

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



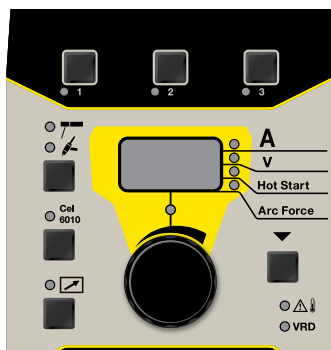
MOBILE SOLUTIONS FOR PROFESSIONAL WELDING



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 mm² 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



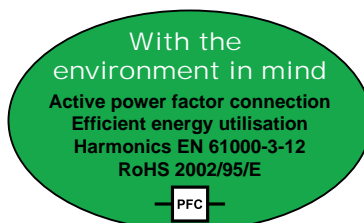
CONTROL PANEL A31

- 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 ² , OKC 50, 3m	0700 006 900
Return cable 200A, 25 mm ² , OKC 50, 3m	0700 006 901
Welding cable 200A, 25 mm ² , OKC 50, 5m	0700 006 884
Return cable 200A, 25 mm ² , 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 ² , OKC 50, 3m	0700 006 902
Return cable 300A, 35 mm ² , OKC 50, 3m	0700 006 903
Welding cable 300A, 35 mm ² , OKC 50, 5m	0700 006 888
Return cable 300A, 35 mm ² , 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 _{1eff} MMA, A	10,8	16,0
Phase current I _{1eff} 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	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

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 ²	0700 006 894
Return cable, complete, 5m, 70mm ²	0700 006 895

Accessories Origo™ Arc 650c and 810c

Welding cable, complete, 5m, 95mm ²	0700 006 896
Return cable, complete, 5m, 95mm ²	0700 006 897

Remote controller

N02 wireless remote controller	0349 304 617
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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

0

1

2

3

4

5

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 CO₂, 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

Rebel™ EMP 215ic
 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.

Rebel™ EM 215ic
 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™ EMP 215ic	Rebel™ EM 215ic	Rebel™ 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 ² H07RN-F	3 m 3x2,5 mm ² H07RN-F	3 m 3x2,5 mm ² 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 CE: IEC/EN 60974-1, 5, 7, 10, 12 & 13. RoHS	CSA: E60974-1-00 CE: IEC/EN 60974-1, 5, 7, 10, 12 & 13. RoHS	CSA: E60974-1-00 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

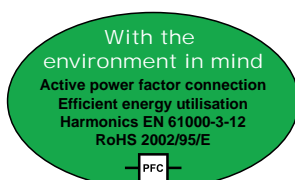
GMA brazing: OK Autrod 19.30, Ø 1,0 mm

Ordering information for wires in 200 mm spools

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

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	0349 310 850
Caddy® Mig C200i	0349 312 030
Two-wheels trolley	0459 366 887



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	0349 311 280
Origo™ Mig C170 3ph	0349 308 670
Origo™ Mag C201	0349 311 290
Origo™ Mig C200 3ph	0349 308 290
Origo™ Mag C251	0349 311 420
Origo™ Mig C250 3ph	0349 307 840

