed
- Choice of two 4-roll wire feed devices, up to 2.4 mm wire electrodes
- Cooler with ELP, ESAB LogicPump (forced switching over of the watercooling if required).
- Automatic standby mode to save energy
- Galvanized sheet steel housing
- Wire feed speed can be controlled remotely
- Comprehensive accessories
- IP 23 - allows use outdoors

## CONTROL PANEL M12



- Wire feed speed
- Creep start
- 2 / 4 stroke torch switchactions
- Wire burn-back time
- Wire feed speed can be controlled remotely
- Prepared for electric Push-Pull welding torches in 6 or 10 m
- Prepared for mechanisation, ESAB Miggytrac and Railtrac



| Technical data                    | Origo™ Mig      |                 |          |
|-----------------------------------|-----------------|-----------------|----------|
|                                   | 320             | 410/410w        | 510/510w |
| Mains supply, V / ph              | 400 / 3         |                 |          |
| Fuse, slow, A                     | 16              | 20              | 35       |
| Setting range, A                  | 40 - 320        | 50 - 400        | 50 - 500 |
| Voltage steps                     | 40              |                 |          |
| Inductance outlets                | 2               | 2               | 3        |
| Dimensions, LxWxH, mm             | 840 x 425 x 830 | 812 x 552 x 925 |          |
| Weight, kg (without cooling unit) | 111             | 144             | 214      |
| Weight, kg (with cooling unit)    | -               | 158             | 228      |
| Enclosure class                   | IP 23           |                 |          |
| Application class                 | S               |                 |          |

| Maximum output at 40°C |          |          |          |
|------------------------|----------|----------|----------|
| Max current, A         |          |          |          |
| at duty cycle %        | 320 / 30 | 400 / 50 | 500 / 60 |
| 60% duty cycle, A      | 250      | 365      | 500      |
| 100% duty cycle, A     | 195      | 280      | 390      |

| Technical data                   | Origo™ Feed     |           |
|----------------------------------|-----------------|-----------|
|                                  | 304 M12         | 484 M12   |
| Wire feed speed, m/min           | 1,9 - 25        | 1,9 - 25  |
| Wire burn-back time, sec         | 0 - 0,5         |           |
| 2/4 cycle torch controller       | yes             |           |
| Creep start                      | yes             |           |
| No-current threading of the wire | optional        |           |
| Gas test                         | optional        |           |
| Dimensions, LxWxH, mm            | 690 x 275 x 420 |           |
| Weight, kg                       | 15              | 19        |
| Spool type, Ø mm/kg              | 300 / 18        |           |
| Feeding rolls                    | 4 rollers       | 4 rollers |
| Enclosure class                  | IP23            |           |

| Usable wire diameters, mm |           |           |
|---------------------------|-----------|-----------|
| Mild and stainless steels | 0,6 - 1,6 | 0,6 - 2,4 |
| Cored wires               | 0,8 - 1,6 | 0,8 - 2,4 |
| Aluminium                 | 1,0 - 1,6 | 1,0 - 2,4 |

## Delivery includes

Trolley with gas bottle shelf and safety chain, wire feeder pivot, 5m mains cable and 5m earth cable.



## Complete Package

|  |                     |
|--|---------------------|
| <ul style="list-style-type: none"> <li>Origo™ Mig 410 with V/A + Origo™ Feed 304 M12</li> <li>+ PSF™ 405 – 4,5 mt. + earth cable 5 mt.</li> <li>+ connection cable 10 mt</li> </ul>    | <b>0479 100 210</b> |
| <ul style="list-style-type: none"> <li>Origo™ Mig 410w with V/A + Origo™ Feed 304w M12</li> <li>+ PSF™ 410w – 4,5 mt. + earth cable 5 mt.</li> <li>+ connection cable 10 mt</li> </ul> | <b>0479 100 211</b> |
| <ul style="list-style-type: none"> <li>Origo™ Mig 510w with V/A + Origo™ Feed 304w M12</li> <li>+ PSF™ 510w – 4,5 mt. + earth cable 5 mt.</li> <li>+ connection cable 10 mt</li> </ul> | <b>0479 100 212</b> |

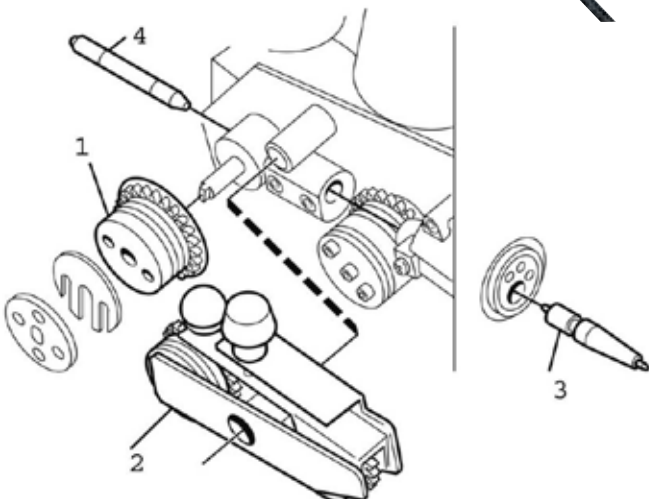
## Accessories

|   |                     |
|---|---------------------|
| Dust filter (steel grid) Origo™ Mig 320                   | <b>0349 302 599</b> |
| Dust filter (steel grid) Origo™ Mig 410-510               | <b>0349 302 423</b> |
| Cable holder  | <b>0349 303 362</b> |
| Digital instruments kit for Origo™ Mig 320                | <b>0349 302 598</b> |
| Digital instruments kit for Origo™ Mig 410                | <b>0349 302 451</b> |
| Digital instruments kit for Origo™ Mig 510                | <b>0349 302 424</b> |
| Transformer kit for CO2 preheater (42V – 50/60 Hz)        | <b>0349 302 250</b> |
| Stabilizer (for counterbalance device) Origo™ Mig 320     | <b>0349 303 475</b> |
| Stabilizer (for counterbalance device) Origo™ Mig 410-510 | <b>0349 303 474</b> |
| Reinforcement for counterbalance device                   | <b>0349 309 748</b> |
| Pressure reducer with flux-meter                          | <b>0760 030 300</b> |
| Water flow guard  | <b>0349 302 251</b> |
| Wheels kit for Origo™ Feed                                | <b>0458 707 880</b> |
| Strain relief for welding torch                           | <b>0457 341 881</b> |
| Lifting eye   | <b>0458 706 880</b> |
| Quick connector for MarathonPac                           | <b>F102 440 880</b> |
| Adapter for 5kg spool                                     | <b>0455 410 001</b> |
| Adapter for 440 mm spool                                  | <b>0459 233 880</b> |
| Support for double wire feeder                            | <b>0458 522 880</b> |
| Counterbalance device                                     | <b>0458 705 880</b> |
| Steel spool cover   | <b>0459 431 880</b> |
| Button for wire inching and gas test                      | <b>0459 465 880</b> |

Wear and spare parts for torches at page 60



Wear and spare parts for wire feeders at page 64



## Ordering information

### Power sources, with digital V/A instrument

|                               |                     |
|-------------------------------|---------------------|
| Origo™ Mig 320 MV V/A         | <b>0349 312 600</b> |
| Origo™ Mig 410                | <b>0349 303 563</b> |
| Origo™ Mig 510 HALLÅ          | <b>0349 303 565</b> |
| Origo™ Mig 410w water cooling | <b>0349 303 564</b> |
| Origo™ Mig 510w water cooling | <b>0349 303 566</b> |

### Power sources, multivoltage versions

(230 / 400-415 / 500 V 50 Hz; 230 / 440-460 V 60 Hz)

|                         |                     |
|-------------------------|---------------------|
| Origo™ Mig 320 MV V/A   | <b>0349 312 600</b> |
| Origo™ Mig 410 MV V/A   | <b>0349 312 610</b> |
| Origo™ Mig 410 w MV V/A | <b>0349 312 620</b> |

### Wire feeders

|                                    |                     |
|------------------------------------|---------------------|
| Origo™ Feed 304 M12                | <b>0459 116 882</b> |
| Origo™ Feed 304w M12 water cooling | <b>0459 116 892</b> |
| Origo™ Feed 484w M12 water cooling | <b>0459 116 992</b> |

### Connection cables

#### for Origo™ Mig 320, 410, self-cooling

|                            |                     |
|----------------------------|---------------------|
| Connection cable - mt. 1,7 | <b>0469 836 880</b> |
| Connection cable - mt. 5   | <b>0469 836 981</b> |
| Connection cable - mt. 10  | <b>0469 836 881</b> |
| Connection cable - mt. 15  | <b>0469 836 882</b> |
| Connection cable - mt. 25  | <b>0469 836 883</b> |
| Connection cable - mt. 35  | <b>0469 836 884</b> |

#### for Origo™ Mig 410w, water cooling

|                            |                     |
|----------------------------|---------------------|
| Connection cable - mt. 1,7 | <b>0469 836 885</b> |
| Connection cable - mt. 5   | <b>0469 836 983</b> |
| Connection cable - mt. 10  | <b>0469 836 886</b> |
| Connection cable - mt. 15  | <b>0469 836 887</b> |
| Connection cable - mt. 25  | <b>0469 836 888</b> |
| Connection cable - mt. 35  | <b>0469 836 889</b> |

#### for Origo™ Mig 510, self-cooling

|                            |                     |
|----------------------------|---------------------|
| Connection cable - mt. 1,7 | <b>0469 836 890</b> |
| Connection cable - mt. 5   | <b>0469 836 982</b> |
| Connection cable - mt. 10  | <b>0469 836 891</b> |
| Connection cable - mt. 15  | <b>0469 836 892</b> |
| Connection cable - mt. 25  | <b>0469 836 893</b> |
| Connection cable - mt. 35  | <b>0469 836 894</b> |

#### for Origo™ Mig 510w, water cooling

|                            |                     |
|----------------------------|---------------------|
| Connection cable - mt. 1,7 | <b>0469 836 895</b> |
| Connection cable - mt. 5   | <b>0469 836 984</b> |
| Connection cable - mt. 10  | <b>0469 836 896</b> |
| Connection cable - mt. 15  | <b>0469 836 897</b> |
| Connection cable - mt. 25  | <b>0469 836 898</b> |
| Connection cable - mt. 35  | <b>0469 836 899</b> |

### Welding torches

|                                    |                     |
|------------------------------------|---------------------|
| PSF™ 305, L = 3,0 m, self-cooled   | <b>0458 401 880</b> |
| PSF™ 305, L = 4,5 m, self-cooled   | <b>0458 401 881</b> |
| PSF™ 405, L = 3,0 m, self-cooled   | <b>0458 401 882</b> |
| PSF™ 405, L = 4,5 m, self-cooled   | <b>0458 401 883</b> |
| PSF™ 505, L = 3,0 m, self-cooled   | <b>0458 401 884</b> |
| PSF™ 505, L = 4,5 m, self-cooled   | <b>0458 401 885</b> |
| PSF™ 410w, L = 3,0 m, water cooled | <b>0458 400 882</b> |
| PSF™ 410w, L = 4,5 m, water cooled | <b>0458 400 883</b> |
| PSF™ 510w, L = 3,0 m, water cooled | <b>0458 400 884</b> |
| PSF™ 510w, L = 4,5 m, water cooled | <b>0458 400 885</b> |

# ORIGO™ MIG 402c, 502c AND 652c

## VERSATILE POWER SOURCES FOR HEAVY DUTY USE



- A power source for MIG/MAG, manual electric and gouging for the heavy duty capacity range
- Stepless voltage setting
- Intermediate cables up to 35 metres
- Electronically regulated motors for constant wire feed
- Choice of two 4-roll wire feed devices, up to 2.4 mm wire electrodes
- Cooler with ELP, ESAB LogicPump (forced switching over of the water cooling if required)
- Automatic standby mode to save energy
- Galvanized sheet steel housing
- Comprehensive accessories
- IP 23 - allows use outdoors



| Technical data                    | Origo™ Mig      |          |          |
|-----------------------------------|-----------------|----------|----------|
|                                   | 402c            | 502c     | 652c     |
| Mains supply, V / ph              | 400 / 3         |          |          |
| Fuse, slow, A                     | 25              | 35       | 50       |
| Setting range, A                  | 20 - 400        | 20 - 500 | 20 - 650 |
| Voltage adjustment                | stepless        |          |          |
| Inductance adjustment             | stepless        |          |          |
| v                                 | 830 x 640 x 835 |          |          |
| Weight, kg (without cooling unit) | 158             | 194      | 228      |
| Weight, kg (with cooling unit)    | 172             | 208      | 242      |
| Enclosure class                   | IP 23           |          |          |
| Application class                 | S               |          |          |

| Maximum output at 40°C |     |     |     |
|------------------------|-----|-----|-----|
| 60% duty cycle, A      | 400 | 500 | 650 |
| 100% duty cycle, A     | 310 | 400 | 500 |

| Technical data                    | Origo™          | Origo™       |
|-----------------------------------|-----------------|--------------|
|                                   | Feed 304 M13    | Feed 484 M13 |
| Wire feed speed, m/min            | 1,9 - 25        |              |
| Wire burn-back time, sec          | 0 - 0,5         |              |
| 2 / 4 stroke torch switch actions | yes             |              |
| Creep start                       | yes             |              |
| Voltage free wire inching         | optional        |              |
| Gas Test                          | optional        |              |
| Dimensions, LxWxH, mm             | 690 x 275 x 420 |              |
| Weight, kg                        | 15              | 19           |
| Spool type, Ø mm/kg               | 300 / 18        |              |
| Feeding rolls                     | 4               |              |
| Enclosure class                   | IP 23           |              |

| Usable wire diameters, mm |           |           |
|---------------------------|-----------|-----------|
| Mild and stainless steels | 0,6 - 1,6 | 0,6 - 2,4 |
| Cored wires               | 0,8 - 1,6 | 0,8 - 2,4 |
| Aluminium                 | 1,0 - 1,6 | 1,0 - 2,4 |



## CONTROL PANEL A13

- Controller in the current source for MMA electrode welding and gouging, regardless of the wire feed unit
- Can be controlled remotely from the current source
- Provided as standard with Origo™ Mig 502c/502cw/652c/652cw
- Optional with the Origo™ Mig 402c/402cw
- TIG welding with contact striking optional
- Hot Start and Arc Force



## CONTROL PANEL M13

- Controller in the wire feed device for MIG/MAG welding
- TrueArcVoltage™ guarantees an exact welding voltage
- 2 / 4 -stroke torch controller
- End crater filling, wire burn-back time
- Creep start
- Gas test and voltage free wire inch optional
- Cooler with ELP, ESAB LogicPump (forced switching over of the water cooling if required)

### Delivery includes:

Trolley with gas bottle shelf and safety chain, wire feeder pivot, 5m mains cable and 5m earth cable

Origo™ Feed 304: Consumables for 1.0 - 1.2 mm steel wire

Origo™ Feed 484: Consumables for 0.9 - 1.6 mm steel wire

### Complete Package

● Origo™ Mig 402cw + Origo™ Feed 304w M13 V/A  
+ PSF™ 410w – 4,5 mt. + earth cable 5 mt.  
+ connection cable 10 m

**0479 100 220**

● Origo™ Mig 502cw + Origo™ Feed 304w M13 V/A  
+ PSF™ 510w – 4,5 mt. + earth cable 5 mt.  
+ connection cable 10 m

**0479 100 221**



Remote controller, see page 68



Gouging torches, see ESAB Accessories catalogue




Welding mechanization with Miggytrac and Railtrac see page 85.





# ORIGO™ MIG 402c, 502c AND 652c

Gas=self-cooled, W=water cooled

| Origo™ Mig   |              | 402c |   | 502c |   | 652c |   |
|--|--------------|------|---|------|---|------|---|
|  |              | Gas  | W | Gas  | W | Gas  | W |
| <b>Power sources, multivoltage options</b>                   |              |      |   |      |   |      |   |
| <b>(230/400-415/500 V, 50Hz, 230/440-460 V, 60Hz3-phase)</b> |              |      |   |      |   |      |   |
| Origo™ Mig 402c  | 0349 311 220 | ●    |   | ●    |   | ●    |   |
| Origo™ Mig 402cw   | 0349 311 230 |      | ● |      | ● |      | ● |
| Origo™ Mig 502c  | 0349 311 240 | ●    |   | ●    |   | ●    |   |
| Origo™ Mig 502cw   | 0349 311 250 |      | ● |      | ● |      | ● |
| Origo™ Mig 652c  | 0349 311 260 | ●    |   | ●    |   | ●    |   |
| Origo™ Mig 652cw   | 0349 311 270 |      | ● |      | ● |      | ● |

| Wire feeders,<br>with V/A instruments  | Mig          | 402c |   | 502c |   | 652c |   |
|--|--------------|------|---|------|---|------|---|
|  |              | Gas  | W | Gas  | W | Gas  | W |
| Origo™ Feed 304 M13  | 0459 116 864 | ●    |   | ●    |   | ●    |   |
| Origo™ Feed 304w M13   | 0459 116 874 |      | ● |      | ● |      | ● |
| Origo™ Feed 484w M13  | 0459 116 974 |      | ● |      | ● |      | ● |

| Welding torches   | Mig          | 402c |   | 502c |   | 652c |   |
|---|--------------|------|---|------|---|------|---|
|   |              | Gas  | W | Gas  | W | Gas  | W |
| PSF™ 405, L=3,0m, self cooled   | 0458 401 882 | ●    |   |      |   |      |   |
| PSF™ 405, L=4,5m, self cooled   | 0458 401 883 | ●    |   |      |   |      |   |
| PSF™ 410w, L=3,0m, water cooled   | 0458 400 882 |      | ● |      |   |      |   |
| PSF™ 410w, L=4,5m, water cooled    | 0458 400 883 |      | ● |      |   |      |   |
| PSF™ 505, L=3,0m, self cooled   | 0458 401 884 |      |   | ●    |   | ●    |   |
| PSF™ 505, L=4,5m, self cooled   | 0458 401 885 |      |   | ●    |   | ●    |   |
| PSF™ 510w, L=3,0m, water cooled   | 0458 400 884 |      |   |      | ● |      | ● |
| PSF™ 510w, L=4,5m, water cooled  | 0458 400 885 |      |   |      | ● |      | ● |

Push-pull torches MXH™ at page 59

| Origo™ Mig                 |              | 402c |   | 502c |   | 652c |   |
|----------------------------|--------------|------|---|------|---|------|---|
|                            |              | Gas  | W | Gas  | W | Gas  | W |
| Connection cables          |              |      |   |      |   |      |   |
| Connection cable - mt. 1,7 | 0459 836 880 | ●    |   |      |   |      |   |
| Connection cable - mt. 5   | 0459 836 881 | ●    |   |      |   |      |   |
| Connection cable - mt. 10  | 0459 836 882 | ●    |   |      |   |      |   |
| Connection cable - mt. 15  | 0459 836 883 | ●    |   |      |   |      |   |
| Connection cable - mt. 25  | 0459 836 884 | ●    |   |      |   |      |   |
| Connection cable - mt. 35  | 0459 836 885 | ●    |   |      |   |      |   |
| Connection cable - mt. 1,7 | 0459 836 890 |      | ● |      |   |      |   |
| Connection cable - mt. 5   | 0459 836 891 |      | ● |      |   |      |   |
| Connection cable - mt. 10  | 0459 836 892 |      | ● |      |   |      |   |
| Connection cable - mt. 15  | 0459 836 893 |      | ● |      |   |      |   |
| Connection cable - mt. 25  | 0459 836 894 |      | ● |      |   |      |   |
| Connection cable - mt. 35  | 0459 836 895 |      | ● |      |   |      |   |
| Connection cable - mt. 1,7 | 0459 836 980 |      |   | ●    |   | ●    |   |
| Connection cable - mt. 5   | 0459 836 981 |      |   | ●    |   | ●    |   |
| Connection cable - mt. 10  | 0459 836 982 |      |   | ●    |   | ●    |   |
| Connection cable - mt. 15  | 0459 836 983 |      |   | ●    |   | ●    |   |
| Connection cable - mt. 25  | 0459 836 984 |      |   | ●    |   | ●    |   |
| Connection cable - mt. 35  | 0459 836 985 |      |   | ●    |   | ●    |   |
| Connection cable - mt. 1,7 | 0459 836 990 |      |   |      | ● |      | ● |
| Connection cable - mt. 5   | 0459 836 991 |      |   |      | ● |      | ● |
| Connection cable - mt. 10  | 0459 836 992 |      |   |      | ● |      | ● |
| Connection cable - mt. 15  | 0459 836 993 |      |   |      | ● |      | ● |
| Connection cable - mt. 25  | 0459 836 994 |      |   |      | ● |      | ● |
| Connection cable - mt. 35  | 0459 836 995 |      |   |      | ● |      | ● |

| Accessories  | Mig          | 402c |   | 502c |   | 652c |   |
|--|--------------|------|---|------|---|------|---|
|  |              | Gas  | W | Gas  | W | Gas  | W |
| <b>Cables support:</b>   |              |      |   |      |   |      |   |
| for power sources  | 0349 311 700 | ●    | ● | ●    | ● | ●    | ● |
| for wire feeders   | 0459 234 880 | ●    | ● | ●    | ● | ●    | ● |
| Pressure reducer with flux-meter                               | 0760 030 300 | ●    | ● | ●    | ● | ●    | ● |
| Dust filter  | 0349 302 252 | ●    | ● | ●    | ● | ●    | ● |
| Steel spool cover  | 0459 431 880 | ●    | ● | ●    | ● | ●    | ● |
| Wheels kit for Origo™ Feed                                     | 0458 707 880 | ●    | ● | ●    | ● | ●    | ● |
| Strain relief for welding torch                                | 0457 341 881 | ●    | ● | ●    | ● | ●    | ● |
| Lifting eye  | 0458 706 880 | ●    | ● | ●    | ● | ●    | ● |
| Adapter for 5kg spool  | 0455 410 001 | ●    | ● | ●    | ● | ●    | ● |
| Plastic spools adapter   | 0000 701 981 | ●    | ● | ●    | ● | ●    | ● |
| V/A Digital instruments kit                                    | 0455 173 882 | ●    | ● | ●    | ● | ●    | ● |
| Kit panel A13 with V/A for Mig 402c/402cw                      | 0349 310 396 | ●    | ● |      |   |      |   |
| Transformer kit for CO <sub>2</sub> preheater (42V – 50/60 Hz) | 0349 302 250 | ●    | ● | ●    | ● | ●    | ● |
| Cable holder   | 0349 303 362 | ●    | ● | ●    | ● | ●    | ● |
| Water flow guard   | 0349 302 251 | ●    | ● | ●    | ● | ●    | ● |
| ESAB Coolant 10l   | 0460 720 002 | ●    | ● | ●    | ● | ●    | ● |
| Quick connector for MarathonPac™                               | F102 440 880 | ●    | ● | ●    | ● | ●    | ● |
| Button for wire inching and gas test                           | 0459 465 880 | ●    | ● | ●    | ● | ●    | ● |

# WARRIOR™ 400i AND 500i CC/CV

THE RELIABLE MULTI-PROCESS WELDING EQUIPMENT DESIGNED FOR HEAVY DUTY PRODUCTIVITY



Warrior™ YardFeed 200

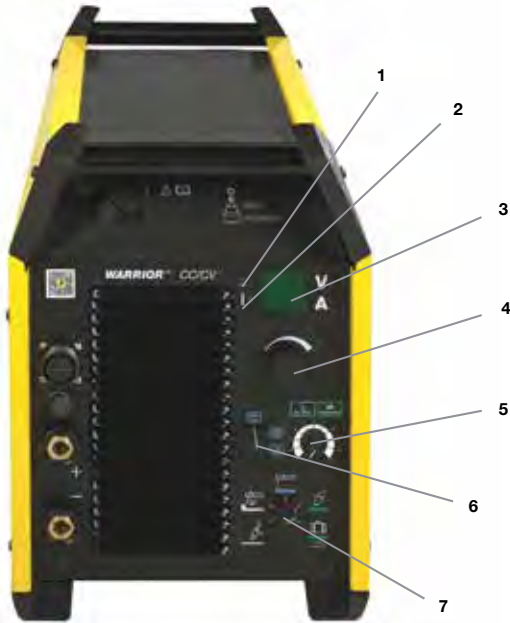
- Multi-Process: including MIG, Flux-Cored, Stick, Live TIG and Arc Gouging
- High Duty cycle for long runs and various applications giving high productivity
- IP23 rating for outdoor and indoor use in rough environment
- Simple and clear user interface
- Robust and ergonomic handles also for mechanical lifting
- Easy to read sun friendly display
- Inverter technology - Smaller, lighter and less energy cost
- Generator compatible for flexible use in different job sites
- Automatic Hot Start/Variable Arc Control
- Wide input voltage range to support regional requirements



| Technical data*                              | Warrior™        |            |
|--|-----------------|------------|
|  | 400i CC/CV      | 500i CC/CV |
| Mains Supply, 3 ph 50/60HZ, V                | 380-415, +/-10% |            |
| Mains cable, Ø mm <sup>2</sup>               | 4 x 6           |            |
| Fuse, slow A                                 | 25              | 32         |
| Setting range A                              |                 |            |
| MIG/MAG, MMA                                 | 16-400          | 16-500     |
| TIG  | 5-400           | 5-500      |
| Open circuit voltage, V                      | 54              |            |
| Idle Power, W                                | 120             |            |
| Efficiency at max. current %                 | 88              |            |
| Power factor at max current                  | 0.91            |            |
| Enclosure class                              | IP23            |            |
| Dimensions, LxWxH, mm (without cooling unit) | 712x325x470     |            |
| Dimensions, LxWxH, mm (with cooling unit)    | 712x325x700     |            |
| Weight, kg (without cooling unit)            | 59              |            |
| Weight, kg (with cooling unit)               | 74              |            |
| Operating Temperature, °C                    | -10 - +40       |            |
| Application class                            | S               |            |
| <b>Maximum output at 40°C</b>                |                 |            |
| 60% duty cycle, A/V, 3ph                     | 400/36          | 500/40     |
| 100% duty cycle, A/V, 3ph                    | 300/32          | 400/36     |

\*Technical data are subject to change.





## CONTROL PANEL 400i / 500i CC/CV

1. Indicator lamp, yellow, overheating
2. Indicator lamp, green, VRD function (reduced open circuit voltage)
3. Display, current (A) and voltage (V)
4. Knob for setting:  
MIG/MAG air gouging: Current (A)  
Mobile Feed mode: Voltage (V)
5. Knob for choice of electrode type
6. Knob for inductance (MIG/MAG) and arc force (MMA)
7. Knob for welding method



Welding mechanization with Miggytrac and Railtrac, see page 85.



Remote controller, see page 68



Gouging torches, see ESAB Accessories catalogue

### Delivery includes:

3m mains cable and 5m return cable incl. earth clamp.

### Complete Package

- Warrior™ 400i + Warrior™ Feed 304 + 4 wheels trolley + PSF™ 405 - 4.5mt + connection cable 1.7mt **0479 000 102**
- Warrior™ 400i + Warrior™ Feed 304 + 4 wheels trolley + PSF™ 405 - 4.5mt + connection cable 10mt **0479 000 103**
- Warrior™ 400iw + Warrior™ Feed 304w + 4 wheels trolley + COOL 2 + PSF™ 410w - 4.5mt + connection cable 1.7mt **0479 000 104**
- Warrior™ 400iw + Warrior™ Feed 304w + 4 wheels trolley + COOL 2 + PSF™ 410w - 4.5mt + connection cable 10mt **0479 000 105**
- Warrior™ 500iw + Warrior™ Feed 304w + 4 wheels trolley + COOL 2 + PSF™ 510w - 4.5mt + connection cable 1.7mt **0479 000 108**
- Warrior™ 500iw + Warrior™ Feed 304w + 4 wheels trolley + COOL 2 + PSF™ 510w - 4.5mt + connection cable 10mt **0479 000 109**

| Technical data*         | Warrior™<br>Feed 304 | Warrior™<br>YardFeed 200 |
|-------------------------|----------------------|--------------------------|
| Power suppl, VAC        | 42                   | 42                       |
| Wire spool capacity, kg | 18                   | 5                        |
| Max. spool diameter, mm | 300                  | 200                      |
| Wire feed speed, m/min  | 0.8-25.0             | 1.9-25.0                 |
| Dimensions, LxWxH, mm   | 675x264x418*         | 593x219x213              |
| Weight, kg              | 14.5                 | 12                       |
| Temp. working range     | -10/+40 C            | -10/+40 C                |
| Enclosure class         | IP23                 | IP23                     |

\* Incl. spool cover

### Usable wire diameters, mm

|                 |           |           |
|-----------------|-----------|-----------|
| Mild steel      | 0,6 - 1,6 | 0,6 - 1,2 |
| Stainless steel | 0,6 - 1,6 | 0,6 - 1,2 |
| Aluminium       | 0,8 - 1,6 | 1,0 - 1,2 |
| Cored wires     | 0,9 - 1,6 | 0,8 - 1,6 |

# WARRIOR™ 400i AND 500i CC/CV

| Warrior™                                 |      | 400i CC/CV   |   | 500i CC/CV |    |
|--|------|--------------|---|------------|----|
|  |      | Gas          | W | Gas        | Wr |
| <b>Power sources</b>                     |      |              |   |            |    |
| Warrior™ 400i CC/CV                      | ●●●● | 0465 350 884 | ● | ●          |    |
| Warrior™ 500i CC/CV                      | ●●   | 0465 350 883 |   | ●          |    |
| COOL 2, water cooler                     | ●●●● | 0465 427 880 |   | ●          | ●  |
| <b>Wire feeders with V/A instruments</b> |      | 400i CC/CV   |   | 500i CC/CV |    |
|  |      | Gas          | W | Gas        | W  |
| Warrior™ Feed 304                        | ●●   | 0465 250 880 | ● | ●          |    |
| Warrior™ Feed 304w                       | ●●●● | 0465 250 881 |   | ●          | ●  |
| MobileFeed 301 AVS                       |      | 0558 102 207 | ● | ●          |    |
| Warrior™ YardFeed 200                    |      | 0459 906 900 | ● | ●          |    |
| Warrior™ YardFeed 200w                   |      | 0459 906 901 |   | ●          | ●  |
| <b>Welding torches</b>                   |      | 400i CC/CV   |   | 500i CC/CV |    |
|  |      | Gas          | W | Gas        | W  |
| PSF™ 405, L=3,0m self-cooled             |      | 0458 401 882 | ● |            |    |
| PSF™ 405, L=4,5m self-cooled             | ●●   | 0458 401 883 | ● |            |    |
| PSF™ 410w, L=3,0m water-cooled           |      | 0458 400 882 |   | ●          |    |
| PSF™ 410w, L=4,5m water-cooled           | ●●   | 0458 400 883 |   | ●          |    |
| PSF™ 505, L=3,0m self-cooled             |      | 0458 401 884 |   | ●          |    |
| PSF™ 505, L=4,5m self-cooled             |      | 0458 401 885 |   | ●          |    |
| PSF™ 510w, L=3,0m water-cooled           |      | 0458 400 884 |   |            | ●  |
| PSF™ 510w, L=4,5m water-cooled           | ●●   | 0458 400 885 |   |            | ●  |

Push-Pull torches MXH™ at page 59

| Connection cables          |   | 400i CC/CV   |   | 500i CC/CV |   |
|----------------------------|---|--------------|---|------------|---|
|                            |   | Gas          | W | Gas        | W |
| Connection cable - mt. 1,7 | ● | 0459 836 880 | ● |            |   |
| Connection cable - mt. 5   |   | 0459 836 881 | ● |            |   |
| Connection cable - mt. 10  | ● | 0459 836 882 | ● |            |   |
| Connection cable - mt. 15  |   | 0459 836 883 | ● |            |   |
| Connection cable - mt. 25  |   | 0459 836 884 | ● |            |   |
| Connection cable - mt. 35  |   | 0459 836 885 | ● |            |   |
| Connection cable - mt. 1,7 | ● | 0459 836 890 |   | ●          |   |
| Connection cable - mt. 5   |   | 0459 836 891 |   | ●          |   |
| Connection cable - mt. 10  | ● | 0459 836 892 |   | ●          |   |
| Connection cable - mt. 15  |   | 0459 836 893 |   | ●          |   |
| Connection cable - mt. 25  |   | 0459 836 894 |   | ●          |   |
| Connection cable - mt. 35  |   | 0459 836 895 |   | ●          |   |
| Connection cable - mt. 1,7 |   | 0459 836 980 |   | ●          |   |
| Connection cable - mt. 5   |   | 0459 836 981 |   | ●          |   |
| Connection cable - mt. 10  |   | 0459 836 982 |   | ●          |   |
| Connection cable - mt. 15  |   | 0459 836 983 |   | ●          |   |
| Connection cable - mt. 25  |   | 0459 836 984 |   | ●          |   |
| Connection cable - mt. 35  |   | 0459 836 985 |   | ●          |   |
| Connection cable - mt. 1,7 | ● | 0459 836 990 |   |            | ● |
| Connection cable - mt. 5   |   | 0459 836 991 |   |            | ● |
| Connection cable - mt. 10  |   | 0459 836 992 |   |            | ● |
| Connection cable - mt. 15  |   | 0459 836 993 |   |            | ● |
| Connection cable - mt. 25  |   | 0459 836 994 |   |            | ● |
| Connection cable - mt. 35  |   | 0459 836 995 |   |            | ● |


●●● Package - see previous page

# Warrior™

## 400i CC/CV

## 500i CC/CV

### Accessories

|  |              | Gas | W | Gas | W |
|--|--------------|-----|---|-----|---|
| 4 wheels trolley  | 0465 510 880 | ●   | ● | ●   | ● |
| Wheel kit Warrior™   | 0465 416 880 | ●   | ● | ●   | ● |
| Wheel kit I Warrior™ Feed  | 0458 707 880 | ●   | ● | ●   | ● |
| Wheel kit II Warrior™ Feed   | 0458 707 881 | ●   | ● | ●   | ● |
| Lifting eye Warrior™ Feed  | 0458 706 880 | ●   | ● | ●   | ● |
| Strain relief torch Warrior™ Feed  | 0457 341 881 | ●   | ● | ●   | ● |
| Strain relief bracket Warrior™ Feed  | 0459 234 880 | ●   | ● | ●   | ● |
| Quick connector MPac Warrior™ Feed   | F102 440 880 | ●   | ● | ●   | ● |
| Remote connection kit Warrior™ Feed  | 0465 451 880 | ●   | ● | ●   | ● |
| Counter balance device   | 0458 705 880 | ●   | ● | ●   | ● |
| Cooling liquid (10l)   | 0007 810 012 |     | ● |     | ● |



# ORIGO™ MIG 4004i AND 5004i

## VERSATILE WELDING INVERTERS FOR COMMERCE AND INDUSTRY

Origo™ Mig 4004i and 5004i provide high duty cycles for those maximum performance heavy duty applications. These third generation inverters offer considerable improved power efficiency and a close to unity Power Factor. This minimizes your energy consumption and will offer significant reductions in your energy costs with the same welding conditions.

Origo™ Mig 4004i & 5004i offer you undreamt of versatility with their wide range of control panels.

For your MIG/MAG and MMA applications select from the MA23 or MA24 control panels. The MA23 control panel includes all basic functions required for high productivity welding as well as parameter memory functions. The MA24 control panel has the added functionality of 35 pre-programmed synergic lines and is equipped with ESAB's patented QSet™ intelligent technology for improved productivity and quality.

By selecting Origo™ Mig 4004i A44, you can use it without a wire feed unit for high quality professional MMA welding and for TIG welding with the new LiveTig™ ignition.



Origo™ Mig 4004i A44  
Origo™ Feed 3004 MA24

Origo™ Mig 5004iw  
Origo™ Feed 3004w MA24

- Superlative welding properties - High utility and high quality through TrueArcVoltage™
- Professional MMA electrode welding with ArcPlus™ II controller
- Automatic standby mode to save energy
- ELP - ESAB LogicPump, starts the water pump automatically
- Type of insulation IP 23 - for work outdoors
- Can be controlled remotely, digital display
- Optionally with electric Push-Pull welding torch in 6 and 10 m
- Can be used with mechanisation, ESAB Miggytrac and Railtrac
- These 3rd generation inverters offer considerable improved efficiency and power factor is approximately 1.



| Technical data                          | Origo™ Mig 4004i | Origo™ Mig 5004i |
|---|------------------|------------------|
| Mains supply, V / ph                    | 380 - 440 / 3    |                  |
| Fuse, slow, A                           | 25               | 35               |
| Setting range (MIG/MAG), A              | 16 - 400         | 16 - 500         |
| Open circuit voltage, V                 | 55               |                  |
| Idle power, W                           | 40               |                  |
| Power factor (MIG)                      | 0,93             | 0,95             |
| Efficiency at max power (MIG), %        | 89               |                  |
| Dimensions, LxWxH, mm                   | 610 x 250 x 445  |                  |
| Dim. (with cooling unit), mm            | 610 x 250 x 675  |                  |
| Weight, kg (without cooling unit)       | 46               |                  |
| Weight, kg (with cooling unit)          | 62,5             |                  |
| Cooling power, W (l/min)                | 1300 (2,0)       |                  |
| Enclosure class                         | IP 23            |                  |
| Application class                       | S                |                  |
| <b>Maximum output (MIG/MAG) at 40°C</b> |                  |                  |
| 60% duty cycle, A/V                     | -                | 500 / 40         |
| 80% duty cycle, A/V                     | 400 / 36         | 400 / 36         |
| 100% duty cycle, A/V                    | 350 / 32         | 350 / 32         |

Note: 4004i with A44 panel = 400A @ 60% and 300A @ 100%



## CONTROL PANEL MA23

- Controller in the wire feed device for MIG/MAG and MMA welding
- 2 / 4 stroke torch switch actions
- Gas test and tension-free wire feed
- Gas pre- and post-flow can be set
- Continuous choke setting
- 3 memory slots, called up from the torch button
- Can be controlled remotely, digital display



## CONTROL PANEL MA24

- Controller in the wire feed device for MIG/MAG and MMA welding
- 35 preprogrammed synergic lines
- QSet™ Parameter automation
- 2 / 4 stroke torch switch actions
- Gas test and tension-free wire feed
- Gas pre- and post-flow can be set
- Creep start and end crater filling
- Continuous choke setting
- 3 memory slots, can be called up from the torch button
- Can be controlled remotely, digital display

## Delivery includes

5m mains cable with CEE plug and 4,5m earth cable.

## Suggested configurations

### Origo™Mig 4004i with Origo™Feed 3004w MA24, water cooling

|                                 |              |
|---------------------------------|--------------|
| Origo™Mig 4004i                 | 0465 154 880 |
| Water Cooler, COOL1             | 0462 300 880 |
| Origo™Feed 3004w, MA24          | 0460 526 899 |
| Connection cable – mt. 1.7      | 0459 528 790 |
| PSF™410w, L=3.0 m, water cooled | 0458 400 882 |
| 4 wheels trolley                | 0462 151 880 |

### Origo™Mig 5004i with Origo™Feed 4804w MA24, water cooling

|                                 |              |
|---------------------------------|--------------|
| Origo™Mig 5004i                 | 0465 155 880 |
| Water Cooler, COOL1             | 0462 300 880 |
| Origo™Feed 4804w, MA24          | 0460 526 999 |
| Connection cable – mt. 1.7      | 0459 528 990 |
| PSF™510w, L=3.0 m, water cooled | 0458 400 884 |
| 4 wheels trolley                | 0462 151 880 |




## CONTROL PANEL A44

- Controller in the current source for MMA electrode welding regardless of the wire feed device (optional)
- MMA electrode welding with ArcPlus™ II
- Selection of electrode type, basic - rutile - cellulose
- MMA welding and TIG with LiveTig™ striking
- Hot Start and Arc Force can be set
- Stepless inductance setting
- Voltage Reduction Device
- Carbon arc gouging
- Two memories
- Drop welding and setting of TIG minimum current through a background menu
- Optional MIG/MAG welding with MobileFeed 301 AVS


# ORIGO™ MIG 4004i AND 5004i

Gas=self-cooled, W=water cooled, A24/A44=control with two controllers

| Origo™ Mig           |              | 4004i |       |   |       | 5004i |   |
|----------------------|--------------|-------|-------|---|-------|-------|---|
|                      |              | Gas   | G A44 | W | W A44 | Gas   | W |
| Origo™ Mig 4004i     | 0465 154 880 | ●     |       | ● |       |       |   |
| Origo™ Mig 5004i     | 0465 155 880 |       |       |   |       |       | ● |
| Origo™ Mig 4004i A44 | 0465 152 880 |       | ●     |   | ●     | ●     |   |
| COOL1 cooling unit   | 0462 300 880 |       |       | ● | ●     |       | ● |

| Origo™ Mig  |              | 4004i |       |   |       | 5004i |   |
|---|--------------|-------|-------|---|-------|-------|---|
|   |              | Gas   | G A44 | W | W A44 | Gas   | W |
| Origo™ Feed 3004 MA23   | 0460 526 887 | ●     | ●     |   |       | ●     |   |
| Origo™ Feed 3004w MA23  | 0460 526 897 | ●     | ●     | ● | ●     |       | ● |
| Origo™ Feed 3004 MA24  | 0460 526 889 | ●     | ●     |   |       | ●     |   |
| Origo™ Feed 3004w MA24  | 0460 526 899 |       |       | ● | ●     |       | ● |
| Origo™ Feed 4804w MA23  | 0460 526 997 |       |       | ● | ●     |       | ● |
| Origo™ Feed 4804w MA24  | 0460 526 999 |       |       | ● | ●     |       | ● |

| Origo™ Mig                                      |              | 4004i |       |   |       | 5004i |   |
|---|--------------|-------|-------|---|-------|-------|---|
|   |              | Gas   | G A44 | W | W A44 | Gas   | W |
| Connection cable - mt. 1.7                      | 0459 528 790 |       |       | ● | ●     |       | ● |
| Connection cable - mt. 1.7 (95mm <sup>2</sup> ) | 0459 528 990 |       |       |   |       |       | ● |
| Connection cable - mt. 5                        | 0459 528 791 |       |       | ● | ●     |       | ● |
| Connection cable - mt. 10                       | 0459 528 792 |       |       | ● | ●     |       | ● |
| Connection cable - mt. 15                       | 0459 528 793 |       |       | ● | ●     |       | ● |
| Connection cable - mt. 25                       | 0459 528 794 |       |       | ● | ●     |       | ● |
| Connection cable - mt. 35                       | 0459 528 795 |       |       |   |       |       | ● |
| Cables support for length over 5m               | 0459 234 880 | ●     | ●     | ● | ●     |       | ● |

| Origo™ Mig   |              | 4004i              |       |   |       | 5004i              |   |
|--|--------------|--------------------|-------|---|-------|--------------------|---|
|  |              | 70 mm <sup>2</sup> |       |   |       | 95 mm <sup>2</sup> |   |
| Connection cable   |              | Gas                | G A44 | W | W A44 | Gas                | W |
| Air Cooled   |              |                    |       |   |       |                    |   |
| Connection cable - mt. 1.7  | 0459 528 780 | ●                  | ●     |   |       | ●                  |   |
| Connection cable - mt. 1.7(95mm <sup>2</sup> )   | 0459 528 980 | ●                  | ●     |   |       | ●                  |   |
| Connection cable - mt. 5   | 0459 528 781 | ●                  | ●     |   |       | ●                  |   |
| Connection cable - mt. 10  | 0459 528 782 | ●                  | ●     |   |       | ●                  |   |
| Connection cable - mt. 15  | 0459 528 783 | ●                  | ●     |   |       | ●                  |   |
| Connection cable - mt. 25  | 0459 528 784 | ●                  | ●     |   |       | ●                  |   |
| Connection cable - mt. 35  | 0459 528 785 | ●                  | ●     |   |       | ●                  |   |

 Package -see previous page



| Origo™ Mig                      |              | 4004i |       |   |       | 5004i |   |
|---------------------------------|--------------|-------|-------|---|-------|-------|---|
|                                 |              | Gas   | G A44 | W | W A44 | Gas   | W |
| Welding Pistols                 |              |       |       |   |       |       |   |
| PSF™ 405, L=3,0m, self-cooled   | 0458 401 882 | ●     | ●     |   |       |       |   |
| PSF™ 405, L=4,5m, self-cooled   | 0458 401 883 | ●     | ●     |   |       |       |   |
| PSF™ 410w, L=3,0m, water-cooled | 0458 400 882 |       | ●     | ● |       |       |   |
| PSF™ 410w, L=4,5m, water-cooled | 0458 400 883 |       | ●     | ● |       |       |   |
| PSF™ 505, L=3,0m, self-cooled   | 0458 401 884 |       |       |   |       | ●     |   |
| PSF™ 505, L=4,5m, self-cooled   | 0458 401 885 |       |       |   |       | ●     |   |
| PSF™ 510w, L=3,0m, water-cooled | 0458 400 884 |       |       |   |       |       | ● |
| PSF™ 510w, L=4,5m, water-cooled | 0458 400 885 |       |       |   |       |       | ● |

| Origo™ Mig  |              | 4004i |       |   |       | 5004i |   |
|---|--------------|-------|-------|---|-------|-------|---|
|   |              | Gas   | G A44 | W | W A44 | Gas   | W |
| Accessories   |              |       |       |   |       |       |   |
| 4 wheels trolley  | 0462 151 880 | ●     | ●     | ● | ●     | ●     | ● |
| 4 wheels trolley<br>(for counterbalance device)                           | 0460 565 880 | ●     | ●     | ● | ●     | ●     | ● |
| Wheels kit for Origo™ Feed  | 0458 707 880 | ●     | ●     | ● | ●     | ●     | ● |
| Water flow guard for COOL1  | 0456 855 881 |       |       | ● | ●     |       | ● |
| Strain relief for welding torch   | 0457 341 881 | ●     | ●     | ● | ●     | ●     | ● |
| Lifting eye for Origo™ Feed   | 0458 706 880 | ●     | ●     | ● | ●     | ●     | ● |
| Adapter for 5Kg spool   | 0455 410 001 | ●     | ●     | ● | ●     | ●     | ● |
| Connection kit for mechanization<br>with Miggytrac-Railtrac               | 0459 681 880 | ●     | ●     | ● | ●     | ●     | ● |
| Connection kit for electric Push-pull<br>torches, start/stop function     | 0459 020 883 | ●     | ●     | ● | ●     | ●     | ● |
| Connection kit for electric Push-pull<br>torches, with wire speed control | 0459 681 881 | ●     | ●     | ● | ●     | ●     | ● |
| Mounting accessories  |              |       |       |   |       |       |   |
| Counterbalance device   | 0458 705 880 | ●     | ●     | ● | ●     | ●     | ● |
| Kit to assembly 4004i/5004i to trolley 0460 565 880                       | 0461 310 880 | ●     | ●     | ● | ●     | ●     | ● |
| Stabilizer (for counterbalance device)                                    | 0460 946 880 | ●     | ●     | ● | ●     | ●     | ● |
| Trolley bracket (when used without COOL1)                                 | 0463 125 880 | ●     | ●     |   |       | ●     |   |

# ORIGO™ / ARISTO® MIG 4002c, 5002c, 6502c



## MAXIMUM PERFORMANCE FOR HEAVY DUTY APPLICATIONS

Mig 4002c, 5002c and 6502c are workhorses for MIG/MAG and MMA electrode welding. Robust, continuously variable rectifiers with digital control, ESAB TrueArcVoltage™ technology and a fantastic price/performance ratio. Four different operating panels are available for the wire feed unit.

**Origo™ MA23** offers you the main functions for MIG/MAG and MMA welding.

**Origo™ MA24** offers you 35 preprogrammed synergic lines and the QSet™ function, the self-learning parameter automation system for the perfect short arc.

**Aristo® U6:** MIG/MAG pulse-welding with preprogrammed synergic lines and the QSet™ function. Menu guidance in English and many other languages.

**Aristo® U8<sub>2</sub> and U8<sub>2</sub> Plus:**

See page 76 for further details.

## POWER SOURCE FEATURES

- High duty cycle. Multi-voltage versions for special mains voltages
- Superlative welding properties - High utility and high quality through TrueArcVoltage™
- Choice of two 4-roll wire feed devices, up to 2.4 mm wire electrodes
- Continuously variable rectifiers
- Crane lifting eyes, frame suitable for lifting with forklifts
- Solid, galvanized sheet steel housing with optional air filter. IP 23 insulation - for work outdoors
- ELP - ESAB LogicPump, starts the water pump automatically
- Automatic standby mode to save energy
- Can be controlled remotely, digital display
- Optionally with electric Push-Pull welding torches in 6 or 10 m
- Can be used with mechanisation, ESAB Miggytrac and Railtrac

For more information on WeldCloud™ see page 81



| Technical data                    | Mig 4002c       | Mig 5002c | Mig 6502c |
|-----------------------------------|-----------------|-----------|-----------|
| Mains supply, V / ph              | 400-415 / 3     |           |           |
| Fuse, slow, A                     | 32              | 32        | 50        |
| Setting range (MIG/MAG), A        | 16 - 400        | 16 - 500  | 16 - 650  |
| Open circuit voltage, V           | 62              |           |           |
| Power factor                      | 0,88            | 0,9       | 0,9       |
| Efficiency at max power, %        | 70              | 72        | 83        |
| Dimensions, LxWxH, mm             | 830 x 640 x 835 |           |           |
| Weight, kg (without cooling unit) | 149             | 185       | 222       |
| Weight, kg (with cooling unit)    | 163             | 199       | 236       |
| Cooling power, W (l/min)          | 2500 (1,5)      |           |           |
| Enclosure class                   | IP 23           |           |           |
| Application class                 | S               |           |           |

| Maximum output at 40°C | Mig 4002c | Mig 5002c | Mig 6502c |
|------------------------|-----------|-----------|-----------|
| 60% duty cycle, A/V    | 400 / 34  | 500 / 39  | 650 / 44  |
| 100% duty cycle, A/V   | 310 / 30  | 400 / 34  | 500 / 39  |



## CONTROL PANEL MA23

- Controller in the wire feed device for MIG/MAG and MMA welding
- 2 / 4 stroke torch switch actions
- Gas test and tension-free wire feed
- Gas pre- and post-flow can be set
- Continuous choke setting
- 3 memory slots, called up from the torch button
- Can be controlled remotely, digital display



## CONTROL PANEL MA24

- Controller in the wire feed device for MIG/MAG and MMA welding
- 35 preprogrammed synergic lines
- QSet™ Parameter automation
- 2 / 4 stroke torch switch actions
- Gas test and tension-free wire feed
- Gas pre- and post-flow can be set
- Creep start and end crater filling
- Continuous choke setting
- 3 memory slots, can be called up from the torch button
- Can be controlled remotely, digital display

## CONTROL PANEL ARISTO U82

See page 76



### Complete Package

● Origo™ Mig 5002cw + Origo™ Feed 3004w MA24 V/A + PSF™ 510w, 4,5 mt. + earth cable 5 mt. + connection cable 10 m. **0479 100 242**

### Delivery includes

Running gear with gas bottle shelf and safety chain, wire feeder pivot, 5m mains cable and 5m earth cable

### Suggested configurations

#### Origo™ Mig 4002cw with Origo™ Feed 3004w MA23, water cooling

|                                 |                     |
|---------------------------------|---------------------|
| Mig 4002cw                      | <b>0349 309 780</b> |
| Origo™ Feed 3004w, MA23         | <b>0460 526 897</b> |
| Connection cable - m. 1,7       | <b>0459 528 790</b> |
| PSF™ 410w, L=3,0m, water cooled | <b>0458 400 882</b> |

#### Aristo® Mig 4002cw with Aristo® Feed 3004w U6, water cooling, pulsed arc

|                                 |                     |
|---------------------------------|---------------------|
| Mig 4002cw                      | <b>0349 309 780</b> |
| Aristo® Feed 3004w, U6          | <b>0460 526 896</b> |
| Connection cable - m. 1,7       | <b>0459 528 790</b> |
| PSF™ 410w, L=3,0m, water cooled | <b>0458 400 882</b> |

#### Aristo® Mig 5002cw with Aristo® Feed 3004w U6, water cooling, pulsed arc

|                                 |                     |
|---------------------------------|---------------------|
| Mig 5002cw                      | <b>0349 311 350</b> |
| Aristo® Feed 3004w, U6          | <b>0460 526 896</b> |
| Connection cable - m. 1,7       | <b>0459 528 790</b> |
| PSF™ 510w, L=3,0m, water cooled | <b>0458 400 884</b> |

#### Origo™ Mig 6502cw with Origo™ Feed 4804w, MA23, water cooling

|                                 |                     |
|---------------------------------|---------------------|
| Mig 6502cw                      | <b>0349 311 390</b> |
| Origo™ Feed 4804w, MA23         | <b>0460 526 997</b> |
| Connection cable - m. 1,7       | <b>0459 528 790</b> |
| PSF™ 510w, L=3,0m, water cooled | <b>0458 400 884</b> |




## CONTROL PANEL U6


- MIG/MAG pulse-type welding or professional MMA welding
- QSet™ Parameter automation
- Preprogrammed synergic lines
- 2 / 4 stroke torch switch actions
- End crater filling
- Creep start, Hot Start and wire burn-back time that can be set
- Gas pre- and post-flow can be set
- Gas test and tension-free wire feed
- 10 memory slots
- Limit value assignment, password protection

# MIG 4002c, 5002c AND 6502c

Gas=self-cooled, W=water cooled


| Mig  |              | 4002c |   | 5002c |   | 6502c |   |
|--|--------------|-------|---|-------|---|-------|---|
|  |              | Gas   | W | Gas   | W | Gas   | W |
| <b>Power sources</b>   |              |       |   |       |   |       |   |
| Mig 4002c  | 0349 311 300 | ●     |   |       |   |       |   |
| Mig 4002cw   | 0349 309 780 |       | ● |       |   |       |   |
| Mig 4002c MV *   | 0349 311 310 | ●     |   |       |   |       |   |
| Mig 4002cw MV *  | 0349 311 320 |       | ● |       |   |       |   |
| Mig 5002c  | 0349 311 330 |       |   | ●     |   |       |   |
| Mig 5002cw  | 0349 311 350 |       |   |       | ● |       |   |
| Mig 5002c MV*  | 0349 311 340 |       |   | ●     |   |       |   |
| Mig 5002cw MV *  | 0349 311 360 |       |   |       | ● |       |   |
| Mig 6502c  | 0349 311 370 |       |   |       |   | ●     |   |
| Mig 6502cw   | 0349 311 390 |       |   |       |   |       | ● |
| Mig 6502c MV *   | 0349 311 380 |       |   |       |   | ●     |   |
| Mig 6502cw MV *  | 0349 311 400 |       |   |       |   |       | ● |

\*Power sources, multi-voltage types (230/400-415/500 V, 50Hz, 230/440-460 V, 60Hz, 3-ph)

| Wire feeders   | Mig          | 4002c |   | 5002c |   | 6502c |   |
|--|--------------|-------|---|-------|---|-------|---|
|  |              | Gas   | W | Gas   | W | Gas   | W |
| Origo™ Feed 3004 MA23  | 0460 526 887 | ●     |   | ●     |   | ●     |   |
| Origo™ Feed 3004w MA23   | 0460 526 897 |       | ● |       | ● |       | ● |
| Origo™ Feed 3004 MA24  | 0460 526 889 | ●     |   | ●     |   | ●     |   |
| Origo™ Feed 3004w MA24  | 0460 526 899 |       | ● |       | ● |       | ● |
| Origo™ Feed 4804w MA23   | 0460 526 997 |       | ● |       | ● |       | ● |
| Origo™ Feed 4804w MA24   | 0460 526 999 |       | ● |       | ● |       | ● |
| Aristo® Feed 3004 U6   | 0460 526 886 | ●     |   | ●     |   | ●     |   |
| Aristo® Feed 3004w U6  | 0460 526 896 |       | ● |       | ● |       | ● |
| Aristo® Feed 4804w U6  | 0460 526 996 |       | ● |       | ● |       | ● |

| Wire feeders<br>for process controller U8 <sub>2</sub> | Mig          | 4002c |   | 5002c |   | 6502c |   |
|--|--------------|-------|---|-------|---|-------|---|
|  |              | Gas   | W | Gas   | W | Gas   | W |
| Aristo® U8 <sub>2</sub>                                | 0460 820 880 | ●     | ● | ●     | ● | ●     | ● |
| Aristo® U8 <sub>2</sub> Plus                           | 0460 820 881 | ●     | ● | ●     | ● | ●     | ● |
| Aristo® Feed 3004 **                                   | 0460 526 881 | ●     |   | ●     |   | ●     |   |
| Aristo® Feed 3004w **                                  | 0460 526 891 |       | ● |       | ● |       | ● |
| Aristo® Feed 4804w                                     | 0460 526 991 |       | ● |       | ● |       | ● |

\*\* SuperPulse™ function

| Welding torches   | Mig          | 4002c |   | 5002c |   | 6502c |   |
|---|--------------|-------|---|-------|---|-------|---|
|   |              | Gas   | W | Gas   | W | Gas   | W |
| PSF™ 405, L=3,0m, self-cooled   | 0458 401 882 | ●     |   |       |   |       |   |
| PSF™ 405, L=4,5m, self-cooled   | 0458 401 883 | ●     |   |       |   |       |   |
| PSF™ 410w, L=3,0m, water cooled   | 0458 400 882 |       | ● |       |   |       |   |
| PSF™ 410w, L=4,5m, water cooled   | 0458 400 883 |       | ● |       |   |       |   |
| PSF™ 505, L=3,0m, self-cooled   | 0458 401 884 |       |   | ●     |   | ●     |   |
| PSF™ 505, L=4,5m, self-cooled   | 0458 401 885 |       |   | ●     |   | ●     |   |
| PSF™ 510w, L=3,0m, water cooled   | 0458 400 884 |       |   |       | ● |       | ● |
| PSF™ 510w, L=4,5m, water cooled  | 0458 400 885 |       |   |       | ● |       | ● |

Push-pull torches MXH™ at page 59

 Package - see previous page



| Mig                        |              | 4002c |   | 5002c |   | 6502c |   |
|----------------------------|--------------|-------|---|-------|---|-------|---|
|                            |              | Gas   | W | Gas   | W | Gas   | W |
| <b>Connection cables</b>   |              |       |   |       |   |       |   |
| Connection cable - mt. 1,7 | 0459 528 780 | ●     |   | ●     |   | ●     |   |
| Connection cable - mt. 5   | 0459 528 781 | ●     |   | ●     |   | ●     |   |
| Connection cable - mt. 10  | 0459 528 782 | ●     |   | ●     |   | ●     |   |
| Connection cable - mt. 15  | 0459 528 783 | ●     |   | ●     |   | ●     |   |
| Connection cable - mt. 25  | 0459 528 784 | ●     |   | ●     |   | ●     |   |
| Connection cable - mt. 35  | 0459 528 785 | ●     |   | ●     |   |       |   |
| Connection cable - mt. 1,7 | 0459 528 790 |       | ● |       | ● |       | ● |
| Connection cable - mt. 5   | 0459 528 791 |       | ● |       | ● |       | ● |
| Connection cable - mt. 10  | 0459 528 792 |       | ● |       | ● |       | ● |
| Connection cable - mt. 15  | 0459 528 793 |       | ● |       | ● |       | ● |
| Connection cable - mt. 25  | 0459 528 794 |       | ● |       | ● |       | ● |
| Connection cable - mt. 35  | 0459 528 795 |       | ● |       | ● |       | ● |
| Connection cable - mt. 1,7 | 0459 528 980 |       |   |       |   | ●     |   |
| Connection cable - mt. 1,7 | 0459 528 990 |       |   |       |   |       | ● |
| Connection cable - mt. 5   | 0459 528 991 |       |   |       |   |       | ● |
| Connection cable - mt. 10  | 0459 528 992 |       |   |       |   |       | ● |
| Connection cable - mt. 15  | 0459 528 993 |       |   |       |   |       | ● |
| Connection cable - mt. 25  | 0459 528 994 |       |   |       |   |       | ● |

| Accessories   | Mig          | 4002c |   | 5002c |   | 6502c |   |
|---|--------------|-------|---|-------|---|-------|---|
|   |              | Gas   | W | Gas   | W | Gas   | W |
| <b>Cables support:</b>  |              |       |   |       |   |       |   |
| for power sources   | 0349 311 700 | ●     | ● | ●     | ● | ●     | ● |
| for wire feeders  | 0459 234 880 | ●     | ● | ●     | ● | ●     | ● |
| Pressure reducer with flux-meter  | 0760 030 300 | ●     | ● | ●     | ● | ●     | ● |
| Dust filter   | 0349 302 252 | ●     | ● | ●     | ● | ●     | ● |
| Steel spool cover   | 0459 431 880 | ●     | ● | ●     | ● | ●     | ● |
| Wheels kit for wire feeder  | 0458 707 880 | ●     | ● | ●     | ● | ●     | ● |
| Strain relief for welding torch   | 0457 341 881 | ●     | ● | ●     | ● | ●     | ● |
| Lifting eye   | 0458 706 880 | ●     | ● | ●     | ● | ●     | ● |
| Adapter for 5kg spool   | 0455 410 001 | ●     | ● | ●     | ● | ●     | ● |
| Plastic spools adapter  | 0000 701 981 | ●     | ● | ●     | ● | ●     | ● |
| Transformer kit for CO <sub>2</sub> preheater (42V – 50/60 Hz)            | 0349 302 250 | ●     | ● | ●     | ● | ●     | ● |
| Cable holder  | 0349 303 362 | ●     | ● | ●     | ● | ●     | ● |
| Water flow guard  | 0349 302 251 | ●     | ● | ●     | ● | ●     | ● |
| ESAB Coolant 10l  | 0465 720 002 | ●     | ● | ●     | ● | ●     | ● |
| Quick connector for MarathonPac™  | F102 440 880 | ●     | ● | ●     | ● | ●     | ● |
| Connection kit for mechanization<br>with Miggytrac-Railtrac               | 0459 681 880 | ●     | ● | ●     | ● | ●     | ● |
| Connection kit for electric Push-pull torches,<br>start/stop function     | 0459 020 883 | ●     | ● | ●     | ● | ●     | ● |
| Connection kit for electric Push-pull torches,<br>wire feed speed control | 0459 681 881 | ●     | ● | ●     | ● | ●     | ● |

# ARISTO® MIG 3001i

## OPTIMAL WELDING SOLUTIONS

Aristo® Mig is designed for high productivity advanced manual and robotic welding applications. ESAB TrueArcVoltage™ technology, advanced knowledge of hardware and software together with more than 20 years of experience in the construction of digital welding units have been combined to produce the perfect solution. For ESAB innovation also means intuitive operation. Settings menus available in English and in many other languages.

### Aristo® U6

MIG/MAG pulse-welding with preprogrammed synergic lines that can be replaced as desired and the unique QSet™ function, the self-learning parameter automation system for the perfect short arc.

### Aristo® U8<sub>2</sub>

Providing you with the ultimate level of control over the welding process. With ESAB SuperPulse™ and Aristo® Feed 3004 you have the toughest welding tasks well under control. Your welding data settings can be managed optimally and saved on a memory card or stick. Documentation of your welding data? No problem, that too is available as standard.



- Superlative welding properties - High utility and high quality through TrueArcVoltage™
- Inverters based on IGBT technology - High performance and reliability
- Housings made of galvanized steel - Robust and durable
- Professional MMA welding with ArcPlus™
- Automatic standby mode to save energy
- ELP - ESAB LogicPump, starts the water pump automatically
- IP 23 protection - for work outdoors
- Can be controlled remotely, digital display
- Optionally with electric Push-Pull welding torch in 6 and 10 m
- Can be used with mechanisation, ESAB Miggytrac and Railtrac



| Technical data                            | Aristo® Mig 3001i |
|---|-------------------|
| Mains supply, V / ph                      | 400 / 3           |
| Fuse, slow, A                             | 20                |
| Setting range (MIG/MAG), A                | 16 - 300          |
| Open circuit voltage, V                   | 67                |
| Open circuit power, W                     | 30                |
| Power factor (MIG)                        | 0,9               |
| Efficiency at max power (MIG), %          | 85                |
| Dimensions, LxWxH, mm                     | 652 x 249 x 423   |
| Dimensions (with cooling unit), LxWxH, mm | 714 x 249 x 693   |
| Weight, kg (without cooling unit)         | 33                |
| Weight, kg (with cooling unit)            | 53,5              |
| Cooling power, W (l/min)                  | 1100 (1,0)        |
| Enclosure class                           | IP 23             |
| Application class                         | S                 |

| Maximum output (MIG/MAG)at 40°C |          |
|---------------------------------|----------|
| 35% duty cycle, A/V             | 300 / 29 |
| 60% duty cycle, A/V             | 240 / 26 |
| 100% duty cycle, A/V            | 200 / 24 |



## CONTROL PANEL U6

- MIG/MAG pulse-type welding or professional MMA welding
- QSet™ Parameter automation
- Preprogrammed synergic lines
- 2 / 4 stroke torch switch actions
- End crater filling
- Creep start, Hot Start and wire burn-back time that can be set
- Gas pre- and post-flow can be set
- Gas test and tension-free wire feed
- 10 memory slots
- Limit value assignment, password protection



Aristo Mig 3001iw/Feed 3004w U6

## CONTROL PANEL ARISTO U82

See page 76



Remote controller, see on page 68



Gouging torches, see ESAB Accessories catalogue

### Delivery includes

5m mains cable with CEE plug and 4,5m earth cable.