Accessories

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

MXL™ TORCHES

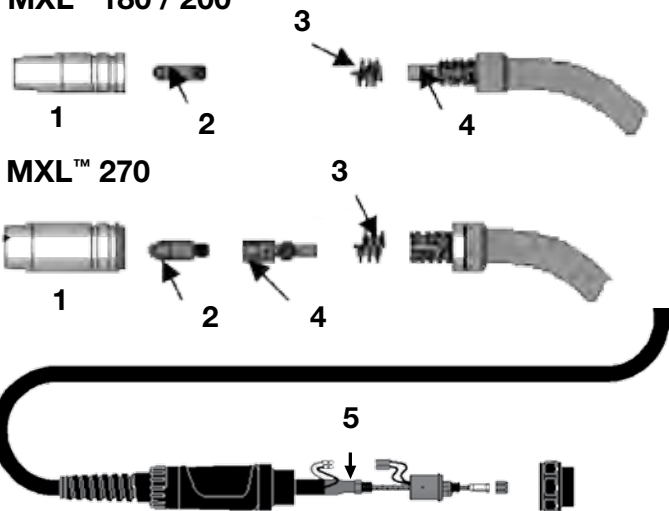


Technical data	MXL™ 150V	MXL™ 180	MXL™ 200	MXL™ 270
	With fixed connection		With central connector	
CO ₂ , A / duty cycle, %	150 / 35	180 / 35	200 / 35	270 / 35
Ar/CO ₂ , A / duty cycle, %	150 / 35	150 / 35	170 / 35	260 / 35
Wire diameters, mm	0,6 - 0,8	0,6 - 1,0	0,6 - 1,0	0,8 - 1,2

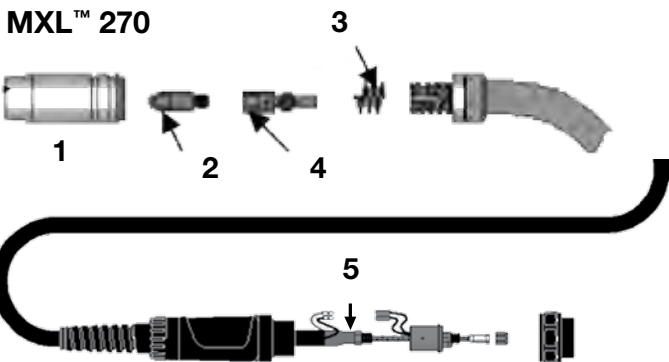
Ordering information – torches and wear parts

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

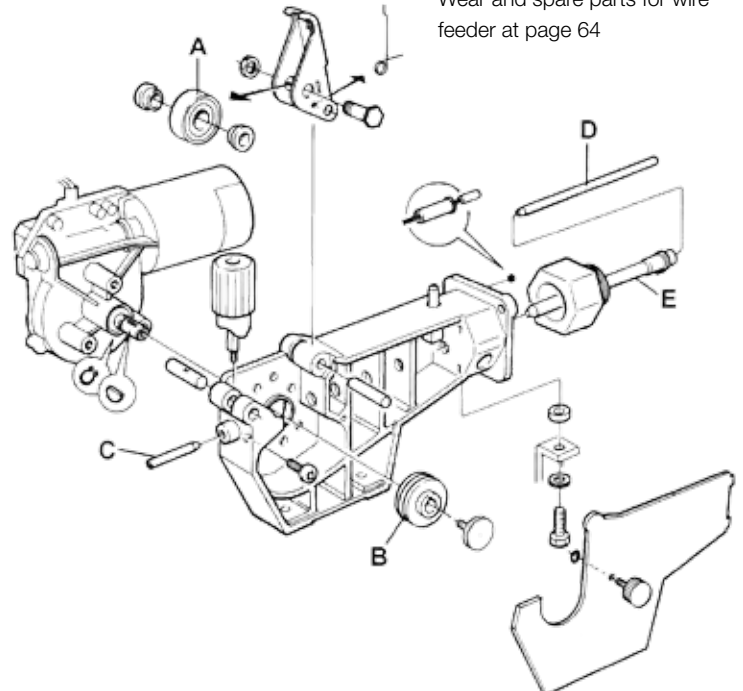
MXL™ 180 / 200



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™ Mig C280 PRO	Origo™ Mig C280 PRO 4WD	Origo™ 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™ Mig C340 PRO 4WD	Origo™ 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™ 305 / 4,5 m Euro	PSF™ 405 / 410w 4,5 m Euro
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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