### Suggested configurations

#### Aristo® Mig 3001i with Aristo® Feed 3004 U6

|                               |              |
|-------------------------------|--------------|
| Mig 3001i                     | 0459 740 882 |
| Aristo® Feed 3004, U6         | 0460 526 886 |
| Connection cable - m. 1,7     | 0459 528 780 |
| PSF™ 305, L=3,0m, self-cooled | 0458 401 880 |
| 4 wheels trolley              | 0460 565 880 |

#### Aristo® Mig 3001iw with Aristo Feed 3004w U6, water cooling

|                                 |              |
|---------------------------------|--------------|
| Mig 3001iw                      | 0459 740 883 |
| Aristo® Feed 3004iw, U6         | 0460 526 896 |
| Connection cable - m. 1,7       | 0459 528 790 |
| PSF™ 410w, L=3,0m, water cooled | 0458 400 883 |
| 4 wheels trolley                | 0460 565 880 |

For other configurations, see page 54

# ARISTO® MIG 4004i PULSE



## LOW WEIGHT MULTI-PROCESS INVERTER EQUIPMENT

- High Duty Cycle – suitable for long runs
- Wide mains input tolerance: 380 - 440 V +/- 10%
- Generator compatible – for on site use
- Pre-programmed synergic lines to ensure optimum settings with a wide choice of materials, wire dimensions and gas combinations.
- Memory for 10 (U6) or 255 (U8<sub>2</sub>) welding schedules
- Customized synergic lines (U8<sub>2</sub>)
- Creep start, gas pre-flow and hot start provide a soft and more direct start with less spatter
- Crater filling adjustable burn-back time and post gas
- Standby Function – energy saving system



WeldCloud™

For more information on WeldCloud™ see page 81



| Technical data                 | Aristo® Mig 4004i Pulse |
|--------------------------------|-------------------------|
| Mains supply, V/Hz             | 380-440, 3-50/60        |
| Fuse, anti surge, A            | 20                      |
| Mains cable, Ø mm <sup>2</sup> | 4 x 4                   |
| Setting range, A               |                         |
| MIG/MAG                        | 16 - 400                |
| MMA                            | 16 - 400                |
| TIG (LiveTIG)                  | 4-400                   |
| Open circuit voltage, V        | 55                      |
| Open circuit voltage VRD, V    | < 35                    |
| Idle power, W                  | 40                      |
| Efficiency at max current, %   | 88                      |
| Power factor at max current    | 0.94                    |
| Dimensions L x W x H, mm       | 610 x 250 x 445         |
| Weight, kg                     | 44.5                    |
| Incl COOL 1 excl. coolant, Kg  | 58                      |
| Operating temperature, °C      | -10 to +40              |
| Enclosure class                | IP 23                   |
| Application class              | S                       |
| Insulation class               | H                       |
| zCertification                 | CE                      |

### Maximum output (MIG/MAG)at 40°C

|                      |          |
|----------------------|----------|
| 60% duty cycle, A/V  | 400 / 34 |
| 100% duty cycle, A/V | 300 / 29 |





## CONTROL PANEL MA25 PULSE

- Advanced Pulsed welding
- Steel and Aluminium panel options
- Synergic lines (Steel 54, Aluminium 30)
- QSet™
- Hot Start & adjustable burn-back time
- 3 memory slots
- Continuous choke setting
- Current slope up / slope down
- Gas pre-flow / post-flow
- 2/4 stroke
- Digital V/A-meter
- Optional digital remote control
- MMA functions ArcPlus™ II, Hot Start and Arc Force



## CONTROL PANEL U6

- MIG/MAG pulse-type welding or professional MMA welding
- QSet™ Parameter automation
- Preprogrammed synergic lines
- 2 / 4 stroke torch switch actions
- End crater filling
- Creep start, Hot Start and wire burn-back time that can be set
- Gas pre- and post-flow can be set
- Gas test and tension-free wire feed
- 10 memory slots
- Limit value assignment, password protection

### Complete Package

- Aristo® Mig 4004i Pulse + Aristo® Feed 3004w U6 + 4 wheels trolley + COOL 1 + PSF™ 410w - 4.5mt + connection cable 1.7mt **0479 000 002**
- Aristo® Mig 4004i Pulse + Aristo® Feed 3004w + Aristo® U8<sub>2</sub> Plus + COOL 1 + PSF™ 410w - 4.5mt + connection cable 1.7mt **0479 000 003** + 4 wheels trolley

### Delivery includes

5m mains cable with CEE plug and 5m earth cable incl clamp.

### Suggested configurations

#### Aristo® Mig 4004i Pulse with Aristo® Feed 3004 U6

|                               |                     |
|-------------------------------|---------------------|
| Aristo® Mig 4004i Pulse       | <b>0465 152 883</b> |
| Aristo® Feed 3004, U6         | <b>0460 526 886</b> |
| Connection cable - m. 1,7     | <b>0459 528 780</b> |
| PSF™ 405, L=3,0m, self-cooled | <b>0458 401 882</b> |
| 4 wheels trolley              | <b>0462 151 880</b> |
| Trolley bracket               | <b>0463 125 880</b> |
| Autotransformer TUA1          | <b>0459 144 880</b> |

#### Aristo® Mig 4004i Pulse with Aristo® Feed 3004 U8<sub>2</sub> Plus

|                               |                     |
|-------------------------------|---------------------|
| Aristo® Mig 4004i Pulse       | <b>0465 152 883</b> |
| Aristo® Feed 3004             | <b>0460 526 881</b> |
| Aristo® U8 <sub>2</sub> Plus  | <b>0460 820 881</b> |
| Connection cable - m. 1,7     | <b>0459 528 780</b> |
| PSF™ 405, L=3,0m, self-cooled | <b>0458 401 882</b> |
| 4 wheels trolley              | <b>0462 151 880</b> |
| Trolley bracket               | <b>0463 125 880</b> |
| Autotransformer TUA1          | <b>0459 144 880</b> |



## CONTROL PANEL ARISTO U82




See page 76




# ARISTO® MIG 3001i AND 4004i PULSE

Gas=self-cooled, W=water cooled

| Aristo® Mig  |              | 3001i |   | 4004i Pulse |   |
|--|--------------|-------|---|-------------|---|
|  |              | Gas   | W | Gas         | W |
| Mig 3001i  | 0459 740 882 | ●     |   |             |   |
| Mig 3001iw   | 0459 740 883 |       | ● |             |   |
| Mig 4004i Pulse       | 0465 152 883 |       |   | ●           | ● |
| COOL 1, water cooler  | 0462 300 880 |       |   |             | ● |

| Wire feeders<br>for process controller MA25, U6, and U8 <sub>2</sub>   | Aristo® Mig  | 3001i |   | 4004i Pulse |   |
|--|--------------|-------|---|-------------|---|
|  |              | Gas   | W | Gas         | W |
| Aristo® Feed 3004 MA25 Aluminium   | 0460 526 670 | ●     |   | ●           |   |
| Aristo® Feed 3004w MA25 Aluminium  | 0460 526 671 |       | ● |             | ● |
| Aristo® Feed 3004 MA25 Steel   | 0460 526 672 | ●     |   | ●           |   |
| Aristo® Feed 3004w MA25 Steel  | 0460 526 673 |       | ● |             | ● |
| Aristo® Feed 3004 U6   | 0460 526 886 | ●     |   | ●           |   |
| Aristo® Feed 3004w U6         | 0460 526 896 |       | ● |             | ● |
| Aristo® YardFeed 2000 U6   | 0459 906 886 | ●     |   | ●           |   |
| Aristo® YardFeed 2000w U6  | 0459 906 896 |       | ● |             | ● |
| Aristo® Feed 4804w   | 0460 526 996 |       | ● |             | ● |
| Aristo® U8 <sub>2</sub>  | 0460 820 880 | ●     | ● | ●           | ● |
| Aristo® U8 <sub>2</sub> Plus  | 0460 820 881 | ●     | ● | ●           | ● |
| Aristo® Feed 3004 **   | 0460 526 881 | ●     |   | ●           |   |
| Aristo® Feed 3004w **         | 0460 526 891 |       | ● |             | ● |
| Aristo® Feed 4804w   | 0460 526 891 |       | ● |             | ● |

\*\*With SuperPulse™ function

| Connection cables Feed 3004/4804   | Aristo® Mig  | 3001i |   | 4004i Pulse |   |
|--|--------------|-------|---|-------------|---|
|  |              | Gas   | W | Gas         | W |
| Connection cable - mt. 1,7   | 0459 528 780 | ●     |   | ●           |   |
| Connection cable - mt. 5   | 0459 528 781 | ●     |   | ●           |   |
| Connection cable - mt. 10  | 0459 528 782 | ●     |   | ●           |   |
| Connection cable - mt. 15  | 0459 528 783 | ●     |   | ●           |   |
| Connection cable - mt. 25  | 0459 528 784 | ●     |   | ●           |   |
| Connection cable - mt. 35  | 0459 528 785 | ●     |   | ●           |   |
| Connection cable - mt. 1,7  | 0459 528 790 |       | ● |             | ● |
| Connection cable - mt. 5   | 0459 528 791 |       | ● |             | ● |
| Connection cable - mt. 10  | 0459 528 792 |       | ● |             | ● |
| Connection cable - mt. 15  | 0459 528 793 |       | ● |             | ● |
| Connection cable - mt. 25  | 0459 528 794 |       | ● |             | ● |
| Connection cable - mt. 35  | 0459 528 795 |       | ● |             | ● |

| Connection cables YardFeed 2000 | Aristo® Mig  | 3001i |   | 4004i Pulse |   |
|---------------------------------|--------------|-------|---|-------------|---|
|                                 |              | Gas   | W | Gas         | W |
| Connection cable - mt. 10       | 0459 528 562 | ●     |   | ●           |   |
| Connection cable - mt. 15       | 0459 528 563 | ●     |   | ●           |   |
| Connection cable - mt. 25       | 0459 528 564 | ●     |   | ●           |   |
| Connection cable - mt. 35       | 0459 528 565 | ●     |   | ●           |   |
| Connection cable - mt. 50       | 0459 528 566 | ●     |   | ●           |   |
| Connection cable - mt. 10       | 0459 528 572 |       | ● |             | ● |
| Connection cable - mt. 15       | 0459 528 573 |       | ● |             | ● |
| Connection cable - mt. 25       | 0459 528 574 |       | ● |             | ● |
| Connection cable - mt. 35       | 0459 528 575 |       | ● |             | ● |
| Connection cable - mt. 50       | 0459 528 576 |       | ● |             | ● |

 Package -see previous page

## Aristo® Mig

### 3001i

### 4004i Pulse

#### Accessories

|   |              | Gas | W | Gas | W |
|---|--------------|-----|---|-----|---|
| 4 wheels trolley compatible with counterbalance *               | 0460 565 880 | ●   | ● | ●   | ● |
| 4 wheels trolley not compatible with counterbalance ⓐⓑ          | 0462 151 880 |     |   | ●   | ● |
| 2 wheels trolley **   | 0460 564 880 | ●   | ● | ●   | ● |
| Water flow guard for CoolMidi 1000                              | 0456 855 881 |     | ● |     | ● |
| 7.5 m control cable extension for Aristo U82                    | 0460 877 891 | ●   | ● | ●   | ● |
| Strain relief for welding torch                                 | 0457 341 881 | ●   | ● | ●   | ● |
| Lifting eye for wire feeder                                     | 0458 706 880 | ●   | ● | ●   | ● |
| Wheels kit for wire feeder                                      | 0458 707 880 | ●   | ● | ●   | ● |
| Adapter for 5kg spool   | 0455 410 001 | ●   | ● | ●   | ● |
| Connection kit for mechanization with Miggytrac-Railtrac        | 0459 681 880 | ●   | ● | ●   | ● |
| Connection kit for electric PP torches, start/stop function     | 0459 020 883 | ●   | ● | ●   | ● |
| Connection kit for electric PP torches, wire feed speed control | 0459 681 881 | ●   | ● | ●   | ● |
| Autotransformer TUA1  | 0459 144 880 | ●   | ● | ●   | ● |

#### Mounting accessories

|  |              |   |   |   |   |
|--|--------------|---|---|---|---|
| Counterbalance device                                    | 0458 705 880 | ● | ● | ● | ● |
| Bracket kit to assembly to the trolleys 0460 564/565 880 | 0461 310 880 |   |   | ● | ● |
| Stabilizer (for counterbalance device)                   | 0460 946 880 | ● | ● | ● | ● |
| Rack mounting brackets                                   | 0460 911 880 | ● | ● |   |   |

Push-Pull torches MXH™ see page 59

\* for counterbalance device solution for Aristo® Mig 4004i Pulse

\*\*for 2 wheels trolley application for Aristo® Mig 4004i Pulse

|                                    | Aristo® Mig  | 3001i |   | 4004i Pulse |   |
|------------------------------------|--------------|-------|---|-------------|---|
|                                    |              | Gas   | W | Gas         | W |
| PSF™305, L=3,0m                    | 0458 401 880 | ●     |   |             |   |
| PSF™305, L=4,5m                    | 0458 401 881 | ●     |   |             |   |
| PSF™ 405, L=3,0m, self-cooled      | 0458 401 882 |       |   | ●           |   |
| PSF™ 405, L=4,5m, self-cooled      | 0458 401 883 |       |   | ●           |   |
| PSF™ 410w, L=3,0m, water cooled    | 0458 400 882 |       | ● |             | ● |
| PSF™ 410w, L=4,5m, water cooled ⓐⓑ | 0458 400 883 |       | ● |             | ● |

# ARISTO® MIG U4000iw, 5000iw AND U5000iw

## OPTIMAL WELDING SOLUTIONS

- Superlative welding properties - High benefits from TrueArcVoltage™
- Inverter based on IGBT technology - High performance and reliability
- Housing with frame made of aluminium extruded profile, can be lifted by crane
- Dust filter included - reduces possible failures due to deposits of grinding dust, for example
- Energy-saving mode after 6.5 minutes if welding is interrupted
- ELP, ESAB LogicPump, starts the water pump automatically
- Optionally with electric Push-Pull welding torches in 6 or 10 m length
- Can be used with mechanisation, ESAB Miggytrac and Railtrac
- Can be controlled remotely, digital display
- IP 23 - allows use outdoors

## PROFESSIONAL TIG DC WELDING WITH MIG U4000iw AND U5000iw

- High frequency and LiftArc™ striking
- TIG pulse-welding with DC
- Current rise time, welding current, pulse time, base current, base current time, current reduction and post-current time can be set



WeldCloud™

For more information on WeldCloud™ see page 81



| Technical data                 | Aristo® Mig U4000iw | Aristo® Mig 5000iw/U5000iw |
|--------------------------------|---------------------|----------------------------|
| Mains supply, V / ph           | 400 / 3             |                            |
| Fuse, slow, A                  | 35                  |                            |
| Setting range, A               | 16 - 400            | 16 - 500                   |
| Open circuit voltage, V        | 55 - 70             | 68 - 88                    |
| Open circuit power, W          | 60                  | 50                         |
| Dimensions, LxWxH, mm          | 625 x 394 x 776     |                            |
| Weight, kg (with cooling unit) | 77                  | 86                         |
| Enclosure class                | IP 23               |                            |
| Application class              | S                   |                            |
| <b>Maximum output at 40°C</b>  |                     |                            |
| 35% duty cycle, A/V            | 400                 | -                          |
| 60% duty cycle, A/V            | 320                 | 500                        |
| 100% duty cycle, A/V           | 250                 | 400                        |

### Delivery includes

5m mains cable with CEE plug and 5m earth cable.





## CONTROL PANEL U6

- MIG/MAG pulse-type welding or professional MMA welding
- QSet™ Parameter automation
- Preprogrammed synergic lines
- 2 / 4 stroke torch switch actions
- End crater filling
- Creep start, Hot Start and wire burn-back time that can be set
- Gas pre- and post-flow can be set
- Gas test and tension-free wire feed
- 10 memory slots
- Limit value assignment, password protection

## CONTROL PANEL ARISTO U82

See page 76



### Suggested configurations

#### Aristo® Mig U4000iw with Aristo® Feed 3004w U6

|                                 |              |
|---------------------------------|--------------|
| Aristo® Mig U4000iw             | 0458 625 885 |
| Aristo® Feed 3004w U6           | 0460 526 896 |
| Connection cable - m. 1,7       | 0459 528 970 |
| PSF™4 10w, L=3,0m, water cooled | 0458 400 882 |
| 4 wheels trolley                | 0458 530 880 |

#### Aristo® Mig U4000iw with Aristo® Feed 3004w U8<sub>2</sub>

|                                 |              |
|---------------------------------|--------------|
| Aristo® Mig U4000iw             | 0458 625 885 |
| Aristo® Feed 3004w              | 0460 526 891 |
| Aristo® U8 <sub>2</sub>         | 0460 820 880 |
| Connection cable - m. 1,7       | 0459 528 970 |
| PSF™ 410w, L=3,0m, water cooled | 0458 400 882 |
| 4 wheels trolley                | 0458 530 880 |

#### Aristo® Mig U4000iw with Aristo® Feed 3004w U8<sub>2</sub> Plus

|                                 |              |
|---------------------------------|--------------|
| Aristo® Mig U4000iw             | 0458 625 885 |
| Aristo® Feed 3004w              | 0460 526 891 |
| Aristo® U8 <sub>2</sub> Plus    | 0460 820 881 |
| 4 wheels trolley                | 0458 530 880 |
| Connection cable - m. 1,7       | 0459 528 970 |
| PSF™ 410w, L=3,0m, water cooled | 0458 400 882 |

#### Aristo® Mig 5000iw with Aristo® Feed 4804w U6

|                                 |              |
|---------------------------------|--------------|
| Aristo® Mig 5000iw              | 0459 230 881 |
| Aristo® Feed 4804w U6           | 0460 526 996 |
| Connection cable - m. 1,7       | 0459 528 970 |
| PSF™ 510w, L=3,0m, water cooled | 0458 400 884 |
| 4 wheels trolley                | 0458 530 880 |

#### Aristo® Mig 5000iw with Aristo® Feed 3004w U8<sub>2</sub> Plus, double wire feeder

|                                       |              |
|---------------------------------------|--------------|
| Aristo® Mig 5000iw                    | 0459 230 881 |
| Aristo® Feed 3004w (x2)               | 0460 526 891 |
| Aristo® U8 <sub>2</sub> Plus          | 0460 820 881 |
| 4 wheels trolley - large              | 0458 603 880 |
| Kit for double wire feeder attachment | 0459 546 880 |
| Connection cable - m. 1,7 (x2)        | 0459 528 970 |
| PSF™ 510w, L=3,0m, water cooled (x2)  | 0458 400 884 |

## Aristo® Mig U4000iw - 5000iw - U5000iw

### Power Sources

|  |              |
|--|--------------|
| Aristo® Mig U4000iw                    | 0458 625 885 |
| Aristo® Mig 5000iw                     | 0459 230 881 |
| Aristo® Mig 5000iw,<br>with flow guard | 0459 230 896 |
| Aristo® Mig U5000iw                    | 0459 230 883 |

### Wire feeders

|  |              |
|--|--------------|
| Aristo® Feed 3004w U6                  | 0460 526 896 |
| Aristo® Feed 4804w U6                  | 0460 526 996 |
| Aristo® Feed 3004w<br>with SuperPulse™ | 0460 526 891 |
| Aristo® Feed 4804w                     | 0460 526 991 |
| Aristo® U8 <sub>2</sub>                | 0460 820 880 |
| Aristo® U8 <sub>2</sub> Plus           | 0460 820 881 |

### Connection cables

|                             |              |
|-----------------------------|--------------|
| Connection cable - mt. 1,7  | 0459 528 970 |
| Connection cable - mt. 5,0  | 0459 528 971 |
| Connection cable - mt. 10,0 | 0459 528 972 |
| Connection cable - mt. 15,0 | 0459 528 973 |
| Connection cable - mt. 25,0 | 0459 528 974 |
| Connection cable - mt. 35,0 | 0459 528 975 |

### Accessories

|  |              |
|--|--------------|
| 4 wheels trolley   | 0458 530 880 |
| Pressure reducer with flux-meter                                   | 0760 030 300 |
| Steel spool cover  | 0459 431 880 |
| Wheels kit for wire feeder   | 0458 707 880 |
| Strain relief for welding torch                                    | 0457 341 881 |
| Cable holder   | 0459 234 880 |
| Lifting eye  | 0458 706 880 |
| Counterbalance device  | 0458 705 880 |
| Adapter for 5kg spool  | 0455 410 001 |
| Plastic spools adapter   | 0000 701 981 |
| Water flow guard   | 0456 855 880 |
| Memory stick USB   | 0462 062 001 |
| 7,5m extension cable for Aristo® U8 <sub>2</sub>                   | 0460 877 891 |
| Multi-voltage unit (208-575V 50/60Hz)                              | 0459 145 880 |
| Conn. kit for electric Push-pull torches, wire feed speed control  | 0459 681 881 |
| Connection kit for electric Push-pull torches, start/stop function | 0459 020 883 |
| ESAB Coolant 10l   | 0465 720 002 |
| Quick connector for MarathonPac™                                   | F102 440 880 |
| Autotransformer TUA2   | 0459 145 880 |

### Accessories for double wire feeder

|  |              |
|--|--------------|
| 4-wheels trolley, large, with gas bottle shelf, for double wire feeder | 0458 603 880 |
| Attachment kit for double wire feeder                                  | 0459 546 880 |

# PSF™ WELDING TORCHES

## PROFESSIONAL MIG/MAG WELDING TORCHES

- Ergonomically shaped welding torches
- Ball joint in the hand piece
- Screwed gas nozzles
- Sprung switch contact pins
- Available in lengths of 3 m or 4.5 m
- PSF™ Centrovac fume extraction torch
- PSF™ RS3 - with 3 program switches
- CuCrZr contact tips with a long working life
- HELIX™ contact for mechanized applications



### Ordering information

#### PSF™ self-cooled

|                 |              |
|-----------------|--------------|
| PSF™ 250, 3,0 m | 0368 100 882 |
| PSF™ 250, 4,5 m | 0368 100 883 |
| PSF™ 305, 3,0 m | 0458 401 880 |
| PSF™ 305, 4,5 m | 0458 401 881 |
| PSF™ 405, 3,0 m | 0458 401 882 |
| PSF™ 305, 5,0 m | 0458 401 896 |
| PSF™ 405, 4,5 m | 0458 401 883 |
| PSF™ 505, 3,0 m | 0458 401 884 |
| PSF™ 505, 4,5 m | 0458 401 885 |

#### PSF™ water cooled

|                  |              |
|------------------|--------------|
| PSF™ 410w, 3,0 m | 0458 400 882 |
| PSF™ 410w, 4,5 m | 0458 400 883 |
| PSF™ 510w, 3,0 m | 0458 400 884 |
| PSF™ 510w, 4,5 m | 0458 400 885 |
| PSF™ 401w, 5,0 m | 0458 400 886 |
| PSF™ 501w, 5,0 m | 0458 400 887 |

**Euro adapter**, for connection to old ESAB machines **0349 501 001**



### Ordering information

#### PSF™ with fume extraction

|                    |              |
|--------------------|--------------|
| PSF™ 250C, 3,0 m   | 0468 410 882 |
| PSF™ 250C, 4,5 m   | 0468 410 883 |
| PSF™ 315CLD, 3,0 m | 0468 410 885 |
| PSF™ 315CLD, 4,5 m | 0468 410 886 |
| PSF™ 405C, 3,0 m   | 0458 499 882 |
| PSF™ 405C, 4,5 m   | 0458 499 883 |
| PSF™ 410Cw, 3,0 m  | 0458 450 880 |
| PSF™ 410Cw, 4,5 m  | 0458 450 881 |

#### PSF™ with 3 program switches

|                       |              |
|-----------------------|--------------|
| PSF™ 405 RS3, 4,5 m   | 0458 401 893 |
| PSF™ 305 RS3, 4,5 m   | 0458 401 895 |
| PSF™ 405 RS3, 3,0 m   | 0458 401 892 |
| PSF™ 410w RS3, 3,0 m  | 0458 400 898 |
| PSF™ 410w RS3, 4,5 m  | 0458 400 899 |
| PSF™ 510w RS3, 3,0 m  | 0458 400 900 |
| PSF™ 510w RS3, 4,5 m  | 0458 400 901 |
| PSF™ 410Cw RS3, 3,0 m | 0458 450 884 |
| PSF™ 410Cw RS3, 4,5 m | 0458 450 885 |

| Technical data<br>PSF™ torches | Max welding current |           |            | Wire diameter (mm) |             |           |     | Weight (kg) |  |
|--------------------------------|---------------------|-----------|------------|--------------------|-------------|-----------|-----|-------------|--|
|                                | CO <sub>2</sub>     | Mix       | Mild steel | Stainless          | Cored wires | Aluminium | 3 m | 4,5 m       |  |
| PSF™ 250                       | 250A 60%            | 225A 60%  | 0,6 - 1,0  | 0,6 - 1,0          | 1,0         | 1,0       | 1,8 | 2,5         |  |
| PSF™ 305                       | 315A 60%            | 285A 60%  | 0,8 - 1,2  | 0,8 - 1,2          | 1,0 - 1,2   | 1,0 - 1,2 | 2,5 | 3,3         |  |
| PSF™ 405                       | 380A 60%            | 325A 60%  | 0,8 - 1,6  | 0,8 - 1,2          | 1,0 - 1,6   | 1,0 - 1,6 | 3,1 | 4,2         |  |
| PSF™ 505                       | 475A 60%            | 410A 60%  | 1,0 - 2,4  | 1,0 - 1,6          | 1,0 - 2,4   | 1,2 - 2,4 | 3,9 | 5,3         |  |
| PSF™ 410w                      | 400A 100%           | 350A 100% | 0,8 - 1,6  | 0,8 - 1,2          | 1,0 - 1,6   | 1,0 - 1,6 | 3,0 | 3,9         |  |
| PSF™ 510w                      | 500A 100%           | 440A 100% | 1,0 - 2,4  | 1,0 - 1,6          | 1,0 - 2,4   | 1,2 - 2,4 | 3,3 | 4,0         |  |
| PSF™ 250C                      | 250A 60%            | 225A 60%  | 0,6 - 1,0  | 0,6 - 1,0          | 1,0         | 1,0       | 3,5 | 5,0         |  |
| PSF™ 315CLD                    | 315A 60%            | 285A 60%  | 0,8 - 1,2  | 0,8 - 1,2          | 1,0 - 1,2   | 1,0 - 1,2 | 4,3 | 5,4         |  |
| PSF™ 405C                      | 380A 60%            | 325A 60%  | 0,8 - 1,6  | 0,8 - 1,2          | 1,0 - 1,6   | 1,0 - 1,6 | 4,6 | 6,8         |  |
| PSF™ 410Cw                     | 400A 100%           | 350A 100% | 0,8 - 1,6  | 0,8 - 1,2          | 1,0 - 1,6   | 1,0 - 1,6 | 4,0 | 6,2         |  |

# MXH™ WELDING TORCHES



## ELECTRIC PUSH-PULL WELDING TORCHES

- Available in 6 m or 10 m length
- Optimal matching of the gear ratio with any Origo™, Aristo® Feed and Warrior™ Feed
- Usable with compact units Origo™ Mig C340, C420 and Mig C3000i
- Ideal for the welding of soft or thin wires, such as aluminium
- Swan neck that can be rotated by 360°
- CuCrZr contact tips with a long working life
- High ability to react to changes in the wire feed speed
- Ideal for the Aristo® SuperPulse process



### Ordering information

#### MXH™ Push-pull torches

|                                   |              |
|-----------------------------------|--------------|
| MXH™ 300 PP, 6 m*                 | 0700 200 017 |
| MXH™ 300 PP, 10 m*                | 0700 200 018 |
| MXH™ 300 PP, 10 m, swan neck 45°  | 0700 200 020 |
| MXH™ 400w PP, 6 m*                | 0700 200 015 |
| MXH™ 400w PP, 10 m*               | 0700 200 016 |
| MXH™ 400w PP, 10 m, swan neck 45° | 0700 200 019 |

\*Straight swan neck

### Accessories

#### Connection kit, start/stop function

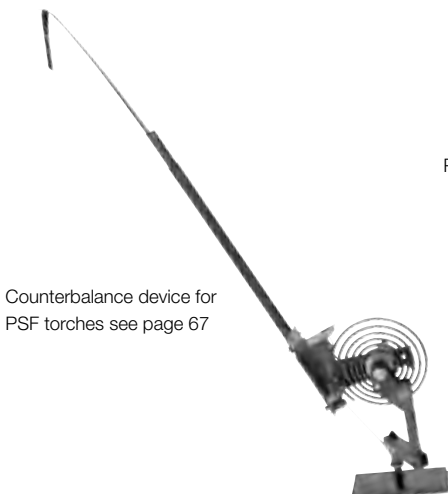
|                                       |              |
|---------------------------------------|--------------|
| For Feed 3004 and 4804 und Mig C3000i | 0459 020 883 |
| For Origo™ Mig C340                   | 0349 308 980 |
| For Origo™ Mig C420                   | 0349 308 337 |

#### Connection kit, wire speed control function

|                        |              |
|------------------------|--------------|
| For Feed 3004 and 4804 | 0459 681 881 |
| For Warrior Feed       | 0465 451 880 |
| For Mig C3000i         | 0459 681 891 |

In conjunction with Origo™ Feed M12/M13 adapter is not needed

| Technical data<br>MXH™ Torches | Max welding current |            | Wire diameter (mm) |           |             |           | Weight (kg) |      |
|--------------------------------|---------------------|------------|--------------------|-----------|-------------|-----------|-------------|------|
|                                | CO <sub>2</sub>     | Mix        | Mild steel         | Stainless | Cored wires | Aluminium | 6 m         | 10 m |
| MXH™ 300 PP                    | 290A 60 %           | 260A 60 %  | 0,8 - 1,2          | 0,8 - 1,2 | 0,9 - 1,2   | 0,8 - 1,2 | 6,6         | 9,2  |
| MXH™ 400w PP                   | 400A 100 %          | 350A 100 % | 0,8 - 1,2          | 0,8 - 1,2 | 0,9 - 1,2   | 0,8 - 1,6 | 5,6         | 7,8  |



Counterbalance device for PSF torches see page 67

PKB torches see page 66



Carryvac welding fume extraction unit: see ESAB PPE catalogue

# WELDING TORCHES WEAR PARTS



|                         |             | PSF™ 250     | PSF™ 305<br>PSF™ 410w | PSF™ 405<br>PSF™ 510w | PSF™ 505     |
|-------------------------|-------------|--------------|-----------------------|-----------------------|--------------|
| Swan neck               | straight 0° | 0469 329 880 | 0469 333 880          | 0469 334 880          | 0469 335 880 |
| Self-cooled             | angled 45°  | 0366 315 880 | 0366 388 880          | 0366 389 880          | 0366 390 880 |
| PSF™ 250 - 505          | angled 60°  | 0467 985 880 | -                     | 0467 988 880          | 0467 989 880 |
| Swan neck               | angled 0°   | -            | 0458 403 886          | 0458 403 887          | -            |
| Water cooled            | angled 45°  | -            | 0458 403 881          | 0458 403 882          | -            |
| PSF™ 410w - 510w        | angled 60°  | -            | -                     | 0458 403 884          | 0458 403 885 |
| -                       |             |              |                       |                       |              |
| Gas nozzle              | conical     | 0458 465 881 | 0458 465 882          | 0458 465 883          | 0458 465 884 |
| Threaded                | standard    | 0458 464 881 | 0458 464 882          | 0458 464 883          | 0458 464 884 |
| With spatter protection | straight    | 0458 470 881 | 0458 470 882          | 0458 470 883          | 0458 470 884 |
| Spatter protection      |             | 0458 471 002 | 0458 471 003          | 0458 471 004          | 0458 471 005 |
| Spot welding acc.       |             | 0366 643 881 | -                     | -                     | -            |
| Tip adaptor             | M6          | 0366 314 001 | -                     | -                     | -            |
| (gas diffusor)          | M8, short   | -            | 0460 819 001          | 0460 819 001          | 0366 395 001 |
|                         | M8, long    | -            | 0458 224 001          | 0458 224 001          | -            |
|                         | HELIX™ M7   | -            | 0368 311 001          | 0368 311 001          | -            |
|                         | HELIX™ M8   | -            | -                     | 0460 819 001          | 0366 395 001 |



|                | CO <sub>2</sub> | Mix |               |               |               |               |
|----------------|-----------------|-----|---------------|---------------|---------------|---------------|
| Contact tip    | 0,6             | -   | 0468 500 001  | 0468 500 001  | 0468 500 001  | -             |
| M6 x 27 CuCrZr | -               | 0,6 | 0468 500 002  | 0468 500 002  | 0468 500 002  | -             |
|                | 0,8             | -   | 0468 500 003* | 0468 500 003* | 0468 500 003* | -             |
|                | 0,9             | 0,8 | 0468 500 004  | 0468 500 004  | 0468 500 004  | -             |
|                | 1,0             | 0,9 | 0468 500 005* | 0468 500 005* | 0468 500 005* | -             |
|                | 1,2             | 1,0 | 0468 500 007* | 0468 500 007* | 0468 500 007* | -             |
|                | 1,4             | 1,2 | -             | 0468 500 008* | 0468 500 008* | -             |
|                | 1,6             | -   | -             | 0468 500 009  | 0468 500 009  | -             |
|                | -               | 1,6 | -             | 0468 500 010  | 0468 500 010  | -             |
| Contact tip    | 0,8             | -   | -             | 0468 502 003* | 0468 502 003* | 0468 502 003* |
| M8 x 37 CuCrZr | 0,9             | 0,8 | -             | 0468 502 004  | 0468 502 004  | 0468 502 004  |
|                | 1,0             | 0,9 | -             | 0468 502 005* | 0468 502 005* | 0468 502 005* |
|                | 1,2             | 1,0 | -             | 0468 502 007* | 0468 502 007* | 0468 502 007* |
|                | 1,4             | 1,2 | -             | 0468 502 008* | 0468 502 008* | 0468 502 008* |
|                | 1,6             | -   | -             | 0468 502 009  | 0468 502 009  | 0468 502 009  |
|                | -               | 1,6 | -             | 0468 502 010  | 0468 502 010  | 0468 502 010  |
|                | 2,0             | 2,0 | -             | -             | 0468 502 011  | 0468 502 011  |
|                | 2,4             | 2,4 | -             | -             | 0468 502 012  | 0468 502 012  |

For more details on HELIX™, gas nozzles, contact tips and other items please refer to instruction manuals

|                           |             | 3 m / 4,5 m    | 3 m / 4,5 m    | 3 m / 4,5 m    | 3 m / 4,5 m    |
|---------------------------|-------------|----------------|----------------|----------------|----------------|
| Steel liner               | 0,6 - 0,8   | 0366 549 882/3 | 0366 549 882/3 | 0366 549 882/3 | -              |
| for steel and cored wires | 0,9 - 1,0   | 0366 549 884/5 | 0366 549 884/5 | 0366 549 884/5 | 0366 549 884/5 |
|                           | 1,2         | -              | 0366 549 886/7 | 0366 549 886/7 | 0366 549 886/7 |
|                           | 1,4         | -              | 0366 549 888/9 | 0366 549 888/9 | 0366 549 888/9 |
|                           | 1,6         | -              | 0366 549 890/1 | 0366 549 890/1 | 0366 549 890/1 |
|                           | 2,0 (4,5 m) | -              | -              | 0366 549 898   | 0366 549 898   |
|                           | 2,4 (4,5 m) | -              | -              | 0366 549 899   | 0366 549 899   |
| PTFE liner                | -           | -              | -              | -              | -              |
| for steel and aluminium.  | 0,8         | 0366 550 882/3 | 0366 550 882/3 | 0366 550 882/3 | -              |
|                           | 0,9 - 1,0   | 0366 550 884/5 | 0366 550 884/5 | 0366 550 884/5 | 0366 550 884/5 |
|                           | 1,2         | -              | 0366 550 886/7 | 0366 550 886/7 | 0366 550 886/7 |
|                           | 1,4         | -              | 0366 550 888/9 | 0366 550 888/9 | 0366 550 888/9 |
|                           | 1,6         | -              | 0366 550 890/1 | 0366 550 890/1 | 0366 550 890/1 |
|                           | 2,0/2,4     | -              | -              | 0366 550 892/3 | 0366 550 892/3 |

For more detail please refer to instruction manuals.

|   |                 |                |                |                |                |
|---|-----------------|----------------|----------------|----------------|----------------|
| Duraliner (beige)   | 1,0 - 1,2       | 0457 969 882/3 | 0457 969 882/3 | 0457 969 882/3 | 0457 969 882/3 |
|   | 1,4 - 1,6 (3 m) | -              | 0457 969 884   | 0457 969 884   | 0457 969 884   |
| Ceramic PTFE liner, without wear insert, for aluminium and alloyed steels |                 |                |                |                |                |
| LF-Liner™   | 0,8 - 1,2       | 0460 233 880/1 | 0460 233 880/1 | 0460 233 880/1 | 0460 233 880/1 |
| Special liner for aluminium wires   |                 | 0460 233 890/1 |                |                |                |

\* Available in 100 pieces packing 0468 500/502 -303, 305, 307, 308 only valid for 0468 502.



|  |  | PSF™ 250C | PSF™ 315 CLD | PSF™ 410Cw | PSF™ 405C |
|--|--|-----------|--------------|------------|-----------|
|--|--|-----------|--------------|------------|-----------|

**For torches with fume extraction**

|                        |            |              |              |              |              |
|------------------------|------------|--------------|--------------|--------------|--------------|
| Swan neck              | angled 45° | 0366 315 880 | 0457 862 880 | 0458 487 880 | 0459 763 880 |
| Fume extraction nozzle | straight   | 0369 796 002 | 0369 796 002 | 0458 495 001 | 0458 495 001 |
|                        | conical    | 0466 905 002 | 0466 905 004 | 0458 498 001 | 0458 498 001 |
|                        | short      | 0466 905 003 | -            | -            | -            |

|  |  | MXH™ 300 PP | MXH™ 400w PP |
|--|--|-------------|--------------|
|--|--|-------------|--------------|

|                                   |                         |              |              |
|-----------------------------------|-------------------------|--------------|--------------|
| Swan neck<br>(without wear parts) | angled 0°               | 0700 200 252 | 0700 200 250 |
|                                   | angled 45°              | 0700 200 253 | 0700 200 251 |
| Wear parts<br>(for swan necks)    | angled 0°               | 0700 200 182 | 0700 200 182 |
|                                   | angled 45°              | 0700 200 183 | 0700 200 183 |
| Gas nozzle                        | conical                 | 0458 465 882 | 0458 465 882 |
|                                   | Threaded                | 0458 464 882 | 0458 464 882 |
|                                   | With spatter protection | 0458 470 882 | 0458 470 882 |
| Spatter protection                |                         | 0458 471 003 | 0458 471 004 |
| Tip adaptor<br>(gas diffusor)     | M8, short               | 0460 819 001 | 0460 819 001 |
|                                   | M8, long                | 0458 224 001 | 0458 224 001 |
|                                   | HELIX™ M8               | 0460 819 001 | 0460 819 001 |

|                | CO <sub>2</sub> | Mix/Ar |               |               |
|----------------|-----------------|--------|---------------|---------------|
| Contact tip    | 0,8             | -      | 0468 502 003* | 0468 502 003* |
| M8 x 37 CuCrZr | 0,9             | 0,8    | 0468 502 004  | 0468 502 004  |
|                | 1,0             | 0,9    | 0468 502 005* | 0468 502 005* |
|                | 1,2             | 1,0    | 0468 502 007* | 0468 502 007  |
|                | 1,4             | 1,2    | 0468 502 008* | 0468 502 008* |
|                | 1,6             | -      | 0468 502 009  | 0468 502 009  |
|                | -               | 1,6    | 0468 502 010  | 0468 502 010  |

For more details on HELIX™, gas nozzles, contact tips and other items please refer to instruction manuals

|                |           |              |              |
|----------------|-----------|--------------|--------------|
| Polyamid liner | 1,0 - 1,6 | 0700 200 181 | 0700 200 181 |
| PTFE liner     | 0,8       | 0700 200 179 | 0700 200 179 |
| Steel liner    | 0,8       | 0700 200 176 | 0700 200 176 |
| Steel liner    | 1,0 - 1,2 | 0700 200 177 | 0700 200 177 |

**Feeding rolls**

|  |              |              |
|--|--------------|--------------|
| For 0,8 mm steel, stainless, aluminium wires | 0700 200 184 | 0700 200 184 |
| For 1,0 mm steel, stainless, aluminium wires | 0700 200 185 | 0700 200 185 |
| For 1,2 mm steel, stainless, aluminium wires | 0700 200 186 | 0700 200 186 |
| For 1,6 mm aluminium wires                   | 0700 200 205 | 0700 200 205 |

\* Available in 100 pieces packing 0468 500/502 -303, 305, 307. 308 only valid for 0468 502.



# WIRE FEED UNITS

## GOOD WIRE FEED UNITS ARE CRUCIAL FOR MIG/MAG WELDING

The Feed 304, 3004, 484 and 4804 have been designed for professional use and to meet the toughest quality requirements. The wire feed units have robust 4-rolls drives with grooved and geared feed and pressure rollers. The pressure rolls are mounted in a balancing beam that distributes the pressure evenly over the rolls. The wire is fed consistently and accurately.

Electronically regulated motors ensure that there is a constant feeding of wire and thus for a constant welding current. The wire feed speed that you set is maintained with high precision. ESAB LogicPump ELP, the coolant pump is switched on automatically when connecting a water-cooled welding torch.

Feed 304 and 3004 can be used for welding wires of up to 1.6 mm, Feed 484 and 4804 for hard continuous use with up to 2.4 mm wire diameter. The relevant control panels decide the versatile functionality in connection with the selected welding current source.

For further details on panel options see page 78

## Aristo® / Origo™ Feed\*



\* depending on choice of panel

| Technical data                         | Feed 304 / 3004     | Feed 484 / 4804     |
|--|---------------------|---------------------|
| Primary Voltage, V AC, Hz              | 42, 50/60           |                     |
| Spool type, weight kg                  | 18                  |                     |
| Weight of the wire feeder, kg          | 15                  | 19                  |
| Wire feed speed, m/min                 | 1.9 - 25 / 0,8 - 25 | 1.9 - 25 / 0,8 - 25 |
| Max welding current, 60% duty cycle, A | 630                 |                     |

### Usable wire diameters, mm

|                  |           |           |
|------------------|-----------|-----------|
| Mild steel       | 0,6 - 1,6 | 0,6 - 2,4 |
| Stainless steels | 0,6 - 1,6 | 0,6 - 2,4 |
| Aluminium        | 1,0 - 1,6 | 1,0 - 2,4 |
| Cored wires      | 0,8 - 1,6 | 0,8 - 2,4 |



## MobileFeed 301 AVS

| Technical data  | MobileFeed 201 | MobileFeed 301 |
|---|----------------|----------------|
| Primary Voltage, V DC<br>(arc voltage - open circuit voltage) | 14 - 100       |                |
| Spool type, weight kg   | 5 - 7.5        | 18             |
| Weight of the wire feeder, kg                                 | 12.2           | 15.9           |
| Wire feed speed, m/min  | 1.3 - 19       |                |

### Usable wire diameters, mm

|                  |           |           |
|------------------|-----------|-----------|
| Mild steel       | 0,8 - 1,6 | 0,8 - 1,6 |
| Stainless steels | 0,8 - 1,6 | 0,8 - 1,6 |
| Aluminium        | 0,9 - 1,6 | 0,9 - 1,6 |
| Cored wires      | 0,8 - 2,0 | 0,8 - 2,0 |

### Ordering information

|                                    |              |
|------------------------------------|--------------|
| MobileFeed 301 AVS with meter (CE) | 0558 102 207 |
| MobileFeed 201 AVS with meter (CE) | 0558 102 206 |

### Ordering information

|   |              |
|---|--------------|
| <b>Origo™ YardFeed 200</b>              |              |
| M13y water cooling, with V/A instrument | 0459 906 892 |

|                             |              |
|-----------------------------|--------------|
| <b>Origo™ YardFeed 2000</b> |              |
| MA23 self cooling           | 0459 906 887 |
| MA23 water cooling          | 0459 906 897 |

|                              |              |
|------------------------------|--------------|
| <b>Aristo® YardFeed 2000</b> |              |
| U6 water cooling             | 0459 906 896 |

|                              |              |
|------------------------------|--------------|
| <b>Warrior™ YardFeed 200</b> |              |
| self cooling                 | 0459 906 900 |
| water cooling                | 0459 906 901 |

Connnection cables, accessories and configurations, on request

| Technical data                         | Yard Feed<br>200 / 2000 |
|--|-------------------------|
| Primary Voltage, V AC, Hz              | 42, 50/60               |
| Spool type, weight kg                  | 5                       |
| Weight of the wire feeder, kg          | 12                      |
| Wire feed speed, m/min                 | 1.9 - 25 / 0.8 - 25     |
| Max welding current, 60% duty cycle, A | 365                     |
| <b>Usable wire diameters, mm</b>       |                         |
| Mild steel                             | 0,6 - 1,2               |
| Stainless steels                       | 0,6 - 1,2               |
| Aluminium                              | 1,0 - 1,2               |
| Cored wires                            | 0,8 - 1,6               |

## TAKING MOBILITY TO A NEW LEVEL

The MobileFeeds are „Off the Arc“ wire feed units. They draw their power directly from the welding circuit. This means that you do not require a heavy intermediate cable or a delicate control cable to the welding power source. The welding cable is sufficient. When using self-protecting filler wires you can even do without the gas bottle.

Used with an Warrior™ 400i CC/CV or Origo™ Mig 4004i, A44 the MobileFeeds becomes a light an extremely robust installation unit for MIG/MAG welding in the short and spray arc fields. Or alternatively use an MMA rectifier with the MobileFeeds. The MobileFeeds has a fully encapsulated and extremely robust housing.

With 4-roll wire feed and electronically regulated motor for even wire feeding.

## YARDFEED 200 AND 2000

YardFeed 200 and 2000 are special versions of the Feed 3004, with especially small dimensions. Designed so that they can also reach welding areas that are very hard to get to, for example, through manholes. YardFeed is mounted in a protective frame that is provided with plastic runners to allow it to be moved easily. For 5 kg and 200 mm wire coils. Intermediate cables to the welding current source of up to 50 m are available.

Configuration options with step-switched and stepless current sources.



**Origo™ YardFeed**

**Aristo® YardFeed**



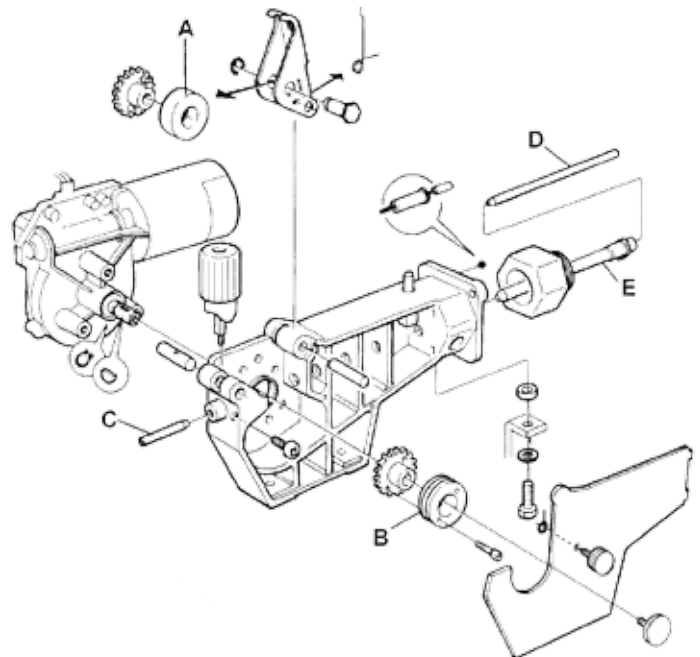
**Warrior™ YardFeed**

# WIRE FEEDER WEAR PARTS

## Origo™ Mig C340 PRO - Origo™ Feed 302

|   |                 |                     |   |
|---|-----------------|---------------------|---|
| A | Pressure roller | <b>0369 728 001</b> | Fe, Ss, C, Al                                   |
|   |                 | <b>0466 262 001</b> | C, 1,0/1,2/1,4/1,6 mm                           |
|   |                 | <b>0369 557 001</b> | Fe, Ss, C, 0,6/0,8 mm                           |
|   |                 | <b>0369 557 002</b> | Fe, Ss, C, 0,8/1,0 mm                           |
|   |                 | <b>0369 557 003</b> | Fe, Ss, C, 1,0/1,2 mm                           |
| B | Feed roller     | <b>0369 557 004</b> | C, 1,0/1,2/1,4/1,6 mm                           |
|   |                 | <b>0369 557 006</b> | Al, 1,0/1,2 mm                                  |
|   |                 |                     | knurled   |
| C | Inlet nozzle    | <b>0466 074 001</b> |   |
| D | Insert tube     | <b>0455 894 001</b> | Plastic, for Al<br>to be used with 0455 885 001 |
|   |                 | <b>0455 889 001</b> | for Fe, Ss, C<br>to be used with 0455 886.001   |
|   |                 | <b>0455 885 001</b> | for Al,<br>to be used with 0455 894 001         |
| E | Outlet nozzle   | <b>0455 886 001</b> | for Fe, Ss, C<br>to be used with 0455 889 001   |
|   |                 |                     |   |

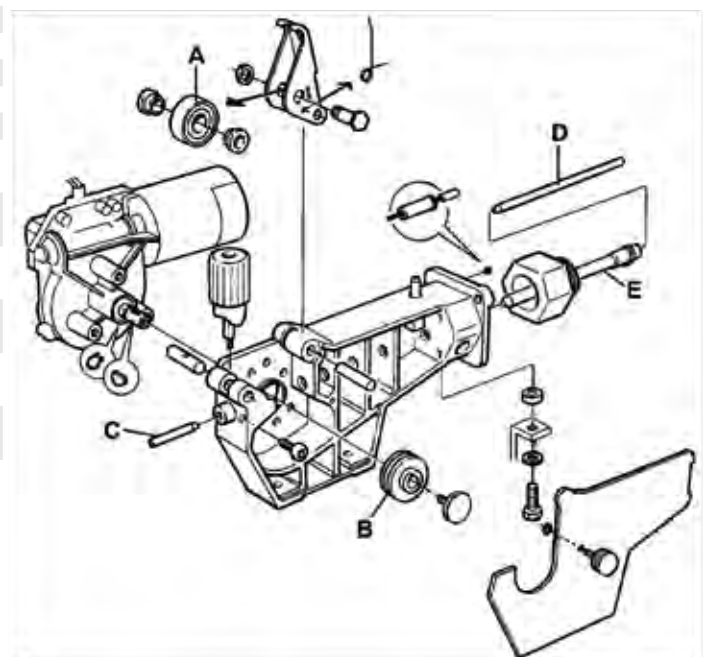
Fe = Steel - Ss = Stainless steel - C = Cored wires - Al = Aluminium



## Origo™ Mig/Mag C170, C171, C200, C201, C250 3ph, Feed L302

|   |                 |                     |   |
|---|-----------------|---------------------|---|
| A | Pressure roller | <b>0455 907 001</b> | Fe, Ss, C, Al                                   |
| B | Feed roller     | <b>0367 556 001</b> | Fe, Ss, C, 0,6/0,8 mm                           |
|   |                 | <b>0367 556 002</b> | Fe, Ss, C, 0,8/1,0 mm                           |
|   |                 | <b>0367 556 003</b> | Fe, Ss, C 1,0/1,2 mm                            |
|   |                 | <b>0367 556 004</b> | Al, 1,0/1,2 mm                                  |
| C | Inlet nozzle    | <b>0466 074 001</b> | Fe, Ss, C, Al                                   |
| D | Insert tube     | <b>0455 894 001</b> | Plastic, for Al<br>to be used with 0455 885 001 |
|   |                 | <b>0455 889 001</b> | for Fe, Ss, C<br>to be used with 0455 886 001   |
|   |                 | <b>0455 885 001</b> | for Al,<br>to be used with 0455 894 001         |
| E | Outlet nozzle   | <b>0455 886 001</b> | for Fe, Ss, C<br>to be used with 0455 889 001   |
|   |                 |                     |   |

Fe = Steel - Ss = Stainless steel - C = Cored wires - Al = Aluminium

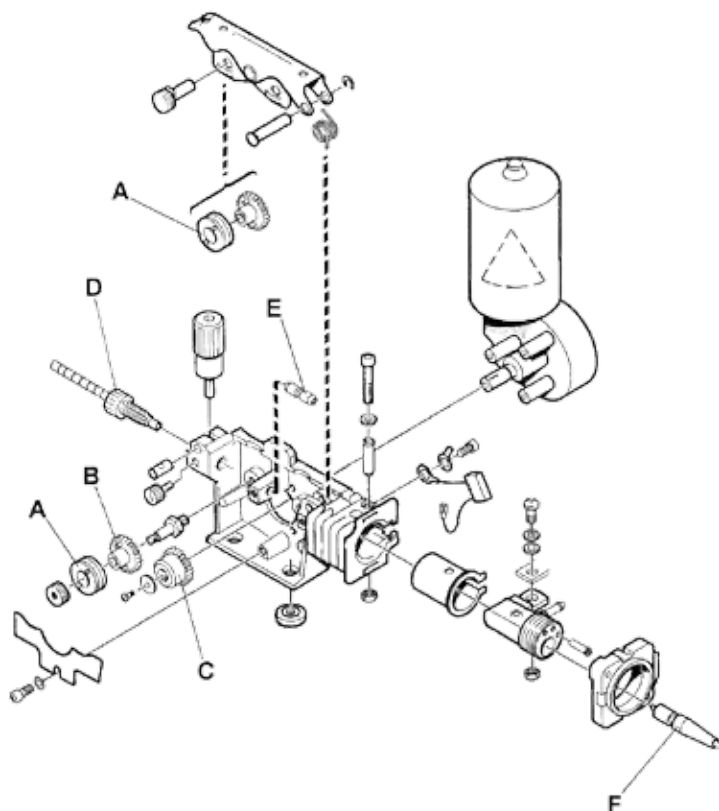




# Origo™ Mig C280 PRO 4WD - C340 PRO 4WD - C420 PRO - C3000i Feed 304, 3004 - Yard Feed 200, 2000

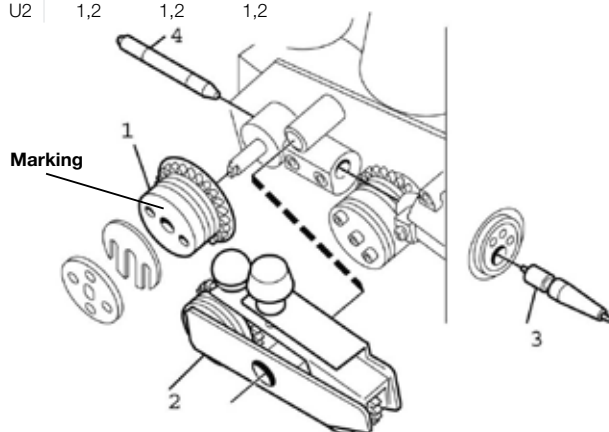
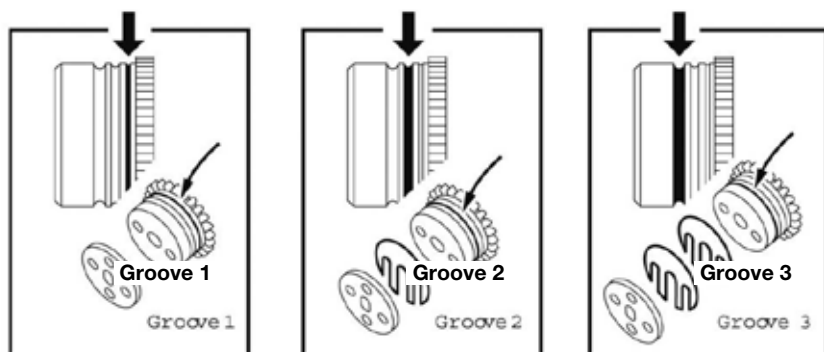
|   |                      |                      |                       |
|---|----------------------|----------------------|-----------------------|
| A | Pressure/feed roller | 0459 052 002         | Fe, Ss, C, 0,8/1,0 mm |
|   |                      | 0459 052 003         | Fe, Ss, C, 1,0/1,2 mm |
|   |                      | knurled 0458 825 001 | C, 0,9/1,2 mm         |
|   |                      | knurled 0458 825 002 | C, 1,2/1,4 mm         |
|   |                      | 0458 824 001         | Al, 0,8/1,0 mm        |
|   |                      | 0458 824 002         | Al, 1,0/1,2 mm        |
|   |                      | 0458 824 003         | Al, 1,2/1,6 mm        |
| B | Gear adapter         | 0459 441 880         |                       |
| C | Drive gear           | 0459 440 001         |                       |
| D | Inlet nozzle         | 0455 049 001         | Fe, Ss, C, Al         |
| E | Intermediate nozzle  | 0455 072 002         | Fe, Ss, C             |
|   |                      | 0456 615 001         | Al                    |
| F | Outlet nozzle        | 0469 837 880         | Ø 2,0 mm Steel        |
|   |                      | 0469 837 881         | Al                    |

Fe = Steel - Ss = Stainless steel - C = Cored wires - Al = Aluminium



## Feed 484, 4804

| Wire Ø mm | Wire type | 1. Feed roller | 2. Bogie     | 3. Outlet nozzle | 4. Insert tube | Groove type | Marking | 1        | 2       | 3        |   |
|-----------|-----------|----------------|--------------|------------------|----------------|-------------|---------|----------|---------|----------|---|
| 0,6-1,2   | Fe, Ss, C | 0366 966 880   | 0366 902 880 | 0469 837 880     | 0156 603 001   | V           | 1       | 0,6-0,8  | 0,9-1,0 | 1,2      | Fe = Steel<br>Ss = Stainless steel<br>C = Cored wires<br>Al = Aluminium<br>G = Knurled groove |
| 0,9-1,6   | Fe, Ss, C | 0366 966 900   | 0366 902 900 | 0469 837 880     | 0156 603 001   | V           | 6       | 0,9-1,0* | 1,2*    | 1,4-1,6* |   |
| 1,2       | Fe, Ss, C | 0366 966 889   | 0366 902 894 | 0469 837 880     | 0156 603 001   | V           | 7       | 1,2      | 1,2     | 1,2      |   |
| 1,4-2,4   | Fe, Ss, C | 0366 966 881   | 0366 902 881 | 0469 837 880     | 0156 603 001   | V           | 2       | 1,4-1,6  | 2,0     | 2,4      |   |
| 1,2-2,0   | C         | 0366 966 882   | 0366 902 882 | 0469 837 880     | 0332 322 001   | V-G         | 3       | 1,2      | 1,4-1,6 | 2,0      |   |
| 2,4       | C         | 0366 966 883   | 0366 902 883 | 0469 837 882     | 0332 322 002   | V-G         | 4       | 2,4      | -       | -        |   |
| 1,0-1,6   | Al        | 0366 966 899   | 0366 902 899 | 0469 837 881     | 0156 603 001   | U           | U4      | 1,0      | 1,2     | 1,6      |   |
| 1,2       | Al        | 0366 966 885   | 0366 902 886 | 0469 837 881     | 0156 603 001   | U           | U2      | 1,2      | 1,2     | 1,2      |   |



# ORIGO™ FEED AIRMATIC AND PKB™ WELDING TORCH



- Wire feed device for compressed air-operated Push-Pull torches PKB™
- Excellent wire feeding, especially when used with soft wires
- Hose package lengths up to 16 m and large radius of action – intermediate cables up to 35 m
- Can be used with step-controlled welding power sources Origo™ Mig 320/410/510 and steplessly-controlled welding powers source Origo™ Mig 402c/502c/652c
- FeedAirmatic Digital Box enables use with the digital CAN bus power sources Aristo® Mig 3000i and Aristo® Mig 4004i/5004i/4004i Pulse
- In connection with Origo™ Mig 402c/502c/652c remote control of the welding voltage and digital display
- Regulation of the wire feed speed by the torch

| Technical data                   | Origo™<br>Feed Airmatic |  |
|----------------------------------|-------------------------|--|
| Primary Voltage, V AC, Hz        | 42, 50/60               |  |
| Compressed air                   | 5 bar                   |  |
| Weight of the wire feeder, kg    | 15                      |  |
| Wire feed speed, m/min           | max. 15                 |  |
| Dimensions LxWxH, mm             | 690 x 275 x 420         |  |
| Wire spool, Ø mm/ kg             | 300 / 18                |  |
| Wire feeder type                 | 2 rollers               |  |
| Max welding current,             | 400 A, 60% cycle        |  |
| Insulation class                 | IP 23                   |  |
| <b>Usable wire diameters, mm</b> |                         |  |
| Mild steel                       | 0,6 - 1,6               |  |
| Stainless steels                 | 0,6 - 1,6               |  |
| Aluminium                        | 0,8 - 1,6               |  |
| Cored wires                      | 0,8 - 1,6               |  |

| Technical data                    | PKB™<br>250 | PKB™<br>400 |
|-----------------------------------|-------------|-------------|
| <b>Max load at 60% duty cycle</b> |             |             |
| Protection gas CO <sub>2</sub>    | 250 A       | 400 A       |
| Argon and mix                     | 200 A       | 280 A       |
| Wire diameters, mm                | 0,6 - 1,2   | 0,6 - 1,6   |
| Max air consumption, l/min        | 280         | 280         |

## Ordering information

|                                  |              |
|----------------------------------|--------------|
| Origo™ Feed Airmatic             | 0459 116 680 |
| Feed Airmatic Digital Box        | 0464 554 880 |
| Feed Airmatic Digital Box Remote | 0464 554 881 |

## Welding torches

|                         |              |
|-------------------------|--------------|
| PKB™ 250                | 0152 700 881 |
| PKB™ 400                | 0152 470 881 |
| PKB™ 400, swan neck 45° | 0152 470 882 |

## Multiple cable (connection Origo™ Feed Airmatic with PKB™)

|                    |              |
|--------------------|--------------|
| 5 m, for PKB™ 250  | 0460 380 880 |
| 10 m, for PKB™ 250 | 0460 380 881 |
| 16 m, for PKB™ 250 | 0460 380 882 |
| 5 m, for PKB™ 400  | 0460 380 883 |
| 10 m, for PKB™ 400 | 0460 380 884 |
| 16 m, for PKB™ 400 | 0460 380 885 |

## Connection cable (from Origo™ Feed Airmatic to power source)

|   |              |
|---|--------------|
| 1,7 m   | 0469 836 900 |
| 5 m   | 0469 836 901 |
| 10 m  | 0469 836 902 |
| 15 m  | 0469 836 903 |
| 19-23 poles adapter for Origo™ Mig 402c/502c/652c | 0349 311 511 |
| Cable set 1.0m amphenol 10 pole                   | 0464 558 880 |
| Assembly kit for Mig 3001i                        | 0464 555 880 |
| Assembly kit for Mig 4004i/5004i/4004i Pulse      | 0464 555 881 |

## Accessories

|                                  |              |
|----------------------------------|--------------|
| Pressure reducer with flux-meter | 0760 030 300 |
| Steel spool cover                | 0459 431 880 |
| Wheels kit for wire feeder       | 0458 707 880 |
| Cable holder                     | 0459 234 880 |
| Lifting eye                      | 0458 706 880 |
| Counterbalance device            | 0458 705 880 |
| Adapter for 5kg spool            | 0455 410 001 |
| Plastic spools adapter           | 0000 701 981 |
| V/A instruments kit*             | 0455 173 882 |
| Swan neck for PKB™ 250           | 0367 581 881 |
| Swan neck for PKB™ 400           | 0367 582 880 |
| Quick connector for MarathonPac  | F102 440 880 |

\*In conjunction with Origo™ Mig 402c

## Delivery of Origo™ Feed Airmatic includes

Plastic spool cover and wear parts for wires 0,6-1,0 mm

## Suggested configurations

### Origo™ Mig 320 with Origo™ Feed Airmatic and PKB™ 250

|                           |              |
|---------------------------|--------------|
| Origo™ Mig 320            | 0349 302 676 |
| Origo™ Feed Airmatic      | 0459 116 680 |
| PKB™ 250                  | 0152 700 881 |
| Multiple cable, 5 m       | 0460 380 880 |
| Connection cable - m. 1,7 | 0469 836 900 |

### Origo™ Mig 402c with Origo™ Feed Airmatic and PKB™ 400:

|                           |              |
|---------------------------|--------------|
| Origo™ Mig 402c           | 0349 310 750 |
| Origo™ Feed Airmatic      | 0459 116 680 |
| PKB™ 400                  | 0152 470 881 |
| Multiple cable, 10 m      | 0460 380 884 |
| Connection cable - m. 1,7 | 0469 836 902 |
| Adapter 19-23 poles       | 0349 311 511 |

# MACHINE ACCESSORIES



## Counter balance device

Spring-supported counterbalance for wire feed units. Can be rotated by 360°. Suits most power sources. Note the instructions for use regarding compatibility.