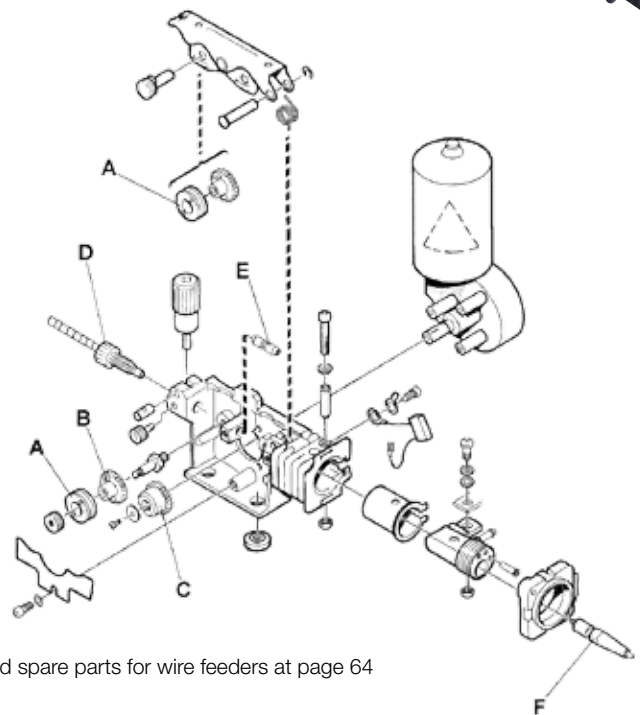
Accessories

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™)	0459 750 881
Aristo® Mig C3000i U6	0459 750 882
Two-wheels trolley	0459 366 890
Four-wheels trolley	0460 060 880
Cooling unit CoolMidi 1800	0459 840 880

Welding torches

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

Torches MXH™, electric Push-pull, page 59

Accessories

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

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 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

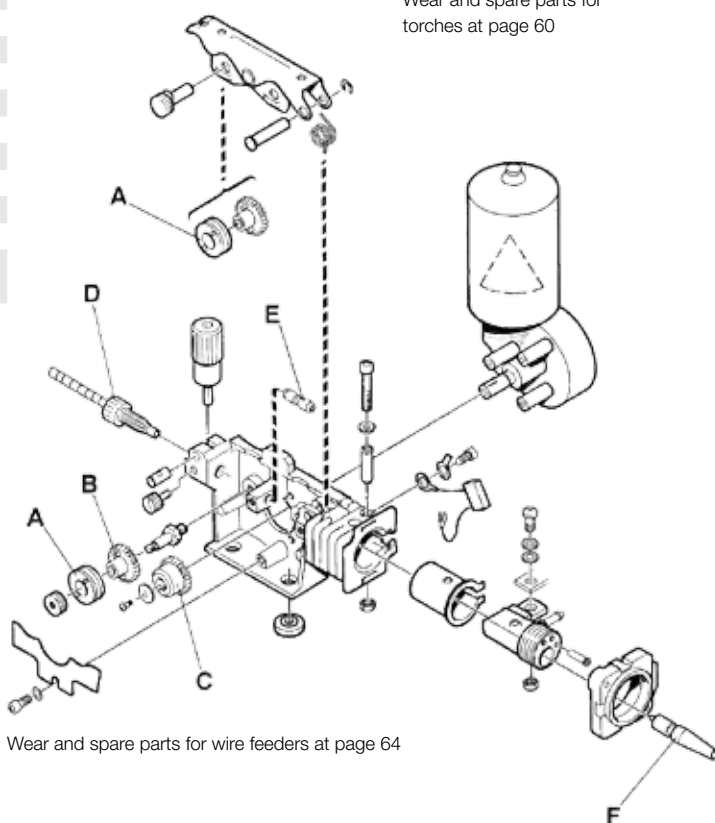
Origo™ Mig L405w	0349 306 563
Origo™ Feed L304w, open	0459 495 892
Air/water connection cable - m. 1,7	0459 532 880
PSF™ 410w, L=3,0m, water cooled	0458 400 882