Counterbalance device **0458 705 880**



## Strain relief for welding torches

Fits all Origo™ and Aristo® Feed, and also YardFeed. Recommended accessories for wheel set.

Strain relief **0457 341 881**



## Rotating piece

The wire feed unit can be rotated on the current source by 360° in combination with MarathonPac™

Rotating piece **0458 703 880**



## Suspension device

Suspension device for wire feed units, suits all Origo™ and Aristo® Feed.

Suspension device **0458 706 880**



## Coil cover, steel

Coil cover made of sheet steel, suits all Origo™ and Aristo® Feed.

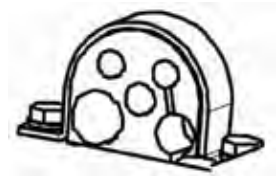
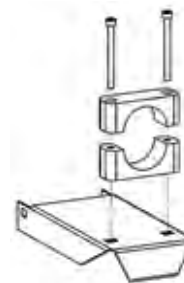
Coil cover, steel **0459 431 880**



## Strain relief

Strain relief for intermediate cables

For wire feeder **0459 234 880**  
 For power sources  
 Mig 402c/502c/652c/4002c/5002c/6502c **0349 311 700**



## Wheel kit

Wheel set for wire feed units, suits all Origo™ and Aristo® Feed.

Wheel kit, front wheels turnable **0458 707 880**  
 Wheel kit, all wheels turnable **0458 707 881**



## Upgrade set

Voltage free wire feed / gas test. For Origo™ Feed M12 and M13

Upgrade set **459 465 880**



# REMOTE CONTROL DIGITAL



## MTA1 CAN

Multi-function remote control. Fixing mechanism, magnetic feet, Connecting cables available in various lengths. MIG/MAG: Voltage and wire feed. MMA: Welding current and Arc Force. TIG: Pulsed current and base current

MTA1 CAN

0459 491 880



Heavy duty connecting cable for extreme stresses, e.g. hot workpiece surfaces. Reduces electromagnetic influences from outside.

|                                     |              | Renegade series | Origo™ Arc, A22/A24 | Caddy® Tig 1500/2200i, TA34 | Caddy® Tig 2200i AC/DC | Origo™ Tig 3000i AC/DC | Aristo® Tig 4000i, TA4 | Aristo® Tig 4000i, TA6 | Origo™ Tig 4300w AC/DC | Aristo® Mig C3000i, MA23/23A | Origo™ Mig, A24 | Origo™ Feed, MAE3/24 | Aristo® Feed, U6 ** | Aristo® Feed, U8 <sub>2</sub> | Aristo® Mig U4000i, U5000i | Aristo® Mig 5000i | Aristo® Mig 4004i Pulse |
|-------------------------------------|--------------|-----------------|---------------------|-----------------------------|------------------------|------------------------|------------------------|------------------------|------------------------|------------------------------|-----------------|----------------------|---------------------|-------------------------------|----------------------------|-------------------|-------------------------|
| AT1 CAN                             | 0459 491 883 | ●               | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      | ●                            | ●               | ●                    | ●                   | ●                             | ●                          | ●                 | ●                       |
| AT1 CF CAN                          | 0459 491 884 | ●               | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      | ●                            | ●               | ●                    | ●                   | ●                             | ●                          | ●                 | ●                       |
| MTA1 CAN                            | 0459 491 880 | ●               | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      | ●                            | ●               | ●                    | ●                   | ●                             | ●                          | ●                 | ●                       |
| M1 10 prog. CAN                     | 0459 491 882 |                 |                     |                             |                        |                        |                        |                        | ●                      |                              | ●               | ●                    | ●                   | ●                             | ●                          | ●                 | ●                       |
| T1 Foot CAN 10 pol.                 | 0460 315 881 |                 |                     | ●                           |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| T1 Foot CAN 12 pol.                 | 0460 315 880 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      |                        |                              |                 |                      |                     | ●                             |                            |                   |                         |
| ER 1 6-pin, 5m                      | 0445 536 881 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| ER 1F Foot 6-pin, 5m                | 0445 550 881 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| <b>Connection Cables 6 poles</b>    |              |                 |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 5 m length                          | 0445 280 880 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 10 m length                         | 0445 280 881 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 25 m length                         | 0445 280 882 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 5 m length, ER 1F                   | 0445 254 880 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 10 m length, ER 1F                  | 0445 254 881 | ●               |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| <b>Connection Cables 12/4 poles</b> |              |                 |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 0,25 m length                       | 0459 554 884 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| 5 m length                          | 0459 554 880 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| 5 m length HD *                     | 0459 554 980 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| 10 m length                         | 0459 554 881 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| 10 m length HD *                    | 0459 554 981 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| 15 m length                         | 0459 554 882 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| 25 m length                         | 0459 554 883 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| Extension cable, 5m length          | 0459 554 886 |                 | ●                   | ●                           | ●                      | ●                      | ●                      | ●                      | ●                      |                              |                 |                      | ●                   | ●                             | ●                          |                   |                         |
| <b>Connection Cables 10/4 poles</b> |              |                 |                     |                             |                        |                        |                        |                        |                        |                              |                 |                      |                     |                               |                            |                   |                         |
| 0,25 m length                       | 0459 960 883 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |
| 5 m length                          | 0459 960 880 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |
| 5 m length HD *                     | 0459 960 980 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |
| 10 m length                         | 0459 960 881 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |
| 10 m length HD *                    | 0459 960 981 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |
| 25 m length                         | 0459 960 882 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |
| 25 m length HD *                    | 0459 960 982 |                 | ●                   |                             |                        |                        |                        |                        |                        | ●                            | ●               | ●                    |                     |                               |                            |                   | ●                       |

\* HD = Heavy Duty

\*\* Aristo™ Feed U6, old series with 12/4 spoles



## ER 1

Remote control to set the welding current MMA & TIG. With digital display for accurate reading of welding amperage and other settings.

|   |                     |
|---|---------------------|
| ER 1 incl. 5 m cable and 6-pin connector  | <b>0445 536 881</b> |
| ER 1 incl. 10 m cable and 6-pin connector | <b>0445 536 882</b> |
| ER 1 incl. 25 m cable and 6-pin connector | <b>0445 536 883</b> |



## AT1 CAN

Remote control to set the welding current MMA & TIG. Fixing mechanism, magnetic feet, Connecting cables available in various lengths.

|         |                     |
|---------|---------------------|
| AT1 CAN | <b>0459 491 883</b> |
|---------|---------------------|



## AT1 CoarseFine CAN

Remote control to set the welding current with coarse and fine setting. MMA & TIG, Fixing mechanism, magnetic feet. Connecting cables available in various lengths

|                    |                     |
|--------------------|---------------------|
| AT1 CoarseFine CAN | <b>0459 491 884</b> |
|--------------------|---------------------|



## M1 10 Prog CAN

MIG/MAG synergic remote control for Aristo® U6 and U8<sub>2</sub>. Call up 10 storage slots and synergic modification. Fixing mechanism, magnetic feet. Connecting cables available in various lengths

|                |                     |
|----------------|---------------------|
| M1 10 Prog CAN | <b>0459 491 882</b> |
|----------------|---------------------|



## Foot Controls

TIG foot-operated remote control. Regulation of welding current, start function. Limiting of the control range via the power source

|   |                     |
|---|---------------------|
| T1 Foot CAN incl. 5 m cable, 12 poles Burndy    | <b>0460 315 880</b> |
| T1 Foot CAN incl. 5 m cable, 10 poles Amphenol  | <b>0460 315 881</b> |
| ER 1F Foot incl. 5 m cable and 6-pin connector  | <b>0445 550 881</b> |
| ER 1F Foot incl. 10 m cable and 6-pin connector | <b>0445 550 882</b> |



# REMOTE CONTROL ANALOG



## MMA1

Remote control to set the welding current, MMA & TIG, suspension eye  
Incl. 10 m connecting cable, 12-pin Burndy

MMA1

0349 501 024

|                                       |              | <i>Caddy® Arc 151i/201i,<br/>A33</i> | <i>Caddy® Arc 251i,<br/>Origo™ Mig A13</i> | <i>Origo™ Arc<br/>410c/650c/810c</i> | <i>Origo™ Feed Airmatic,<br/>M12, M13*</i> | <i>Warrior™ Feed 304**</i> | <i>Warrior™ 400/500***</i> |
|---------------------------------------|--------------|--------------------------------------|--|--------------------------------------|--|----------------------------|----------------------------|
| AT1                                   | 0459 491 896 | ●                                    | ●  | ●                                    |  |                            | ●                          |
| AT1 CF                                | 0459 491 897 | ●                                    | ●  | ●                                    |  |                            | ●                          |
| M1                                    | 0459 491 895 |                                      |  |                                      | ●  | ●                          | ●                          |
| MMA1                                  | 0349 501 024 | ●                                    | ●  | ●                                    |  |                            |                            |
| FS 002                                | 0349 090 886 | ●                                    | ●  |                                      |  |                            |                            |
| <b>Connection Cables 12/8 poles</b>   |              |                                      |  |                                      |  |                            |                            |
| 5 m length                            | 0459 552 880 | ●                                    | ●  | ●                                    |  |                            | ●                          |
| 10 m Length                           | 0459 552 881 | ●                                    | ●  | ●                                    |  |                            | ●                          |
| 15 m length                           | 0459 552 882 | ●                                    | ●  | ●                                    |  |                            | ●                          |
| 25 m length                           | 0459 552 883 | ●                                    | ●  | ●                                    |  |                            | ●                          |
| <b>Connection cables 23 /8 spoles</b> |              |                                      |  |                                      |  |                            |                            |
| 5 m length                            | 0459 553 880 |                                      |  |                                      | ●  | ●                          |                            |
| 10 m length                           | 0459 553 881 |                                      |  |                                      | ●  | ●                          |                            |

\* For step-controlled power sources only the wire speed can be controlled

## AT1

Remote control to set the welding current, MMA & TIG. Fixing mechanism, magnetic feet. Connecting cables available in various lengths

AT1

0459 491 896



## AT1 CoarseFine

Remote control to set the welding current with coarse and fine setting. MMA & TIG, Fixing mechanism, magnetic feet. Connecting cables available in various lengths

AT1 CoarseFine

0459 491 897



## M1

MIG/MAG remote control for voltage and wire feed speed. Fixing mechanism, magnetic feet. Connecting cables available in various lengths

M1

0459 491 895



## FS 002

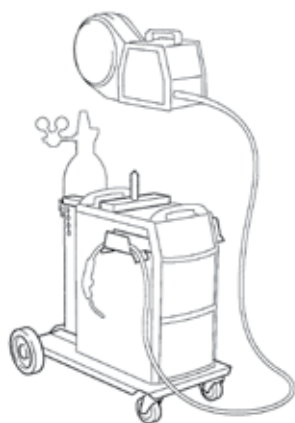
Analogue incl 5 m rubber cable with 12 plug (type C)

FS 002

0349 090 886



# TROLLEYS



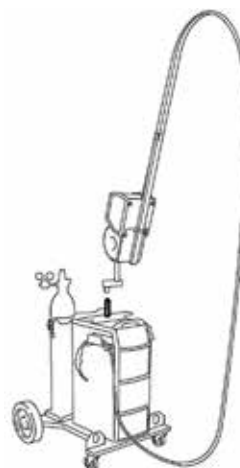
## Trolley 1

### Mig

- Aristo® Mig 5000i
  - Aristo® Mig U4000i/U5000i
- Including arbor.
- Not suitable for counterbalance device.

Trolley 1

0458 530 880



## Trolley 2

### Mig

- Aristo® Mig 5000i
  - Aristo® Mig U4000i/U5000i
- Trolley for counterbalance device or double box operation.
- For two large gas bottles, including two arbors.

Trolley 2

0458 603 880



## Trolley 3

### Tig

- Aristo® Tig 4000i
- Origo™ Tig 4300iw AC/DC

Trolley 3 TIG

0458 530 881



## Trolley 4

### Small gas bottles

This trolley increases the flexibility of the Caddy® Arc/Tig.

For small 5 - 10 l gas bottles

With adjustable handle. Ideal for transport in workshops and service vehicles.

Trolley 4, small

0459 366 885



## Trolley 5

### 2-wheel

- Caddy® Arc 151i/201i
- Caddy® Tig 1500i/2200i
- Caddy® Tig 2200i AC/DC
- Renegade (5.1)

Trolley for large gas bottles 20 - 50 litres. Installation of the device with control panel in the direction of travel.

Trolley 5

0460 330 880

Trolley 5.1

0460 330 881



## Trolley 6

### 2-wheel

- Origo™ Tig 3000i AC/DC
- Origo™ Mig C3000i
- Aristo® Mig C3000i
- Aristo® MechTig 3000i

Universal trolley for MIG and TIG machines, for large gas bottles. Holder for cooling unit CoolMidi 1800.

Trolley 6

0459 366 890





### Trolley 7

#### 4-wheel

- Origo™ Tig 3000i AC/DC
- Origo™ Mig C3000i
- Aristo® Mig C3000i

Universal trolley for MIG and TIG machines.

Holder for Cooling unit CoolMidi 1800.

Trolley 7

0460 060 880



### Trolley 8

#### 2-wheel

- Mig 3001i
- Origo™ Mig 4004i/5004i \*
- Aristo® Mig 4004i Pulse \*

Trolley for MMA, TIG and MIG machines without cooling unit. For central gas supply, no gas bottle holder.

Trolley 8

Shelf for YardFeed and MobileFeed (Large photo)

0460 564 880

0460 815 880

\* Separate fixing brackets to be ordered



### Trolley 9

#### 4-wheel

- Mig 3001i
- Origo™ Mig 4004i/5004i \*
- Aristo® Mig 4004i Pulse \*

Trolley for MIG and TIG machines, with or without cooling unit for large gas bottles. Can also be used with accessories for counterbalance device..

\* For counterbalance device  
Separate fixing brackets to be ordered

Trolley 9

0460 565 880



### Trolley 10

#### Small gas bottles

- Caddy® Mig C160i/C200i
- Rebel

For small 5 - 10 l gas bottles

Trolley 10

0459 366 887



### Trolley 11

#### 4-wheel

- Origo™ Mig 4004i/5004i
- Aristo® Mig 4004i Pulse

Trolley 11

0462 151 880



### Trolley 12

#### 4-wheel

- Warrior™ 400i CC/CV
- Warrior™ 500i CC/CV

Accessory module with extended guide pin can be added. Can also be used with accessories for counterbalance device.

Trolley 12

0465 510 880

# TROLLEYS



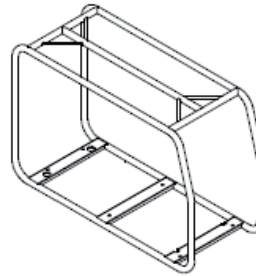
## Trolley 13

### 4-wheel

- Heliarc® 283i AC/DC
- Heliarc® 353i AC/DC

Optional trolley and cooling unit

Providing easy mobility and storage space.



## Protective frame

- Origo™ Arc 4001i
- Mig 3001i/Mig 4001i

Protective frame for MMA, TIG and MIG machines without cooling unit. Lifting and carrying device.

Trolley 13

0558 101 702

Protective frame

0460 459 880

#### Suitable for:

|                  |              |
|------------------|--------------|
| Trolley 1        | 0458 530 880 |
| Trolley 2        | 0458 603 880 |
| Trolley 3        | 0458 530 881 |
| Trolley 4        | 0459 366 885 |
| Trolley 5        | 0460 330 880 |
| Trolley 5.1      | 0460 330 881 |
| Trolley 6        | 0459 366 890 |
| Trolley 7        | 0460 060 880 |
| Trolley 8        | 0460 564 880 |
| Trolley 9        | 0460 565 880 |
| Trolley 10       | 0459 366 887 |
| Trolley 11       | 0462 151 880 |
| Trolley 12       | 0465 510 880 |
| Trolley 13       | 0558 101 702 |
| Protective frame | 0460 459 880 |

|                  | Heliarc® 283i/353i AC/DC | Caddy® Mig C160i/C200i | Aristo® MeshTig 4000iw | Aristo® MeshTig 3000i | Aristo® Mig 5000i | Aristo® Mig LX400i/L5000i | Aristo® Tig 4000i | Origo™ Tig 4300iw AC/DC | Aristo® Mig C3000i | Origo™ Mig C3000i | Origo™ Tig 3000i AC/DC | Caddy® Arc 1s1i/201i/251i | Caddy® Tig 1500i/2200i | Caddy® Tig 2200i AC/DC | Origo/Aristo Mig 3001i | Aristo® Mig 4004i/5004i | Aristo® Mig 4004ii Pulse | Warrior™ 400/500i CC/CV | Renegade series | Rebel series |
|------------------|--------------------------|------------------------|------------------------|-----------------------|-------------------|---------------------------|-------------------|-------------------------|--------------------|-------------------|------------------------|---------------------------|------------------------|------------------------|------------------------|-------------------------|--------------------------|-------------------------|-----------------|--------------|
| Trolley 1        |                          | ●                      |                        | ●                     |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 2        |                          |                        |                        | ●                     |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 3        |                          |                        |                        |                       |                   | ●                         |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 4        |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        | ●                         |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 5        |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        | ●                         |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 5.1      |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         |                          | ●                       |                 |              |
| Trolley 6        |                          |                        |                        |                       |                   |                           |                   |                         | ●                  | ●                 |                        |                           |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 7        |                          |                        | ●                      |                       |                   |                           |                   |                         | ●                  | ●                 |                        |                           |                        |                        |                        |                         |                          |                         |                 |              |
| Trolley 8        |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        | ●                      |                        |                         |                          |                         |                 |              |
| Trolley 9        |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        | ●                      |                        |                         |                          |                         |                 |              |
| Trolley 10       |                          | ●                      |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         |                          |                         |                 | ●            |
| Trolley 11       |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        | ●                       |                          |                         |                 |              |
| Trolley 12       |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         | ●                        |                         |                 |              |
| Trolley 13       | ●                        |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        |                        |                        |                         |                          |                         |                 |              |
| Protective frame |                          |                        |                        |                       |                   |                           |                   |                         |                    |                   |                        |                           |                        | ●                      |                        |                         |                          |                         |                 |              |

# COOLING UNITS AND AUTOTRANSFORMERS



## EC 1000

Compact cooling unit for water cooled TIG torches. No connection kit or tools required. Suited for Renegade ET 300i/ET 300iP.



|                  |              |
|------------------|--------------|
| EC 1000          | 0445 045 880 |
| ESAB Coolant 10l | 0465 720 002 |

## CoolMini

Compact cooling unit for water cooled TIG torches. Suited for Caddy® Tig 2200i and Caddy® Tig 2200i AC/DC.



|                                    |              |
|------------------------------------|--------------|
| CoolMini                           | 0460 144 880 |
| Connection kit for Caddy Tig 2200i | 0460 509 880 |
| ESAB Coolant 10l                   | 0465 720 002 |

## CoolMidi 1000

Compact cooling unit for water cooled torches. Suited for Aristo® Mig 3001i and Origo™ Mig 3001i.



|  |              |
|--|--------------|
| CoolMidi 1000                              | 0460 490 880 |
| Connection kit for Mig 3001i and Tig 3001i | 0460 685 880 |
| Water flow guard                           | 0456 855 881 |
| Water return flow guard                    | 0461 203 880 |
| ESAB Coolant 10l                           | 0465 720 002 |

## CoolMidi 1800

Cooling unit for water cooled torches. Suited for Origo™ Tig 3000i AC/DC, Origo™ Mig C3000i and Aristo® Mig C3000i.



|                         |              |
|-------------------------|--------------|
| CoolMidi 1800           | 0459 840 880 |
| Water flow guard        | 0456 855 881 |
| Water return flow guard | 0461 203 880 |
| ESAB Coolant 10l        | 0465 720 002 |

## COOL 1

Cooling unit for water cooled torches. Suited for Origo™ Mig 4004i/5004i, Aristo® Mig 4004i and Aristo® Mig 4004i Pulse.



|                  |              |
|------------------|--------------|
| COOL 1           | 0462 300 880 |
| Water flow guard | 0456 855 881 |
| ESAB Coolant 10l | 0465 720 002 |

## OCE 2H

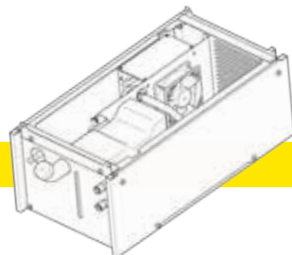
Cooling unit for water cooled torches for manual and mechanized solutions.



|                           |              |
|---------------------------|--------------|
| OCE 2H                    | 0414 191 881 |
| Water flow guard OCE-2 H  | 0414 231 880 |
| Gasket kit for water pump | 0459 699 880 |
| ESAB Coolant 10l          | 0465 720 002 |

## COOL 2

Cooling unit for water cooled torches. Suited for Warrior™ 400i and 500i CC/CV.



|                  |              |
|------------------|--------------|
| COOL 2           | 0465 427 880 |
| ESAB Coolant 10l | 0465 720 002 |

## TUA 1 and TUA 2

Autotransformers suitable for ESAB equipment. TUA 1 Narrow for Origo™ Mig 3001i. TUA 2 Wide for Origo™ Tig 4000i DC, Origo™ Tig 4300i AC/DC and Aristo® Mig 5000i/U4000/U5000i.



|  |              |
|--|--------------|
| TUA 1  | 0459 144 880 |
| TUA 2  | 0459 145 880 |
| Handle for TUA 1 w. mounting screws (2 required) | 0459 307 880 |
| Handle for TUA 2 w. mounting screws (2 required) | 0459 307 881 |

# ARISTO® U8<sub>2</sub> CONTROLLER

## A UNIVERSE OF POSSIBILITIES

### DEVELOPED FOR DURABILITY

ESAB introduced the second generation of Aristo® U8<sub>2</sub> digital controllers offering improved welding capacity and operator convenience.

The new U8<sub>2</sub> has developed as an addition to our Aristo® power sources and wire feed devices is designed for advanced manual and mechanized MIG/MAG welding, Pulsed MIG/MAG, TIG and MMA welding.

### High degree of user-friendliness

Complex controllers are often impossible to understand without an in-depth knowledge of the product. Not so with the new Aristo® U8<sub>2</sub>. The few controls that it has guide the welder intuitively and are ergonomically very easy to use even when wearing protective gloves. The large, bright display is clear and easy to read, with full text in English and in 16 other main languages.

It does not have a multitude of tiny knobs or buttons, nor does it use incomprehensible abbreviations.



### QSet™

QSet™ is the best single parameter automatic arc system on the market for the perfect short arc. The advantages are enormous! You set up the machine with the appropriate gas/wire combination, press the torch switch and start welding within seconds.

The machine determines the optimum parameters and makes any changes as required in a fraction of a second.. The wire stick out which is normally a constant length in MIG/MAG welding, can be varied with QSet™.

Whether you are close to the work piece with the torch or so far away that the gas protection almost ceases, the welding arc remains unchanged - always perfect. Unbeatable in deep seams, if you have to weld around corners or are welding upwards coming out of the downhand position.

Utilised with CO<sub>2</sub> gas you can weld with QSet™ with extremely low levels of spatter and can drastically reduce the gas costs, compared with mixed gas, without any loss of quality. QSet™ is ideal for welding in restricted positions, root welding, GMA brazing and for reproducible results in the series production of parts. QSet™ is also available in many other ESAB controller / machine combinations.

| Controlled functions                | U6 | U8 <sub>2</sub> | U8 <sub>2</sub> Plus |
|-------------------------------------|----|-----------------|----------------------|
| QSet™                               | ●  | ●               | ●                    |
| 2 / 4 -stroke torch controller      | ●  | ●               | ●                    |
| End crater filling                  | ●  | ●               | ●                    |
| Creep start                         | ●  | ●               | ●                    |
| Hot Start                           | ●  | ●               | ●                    |
| Wire burn-back                      | ●  | ●               | ●                    |
| Gas purge and wire inching          | ●  | ●               | ●                    |
| Digital display                     | ●  | ●               | ●                    |
| Pre-programmed synergic lines       | 79 | 111             | 249                  |
| Gas test and tension-free wire feed | ●  | ●               | ●                    |
| Memory slots                        | 10 | 255             | 255                  |
| Pulsed arc / synergic pulsed arc    | ●  | ●               | ●                    |
| Limit values assignation            | ●  | ●               | ●                    |
| File manager                        | -  | -               | ●                    |
| Automatic data backup               | -  | -               | ●                    |
| SuperPulse™                         | -  | -               | ●                    |
| Production statistics               | -  | -               | ●                    |



## Synergy lines

In the Aristo® U8<sub>2</sub> Plus version you have more than 230 synergic lines available to you for your welding applications. From construction steel to Super Duplex, from aluminium to Ni basic alloys or for applications of hard metal. You can create by yourself customized synergic lines for any desired material and any combination of protective gas and save them as new synergic lines. You can transfer data via the USB connection, to another Aristo® U8<sub>2</sub> or to your computer for data backup or exchange by e-mail.

## Quality control

For storage of the measured values you are offered two options in the form of the setting limits and measuring limits. The setting limits prevent the operator from inputting excessively high values for the welding process. The measuring limits ensure that the power source does not exceed the input values. Up to 16 User Accounts on three levels with various access rights and a blocking codes can be used to prevent unauthorized persons from making changes.

## Production statistics

The total arc time, total quantity of material and the number of welding processes can be logged per production statistics item. In addition, the arc time and amount of material for the last welding process are recorded. The calculated molten filler metal per length unit is shown for information purposes.

## SuperPulse™

In order to attain higher welding speeds, deposition rates and better gap bridging, to reduce distortion in the components and to better balance the weld penetration and its profile, you have available in the Aristo® U8<sub>2</sub> Plus a version the ESAB SuperPulse™ function.

SuperPulse™ combines the relevant advantages of the various types of arc. For example, the quality of the pulsed arc with the productivity of the spray arc. Or pulse arc with short arc, to introduce the least amount of heat into the thinnest sheets of metal. Or the combination of two pulsed arcs with different frequencies, for example, for the welding of aluminium with a TIG look. Or a spray arc / short arc for thicker materials in restricted positions.



## FEATURES

- For manual and mechanized applications
- Supports 18 languages
- Large, bright display
- Knobs to set the wire feed speed and tension
- Knob to scroll in the menu
- USB connection to save welding and quality data
- QSet™ the perfect short arc
- Limit value assignment of set / actual values
- Wire free burning
- LAN-compatible (Aristo® W8<sub>2</sub>)
- WeldPoint™ software
- Standard package synergic lines (92)

## ADDITIONAL FUNCTIONS

- Complete package synergic lines (>230)
- SuperPulse™
- File manager
- Automatic welding data backup
- Create your own synergic lines
- Production statistics



For more information see ESAB Tech Tips - a quickguide on Aristo U82 functions XA00174820.

# CONTROL PANELS MIG/MAG

## ORIGO™

## ARISTO®



### M12

- Burn-back time
- Creep start
- Prepared for electric push-pull torches
- Prepared for mechanisation Miggytrac/Railtrac
- 2/4 stroke
- Optional remote control



### U6

MIG/MAG, MMA and TIG as TA6 + MIG/MAG functions:

- Pulsed welding
- Synergic lines (60)
- QSet™
- Creep start
- Crater filling &
- Hot Start (MMA)
- Arc Force (MMA)
- Adjustable burn-back time
- Current slope up / slope down
- Gas pre-flow / post-flow
- 10 memory slots
- Language options
- 2/4 stroke
- Optional digital remote control



### M13

As M12 +

- Crater filling
- TrueArcVoltage™
- Digital V/A-meter



### U82 and U82 Plus

See previous page



### MA23

MIG/MAG and MMA

- 3 memory slots
- Continuous choke setting
- Current slope up / slope down
- Gas pre-flow / post-flow
- MMA functions ArcPlus™ II, Hot Start and Arc Force
- 2/4 stroke
- Digital V/A-meter
- Optional digital remote control



### MA24

As MA23 +

- Synergic lines (35)
- QSet™
- Creep start
- Crater filling



### MA25 Pulse

As MA23 +

- Advanced Pulsed welding
- Steel and Aluminium panel options
- Synergic lines (54/30)
- QSet™
- Hot Start & adjustable burn-back time

# CONTROL PANELS MMA



## ORIGO™



### A11

MMA, gouging and TIG (with scratch start)

- Hot Start
- Arc Force
- Anti Stick

## RENEGADE™



### A35

MMA/TIG (with LiveTIG-start)

- Selection of electrode type, basic, rutile or cellulosic
- Hot Start
- Arc Force
- 3 memory slots
- Digital V/A-meter
- Optional remote control



### A12

As A11 +

- Digital V/A-meter
- Optional remote control N02 or other options

## CADDY®



### A31

MMA and TIG (with scratch start)

- Hot Start (preset)
- Arc Force (preset)



### A13

MMA, gouging and TIG (with scratch start)

- Hot Start
- Arc Force
- Standard with Origo™ Mig 502c/502cw/652x/652cw
- Optional with Origo™ Mig 402c/402cw
- Digital V/A-meter
- Optional remote control



### A32

MMA and TIG (with LiveTIG start)

- Hot Start (background menu)
- Arc Force (background menu)
- ArcPlus™ II
- Drop welding
- Digital V/A-meter
- Optional remote control



### A44

MMA, TIG (with LiveTIG start)  
MIG/MAG (with MobileFeed) and gouging.

- Selection of electrode type, basic, rutile or cellulosic
- Hot Start
- Arc Force
- ArcPlus™ II
- 2+ 2 memory slots
- Digital V/A-meter
- Optional digital remote control



### A33

MMA and TIG (with LiveTIG start)

- Hot Start
- Arc Force
- Drop welding
- 2 + 2 memory slots
- Digital V/A-meter
- Optional remote control



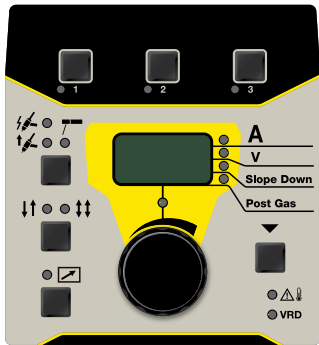
### A34

MMA and TIG (with LiveTIG start)

- Hot Start
- Arc Force
- ArcPlus™ II
- 2 + 2 memory slots
- Digital V/A-meter
- Optional digital remote control

# CONTROL PANELS TIG

## RENEGADE™



### TA35

TIG/MMA

- HF and LiftArc™-start
- Current slope down slope up (background menu)
- Gas post-flow pre-flow (background menu)
- 3 + 3 + 3 memory slots
- 2/4 stroke
- Digital V/A meter
- Hot start / Arc Force (background menu)
- Optional digital remote control

## RENEGADE™



### TA36

TIG/MMA

- TIG DC pulsed welding
- High frequency pulse
- HF and LiftArc™-start
- Current slope up / slope down
- Gas pre-flow / post-flow
- 2/4 stroke
- Digital V/A meter
- Hot start / Arc Force (background menu)
- Optional digital remote control

## ORIGO™ / ARISTO®



### TA4

TIG/MMA and gouging

- HF and LiftArc™-start
- Hot start (MMA)
- Arc Force (MMA)
- Current slope up / slope down
- Gas pre-flow / post-flow
- 2/4-stroke
- Digital V/A-meter

## CADDY®



### TA33

TIG/MMA

- HF and LiftArc™-start
- Sheet thickness parameters
- Current slope down
- Gas post-flow
- 2/4 stroke
- Digital V/A meter



### TA6

As TA4 +

- TIG DC pulsed welding
- MicroPulse
- 10 + 3 memory slots
- Language options
- Optional digital remote control



### TA34

As TA33 +

- TIG DC pulsed welding
- MicroPulse
- Current slope up / slope down
- Gas pre-flow / post-flow
- 2 + 2 memory slots
- Optional digital remote control



### TA24 AC/DC

TIG DC, TIG AC/DC and MMA

- TIG DC pulsed welding
- MicroPulse
- AC frequency
- AC balance
- Electrode preheating
- HF and LiftArc™-start
- Current slope up / slope down
- Gas pre-flow / post-flow
- 2 + 2 memory slots
- 2/4 stroke
- Digital V/A meter
- Optional digital remote control



### TA33 AC/DC

TIG DC, TIG AC/DC and MMA

- HF and LiftArc™-start
- Sheet thickness parameters
- Current slope up / slope down
- Gas pre-flow / post-flow
- 2/4 stroke
- Digital V/A meter
- Optional digital remote control



### TA34 AC/DC

As TA33 AC/DC +

- TIG DC pulsed welding
- MicroPulse
- AC frequency
- AC balance
- Electrode preheating
- 2 + 2 memory slots



## ONLINE WELD MANAGEMENT PLATFORM

WeldCloud™ is a secure, robust and scalable welding data management platform providing insights to facilitate continuous improvement in welding operations by efficiently tracking key parameters for each weld seam produced. This is especially useful for robotic applications as well as other automated solutions.