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

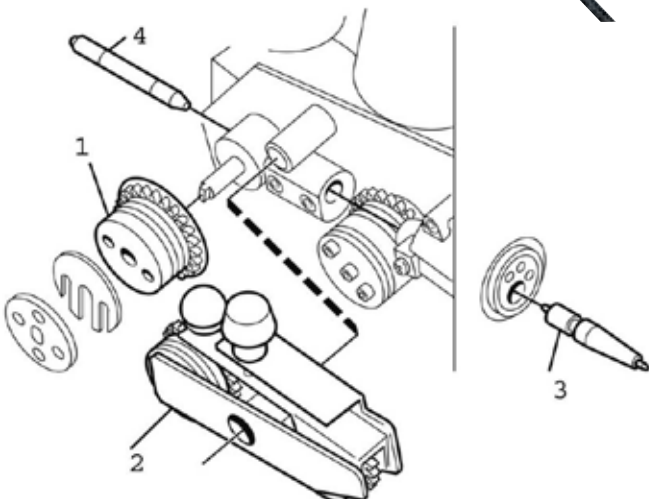
Accessories

Dust filter (steel grid) Origo™ Mig 320	0349 302 599
Dust filter (steel grid) Origo™ Mig 410-510	0349 302 423
Cable holder	0349 303 362
Digital instruments kit for Origo™ Mig 320	0349 302 598
Digital instruments kit for Origo™ Mig 410	0349 302 451
Digital instruments kit for Origo™ Mig 510	0349 302 424
Transformer kit for CO2 preheater (42V – 50/60 Hz)	0349 302 250
Stabilizer (for counterbalance device) Origo™ Mig 320	0349 303 475
Stabilizer (for counterbalance device) Origo™ Mig 410-510	0349 303 474
Reinforcement for counterbalance device	0349 309 748
Pressure reducer with flux-meter	0760 030 300
Water flow guard	0349 302 251
Wheels kit for Origo™ Feed	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
Adapter for 440 mm spool	0459 233 880
Support for double wire feeder	0458 522 880
Counterbalance device	0458 705 880
Steel spool cover	0459 431 880
Button for wire inching and gas test	0459 465 880

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	0349 312 600
Origo™ Mig 410 ●	0349 303 563
Origo™ Mig 510 HALLÅ	0349 303 565
Origo™ Mig 410w water cooling ●	0349 303 564
Origo™ Mig 510w water cooling ●	0349 303 566

Power sources, multivoltage versions

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

Origo™ Mig 320 MV V/A	0349 312 600
Origo™ Mig 410 MV V/A	0349 312 610
Origo™ Mig 410 w MV V/A	0349 312 620

Wire feeders

Origo™ Feed 304 M12 ●	0459 116 882
Origo™ Feed 304w M12 water cooling ●●	0459 116 892
Origo™ Feed 484w M12 water cooling	0459 116 992

Connection cables

for Origo™ Mig 320, 410, self-cooling

Connection cable - mt. 1,7	0469 836 880
Connection cable - mt. 5 ●	0469 836 981
Connection cable - mt. 10 ●	0469 836 881
Connection cable - mt. 15	0469 836 882
Connection cable - mt. 25	0469 836 883
Connection cable - mt. 35	0469 836 884

for Origo™ Mig 410w, water cooling

Connection cable - mt. 1,7	0469 836 885
Connection cable - mt. 5	0469 836 983
Connection cable - mt. 10 ●	0469 836 886
Connection cable - mt. 15	0469 836 887
Connection cable - mt. 25	0469 836 888
Connection cable - mt. 35	0469 836 889

for Origo™ Mig 510, self-cooling

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

for Origo™ Mig 510w, water cooling

Connection cable - mt. 1,7	0469 836 895
Connection cable - mt. 5	0469 836 984
Connection cable - mt. 10 ●	0469 836 896
Connection cable - mt. 15	0469 836 897
Connection cable - mt. 25	0469 836 898
Connection cable - mt. 35	0469 836 899

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™ 505, L = 3,0 m, self-cooled	0458 401 884
PSF™ 505, L = 4,5 m, self-cooled	0458 401 885
PSF™ 410w, L = 3,0 m, water cooled	0458 400 882
PSF™ 410w, L = 4,5 m, water cooled ●	0458 400 883
PSF™ 510w, L = 3,0 m, water cooled	0458 400 884
PSF™ 510w, L = 4,5 m, water cooled ●	0458 400 885

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
Power sources, multivoltage options							
(230/400-415/500 V, 50Hz, 230/440-460 V, 60Hz3-phase)							
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, 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
Cables support:							
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 ₂ 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



- 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

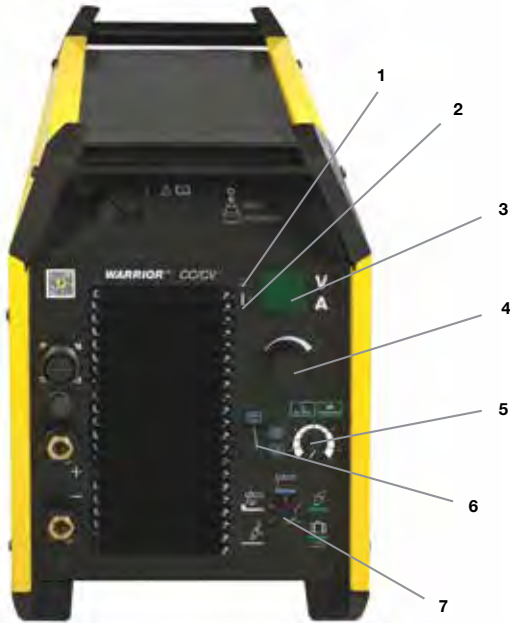


Warrior™ YardFeed 200



Technical data*	Warrior™	
	400i CC/CV	500i CC/CV
Mains Supply, 3 ph 50/60HZ, V	380-415, +/-10%	
Mains cable, Ø mm ²	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	
Maximum output at 40°C		
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™ Feed 304	Warrior™ 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	
Power sources		Gas	W	Gas	Wr
Warrior™ 400i CC/CV	●●●●	0465 350 884	●	●	
Warrior™ 500i CC/CV	●●	0465 350 883		●	
COOL 2, water cooler	●●●●	0465 427 880		●	●

Wire feeders		400i CC/CV		500i CC/CV	
with V/A instruments		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		●	●

Welding torches		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

		400i CC/CV		500i CC/CV	
Connection cables		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 5004i
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	

Maximum output (MIG/MAG) at 40°C	Origo™ Mig 4004i	Origo™ Mig 5004i
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 ²)	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 ²				95 mm ²	
Connection cable		Gas	G A44	W	W A44	Gas	W
Connection cable - mt. 1.7 	0459 528 780	●	●			●	
Connection cable - mt. 1.7(95mm ²)	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 (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 with Miggytrac-Railtrac	0459 681 880	●	●	●	●	●	●
Connection kit for electric Push-pull torches, start/stop function	0459 020 883	●	●	●	●	●	●
Connection kit for electric Push-pull 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® U8₂ and U8₂ 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	0349 309 780
Origo™ Feed 3004w, MA23	0460 526 897
Connection cable - m. 1,7	0459 528 790
PSF™ 410w, L=3,0m, water cooled	0458 400 882

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

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

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

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

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

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




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
Power sources							
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 for process controller U8 ₂	Mig	4002c		5002c		6502c	
		Gas	W	Gas	W	Gas	W
Aristo® U8 ₂	0460 820 880	●	●	●	●	●	●
Aristo® U8 ₂ 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
Connection cables							
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
Cables support:							
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 ₂ 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 with Miggytrac-Railtrac	0459 681 880	●	●	●	●	●	●
Connection kit for electric Push-pull torches, start/stop function	0459 020 883	●	●	●	●	●	●
Connection kit for electric Push-pull torches, 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® U8₂

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 (U8₂) welding schedules
- Customized synergic lines (U8₂)
- 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 ²	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® U8₂ 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	0465 152 883
Aristo® Feed 3004, U6	0460 526 886
Connection cable - m. 1,7	0459 528 780
PSF™ 405, L=3,0m, self-cooled	0458 401 882
4 wheels trolley	0462 151 880
Trolley bracket	0463 125 880
Autotransformer TUA1	0459 144 880

Aristo® Mig 4004i Pulse with Aristo® Feed 3004 U8₂ Plus

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



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 for process controller MA25, U6, and U8 ₂	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 ₂	0460 820 880	●	●	●	●
Aristo® U8 ₂ 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	
	Gas	W	Gas	W
Accessories				
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				

Welding torches	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	
Maximum output at 40°C		
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 U8₂

Aristo® Mig U4000iw	0458 625 885
Aristo® Feed 3004w	0460 526 891
Aristo® U8 ₂	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 U8₂ Plus