As the only productivity tracking platform using 3G combined with Wi-Fi and Ethernet, WeldCloud™ can plug into practically any in-house software system, alleviating irritating firewall and connectivity issues.

- **Traceability.** The platform can trace back to welds that have already been created and provide the details.
- **Two-way communication.** The platform can actually push settings to machines while machines can also send data back to the platform.
- **Alert management.** WeldCloud™ automatically pushes out alerts when machines have issues, as needed and scheduled by the user.
- **Simple integration.** Already own ESAB equipment? WeldCloud™ has solutions that can work with compatible ESAB machines and get you up and running and tracking, quickly.
- **User-friendly interface.** WeldClouds™ responsive design makes using the platform easy from wherever you are, on a desktop, at work on a laptop, or on the move on mobile or tablet devices.
- **100% scalable.** Put WeldCloud™ to the test by adding it on one or two machines and adding it onto others over time. You'll also benefit from new features and functionality that are constantly being developed and updated on the platform.



# WeldCloud™



WeldCloud™ is available for the following machines for both manual and robotic welding applications:

**Aristo® Mig 4004i Pulse** - Integrated in power source or integration with existing power source by adding Top Box mounted on machine and Aristo® U8<sub>2</sub> controller.

**Aristo® Mig 5000i/U5000i** - Integrated in power source or integration with existing power source by adding Mobile Back Pack, Aristo® W8<sub>2</sub> mounted on machine and U8<sub>2</sub> controller.

**Origo™ / Aristo® Mig 4002c/5002c/6502c** - Requires Mobile Back Pack, W8<sub>2</sub> mounted on the machine and U8<sub>2</sub> controller.

### Ordering information

|   |              |
|---|--------------|
| Aristo® Mig 4004i Pulse 400V with Top Box               | 0445 301 880 |
| Aristo® Mig 5000i 400V, integrated W82 and WeldCloud™   | 0445 400 880 |
| Aristo® Mig 5000iw 400V, integrated W82 and WeldCloud™  | 0445 400 881 |
| Aristo® Mig U5000iw 400V, integrated W82 and WeldCloud™ | 0445 400 883 |
| WeldCloud™ Mobile Back Pack                             | 0464 550 880 |
| WeldCloud™ Top Box, integrated W82 for Aristo 4004i     | 0445 302 881 |

### Accessories

|   |              |
|---|--------------|
| Aristo® U82   | 0460 820 880 |
| Aristo® U82 Plus  | 0460 820 881 |
| USB Memory 2GB for WeldCloud™                             | 0462 062 001 |
| Interconnection cable W82 - Aristo® Mig 4002c/5002c/6502c | 0462 000 880 |
| Aristo® W82 Fieldbus (DeviceNet)                          | 0460 891 881 |
| Aristo® W82 Fieldbus (Profibus)                           | 0460 891 882 |
| Aristo® W82 Fieldbus (CANopen)                            | 0460 891 883 |
| Aristo® W82 Fieldbus (EtherNet IP)                        | 0460 891 884 |
| Aristo® W82 Fieldbus (EtherCat)                           | 0460 891 885 |
| Aristo® W82 Fieldbus robotic interface kit, DeviceNet *   | 0445 501 880 |
| Aristo® W82 Fieldbus robotic interface kit, Profibus *    | 0445 501 881 |
| Aristo® W82 Fieldbus robotic interface kit, CANOpen *     | 0445 501 882 |
| Aristo® W82 Fieldbus robotic interface kit, EtherNet IP * | 0445 501 883 |
| Aristo® W82 Fieldbus robotic interface kit, EtherCat *    | 0445 501 884 |

\* Kits are required for robotic applications.

WeldCloud is also available on Aristo® Mig 1000 AD/DC SAW for automated welding.

# ROBOTIC WELDING RANGE

## THE IDEAL POWER SOURCES

The Aristo® inverter power sources and the Origo™ chopper power sources are all designed to provide excellent performance in robotic welding. The inverters offer higher energy efficiency and the most advanced process capabilities and the choppers provide smooth operation and excellent robustness with a high tolerance for power supply variations found in some regions.

The power sources are also designed to integrate with ESAB's industry-leading WeldCloud™ online data management platform via Wi-Fi, mobile cellular or hard-wired Ethernet communication. For more details on WeldCloud™ please see page 81.



## ARISTO® ROBOFEED 3004W/3004HW

RoboFeed 3004W and 3004HW (hollow wrist) are digitally controlled feed units perform accurate speed control with the aid of a pulse encoder on speeds ranging from 0.8 to 30.0 m/min. The 4-roll feed mechanism with grooves in both feed and pressure rolls give stable feeding and low wear of the wire.



## ARISTO® U8<sub>2</sub> CONTROL PANEL

The Aristo® U8<sub>2</sub> control panel is used in combination with Aristo® wire feeders to set and adjust welding parameters. The system is developed to meet the most demanding requirements yet is designed to be simple and easy to use. U8<sub>2</sub> allows you to perform Pulsed or Non pulsed welding with solid or flux cored wire on mild/carbon steel as well as on Stainless. Using solid wire, you can also achieve optimal results in aluminium. Optimal synergic lines for robotic and Swift Arc Transfer (SAT™) welding. For more details on U8<sub>2</sub> see page 76.

## ARISTO® W8<sub>2</sub> INTERFACE

Aristo® W8<sub>2</sub> robotic communication interface that gives you full connectivity to the robot and enables WeldCloud™ connectivity. W8<sub>2</sub> utilizes the Anybus fieldbus connections (DeviceNet, Profibus, CANopen, EtherNet IP & EtherCat) for the Aristo® and Origo™ power sources.

| Technical data                   | RoboFeed 3004W  | RoboFeed 3004HW |
|----------------------------------|-----------------|-----------------|
| Primary voltage, V AC, Hz        | 42, 50/60       | 60 DC (PWM)     |
| Drive mechanism                  |                 | 4 WD            |
| Drive rollers, mm                |                 | 30              |
| Wire feed speed, m/min           |                 | 0,8 - 30,0      |
| Dimensions L x W x H, mm         | 362 x 246 x 235 | 251 x 182 x 221 |
| Weight, kg                       | 7,3             | 5,4             |
| Speed control                    |                 | Pulse encoder   |
| <b>Usable wire diameters, mm</b> |                 |                 |
| Mild steel, Stainless steel      |                 | 0,6 - 1,6       |
| Aluminium                        |                 | 1,0 - 1,6       |
| Cored wires                      |                 | 0,8 - 1,6       |



Aristo® W82 Interface

## ARISTO® RT ROBOTIC TORCHES

A full range of ESAB robotic torches is available in gas or water-cooled versions, for both hollow-wrist and standard arm robots. Aristo® robotic torches are the toughest in the industry allowing us to offer the industry's only guaranteed TCP location stability for the first year of operation.

For detailed information on robotic torches please contact your ESAB representative.

| Technical data             | RT72       | RT82W        |
|----------------------------|------------|--------------|
|                            | Air cooled | Water cooled |
| CO <sub>2</sub> at 100%, A | 480        | 600          |
| CO <sub>2</sub> at 60%, A  | 320        | -            |
| Mixed gas at 100%, A       | 400        | 550          |
| Mixed gas at 60%, A        | 270        | -            |

22° torch swan neck supplied as standard.



## OPTIMIZED ROBOTIC WELDING WITH MARATHON PAC™

MarathonPac™ Endless feedability bulk drums for solid wire and cored wire is essential in maximizing production efficiency and quality.

## SWIFT ARC TRANSFER (SAT™)

SAT™ is a high productivity MIG process using AristoRod™ non-copper coated wires with advanced surface characteristics at travel speeds well beyond the limits of normal spray arc welding. The advantage with AristoRod™ non-copper-coated wire over copper-coated wires is that it does not quickly contaminate the feed system with copper particles.

SAT™ is developed for robotic, automated and mechanized welding and suited for fillet and overlap welds in thin to thick plate, in down hand positions. The process uses ESAB power sources together with the RoboFeed for wire feed speeds up to 30m/min in conjunction with U8<sub>2</sub> controller.

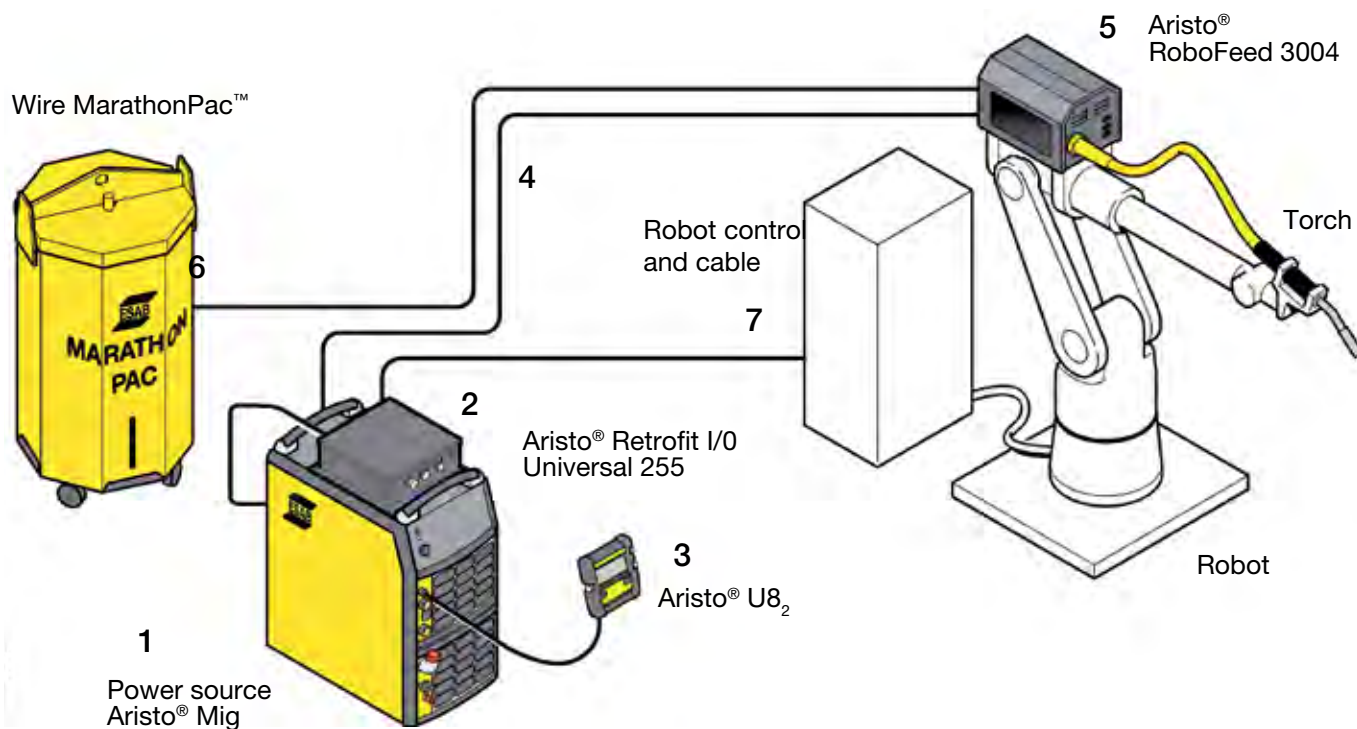
- Synergic lines are available for three AristoRod™ wire sizes and various shielding gases
- SAT™ produces flat welds with a good penetration and without undercut
- An additional advantage is the low heat input, resulting in less deformation



Aristo® Robotic Torches

# RETROFIT I/O UNIVERSAL 255

## ARISTO® ROBOT PACKAGE WITH ROBOFEED 3004W ELP 12P



### Ordering information

#### 1. Power sources

|  |              |
|--|--------------|
| Aristo® Mig 5000i , 400V                       | 0459 230 880 |
| Aristo® Mig 5000iw, 400V                       | 0459 230 881 |
| Aristo® Mig 5000iw, 400V with water flow guard | 0459 230 896 |

#### Accessories for power sources

|   |              |
|---|--------------|
| Water flow guard for Aristo® Mig 5000iw | 0456 855 880 |
| Trolley for Aristo® Mig 5000i/5000iw    | 0461 043 880 |
| Anti return valve                       | 0461 203 880 |

#### 2. 3. Aristo® controller\*

|                                     |              |
|-------------------------------------|--------------|
| Aristo® Retrofit I/O Universal 255* | 0460 090 884 |
| Aristo® U82, Plus I/O *             | 0460 820 883 |

\* The units are delivered with a short connection cable & holder

#### Accessories for Aristo® U82

|                       |              |
|-----------------------|--------------|
| Extension cable 7.5 m | 0460 877 891 |
|-----------------------|--------------|

#### 4. Cable package, power source – wire feeder

|               | Air Cooled   | Water Cooled |
|---------------|--------------|--------------|
| Length 5,0 m  | 0740 538 890 | 0740 538 895 |
| Length 10,0 m | 0740 538 881 | 0740 538 886 |
| Length 15,0 m | 0740 538 882 | 0740 538 887 |
| Length 25,0 m |              | 0740 538 888 |
| Length 35,0 m |              | 0740 538 889 |

### Ordering information

#### 5. Wire feeder\*

|                                |              |
|--------------------------------|--------------|
| Aristo® RoboFeed 3004w ELP 12p | 0461 000 891 |
| Assembly brackets universal    | 0461 173 880 |

\* incl. quick connector Marathon Pac

#### 6. Wire Conduits for MarathonPac™

|                    |              |
|--------------------|--------------|
| Wire conduit 1,8 m | F102 437 881 |
| Wire conduit 3,0 m | F102 437 882 |
| Wire conduit 3,8 m | F102 437 889 |
| Wire conduit 4,5 m | F102 437 883 |
| Wire conduit 6,0 m | F102 437 887 |
| Wire conduit 6,5 m | F102 437 890 |
| Wire conduit 8,0 m | F102 437 884 |
| Wire conduit,0 m   | F102 437 885 |

#### 7. Connection cable, Aristo® Retrofit to robot cabinet\*\*

|       |              |
|-------|--------------|
| 7,5 m | 0461 321 880 |
|-------|--------------|

\*\* Contact the robot integrator for internal robot connections

\* For other feeder alternatives, see the Aristo® robot package sales brochure.

As long as the robot cabinet is equipped with the appropriate I/O board Aristo® Retrofit I/O Universal is a direct fit for: ABB S4, S4C, S4C+, Yaskawa ERC, MRC, XRC, KUKA KRC1, KRC2, Reis RS4, RS5, Fanuc R-J2, R-J3. Remember to always check I/O polarity.

If you cannot find your robot controller in this list, please contact your local ESAB representative.



# MIGGYTRAC™ B501 AND RAILTRAC B42V



## MECHANIZATION MADE EASY

Miggytrac™ B501 is a compact, battery-driven stepper tractor that easily automates your MIG/MAG process. Ideal for use with ESAB's semi-automatic power sources and feed units, Miggytrac B501 features the latest in stepper motor technology for high efficiency. A standard ESAB welding torch can be quickly attached to the unit.

Railtrac B42V is a welding tractor system of components that can be configured to create the optimal solution for your mechanized welding application. To minimize problems associated with harsh environments, most mechanical parts are constructed in aluminum or stainless steel. The system is designed for horizontal and vertical up/down when applicable.

Railtrac B42V can be easily connected to most ESAB wire feeders with no major modification. Remote adapters have to be mounted in feeders Aristo® Feed 3004/4804 and Warrior™ Feed 304. Railtrac B42V features different torch holders for torches and applications.



### Ordering information

|  |              |
|--|--------------|
| Railtrac B42V package                  | 0398 146 016 |
| Miggytrac™ B501 (battery not included) | 0457 357 882 |

Railtrac comes delivered with a universal torch holder Ø10-22 mm and adjusters as standard.

### Miggytrac Options & Accessories

|                                    |              |
|------------------------------------|--------------|
| B501 Magnet kit for front and rear | 0457 357 131 |
| B501 Battery + Battery Charger     | 0457 468 073 |
| B501 Battery                       | 0457 468 070 |
| B501 Battery Charger               | 0457 468 072 |

### Railtrac Options & Accessories

|   |              |
|---|--------------|
| B42V Battery Makita®                            | 0457 468 074 |
| B42V Battery Charger Makita®                    | 0457 468 072 |
| Control Cable Miggytrac/Railtrac 5 m            | 0457 360 880 |
| Connection Cable Universal (only w. 12-pin)     | 0457 360 886 |
| Remote Adapter Kit Miggytrac/Railtrac           | 0465 451 881 |
| Remote Adapter Kit RA 23 CAN Miggytrac/Railtrac | 0459 681 880 |
| Quick-extension bracket for flexible rail       | 0398 146 120 |
| Transformer kit 230 VAC                         | 0457 467 880 |
| Transformer kit 115 VAC                         | 0457 467 882 |
| Floating Head for Torch                         | 0398 145 211 |
| Turning Bracket B42V                            | 0398 145 203 |
| Tilt Bracket Railtrac B42V                      | 0398 145 202 |
| Torch Holder Universal Ø15-30 mm                | 0398 145 106 |
| Torch Holder for PSF                            | 0398 145 101 |
| Flexible Alu Rail, 2.5 m                        | 0398 146 115 |
| Flexible Alu Rail, 5 m                          | 0398 146 119 |
| Flexible Alu Rail, 2.5 m, 8 magnets             | 0398 146 112 |
| Flexible Alu Rail, 2.5 m, 4 vacuum attachments  | 0398 146 113 |
| Stiffener Bar, 2.5 m                            | 0398 146 116 |
| Flip Magnetic Attachment                        | 0398 146 100 |
| Vacuum Attachment, 90°                          | 0398 146 104 |
| Vacuum Attachment, 200°                         | 0398 146 105 |
| Screw Attachment for stiffened rail             | 0398 146 114 |

| Technical data                            | Railtrac<br>B501     |
|---|----------------------|
| Supply voltage, V DC / V AC / * Battery V | 24 -70 / 20 -50 / 18 |
| * Battery running time, h                 | 3 -4                 |
| * Battery power consumption max, W        | 50                   |
| Bending diameter rail min, m              | Ø 1600               |
| Height adjustment slide, mm               | +/-45                |
| Max speed, mm/s                           | 30 (25 with battery) |
| Max load, kg                              | 10 (5 with battery)  |
| Max temperature magnet / vacuum, °C       | 70 / 90              |
| Safety class                              | DIN40050             |
| Dimensions L x W x H, mm                  | 210 x 360 x 270      |
| Weight, kg                                | 8                    |

\* Battery is optional.

| Technical data                                      | Miggytrac™<br>B501 |
|---|--------------------|
| Battery voltage, V DC                               | 18                 |
| Operating time, h                                   | 8                  |
| Travel speed, mm/min                                | 100-1300           |
| Slide adjustment, horizontal, mm                    | ±32                |
| Slide adjustment, vertical, mm                      | ±40                |
| High friction rubber wheel, 4-wheel drive, mm       | 75 x 20            |
| Working temp wheels moving / standing still, °C     | 150 / 70           |
| Horizontal tensile force with / without magnet, kg  | 25 / 12            |
| Max angle, °  | 45                 |
| Vertical tensile force at max angle with magnet, kg | 11                 |
| Dimensions L x W x H, mm                            | 310 x 290 x 250    |
| Weight, kg  | 12                 |



SENTINEL  
AS

ARGON PREMIUM 4.8

ESAB



# TIG WELDING



Tungsten inert gas welding (TIG) is one of the gas-shielded arc welding processes. The arc burns between a tungsten electrode that does not melt and the work piece. The electrodes, the arc and the weld pool are protected against the atmosphere by an inert gas. If a filler metal is required, it is fed in as cold wire, which melts into the weld pool.

It is possible to produce very clean and high-quality welds using the TIG process. There is no spattering, joining defects or undercutting and pores are easily

avoided. The process can be used either manually or partially or fully automated. TIG welding is mostly used on aluminium and high-alloy steels where a higher weld quality is often required.

The TIG process is often used for welding in nuclear facilities and the chemical, aerospace and food industries.



## QWave™

TIG AC welding has been redefined by the unique QWave™ technology: an extremely stable arc with little noise - your advantage: precise completion of the process, top quality, better working environment.



## True AC Rating™

ESAB units with True AC Rating™ always show the actual welding current. That is not necessarily a matter of course.

Inductance in the welding circuit can lead to discrepancies between the set and the actual current strength. Conventional units only show the desired current strength without actually delivering that shown output value

On the other hand, True AC Rating™ ensures the power source really delivers the current output displayed. This is important for monitoring the amount of heat that is applied.

# RENEGADE ET 300i AND 300iP

## POWERFUL AND PORTABLE

The Renegade TIG are inverter based High frequency TIG (HF) and MMA/Stick machines with extreme power to weight ratio. The compact format makes it easy to carry and bring to any jobsite. Combined with high duty cycle and the ability to run the machine on long mains and welding cable makes this a superior welding machine for both on- and off site applications.

The machine has an automatic input voltage sensor and can operate with any input voltage between 208 V and 528 V in 3-phase and 230V in single phase.

Available as none pulsed and as pulsed for thin sheet metal applications.

- Extreme power to weight ratio
- Designed for extreme conditions including up to +55°C ambient temperature
- Widest input voltage tolerance and ability to run on single and three phase with cables up to 100 m
- High speed pulse up to 999 Hz
- Easy to read and quick to set panel increasing the accuracy and reduces the down time
- Modular system with tool less connection to water cooler and trolley
- Rugged composite casing for durability
- IP 23 designed casework suitable for outdoor site work
- For installation and production
- For repair and maintenance



## MOBILE SOLUTIONS FOR PROFESSIONAL WELDING

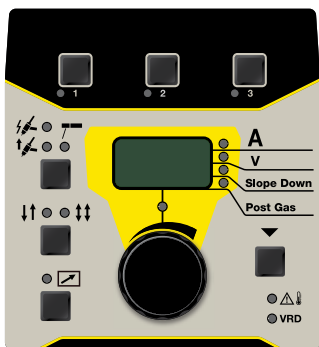


| Technical data*                  | Renegade<br>ET 300i, ET 300iP                              |
|----------------------------------|--|
| Primary Voltage 1 ph, VAC        | 230 VAC +/-10%, 50/60 Hz                                   |
| Primary Voltage 3 ph, VAC        | 230-480 VAC +/-10%, 50/60 Hz                               |
| Fuse Slow, A                     | 16 at 400 V  |
| Energy Save Mode, W              | 88 at 400 V  |
| Maximum Output, A                | 300  |
| PowerFactor at Max Current       | 0.96   |
| Efficiency at Max Current MMA, % | 88   |
| Efficiency at Max Current TIG, % | 84   |
| Open Circuit Voltage, V          | 48   |
| Open Circuit Voltage VRD, V      | 33   |
| Current Range TIG and MMA, A     | 5-300  |
| Approvals                        | CE   |
| Application Class                | S  |
| Protection Class                 | IP23   |
| Mains Cable                      | 3 m 4x2,5 mm <sup>2</sup> (4x4 mm <sup>2</sup> with 230 V) |
| Supply Plug                      | CEE 16 A   |
| Dimensions, Lx W x H, mm         | 460 x 200 x 320  |
| Weight without/with cooler, kg   | 16,9 / 26,9  |

| Maximum output at 40°C | MMA    | TIG    |
|------------------------|--------|--------|
| 40% duty cycle, A/V    | 300/32 | 300/22 |
| 60% duty cycle, A/V    | 250/30 | 250/20 |
| 100% duty cycle, A/V   | 200/28 | 200/18 |

\*Technical data is subject to change.





## CONTROL PANEL TA35

- HF and LiftArc™-start
- Current slope down (slope up can be set in background menu)
- Gas post-flow (pre-flow can be set in background menu)
- 3 + 3 + 3 memory slots, one per process
- Choose between 2 or 4 stroke
- Digital V/A meter to display set or measured values
- Hot start / Arc Force can be set in background menu



## CONTROL PANEL TA36

- TIG DC pulsed welding
- High frequency pulse
- HF and LiftArc™-start
- Current slope up and slope down can be set
- Gas pre-flow and post-flow can be set
- Choose between 2 or 4 stroke
- Digital V/A meter to display set or measured values
- Hot start / Arc Force can be set in background menu



TIG torches at page 102



Optional cooling unit EC 1000

### Ordering information

|  |              |
|--|--------------|
| Renegade ET300i incl 3 m mains cable and plug  | 0445 100 900 |
| Renegade ET300iP incl 3 m mains cable and plug | 0445 100 920 |

### Accessories Renegade ES 300i

|  |              |
|--|--------------|
| Shoulder strap   | 0445 197 880 |
| Trolley 2-wheel (for Renegade)                           | 0460 330 881 |
| TXH 201 TIG Torch 4 m                                    | 0700 300 552 |
| TXH 201TIG Torch 8 m                                     | 0700 300 555 |
| TXH 252w TIG Torch 4 m                                   | 0700 300 855 |
| TXH 252w TIG Torch 8 m                                   | 0700 300 856 |
| EC 1000 Water Cooler                                     | 0445 045 880 |
| ER 1 Remote Control incl. 5 m cable and 6-pin connector  | 0445 536 881 |
| ER 1 Remote Control incl. 10 m cable and 6-pin connector | 0445 536 882 |
| ER 1 Remote Control incl. 25 m cable and 6-pin connector | 0445 536 883 |
| ER 1F Foot Control incl. 5 m cable and 6-pin connector   | 0445 550 881 |
| ER 1F Foot Control incl. 10 m cable and 6-pin connector  | 0445 550 882 |
| 5 m replacement cable with 6-pin conn. for ER 1          | 0445 280 880 |
| 10 m replacement cable with 6-pin conn. for ER 1         | 0445 280 881 |
| 25 m replacement cable with 6-pin conn. for ER 1         | 0445 280 882 |
| 5 m replacement cable with 6-pin conn. for ER 1F         | 0445 254 880 |
| 10 m replacement cable with 6-pin conn. for ER 1F        | 0445 254 881 |



## REMOTE CONTROLLER ER 1

With digital display for accurate reading of welding amperage and other settings.



# CADDY® TIG 1500i AND 2200i DC

## DEVELOPED FOR DURABILITY

The Caddys are equipped with large OKC 50 welding current connections to withstand heavy loads. Due to the compact design with the polymer casing that is impervious to impacts, these devices are light and easy to transport. The large cooling unit and the carefully thought out design ensure a long working life and allow use even under rough working conditions. The inbuilt ArcPlus™ II function further improves the welding arc and ensures that there is less spatter and better restriking of the arc. The Caddy® has been designed in such a way that all the main components in the machine are kept clean and free of dust. Caddy® complies with the requirements of IP 23 and is suitable for use outdoors. The robust construction and the excellent welding properties of the machines ensure reliable use on a day to day basis.

Power Factor Correction - PFC. Caddy® Tig is equipped with automated power factor correction (PFC), which minimizes disturbing feedback effects in the mains supply network and enables maximum use of the available electrical mains supply.

- Professional TIG welding of alloyed, unalloyed and stainless steels
- Large radius of action due to the ability to use intermediate cables.
- Ø 2,5 mm<sup>2</sup> up to 100 m in length without power losses and better compatibility with generators through PFC - Power Factor Correction



- High frequency and LiftArc™ striking
- 2 / 4 stroke torch heliarc
- Professional manual electric welding with ArcPlus™ II regulation and adjustable HotStart and ArcForce
- Polymer-aluminium housing that is impervious to impacts
- Caddy® Tig 2200i optionally gas- or water-cooled with CoolMini cooler
- Cooler with ELP, ESAB LogicPump (forced switching over of the water cooling if required)
- Type of insulation IP 23 - for work outdoors
- Protection against overload
- For site installation and production
- For repair and maintenance
- 2 different trolleys to choose from, page 72



With the environment in mind  
Active power factor connection  
Efficient energy utilisation  
Harmonics EN 61000-3-12  
RoHS 2002/95/E

PFC





## CONTROL PANEL TA33

- Selection of the TIG parameters by inputting the sheet thickness
- Current fall time can be set
- Gas post-flow can be set
- Digital display



## CONTROL PANEL TA34

- Graphic illustration of the course of the process
- TIG pulse-welding
- Micro-pulses up to 0.001 s
- Current rise / fall time can be set
- Gas pre-flow / post-flow time can be set
- Parameter storage (2x), can also be called up during welding via the torch button
- TIG torches with Up/Down remote controller
- Can be controlled remotely / digital display

### Ordering information, complete packages

|  |                     |
|--|---------------------|
| ● Caddy® Tig 1500i TA33, with 3m welding cables and torch TXH 151, 4 m                 | <b>0460 450 880</b> |
| ● Caddy® Tig 2200i TA33, with 3m welding cables and torch TXH 201, 4 m                 | <b>0460 450 881</b> |
| ● Caddy® Tig 1500i TA34, with 3m welding cables and torch TXH 151, 4 m                 | <b>0460 450 882</b> |
| ● Caddy® Tig 2200i TA34, with 3m welding cables and torch TXH 201, 4 m                 | <b>0460 450 883</b> |
| ● Caddy® Tig 2200iw TA33, with cooling unit, 3m welding cables and torch TXH 251w, 4 m | <b>0460 450 884</b> |
| ● Caddy® Tig 2200iw TA34, with cooling unit, 3m welding cables and torch TXH 251w, 4 m | <b>0460 450 885</b> |

### Ordering information, machines

|   |                     |
|---|---------------------|
| Caddy® Tig 1500i, TA33 ●                | <b>0460 450 890</b> |
| Caddy® Tig 2200i, TA33 ●                | <b>0460 450 891</b> |
| Caddy® Tig 1500i, TA34 ●                | <b>0460 450 892</b> |
| Caddy® Tig 2200i, TA34 ●                | <b>0460 450 893</b> |
| Caddy® Tig 2200iw, TA33 water cooling ● | <b>0460 450 894</b> |
| Caddy® Tig 2200iw, TA34 water cooling ● | <b>0460 450 895</b> |

| Technical data             | Caddy® Tig 1500i | Caddy® Tig 2200i |
|----------------------------|------------------|------------------|
| Mains supply, V / ph       | 230 / 1          |                  |
| Fuse, slow, A              | 16               |                  |
| Setting range, TIG (DC), A | 3 - 150          | 3 - 220          |
| Setting range, MMA (DC), A | 4 - 150          | 4 - 170          |
| Open circuit voltage, V    | 55 - 60          | 55 - 60          |
| Dimensions, LxWxH, mm      | 418 x 188 x 208  |                  |
| Weight, kg                 | 9,2              | 9,4              |
| Enclosure class            | IP 23            |                  |
| Application class          | S                |                  |

### Maximum output at 40°C, TIG

|                      |     |     |
|----------------------|-----|-----|
| 20% duty cycle, A/V  | 150 | 220 |
| 60% duty cycle, A/V  | 120 | 150 |
| 100% duty cycle, A/V | 110 | 140 |

### Maximum output at 40°C, MMA

|                      |     |     |
|----------------------|-----|-----|
| 20% duty cycle, A/V  | 150 | 170 |
| 60% duty cycle, A/V  | 100 | 130 |
| 100% duty cycle, A/V | 90  | 110 |

### Cooling unit CoolMini for Caddy® 2200i

|   |                 |
|---|-----------------|
| Weight, without/with cooling liquid, kg | 4,5 / 6,7       |
| Dimensions, LxWxH, mm                   | 407 x 188 x 151 |

### Accessories

|  |                     |
|--|---------------------|
| Adapter for remote-controller torches                      | <b>0459 491 912</b> |
| Foot-operated remote controller T1 Foot CAN, with 5m cable | <b>0460 315 880</b> |
| Shoulder strap   | <b>0460 265 003</b> |
| Pressure reducer with flux-meter                           | <b>0760 030 300</b> |
| ESAB Coolant 10l   | <b>0465 720 002</b> |
| Electrode holder, 150 A, 3m cable ●●                       | <b>0700 006 898</b> |
| Electrode holder, 200 A, 3m cable ●●●●                     | <b>0700 006 900</b> |
| CoolMini cooling unit ●●                                   | <b>0460 144 880</b> |
| Cooling unit mounting kit for Tig 2200i                    | <b>0460 509 880</b> |



### Delivery includes

3m mains cable with CEE plug, 3m earth cable, 2m gas hose with clamps.





WARRIOR™ Tech

ESAB



# BUDDY™ TIG 160



## PORTABLE SOLUTIONS FOR PROFESSIONAL WELDING

The Buddy™ family is a series of robust and durable power source for the professional welders. The machines provides state-of-the-art welding performance and reliability through use of the latest high grade IGBT technology.

### Designed for durability

Buddy™ TIG 160 is a user friendly, robust and still light weight DC TIG machine, offering HF start and a stick (MMA) mode.

The internal electronics are cooled by a highly efficient fan for added reliability and monitored by a thermal protection system. The machine has been equipped with three heat sinks which further extending the life time of the product. The casing has been designed to withstand harsh environments and is rated to IP 23S standard. The machine incorporates both a shoulder strap and a robust carry handle.

Buddy™ TIG 160 provides good TIG welding with smooth arc characteristics. The HF arc start prevents contamination of the weld material and electrode. The built in gas valve automatically controls the gas flow ensuring a low gas consumption. The operator can chose between 2 stroke and 4 stroke torch trigger mode. The machine can weld mild steel or stainless steel with or without filler material.

### Ideal applications

- Plant Fabrication & Maintenance
- Site Maintenance/Repair
- Civil Construction
- General Fabrication
- Agriculture



The control panel on the Buddy™ TIG 160 features one adjustment knob to set the weld current and one to set the slope down time in TIG mode or the arc force in MMA mode.

| Technical data                     | Buddy™ TIG 160 |
|------------------------------------|----------------|
| Mains supply, V / ph Hz            | 230 / 1, 50/60 |
| Fuse, slow, A                      | 16             |
| Setting range MMA / TIG , A        | 5 - 160        |
| Phase current I <sub>eff</sub> , A |                |
| MMA                                | 14,6           |
| TIG (DC)                           | 0,2            |
| Dimensions, LxWxH, mm              | 310x140x230    |
| Weight, kg                         | 6,0            |
| Enclosure class                    | IP 23S         |
| Application class                  | S              |

| Maximum output at 40°C, MMA |            |
|-----------------------------|------------|
| 60% duty cycle, A           | 105 / 24,2 |
| 100% duty cycle, A          | 85 / 23,4  |

| Maximum output at 40°C, TIG (DC) |            |
|----------------------------------|------------|
| 60% duty cycle, A                | 105 / 14,2 |
| 100% duty cycle, A               |            |

| Ordering information       |              |
|----------------------------|--------------|
| Buddy™ Arc 145 CE          | 0700 300 884 |
| Buddy™ Arc 180 CE c/w Plug | 0700 300 680 |
| Buddy™ TIG 160 CE c/w Plug | 0700 300 681 |

| Package includes:                          |              |
|--|--------------|
| 3m Welding cable and return cable kits.    |              |
| TIG Torch ET 17v 4 m (Buddy™ TIG 160 Only) | 0700 300 861 |

# ARISTO® TIG 4000iw DC

The Aristo® Tig 4000iw is the ideal partner for MMA and TIG DC welding in your operation. Unalloyed and low-alloy steels, stainless steels, copper alloys and nickel-based materials can be welded with Aristo® Tig 4000iw with an extremely stable arc and excellent striking properties. A powerful device for production welding, repair or servicing work.

Select what is the optimal unit for you:

## Aristo® TA4

includes the main functions for professional TIG welding

## Aristo® TA6

Extends the TIG functions to include TIG pulse-welding for the optimal application of heat to sheet thicknesses above 0.5 mm.

Optionally, TIG torches with Up/Down remote controller to set the welding current during welding are available, also with flexible torch head.

Both control panels are characterized by simple to operate parameter settings.



- Inverters based on IGBT technology - high performance and reliability
- Excellent welding properties - high utility and high quality
- Housing with frame made of Alutech™ extruded profile, can be lifted by crane
- Dust filter included - reduces possible failures due to deposits of grinding dust, for example
- TIG torches are available with Up/Down remote control
- Energy-saving mode after 6.5 minutes
- ELP, ESAB LogicPump, starts the water pump automatically
- MMA electrodes up to 6.0 mm
- Carbon arc gouging up to 8.0 mm
- Can be controlled remotely, digital display
- IP 23 - allows use outdoors

| Technical data                           | Aristo® Tig 4000iw |
|--|--------------------|
| Mains supply, V / ph                     | 400 / 3            |
| Fuse, slow, A                            | 20                 |
| Setting range, TIG (DC), A               | 4 - 400            |
| Open circuit voltage, V                  | 78 - 90            |
| Open circuit power, W                    | 60                 |
| Power factor (TIG)                       | 0,9                |
| Efficiency at max power (TIG), %         | 86                 |
| Dimensions, incl.cooling unit, LxWxH, mm | 625 x 394 x 776    |
| Weight, incl.cooling unit, kg            | 81,5               |
| Enclosure class                          | IP 23              |
| Application class                        | S                  |
| Cooling power, W (l/min)                 | 2000 (2,0)         |
| Coolant capacity, liter                  | 5,5                |

| Maximum output at 40°C, TIG |     |
|-----------------------------|-----|
| 35% duty cycle, A           | 400 |
| 60% duty cycle, A           | 320 |
| 100% duty cycle, A          | 250 |



## CONTROL PANEL TA4

- TIG and MMA welding, carbon arc gouging
- High frequency and LiftArc™ striking
- 2 / 4 stroke torch switch
- Simple parameter setting for the current rise time, welding current, current fall time and gas pre- and post-flow time
- MMA welding with HotStart and ArcForce



## CONTROL PANEL TA6

- TIG and MMA welding, carbon arc gouging
- Multi-lingual menu guidance
- High frequency and LiftArc™ striking
- 2 / 4 stroke torch switch
- TIG pulse-welding with DC
- Micro-pulses up to 0.001 s
- Gas flushing, gas pre- and post-flow
- Current rise time, welding current, current fall time
- 10 memory storage slots
- 3 memories for parameters that can be called up before, after or during welding from the torch button
- Minimum current setting for remote controller
- Limit value assignment and password protection
- MMA welding with Hot Start and Arc Force

### Ordering information

|                         |              |
|-------------------------|--------------|
| Aristo® Tig 4000iw, TA4 | 0458 630 881 |
| Aristo® Tig 4000iw, TA6 | 0458 630 885 |
| Trolley                 | 0458 530 881 |

### Accessories

|  |              |
|--|--------------|
| ESAB Coolant 10l   | 0465 720 002 |
| Water flow guard   | 0456 855 880 |
| Multi-voltage unit (208-575V 50/60Hz)                      | 0459 145 880 |
| Adapter for remote-controller torches                      | 0459 491 912 |
| Foot-operated remote controller T1 Foot CAN, with 5m cable | 0460 315 880 |
| Pressure reducer with flux-meter                           | 0760 030 300 |
| Electrode holder with 5m cable                             | 0700 006 892 |

### Delivery includes

5m mains cable with CEE plug, 4,5m earth cable, 2m gas hose with clamps.



TIG torches at page 102



Gouging torches, see ESAB Accessories catalogue



Remote controller at page 68



# CADDY® TIG 2200i AC/DC

## FOR COMMERCE AND INDUSTRY WITH TOUGH DEMANDS FOR REPAIR AND SERVICING WORK

The Caddy® are equipped with large OKC 50 welding current connections to withstand heavy loads. Due to the compact design with the polymer casing that is impervious to impacts, these devices are light and easy to transport. The large cooling unit and the carefully thought out design ensure a long working life and allow use even under rough working conditions. The inbuilt ArcPlus™ II function further improves the welding arc and ensures that there is less spatter and better restriking of the arc.

The Caddy® has been designed in such a way that all the main components in the machine are kept clean and free of dust. Caddy® complies with the requirements of IP 23 and is suitable for use outdoors. The robust construction and the excellent welding properties of the machines ensure reliable use on a day to day basis.

Power Factor Correction - PFC. Caddy® Tig is equipped with automated power factor correction (PFC), which minimizes disturbing feedback effects in the mains supply network and enables maximum use of the available electrical mains supply.

Furthermore, the devices are less sensitive to fluctuations in the mains power supply and thus allow operation from generators.



**TIG AC/DC WELDING**

- Professional TIG AC/DC welding
- QWave™ - quiet and highly dynamic AC arc
- True AC Rating™ - correct display of the actual welding current
- Large radius of action, over 100 m with mains cable cross-section 2.5 mm<sup>2</sup> and improved compatibility with generators through PFC - Power Factor Correction
- High frequency and LiftArc™ striking
- 2 / 4 stroke torch switch actions
- Professional MMA welding with DC and AC
- ArcPlus™ regulation with adjustable HotStart, ArcForce and switchable polarity (DC)
- Type of insulation IP 23 - for work outdoors
- Polymer-aluminium housing that is impervious to impacts
- ELP, ESAB LogicPump, automatically switches the water cooling
- Protection against overtemperatures
- For installation and production
- For repair and maintenance
- TIG torches with Up/Down remote controller
- Caddy® Tig 2200i AC/DC optionally gas- or water-cooled with CoolMini cooler
- 2 different trolleys to choose from, page 72



With the environment in mind  
 Active power factor connection  
 Efficient energy utilisation  
 Harmonics EN 61000-3-12  
 RoHS 2002/95/E

PFC

Trolley 0460 330 880





## CONTROL PANEL TA33 AC/DC

- Selection of the TIG parameters by inputting the sheet thickness
- Current slope up / slope down can be set
- Gas pre-flow / post-flow time can be set
- Minimum current setting for remote controller
- Can be controlled remotely / digital display



## CONTROL PANEL TA34 AC/DC

- Graphic illustration of the course of the process
- AC frequency and balance monitoring optimizes the weld pool
- TIG pulse-welding with DC
- DC micro-pulses up to 0.001 s
- Electrode preheating for better striking and longer life of the electrodes in AC welding
- Current slope up / slope down can be set
- Gas pre-flow / post-flow time can be set
- Parameter storage (2x), can also be called up during welding via the torch button
- Minimum current setting for remote controller
- Can be controlled remotely / digital display

### Technical data Caddy® Tig 2200i AC/DC

|                                  |                 |
|----------------------------------|-----------------|
| Mains supply, V / ph             | 230 / 1         |
| Fuse, slow, A                    | 16              |
| Setting range, TIG (AC/DC), A    | 3 - 220         |
| Setting range, (MMA), A          | 4 - 160         |
| Open circuit voltage, V          | 55 - 60         |
| Power factor (TIG)               | 0,99            |
| Efficiency at max power (TIG), % | 66              |
| Dimensions, LxWxH, mm            | 418 x 188 x 345 |
| Weight, kg                       | 15              |
| Enclosure class                  | IP 23           |
| Application class                | S               |

### CoolMini cooling unit

|   |                 |
|---|-----------------|
| Weight, without/with cooling liquid, kg | 4,5 / 6,2       |
| Dimensions, LxWxH, mm                   | 407 x 188 x 151 |

### Maximum output at 40°C, TIG

|                      |     |
|----------------------|-----|
| 20% duty cycle, A/V  | 220 |
| 60% duty cycle, A/V  | 150 |
| 100% duty cycle, A/V | 140 |

### Maximum output at 40°C, MMA

|                      |     |
|----------------------|-----|
| 30% duty cycle, A/V  | 160 |
| 60% duty cycle, A/V  | 120 |
| 100% duty cycle, A/V | 110 |

### Accessories

|  |              |
|--|--------------|
| Adapter for remote-controller torches                      | 0459 491 912 |
| Foot-operated remote controller T1 Foot CAN, with 5m cable | 0460 315 880 |
| Shoulder strap   | 0460 265 003 |
| Pressure reducer with flux-meter                           | 0760 030 300 |
| ESAB Coolant 10l   | 0465 720 002 |
| Electrode holder 200A with 3m cable                        | 0700 006 900 |



### Ordering information, complete packages

- Caddy® Tig 2200i AC/DC, TA33 AC/DC, torch TXH™201 4m and kit MMA **0460 150 882**
- Caddy® Tig 2200i AC/DC, TA34 AC/DC, torch TXH™201 4m and kit MMA **0460 150 883**
- Caddy® Tig 2200i AC/DC, TA34 AC/DC, torch TXH™ 251w 4m, CoolMini, kit MMA and 2-wheels trolley **0460 150 884**

### Ordering information, machines

- Caddy® Tig 2200i AC/DC, TA34 AC/DC **0460 150 880**
- Caddy® Tig 2200i AC/DC, TA33 AC/DC **0460 150 881**
- CoolMini cooling unit **0460 144 880**

### Delivery includes

3m mains cable with CEE plug, 3m earth cable, 2m gas hose with clamps.

# ORIGO™ TIG 3000i AC/DC AND 4300iw AC/DC

FOR DEMANDING APPLICATIONS IN TIG WELDING



- Professional TIG AC/DC welding
- QWave™ - quiet and highly dynamic AC arc
- True AC Rating™ - correct display of the actual welding current
- Professional MMA welding with Origo™ TIG 4300iw AC/DC
- ArcPlus™ regulation, HotStart, ArcForce can be set and switchable polarity (DC)
- IP 23 protection - for work outdoors
- Energy-saving mode after welding is interrupted
- Digital display
- Protection against overtemperatures
- Origo™ TIG 4300iw AC/DC, can be lifted by crane

- Two different trolleys for Origo™ TIG 3000i AC/DC
- Origo™ TIG 3000i AC/DC optionally gas- or water-cooled with cooler CoolMidi 1800
- ELP, ESAB LogicPump, automatically switches the water cooling
- TIG torches with Up/Down remote control



| Technical data                   | Tig 3000i<br>TA24 AC/DC | Tig 4300iw<br>TA24 AC/DC |
|----------------------------------|-------------------------|--------------------------|
| Mains supply, V / ph             |                         | 400 / 3                  |
| Fuse, slow, A                    | 20                      | 25                       |
| Setting range, TIG (AC/DC), A    | 4 - 300                 | 4 - 430                  |
| Setting range, (MMA), A          | 16 - 300                | 16 - 430                 |
| Current slope-up, sec            |                         | 0 - 10                   |
| Current slope-down, sec          |                         | 0 - 10                   |
| Gas post-flow, sec               |                         | 0 - 25                   |
| Pulse frequency DC, sec          |                         | 0,01 - 2,5               |
| Open circuit voltage, V          | 54 - 67                 | 83                       |
| Power factor (TIG)               | 0,65                    | 0,89                     |
| Efficiency at max power (TIG), % | 77                      | 76                       |
| Dimensions, LxWxH, mm            | 652 x 412 x 423         | 625 x 394 x 776          |
| Weight, kg                       | 42                      | -                        |
| Weight with cooling unit., kg    | -                       | 95                       |
| Enclosure class                  | IP 23                   | IP 23                    |
| Application class                |                         | S                        |

| Maximum output at 40°C, TIG |     |     |
|-----------------------------|-----|-----|
| 35% duty cycle, A           | 300 | -   |
| 40% duty cycle, A           | -   | 430 |
| 60% duty cycle, A           | 240 | 400 |
| 100% duty cycle, A          | 200 | 315 |

| CoolMidi 1800 cooling unit              |            |            |
|---|------------|------------|
| Cooling power, W (l/min)                | 1600 (1.2) | 2000 (2,0) |
| Cooling liquid capacity, liter          | 4,2        | 5,5        |
| Weight, without/with cooling liquid, kg | 19 / 23    | -          |
| Dimensions, LxWxH, mm                   |            | -          |

\* CoolMidi 1800 is valid only for Tig 3000i AC/DC.  
Tig 4300i AC/DC has the cooling unit integrated.



## CONTROL PANEL TA24 AC/DC

- Graphic illustration of the course of the process
- High frequency and LiftArc™ striking
- 2 / 4 stroke torch switch action
- AC frequency and balance monitoring optimizes the weld pool
- TIG pulse-welding with DC
- DC micro-pulses up to 0.001 s
- Electrode preheating for better striking and longer life of the electrodes in AC welding
- Current slope up / slope down can be set
- Gas pre-flow / post-flow time can be set
- Parameter storage (2x), can also be called up during welding via the torch button
- Minimum current setting for remote controller
- Can be controlled remotely / digital display



### Complete Package

- Origo™ Tig 3000i AC/DC TA24 + MMA welding cables
- + CoolMidi 1800 + torch TXH™ 251w
- + 4-wheels trolley

0459 795 882

### Ordering information

#### Origo™ Tig 3000i, TA24

|                              |   |              |
|------------------------------|---|--------------|
| Origo™ Tig 3000i, TA24 AC/DC | ○ | 0459 735 880 |
| CoolMidi 1800 cooling unit   | ○ | 0459 840 880 |
| Two-wheels trolley           |   | 0459 366 890 |
| Four-wheels trolley          | ○ | 0460 060 880 |

#### Origo™ Tig 4300i, TA24 water cooling

|                               |  |              |
|-------------------------------|--|--------------|
| Origo™ Tig 4300iw, TA24 AC/DC |  | 0460 100 880 |
| Four-wheels trolley           |  | 0458 530 881 |

### Accessories

|  |   |              |
|--|---|--------------|
| Adapter for remote-controller torches                      |   | 0459 491 912 |
| Foot-operated remote controller T1 Foot CAN, with 5m cable |   | 0460 315 880 |
| Pressure reducer with flow meter                           |   | 0760 030 300 |
| ESAB Coolant 10l   |   | 0465 720 002 |
| Electrode holder with 3m cable                             | ○ | 0700 006 888 |



TIG torches at page 102



Remote controller at page 68

### Delivery includes

5m mains cable with CEE plug, 4,5m earth cable, 2m gas hose with clamps.

# HELIARC™ 283i AND 353i AC/DC

## HIGH QUALITY AC/DC TIG & MMA WELDING

The new Heliarc power sources have everything you need for advanced AC/DC TIG welding of Aluminium, Aluminium alloys, magnesium alloys, stainless steel, mild steel and copper alloys. Heliarc weld stick electrodes, even difficult to start 'Cellulosic' AWS 60XX.

Heliarc has the functionality to achieve excellent results. AC & DC pulse, extended AC frequency & balance controls, Ability to store 60 programs and the ability to switch between two amperage levels while welding are just a few of the features.

**AC & DC Pulse** - Used to regulate heat input, particularly advantageous on thin materials. Using pulse, increases arc stability & puddle control for faster welding speeds with less plate deformation.

**Extended AC Balance** - Reduces tungsten erosion and provides operators with improved penetration or cleaning effect essential for high quality welds.

**Extended AC Frequency** - Permits the use of smaller tungsten electrodes, maintains tungsten shape. provides a focused, narrow and more efficient arc cone resulting in improved penetration, narrow weld bead (requiring less filler material) lower heat input and increased travel speed improve efficiency helping reduce costs.

**AC Hot-start** at low amp AC TIG gives accurate starts when welding thin plates.



- High quality TIG-welding - Exceptional performance across a wide variety of materials.
- Excellent Arc control - Stable arc characteristics and settings provide excellent arc control and fast welding speed
- Hot start AC - Excellent arc starts at low Amp AC TIG welding
- AC or DC Pulsed TIG welding - Easy control of heat input and the weld pool. enhanced aesthetic weld bead appearance
- Dual TIG function - Switch between two weld current levels while welding via torch switch. Allows operator to manually control weld puddle fluidity
- Superior Stick (SMAW) performance - Even with 60XX electrodes
- Liftarc Mode even on AC - Ideal for applications where HF (High Frequency) is not permitted
- Inverter / microprocessor technology - Highly efficient with low input power requirements
- AC Pulsing 0.2-2Hz - Ideal for thin gauge Aluminium







Heliarc™ 35i AC/DC Panel

| Technical data                              | Heliarc™    |             |
|---|-------------|-------------|
|   | 283i AC/DC  | 353iAC/DC   |
| Setting range TIG AC/DC,A                   | 4-280       | 4-350       |
| Mains Supply V/Ph/Hz                        | 400/3/50,60 | 400/3/50,60 |
| Fuse type, A                                | 20          | 25          |
| Gas pre-flow, sec                           | 0,5-30      | 0,5-30      |
| Slope-up time, sec                          | 0,1-10      | 0,1-10      |
| gas-post flow, sec                          | 0,5-30      | 0,5-30      |
| Frequency AC, Hz                            | 20-200      | 20-200      |
| AC balance, %                               | 10-90       | 10-90       |
| DC Pulse frequency, Hz                      | 0,4-300     | 0,4-300     |
| AC Pulse frequency, Hz                      | 0,4-2       | 0,4-2       |
| Pulse Duty(pulse time/background time),%    | 30-65       | 30-65       |
| Background current, % of main A             | 10-90       | 10-90       |
| Slope down time, sec                        | 0,1-10      | 0,1-10      |
| Start/crater current,(4 stroke) % of main A | 10-90       | 10-90       |
| Post purge time, sec                        | 0,5-30      | 0,5-30      |
| Open circuit voltage, max                   | 68          | 68          |
| Power factor at 100 %, TIG mode             | 0,75        | 0,8         |
| Setting range MMA                           | 4-280       | 4-350       |
| Maximum output MMA, DC/AC                   |             |             |
| At 20 % duty cycle, MMA, A                  | -           | 350         |
| At 40 % duty cycle MMA, A                   | 280         | -           |
| KvA TIG, max                                | 11          | 14,5        |
| KVA MMA, max                                | 14,2        | 19          |
| Enclosure class                             | IP21S       | IP21S       |
| External dimensions, LxWxH,mm               | 600x300x620 | 600x300x620 |
| Weight, kg power source                     | 50          | 50          |
| Weight kg Cooling unit without fluid        | 15          | 15          |
| Weight trolley                              | 35          | 35          |
| Standards: IEC 60974-1,3,10                 |             |             |

#### Maximum output TIG DC/AC

|                            |     |     |
|----------------------------|-----|-----|
| At 45% duty cycle, TIG, A  | -   | 350 |
| At 60 % duty cycle TIG, A  | -   | 300 |
| At 100 & duty cycle TIG, A | 280 | -   |

#### Maximum output MMA DC/AC

|                           |     |     |
|---------------------------|-----|-----|
| At 20% duty cycle, TIG, A | -   | 350 |
| At 40 % duty cycle TIG, A | 280 | -   |

#### Complete Package

|                            |              |
|----------------------------|--------------|
| Heliarc™ 283i gas-cooled   | 0479 000 006 |
| Heliarc™ 283i water-cooled | 0479 000 005 |
| Heliarc™ 353i water-cooled | 0479 000 004 |

#### Ordering information

|                             |              |
|-----------------------------|--------------|
| Heliarc™ 283i AC/DC 400V CE | 0700 300 701 |
| Heliarc™ 353i AC/DC 400V CE | 0700 300 702 |

#### Accessories

|                                  |              |
|----------------------------------|--------------|
| Water Cooler                     | 0700 300 703 |
| Four-wheels trolley              | 0558 101 702 |
| Foot Control FC5                 | 0558 004 234 |
| TXH™ 251w 8 m Wheel Remote       | 0700 300 569 |
| TXH™ 251wF Flex 8 m Wheel Remote | 0700 300 663 |
| TXH™ 401w, 4 m, OKC 5            | 0700 300 565 |
| TXH™ 401w HD, 4 m, OKC 50        | 0700 300 566 |
| TXH™ 401w, 8 m, OKC 50           | 0700 300 567 |
| TXH™ 401w HD, 8 m, OKC 50        | 0700 300 568 |
| TXH™ 401w 8 m Wheel Remote       | 0700 300 660 |



Additional TIG torches see page 102

# TXH™ TIG TORCHES

## FOR THE DEMANDING WELDER

The main characteristic of the TXH™ torches is above all their quality. The torches and torch fittings offer a maximum amount of convenience, versatility and ergonomics.

You can vary between air- or water-cooled, with or without gas-valve and with or without flexible neck to suite your individual application.



### Ordering information

#### Self-cooled torches

|                        |                |
|------------------------|----------------|
| TXH™ 121, 4 m OKC 50   | 0700 300 524   |
| TXH™ 121, 8 m OKC 50   | 0700 300 529   |
| TXH™ 151, 4 m OKC 50   | 0700 300 538   |
| TXH™ 151, 8 m OKC 50   | 0700 300 544   |
| TXH™ 201, 4 m OKC 50   | 0700 300 552   |
| TXH™ 201, 8 m OKC 50   | 0700 300 555   |
| TXH™ 121, 4 m OKC 25 C | 0700 300 522** |
| TXH™ 121, 8 m OKC 25 C | 0700 300 527** |
| TXH™ 121, 4 m OKC 25   | 0700 300 532*  |
| TXH™ 121, 8 m OKC 25   | 0700 300 534   |
| TXH™ 151, 4 m OKC 25   | 0700 300 548*  |
| TXH™ 151, 8 m OKC 25   | 0700 300 550*  |
| TXH™ 151, 4 m OKC 25 C | 0700 300 536** |
| TXH™ 151, 8 m OKC 25 C | 0700 300 542** |
| TXH™ 201, 4 m OKC 25   | 0700 300 558   |
| TXH™ 201, 8 m OKC 25   | 0700 300 560   |

\* Only Origo Tig 150i

\*\* Only Caddy Tig 150i

#### With gas valve

|                       |              |
|-----------------------|--------------|
| TXH™ 121V, 4 m OKC 25 | 0700 300 523 |
| TXH™ 121V, 8 m OKC 25 | 0700 300 528 |
| TXH™ 151V, 4 m OKC 25 | 0700 300 537 |
| TXH™ 151V, 8 m OKC 25 | 0700 300 543 |
| TXH™ 151V, 4 m OKC 50 | 0700 300 539 |
| TXH™ 151V, 8 m OKC 50 | 0700 300 545 |
| TXH™ 201V, 4 m OKC 50 | 0700 300 553 |
| TXH™ 201V, 8 m OKC 50 | 0700 300 556 |

#### With flexible head

|                       |              |
|-----------------------|--------------|
| TXH™ 121F, 4 m OKC 25 | 0700 300 525 |
| TXH™ 121F, 8 m OKC 25 | 0700 300 530 |
| TXH™ 121F, 4 m OKC 50 | 0700 300 526 |
| TXH™ 121F, 8 m OKC 50 | 0700 300 531 |
| TXH™ 151F, 4 m OKC 25 | 0700 300 540 |
| TXH™ 151F, 8 m OKC 25 | 0700 300 546 |
| TXH™ 151F, 4 m OKC 50 | 0700 300 541 |
| TXH™ 151F, 8 m OKC 50 | 0700 300 547 |
| TXH™ 201F, 4 m OKC 25 | 0700 300 559 |
| TXH™ 201F, 4 m OKC 50 | 0700 300 554 |
| TXH™ 201F, 8 m OKC 50 | 0700 300 557 |

#### With current adjustment\*

|                       |              |
|-----------------------|--------------|
| TXH™ 121r, 4 m OKC 50 | 0700 300 620 |
| TXH™ 121r, 8 m OKC 50 | 0700 300 622 |
| TXH™ 151r, 4 m OKC 50 | 0700 300 624 |
| TXH™ 151r, 8 m OKC 50 | 0700 300 626 |
| TXH™ 201r, 4 m OKC 50 | 0700 300 628 |
| TXH™ 201r, 8 m OKC 50 | 0700 300 630 |

#### With flexible head and current adjustment\*

|                        |              |
|------------------------|--------------|
| TXH™ 121Fr, 4 m OKC 50 | 0700 300 621 |
| TXH™ 121Fr, 8 m OKC 50 | 0700 300 623 |
| TXH™ 151Fr, 4 m OKC 50 | 0700 300 625 |
| TXH™ 151Fr, 8 m OKC 50 | 0700 300 627 |
| TXH™ 201Fr, 4 m OKC 50 | 0700 300 629 |

### Ordering information

#### Water cooled torches

|                          |              |
|--------------------------|--------------|
| TXH™ 251w, 4 m OKC 50    | 0700 300 561 |
| TXH™ 251w, 8 m OKC 50    | 0700 300 563 |
| TXH™ 252w, 4 m OKC 50    | 0700 300 855 |
| TXH™ 252w, 8 m OKC 50    | 0700 300 856 |
| TXH™ 401w, 4 m OKC 50    | 0700 300 565 |
| TXH™ 401w, 8 m OKC 50    | 0700 300 567 |
| TXH™ 401w HD, 4 m OKC 50 | 0700 300 566 |
| TXH™ 401w HD, 8 m OKC 50 | 0700 300 568 |

#### With flexible head

|                        |              |
|------------------------|--------------|
| TXH™ 251wF, 4 m OKC 50 | 0700 300 562 |
| TXH™ 251wF, 4 m OKC 50 | 0700 300 564 |

#### With current adjustment\*

|                           |              |
|---------------------------|--------------|
| TXH™ 251wr, 4 m OKC 50    | 0700 300 632 |
| TXH™ 251wr, 8 m OKC 50    | 0700 300 634 |
| TXH™ 401wr, 4 m OKC 50    | 0700 300 636 |
| TXH™ 401wr, HD 4 m OKC 50 | 0700 300 637 |
| TXH™ 401wr, 8 m OKC 50    | 0700 300 638 |
| TXH™ 401wr HD, 8 m OKC 50 | 0700 300 639 |

#### With flexible head and current adjustment\*

|                         |              |
|-------------------------|--------------|
| TXH™ 251wFr, 4 m OKC 50 | 0700 300 633 |
| TXH™ 251wFr, 8 m OKC 50 | 0700 300 635 |

### Accessories

#### Adapter for remote-controller torches

|                                 |              |
|---------------------------------|--------------|
| 12 poles                        | 0459 491 912 |
| 10 poles for Origo™ Tig 3001i   | 0459 491 913 |
| ESAB Coolant 10l                | 0465 720 002 |
| Wear part kit for TXH™ 121/251w | 0368 846 880 |
| Wear part kit for TXH™ 151/201  | 0368 846 881 |

### Extensions

#### Special extensions, not for torches with current adjustment

|                                  |              |
|----------------------------------|--------------|
| Length 8 m, 200 A, self-cooled   | 0466 705 880 |
| Length 16 m, 200 A, self-cooled  | 0466 705 882 |
| Length 16 m, 400 A, water-cooled | 0466 705 883 |

\* See Accessories page 67 for suited adapter

| Technical data           | TXH™ 121  | TXH™ 151  | TXH™ 201  | TXH™ 251w/252w | TXH™ 401w | TXH™ 401w HD |
|--------------------------|-----------|-----------|-----------|----------------|-----------|--------------|
| <b>Maximum current</b>   |           |           |           |                |           |              |
| 35% duty cycle, A        | -         | 150       | 200       | -              | -         | -            |
| 60% duty cycle, A        | 120       | 120       | 150       | -              | -         | -            |
| 100% duty cycle, A       | 100       | 100       | 140       | 250            | 400       | 400          |
| Electrode diameter, Ø mm | 1,0 - 3,2 | 1,0 - 3,2 | 1,0 - 4,0 | 1,0 - 3,2      | 1,0 - 4,8 | 1,0 - 4,8    |

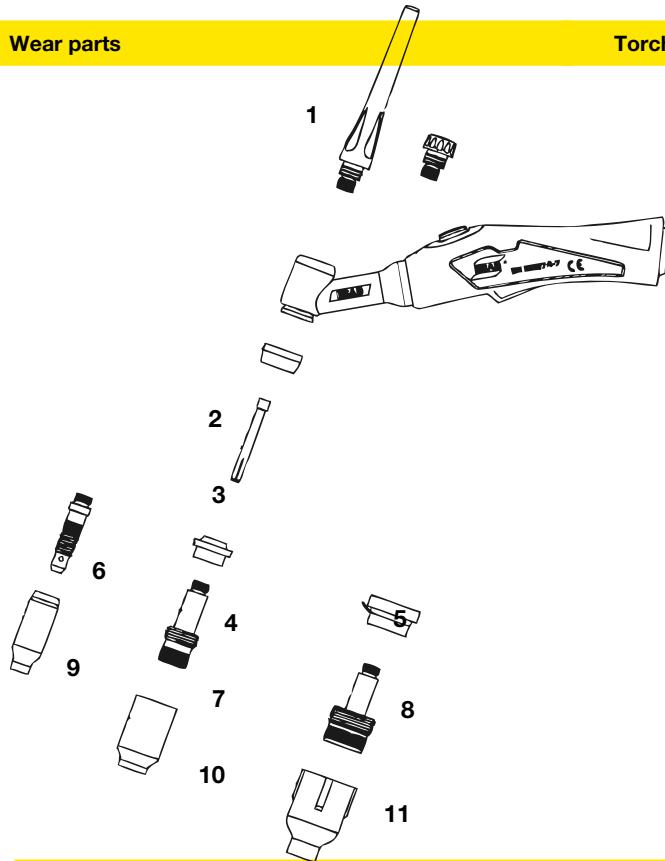
### Wear parts

### Torches TXH™

### 121/251w/252w

### 151/201

### 401w/401wHD



#### Collet body with gas lens (7)

|       |              |              |              |
|-------|--------------|--------------|--------------|
| Ø 1,0 | 0157 121 016 | 0157 123 021 | 0157 123 091 |
| Ø 1,6 | 0157 121 017 | 0157 123 022 | 0157 123 092 |
| Ø 2,4 | 0157 121 018 | 0157 123 023 | 0157 123 093 |
| Ø 3,2 | 0157 121 041 | 0157 123 024 | 0157 123 094 |
| Ø 4,0 | -            | 0157 123 025 | 0157 123 095 |
| Ø 4,8 | -            | -            | 0157 123 075 |