Aristo® Mig U4000iw	0458 625 885
Aristo® Feed 3004w	0460 526 891
Aristo® U8 ₂ 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 U8₂ Plus, double wire feeder

Aristo® Mig 5000iw	0459 230 881
Aristo® Feed 3004w (x2)	0460 526 891
Aristo® U8 ₂ 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, 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 with SuperPulse™	0460 526 891
Aristo® Feed 4804w	0460 526 991
Aristo® U8 ₂	0460 820 880
Aristo® U8 ₂ 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 ₂	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 PSF™ torches	Max welding current			Wire diameter (mm)				Weight (kg)	
	CO ₂	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

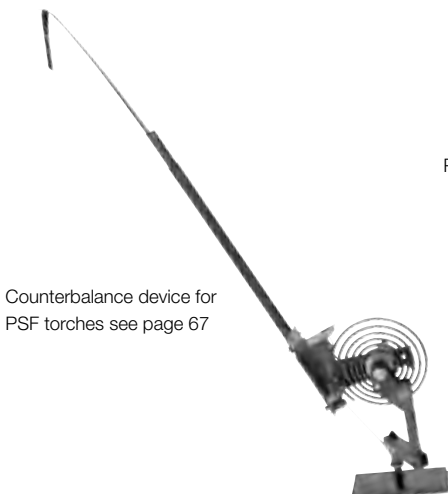
For Feed 3004 and 4804 und Mig C3000i	0459 020 883
For Origo™ Mig C340	0349 308 980
For Origo™ Mig C420	0349 308 337

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 MXH™ Torches	Max welding current		Wire diameter (mm)				Weight (kg)	
	CO ₂	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 PSF™ 410w	PSF™ 405 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 ₂	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
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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
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Swan neck (without wear parts)	angled 0°	0700 200 252	0700 200 250
	angled 45°	0700 200 253	0700 200 251
Wear parts (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 (gas diffuser)	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 ₂	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 (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

Origo™ YardFeed 200	
M13y water cooling, with V/A instrument	0459 906 892

Origo™ YardFeed 2000	
MA23 self cooling	0459 906 887
MA23 water cooling	0459 906 897

Aristo® YardFeed 2000	
U6 water cooling	0459 906 896

Warrior™ YardFeed 200	
self cooling	0459 906 900
water cooling	0459 906 901

Connnection cables, accessories and configurations, on request

Technical data	Yard Feed 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
Usable wire diameters, mm	
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