#### Collet body with extra large gas lens (8)

|             |   |              |   |
|-------------|---|--------------|---|
| Ø 1,6       | - | 0157 123 084 | - |
| Ø 2,4       | - | 0157 123 085 | - |
| Ø 3,2       | - | 0157 123 086 | - |
| Ø 4,0 - 4,8 | - | 0157 123 087 | - |

#### Gas nozzles, standard (9)

|        |                     |                     |   |
|--------|---------------------|---------------------|---|
| Ø 6,4  | 0365 310 044        | 0157 123 052        | - |
| Ø 8,0  | 0365 310 045        | 0157 123 053        | - |
| Ø 9,8  | <b>0365 310 046</b> | 0157 123 054        | - |
| Ø 11,2 | 0365 310 047        | <b>0157 123 055</b> | - |
| Ø 12,7 | 0365 310 048        | 0157 123 056        | - |
| Ø 15,9 | 0588 000 440        | 0588 000 442        | - |
| Ø 19,0 | -                   | 0588 000 441        | - |

#### 5 – Gas nozzle for gas lens (10)

|        |              |              |                     |
|--------|--------------|--------------|---------------------|
| Ø 6,4  | 0157 121 032 | 0157 123 057 | 0157 123 057        |
| Ø 8,0  | 0157 121 033 | 0157 123 058 | 0157 123 058        |
| Ø 9,8  | 0157 121 034 | 0157 123 059 | 0157 123 059        |
| Ø 11,2 | 0157 121 039 | 0157 123 060 | 0157 123 060        |
| Ø 12,7 | 0157 121 040 | 0157 123 061 | <b>0157 123 061</b> |
| Ø 17,5 | -            | 0588 000 439 | -                   |

#### Extra large gas nozzle for extra large gas lens (11)

|        |   |              |   |
|--------|---|--------------|---|
| Ø 9,8  | - | 0157 123 088 | - |
| Ø 12,7 | - | 0157 123 089 | - |
| Ø 15,9 | - | 0588 000 438 | - |
| Ø 19,0 | - | 0157 123 098 | - |
| Ø 24,0 | - | 0588 000 437 | - |

In bold: standard delivery

### Torches TXH™

### 121/251w/252w

### 151/201

### 401w/401wHD

#### Back cap (1)

|        |                     |                     |                     |
|--------|---------------------|---------------------|---------------------|
| Long   | <b>0365 310 051</b> | <b>0157 123 029</b> | <b>0157 123 029</b> |
| Medium | 0365 310 050        | 0588 000 591        | 0588 000 591        |
| Short  | <b>0365 310 049</b> | 0157 123 028        | 0157 123 028        |

#### Heat shield (2/4/5)

|                          |              |              |                     |
|--------------------------|--------------|--------------|---------------------|
| (2)                      | 0366 960 017 | 0366 960 016 | <b>0366 960 018</b> |
| (4)                      | -            | 0366 960 020 | -                   |
| (5) extra large gas lens | -            | 0366 960 021 | -                   |

#### Collet, standard and for gas lens (3)

|       |                     |                     |              |
|-------|---------------------|---------------------|--------------|
| Ø 1,0 | 0365 310 028        | 0157 123 010        | 0157 123 010 |
| Ø 1,6 | 0365 310 029        | 0157 123 011        | 0157 123 011 |
| Ø 2,4 | <b>0365 310 030</b> | <b>0157 123 012</b> | -            |
| Ø 3,2 | 0365 310 091        | 0157 123 013        | -            |
| Ø 4,0 | -                   | 0157 123 014        | -            |

#### Collet body, heavy duty (4)

|       |   |   |                     |
|-------|---|---|---------------------|
| Ø 2,4 | - | - | <b>0157 123 077</b> |
| Ø 3,2 | - | - | 0157 123 078        |
| Ø 4,0 | - | - | 0157 123 079        |
| Ø 4,8 | - | - | 0157 123 074        |

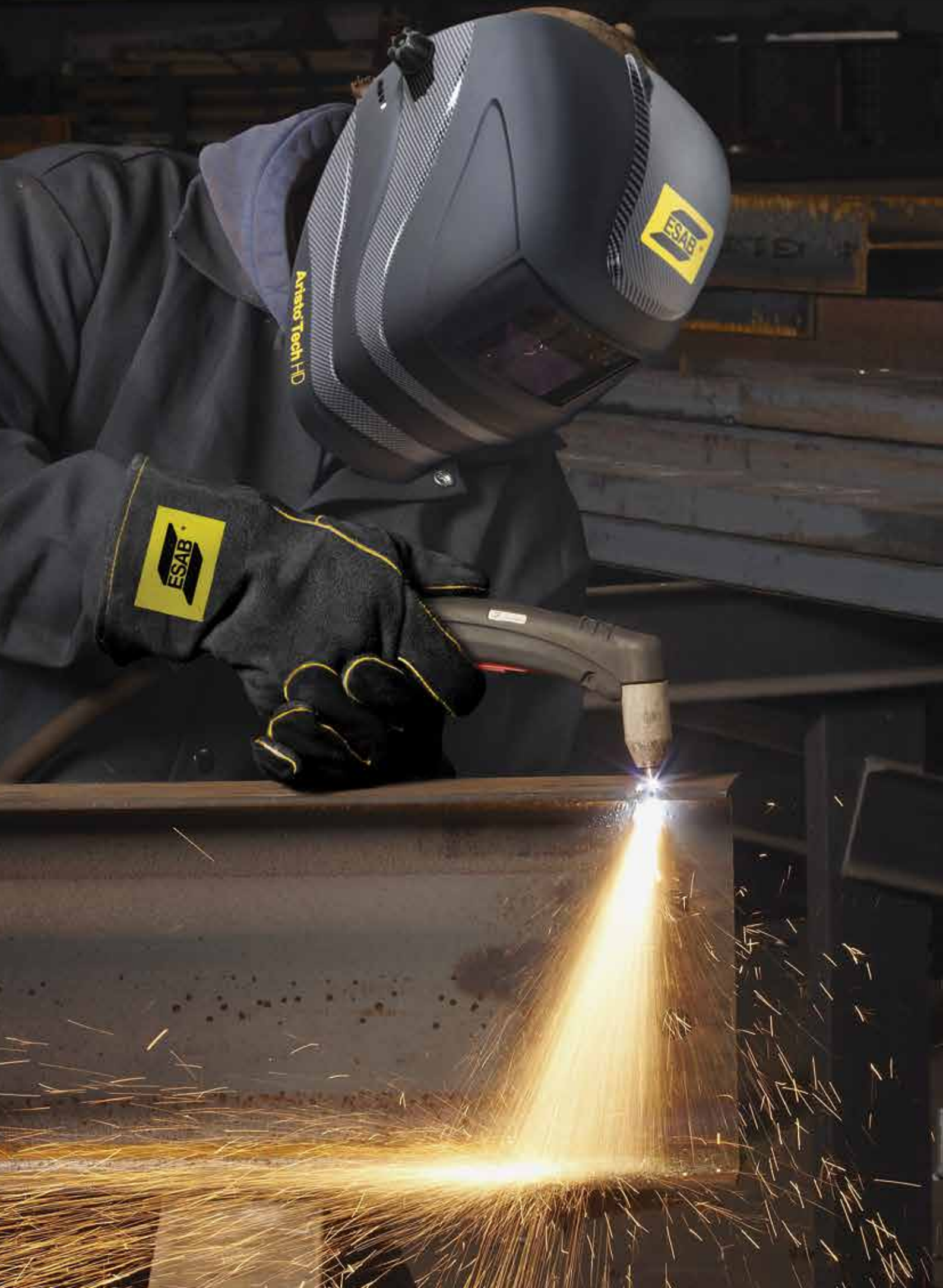
#### Collet body, standard (6)

|             |                     |                     |                     |
|-------------|---------------------|---------------------|---------------------|
| Ø 1,0       | 0365 310 037        | 0157 123 015        | -                   |
| Ø 1,6       | 0365 310 038        | 0157 123 016        | -                   |
| Ø 2,4       | <b>0365 310 039</b> | <b>0157 123 017</b> | -                   |
| Ø 3,2       | 0365 310 090        | 0157 123 018        | -                   |
| Ø 4,0 - 4,8 | -                   | 0157 123 019        | -                   |
| Ø 0,5 - 2,4 | -                   | -                   | <b>0157 123 081</b> |
| Ø 3,2 - 4,0 | -                   | -                   | 0157 123 082        |



Tungsten electrodes: see  
ESAB Accessories catalogue







# PLASMA CUTTING



Plasma cutting is an extremely versatile fusion cutting process to cut almost all metals. In plasma cutting the arc burns in a highly ionised plasma column between an electrode that does not melt and the work piece. It is restricted further by a nozzle, whereby the power density and the stability of the flowing plasma are greatly increased.

The plasma arc that is created in this way has a temperature of up to 25,000 °C. The high energy density of the plasma stream rapidly melts the material and its kinetic energy drives the molten material out of the cutting groove.

The high cutting speed ensures minimal distortion and cleanly cut edges. Compressed air is mainly used as the plasma gas in mobile units, which makes the process very easy to use. Using this procedure it is also possible to cut packages of sheet metal, a process which cannot be done using oxy-fuel flame cutting. High-alloy steels, aluminium and copper can also be cut very economically with plasma cutting. Plasma gouging is also an option with the addition of a gouging nozzle, which has clear advantages over carbon arc gouging torches. It is faster, quieter, cleaner and more precise.



## Plasma gouging

Plasma gouging is the best genuine alternative to gouging using carbon electrodes. Less fumes, quieter, reduced post work cleaning. The initial voltage and power reserve together with the V/A curve are crucial factors for good working results. In addition, the unit must have high voltage reserves to keep the extremely long arc stable during the gouging operation. In the field of mobile plasma units the Cutmaster™ 40-120 have proved to be superior in performance to many other units for plasma gouging.

# CUTMASTER® 60i

## THE NEW FRONTIER IN PLASMA

The Cutmaster® 60i with SL60QD™ 1Torch® is the perfect combination of end-user insight, advanced technology, and intelligent design. Packed with power and offering the highest power-to-weight ratio in its class, the Cutmaster 60i with SL60QD 1Torch also has best in class cutting arc length and the most empowering and engaging user experience no matter the application.



- 7.6 kW rated output, 50% Duty Cycle at 60A built for portability and durability with the integral multi-handle design
- SL60QD 1Torch quick disconnect with ATC® (Advanced Torch Connector) allowing selective replacement of either the torch handle assembly or the torch leads, using the patented SureLok® technology also available as an RPT Torch
- 16 mm recommended cut capacity with greater than 38 mm maximum sever and 16 mm pierce
- High-visibility, oversized display with gas optimizer technology and consumables end-of-life indicator
- Industry leading 3-year warranty on power supply and 1-year warranty on torch

Cutmaster 60i display and end-of-life indicator.



### Cutting Specifications

| Plate Thickness | Recommended Cut Speed | Maximum Cut Speed                     |
|-----------------|-----------------------|---------------------------------------|
| 6 mm            | 2030 mm/min           | 2794 mm/min                           |
| 13 mm *         | 660 mm/min            | 914 mm/min                            |
| 16 mm **        | 480 mm/min            | 610 mm/min                            |
| 19 mm           | 360 mm/min            | Contact ESAB for specific application |
| 25 mm           | 150 mm/min            | Contact ESAB for specific application |
| 32 mm           | 110 mm/min            | Contact ESAB for specific application |
| 38 mm           | 110 mm/min            | Maximum Sever                         |

\*Recommended

\*\* Pierce rating



### Ordering information

|   |                     |
|---|---------------------|
| Cutmaster 60i 3ph with SL60QD 1Torch 6.1 m 75° Head           | <b>0559 156 304</b> |
| Cutmaster 60i 3ph with SL60QD 1Torch 50 ft. (15.2 m) 75° Head | <b>0559 156 314</b> |
| Cutmaster 60i 3ph Power Supply Only                           | <b>0559 356 304</b> |

### Delivery includes

6.1 m 1Torch, spare parts kit, return cable & clamp and power cable, instruction manual and filter wrench.

| Technical data*                         | Cutmaster 60i   |
|---|---|
| Amperage Output, A                      | 10 – 60   |
| Rated Output Power, kW                  | 7.6   |
| Open Circuit Voltage (OCV), V           | 300   |
| Input Voltage, VAC                      | 400 +/-10%  |
| Number of Phases                        | 3   |
| Supply Frequency, Hz                    | 50/60   |
| Input Power Cable and Plug              | 2.7 m   |
| Work Lead with Ground Clamp             | 6 m #8 work cable with 50 mm connection   |
| Operating Temperature Range, °C         | 0-50  |
| Operating Input Air Pressure Range, bar | 6.2 –8.6  |
| Air Flow Requirements , l/min           | 142 –235  |
| Power Supply Gas Filtering Ability      | Particulates to 5 Microns   |
| Maximum Sever, mm                       | 38  |
| Suitable Torches                        | SL60QD 1Torch (supplied), SL60/SL100 1Torch, SL100 1Torch Mechanized, SL100SLV 1Torch Automated |
| Dimensions L x W x H, mm                | 536 x 199 x 593   |
| Weight, kg                              | 16.2  |

\*Technical data is subject to change.

| Maximum output     |    |
|--------------------|----|
| 50% duty cycle, A  | 60 |
| 60% duty cycle, A  | 50 |
| 100% duty cycle, A | 40 |



### Drag Tip Cutting

The preferred method of cutting light gauge metal up to 6 mm thickness. Produces the best cut quality narrowest kerf width, fastest cutting speeds, and with little to no distortion. Traditional drag cutting was limited to 40 A or less; now with Thermal Dynamics TRUE Cut Drag Tip Series™ technology , it is possible to cut up to 60 A. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 A).



### Standoff Cutting

The preferred method of cutting metal thicker than 6 mm and at current levels above 60 A. Provides maximum visibility and accessibility. Shield cup for ,standoff‘ cutting (with the torch tip 3 mm to 6 mm from the work piece). Use the shield cup body together with the deflector for extended parts life and improved resistance to reflect heat. This combination provides cutting results similar to the single piece shield cup, as well as easy changeover to gouging or drag shield cutting.



### Drag Shield Cutting

This is an operator-friendly method of cutting between 70 to 120 A while maintaining a constant standoff distance. For metal thickness greater than 6 mm, simply drag the shield cap in contact with the work piece. Use the shield cup body with the appropriate drag shield cap matching the current level being used. This method is not recommended for cutting light-gauge sheet metal.



### Gouging

A simple method of metal removal by angling the torch to a lead angle of 35°-45°, and using a gouging tip. While maintaining a constant standoff distance, this allows for only a partial penetration into the work, thus removing metal from the surface. The amount of current, travel speed, standoff distance, lead angle, and tip size will determine the amount of material removed and the profile of the gouge. You can use the shield cup body with either the gouging shield cap or the shield deflector. Also, you can use the single piece shield cup.

# CUTMASTER® TRUE SERIES

## TRUE™ CUT CAPACITY

Cutmaster™ TRUE series has been designed with the idea that recommended cut capacity should also be the true cut capacity. The TRUE cut series eliminates the concept of having to buy up, purchasing a machine larger than you actually need. With the introduction of the Cutmaster TRUE series a 25mm recommended capacity machine with cut 25mm all day long.



Cutmaster™ 60



Cutmaster™ 40

- Cutmaster offers excellent performance for cutting stainless steel
- Superior cut quality on thinner metals (Less than 3mm)
- Cutmaster TRUE™ systems can cut with little to no dross
- TRUE GUARD roll bar provides easy transportation, protects the front and rear of the power supply
- Lightweight design improves portability (reduced nearly 50%)
- Auto Pilot Restart instantly reignites the pilot arc while cutting expanded metals
- Multiple torch capability (hand/mechanized/automation)
- 3 year warranty with 1 year warranty torch

| Technical data            | Cutmaster™<br>40  | Cutmaster™<br>60 | Cutmaster™<br>80 |
|---------------------------|-------------------|------------------|------------------|
| Mains supply, V / ph , Hz | 110-230V/1, 50/60 | 400/3, 50/60     | 400/3, 50/60     |
| Fuse slow, A              | 13.5              | 24               | 39               |
| Max output, A             | 40                | 60               | 80               |
| Output power, kW          | 3.8               | 6.2              | 9                |
| Dimensions, L x W x H mm  | 470 x 117 x 228   | 610 x 305 x 381  | 610 x 305 x 381  |
| Weight, kg                | 11.8              | 19.5             | 19.5             |
| Torch Air pressure, bar   | 5.2               | 5.2              | 5.2              |
| Torch Air consumption l/m | 190               | 190              | 190              |
| Enclosure class           | IP 23             | IP 23            | IP 23            |
| Duty Cycle at 40° C, A    | 40% at 40 (230V)  | 40% at 60        | 40 % at 80       |

| Performance                | Cutmaster™<br>40 | Cutmaster™<br>60 | Cutmaster™<br>80 |
|----------------------------|------------------|------------------|------------------|
| <b>Recommended cut, mm</b> | 12               | 20               | 25               |
| Maximum cut, mm            | 22.2             | 32               | 38               |
| Pierce rating, mm          | 6                | 12               | 15               |



### Ordering information

|  |                     |
|--|---------------------|
| Cutmaster™ 40 CE with 1Torch SL60      | <b>0559 142 460</b> |
| Cutmaster™ 60 with 1Torch SL60         | <b>0559 111 304</b> |
| Cutmaster™ 60 with 1Torch SL60 15.2m   | <b>0559 111 314</b> |
| Cutmaster™ 80 with 1Torch SL60         | <b>0559 113 304</b> |
| Cutmaster™ 80 with 1Torch SL60 15.2m   | <b>0559 113 314</b> |
| Cutmaster™ 100 with 1Torch SL100       | <b>0559 117 304</b> |
| Cutmaster™ 100 with 1Torch SL100 15.2m | <b>0559 117 314</b> |
| Cutmaster™ 120 with 1Torch SL100       | <b>0559 119 304</b> |
| Cutmaster™ 120 with 1Torch SL100 15.2m | <b>0559 119 314</b> |

### Delivery includes

6.1m 1Torch, spare parts kit, air filter/regulator, return cable and clamp and power cable.

### Accessories

|                                 |               |
|---------------------------------|---------------|
| Spare parts kit 40A             | <b>5-2551</b> |
| Spare parts kit 60A             | <b>5-2553</b> |
| Spare parts kit 80A             | <b>5-2555</b> |
| Circle cutting guide deluxe     | <b>7-8910</b> |
| Circle cutting guide kit        | <b>7-3291</b> |
| Radius roller cutting guide kit | <b>7-7501</b> |
| Straight line cutting guide     | <b>7-8911</b> |
| Standoff cutting guide 40A      | <b>9-8251</b> |
| Standoff cutting guide 60-120A  | <b>9-8281</b> |
| Trigger guard guide             | <b>9-8420</b> |
| Remote pendant control          | <b>7-3460</b> |
| Hand pendant extension          | <b>7-7744</b> |
| Single stage air filter kit     | <b>7-7507</b> |
| Two stage air filter            | <b>9-9387</b> |
| Multi-purpose trolley           | <b>7-8888</b> |

All Spare parts kits include 10 tips, 5 electrodes and 1 start cartridge.



Cutmaster™ 100

| Technical data             | Cutmaster™<br>100 | Cutmaster™<br>120 |
|----------------------------|-------------------|-------------------|
| Mains supply, V / ph , Hz  | 400/3, 50/60      | 400/3, 50/60      |
| Fuse slow, A               | 27                | 32                |
| Max output, A              | 100               | 120               |
| Output Power, kW           | 12                | 15.4              |
| Dimensions, L x W x H mm   | 762 x 305 x 381   | 762 x 305 x 381   |
| Weight, kg                 | 28.1              | 28.1              |
| Torch Air pressure, bar    | 5.2               | 4.8               |
| Torch Air consumption l/m  | 212               | 212               |
| Enclosure class            | IP 23             | IP 23             |
| Duty Cycle at 40° C, A     | 60% at 100        | 40% at 120        |
| <b>Performance</b>         |                   |                   |
| <b>Recommended cut, mm</b> | 35                | 40                |
| Maximum cut, mm            | 45                | 55                |
| Pierce rating, mm          | 20                | 25                |

# CUTMASTER® ACCESSORIES

## Options & Accessories

|  |        |
|--|--------|
| Cutting Guide Kit (Deluxe)                     | 7-8910 |
| Circle Cutting Guide Kit                       | 7-3291 |
| Filter Wrench                                  | 9-9675 |
| Hand Pendant Extension 7.6 m                   | 7-7744 |
| Lead Extension, 4.6 m                          | 7-7544 |
| Lead Extension, 7.6 m                          | 7-7545 |
| Lead Extension, 15.2 m                         | 7-7552 |
| Leather Lead Covers 6.1 m                      | 9-1260 |
| Multi-Purpose Trolley                          | 7-8888 |
| Radius/Roller Cutting Guide Kit                | 7-7501 |
| Remote Control 6.1 m                           | 7-3460 |
| Single Stage Air Filter Kit                    | 7-7507 |
| Straight Line Cutting Guide                    | 7-8911 |
| Two Stage Air Filter Kit                       | 9-9387 |
| Work Cable #8 with Ground Clamp and 50 mm Plug | 9-9692 |



Cutting guide kit (deluxe)



Single stage air filter



Straight line cutting guide



Two stage air filter

## SL60 Consumables



Replace consumables

8-3487 8-3486



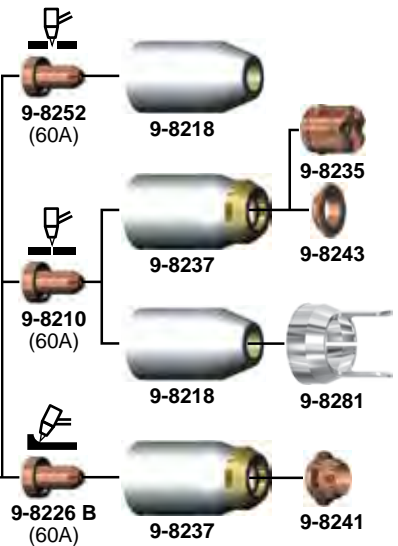
Torch Head

## Wear and spare parts

|                              |        |
|------------------------------|--------|
| Electrode                    | 9-8215 |
| Start cartridge              | 9-8213 |
| Start cartridge – heavy duty | 9-8277 |
| Tip – drag (40A)             | 9-8207 |
| Tip – drag (60A)             | 9-8252 |
| Tip – standoff (40A)         | 9-8208 |
| Tip – standoff (60A)         | 9-8210 |
| Tip – standoff (80A)         | 9-8211 |
| Tip – standoff (90-100A)     | 9-8212 |
| Tip – standoff (120A)        | 9-8253 |
| Tip – gouging A (40A)        | 9-8225 |
| Tip – gouging B (50-100A)    | 9-8226 |
| Tip – gouging C (60-120A)    | 9-8227 |
| Tip – gouging D (60-120A)    | 9-8228 |
| Tip – gouging E (120A)       | 9-8254 |
| Shield cup                   | 9-8218 |
| Shield cup max life          | 9-8237 |
| Shield cap (drag only)       | 9-8235 |
| Shield cap - gouging         | 9-8241 |
| Deflector                    | 9-8243 |

## Gouging profiles

|       | Output Range  | Depth    | Width    | Profile |
|-------|---------------|----------|----------|---------|
| Tip A | 40 Amps (MAX) | Shallow  | Narrow   |         |
| Tip B | 50-100 Amps   | Deep     | Narrow   |         |
| Tip C | 60-120 Amps   | Moderate | Moderate |         |
| Tip D | 60-120 Amps   | Shallow  | Wide     |         |
| Tip E | 120 Amps      | Moderate | Wide     |         |



See next page for more ordering information.

# 1TORCH SL60/SL60QD/SL100



## 1TORCH FEATURES

- Ergonomic handle with trigger release
- Easy replacement of wear parts, less wear parts
- New Advanced Torch Connector (ATC) quick disconnect option
- Excellent cutting ratios even at higher cutting speeds
- 1 year warranty

## Ordering information

|  |        |
|--|--------|
| SL60QD Torch and Lead 6.1 m 75° Head             | 7-5604 |
| SL60QD Torch and Lead 15.2 m 75° Head            | 7-5605 |
| SL60QD Torch Handle Assembly 75° Head (no leads) | 7-5680 |
| SL60QD Lead 6.1 m                                | 4-5604 |
| SL60QD Lead 15.2 m                               | 4-5605 |
| SL60 Torch and Lead 6.1 m 75° Head               | 7-5204 |
| SL60 Torch and Lead 15.2 m 75° Head              | 7-5205 |
| SL60 Torch and Lead 6.1 m 90° Head               | 7-5260 |
| SL100 Mechanized Torch 1.5 m 180° Body           | 7-5213 |
| SL100 Mechanized Torch 3.0 m 180° Body           | 7-5214 |
| SL100 Mechanized Torch 7.6 m 180° Body           | 7-5215 |
| SL100 Mechanized Torch 15.2 m 180° Body          | 7-5216 |



## ADVANCED TORCH CONNECTOR (ATC)

The ATC quick disconnect design brings extra flexibility to almost any plasma system. Switching to a machine torch, swapping out a damaged unit, or simply changing lead lengths is done quickly and requires no tools.

ATC Lead extensions offer the flexibility of working up to 30.4m away from the power supply. The ATC makes it easy to add or subtract total torch lead length as requirements change.

|                                    | SL60/ SL60QD  |
|------------------------------------|---------------|
| <b>Technical data*</b>             | <b>1Torch</b> |
| Amperage Output, A                 | 20-80         |
| Operating Input Air Pressure Range | 6.2 –8.6 bar  |
| Air Flow Requirements              | 142 –235 l/s  |
| Duty Cycle                         | 100% at 60 A  |
| Torch Air Pressure                 | 5.2 bar       |
| Torch Air Consumption              | 190 l/s       |

|                                    | SL100                      |
|------------------------------------|----------------------------|
| <b>Technical data*</b>             | <b>1Torch</b>              |
| Amperage Output, A                 | 20-120                     |
| Operating Input Air Pressure Range | 6.2 –8.6 bar (90 –125 psi) |
| Air Flow Requirements              | 142 –235 l/s               |
| Duty Cycle                         | 100% at 100 A              |
| Torch Air Pressure                 | 5.2 bar                    |
| Torch Air Consumption              | 190 l/s                    |

\*Technical data is subject to change.



# PLASMA TORCHES

PT-37

## Mechanization

|                                 |              |
|---------------------------------|--------------|
| CNC interface with 15,2 m cable | 0558 004 215 |
| Plug-and-play mechanization kit | 0558 007 885 |
| Remote controller               | 0558 008 349 |

## PT-37 plasma torch

|                                  |              |
|----------------------------------|--------------|
| PT-37, with rack, 7,6 m cable    | 0558 004 862 |
| PT-37, without rack, 5,2 m cable | 0558 004 895 |
| Torch support                    | 0558 005 926 |



PT-38

## Ordering information PT-38

|                             |              |
|-----------------------------|--------------|
| Plasma torch PT-38 - 7,6 m  | 0558 006 786 |
| Plasma torch PT-38 - 15,2 m | 0558 006 787 |
| Without consumables         |              |

## Accessories

|   |              |
|---|--------------|
| Kit consumables 60 A                              | 0558 008 419 |
| Kit consumables 90 A                              | 0558 007 640 |
| Deluxe torch guide kit (for circles Ø 45-1060 mm) | 0558 003 258 |
| Basic torch guide kit (for circles Ø 45-750 mm)   | 0558 002 675 |

## Consumables for torch supplied with PowerCut™900

|                          |              |
|--------------------------|--------------|
| Heat shield              | 0558 008 094 |
| Nozzle 60 A              | 0558 008 417 |
| Nozzle 40 A (Drag)       | 0558 007 682 |
| Electrode                | 0558 005 220 |
| Gas diffusor 30-70 A     | 0558 005 217 |
| Stand Off guide          | 0558 008 592 |
| Heat shield for gouging* | 0558 008 591 |
| Gouging nozzle*          | 0558 008 588 |

\*Only for gouging with PowerCut™ 900

## Consumables for torch supplied with PowerCut™1600

|                            |              |
|----------------------------|--------------|
| Heat shield                | 0558 008 094 |
| Nozzle 90 A                | 0558 007 680 |
| Nozzle 70 A                | 0558 005 219 |
| Nozzle 40 A (Drag)         | 0558 007 682 |
| Electrode                  | 0558 005 220 |
| Gas diffusor 30-70 A       | 0558 005 217 |
| Gas diffusor 90 A**        | 0558 004 870 |
| Stand Off guide            | 0558 006 614 |
| Heat shield for gouging ** | 0558 008 186 |
| Gouging nozzle **          | 0558 007 681 |

\*\* Only for gouging with PowerCut™ 1600



## PT-38 FEATURES

- Ergonomic handle for more comfortable operation
- Large switch for better handling when wearing protective gloves
- New blowback technology
- Simple replacement of wear parts, less wear parts.
- Robust strain relief
- Torch change without tools



## PT-39



## PT-26



### Ordering information PT-39

|                                      |              |
|--------------------------------------|--------------|
| PT-39 PC400 Replacement torch 4.5 *) | 0558 010 576 |
| PT-39 PC700 Replacement torch 7.6 *) | 0558 011 580 |

\*) Wear parts to be ordered seperately

### Accessories PT-39

|                      |              |
|----------------------|--------------|
| Wear Part Kit 50A    | 0558 010 585 |
| Wear Part Kit 20-30A | 0558 010 586 |

### Wear Parts PT-39

|                     |              |
|---------------------|--------------|
| Electrode           | 0558 005 220 |
| Swirl Baffle 30-80A | 0558 005 217 |
| Nozzle 20-30A       | 0558 011 620 |
| Nozzle 50A          | 0558 004 878 |
| Heat Shield, CE     | 0558 011 868 |
| Stand-off Guide     | 0558 010 581 |

### Ordering information PT-26

|   |              |
|---|--------------|
| Plasma torch PT-26 - 7,6 m – 70°                | 0558 002 208 |
| Plasma torch PT-26 – 15,2 m – 70°               | 0558 002 209 |
| Plasma torch PT-26 - 7,6 m – 90°                | 0558 004 031 |
| Plasma torch PT-26 – 15,2 m – 90°               | 0558 004 032 |
| PT-26 straight torch for mechanization – 7,6 m  | 0558 002 320 |
| PT-26 straight torch for mechanization – 15,2 m | 0558 002 321 |

### Accessories PT-26

|  |              |
|--|--------------|
| Kit consumables 150 A                    | 0558 002 864 |
| Kit consumables 300 A for Deuce Pack     | 0558 004 030 |
| Leather protection for torch hose 7,6 m  | 0558 002 921 |
| Leather protection for torch hose 15,2 m | 0558 002 922 |

### Accessories PT-26 for gouging

|                               |              |
|-------------------------------|--------------|
| Gouging nozzle 200 A          | 0558 003 718 |
| Gouging nozzle 300 A          | 0558 003 795 |
| Heat shield for torch         | 0558 003 797 |
| Leather protection, see above |              |

### Consumables PT-26

|  |              |
|--|--------------|
| Torch body upper O-ring                            | 0558 003 721 |
| Torch body lower O-ring                            | 0558 003 720 |
| Electrode holder, incl. O-ring                     | 0558 003 707 |
| Electrode holder upper O-ring                      | 0558 003 708 |
| Electrode holder lower O-ring                      | 0558 003 709 |
| Baffle tube  | 0558 003 710 |
| Insulator, incl O-ring                             | 0558 003 711 |
| Insulator O-ring                                   | 0558 003 712 |
| Electrode, Air, N <sub>2</sub> , N <sub>2</sub> /H | 0558 003 722 |
| Electrode, Ar/H                                    | 0558 003 723 |
| Nozzle 50 A (with O-ring)                          | 0558 003 716 |
| Nozzle 150 A (with O-ring)                         | 0558 003 717 |
| Nozzle 250 A (with O-ring)                         | 0558 003 798 |
| Nozzle 300 A (with O-ring)                         | 0558 003 794 |
| Electrode upper O-ring                             | 0558 003 724 |
| Electrode lower O-ring                             | 0558 003 725 |
| Stand-off guide                                    | 0558 003 713 |



Basic circular guide set for PT-38



The deluxe Torch Package for round cuts from 45 to 1060 mm Ø. The middle is fixed with a pin, magnet or sucker pad. Also suitable for straight cuts.

Consumables set PT-38

## **DISCLAIMER**

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