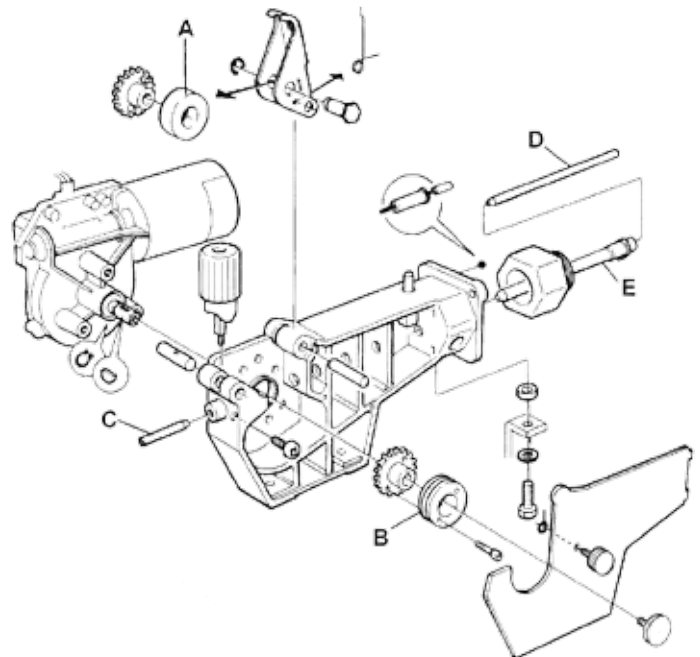
Warrior™ YardFeed

WIRE FEEDER WEAR PARTS

Origo™ Mig C340 PRO - Origo™ Feed 302

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

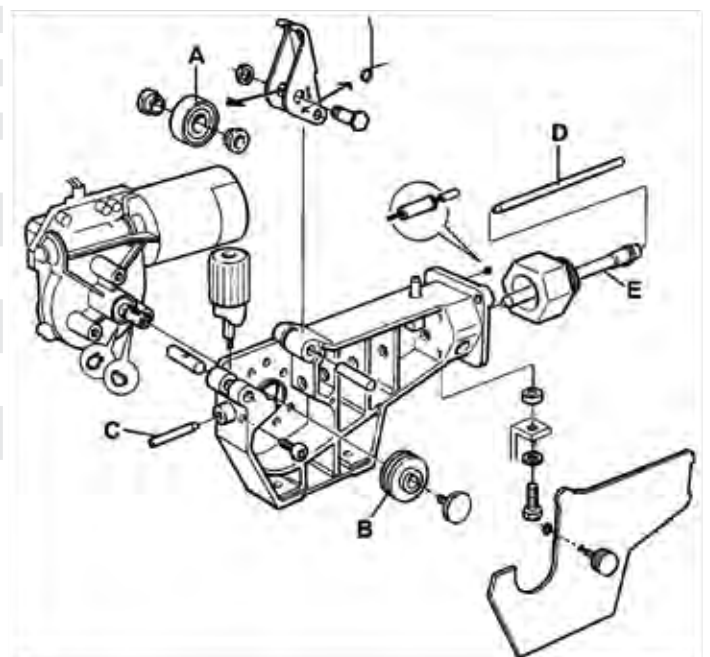
Fe = Steel - Ss = Stainless steel - C = Cored wires - Al = Aluminium



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

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

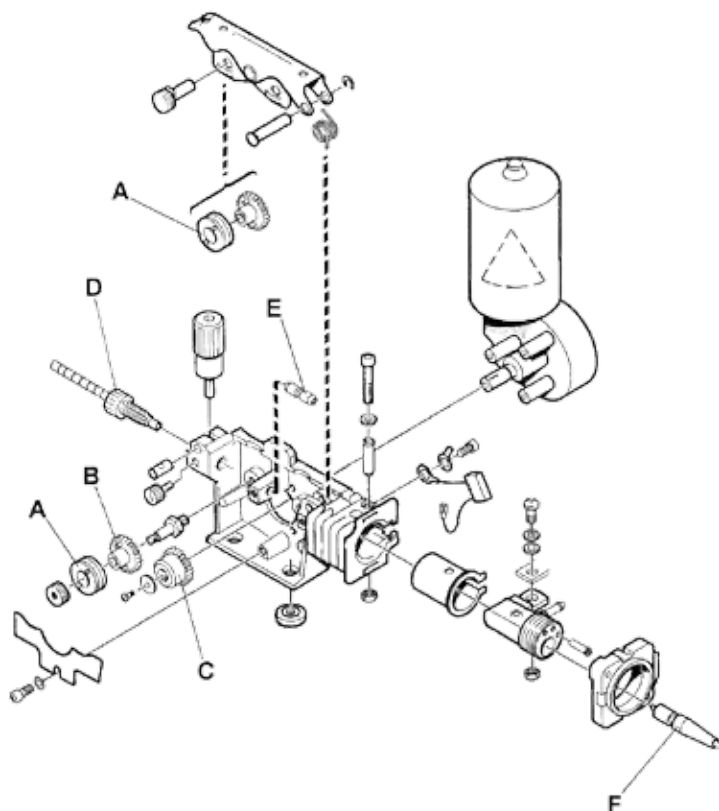
Fe = Steel - Ss = Stainless steel - C = Cored wires - Al = Aluminium



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

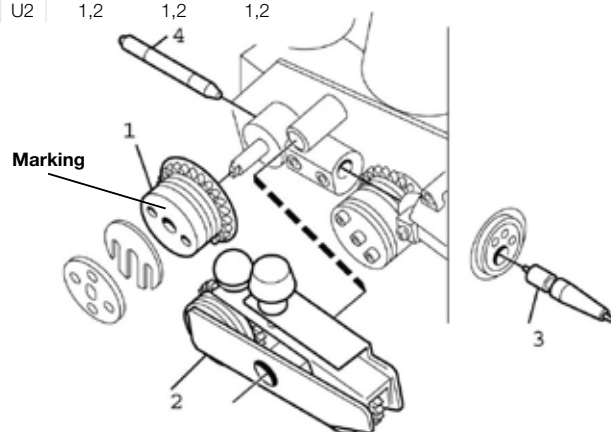
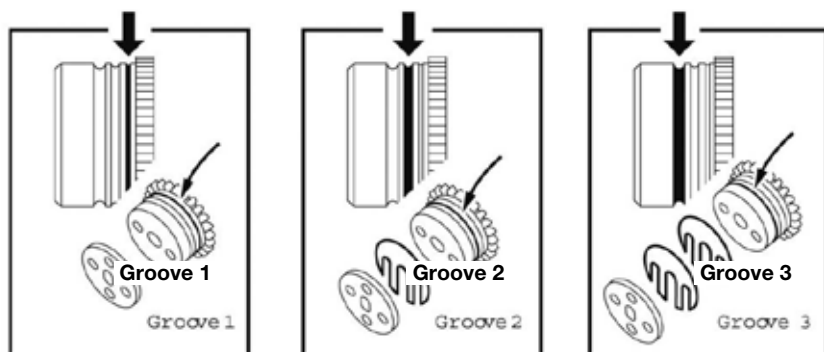
A	Pressure/feed roller	0459 052 002	Fe, Ss, C, 0,8/1,0 mm
		0459 052 003	Fe, Ss, C, 1,0/1,2 mm
		knurled 0458 825 001	C, 0,9/1,2 mm
		knurled 0458 825 002	C, 1,2/1,4 mm
		0458 824 001	Al, 0,8/1,0 mm
		0458 824 002	Al, 1,0/1,2 mm
		0458 824 003	Al, 1,2/1,6 mm
B	Gear adapter	0459 441 880	
C	Drive gear	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 Ss = Stainless steel C = Cored wires Al = Aluminium 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™ 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	
Usable wire diameters, mm		
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™ 250	PKB™ 400
Max load at 60% duty cycle		
Protection gas CO ₂	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.

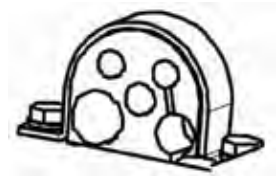
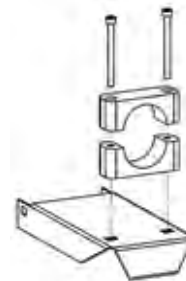
Coil cover, steel **0459 431 880**



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 ₂	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	●															
Connection Cables 6 poles																	
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	●															
Connection Cables 12/4 poles																	
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		●	●	●	●	●	●	●				●	●	●		
Connection Cables 10/4 poles																	
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	0445 536 881
ER 1 incl. 10 m cable and 6-pin connector	0445 536 882
ER 1 incl. 25 m cable and 6-pin connector	0445 536 883



AT1 CAN

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

AT1 CAN	0459 491 883
---------	---------------------



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	0459 491 884
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M1 10 Prog CAN

MIG/MAG synergic remote control for Aristo® U6 and U8₂. Call up 10 storage slots and synergic modification. Fixing mechanism, magnetic feet. Connecting cables available in various lengths

M1 10 Prog CAN	0459 491 882
----------------	---------------------



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	0460 315 880
T1 Foot CAN incl. 5 m cable, 10 poles Amphenol	0460 315 881
ER 1F Foot incl. 5 m cable and 6-pin connector	0445 550 881
ER 1F Foot incl. 10 m cable and 6-pin connector	0445 550 882



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, A33</i>	<i>Caddy® Arc 251i, Origo™ Mig A13</i>	<i>Origo™ Arc 410c/650c/810c</i>	<i>Origo™ Feed Airmatic, 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	●	●				
Connection Cables 12/8 poles							
5 m length	0459 552 880	●	●	●			●
10 m Length	0459 552 881	●	●	●			●
15 m length	0459 552 882	●	●	●			●
25 m length	0459 552 883	●	●	●			●
Connection cables 23 /8 spoles							
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

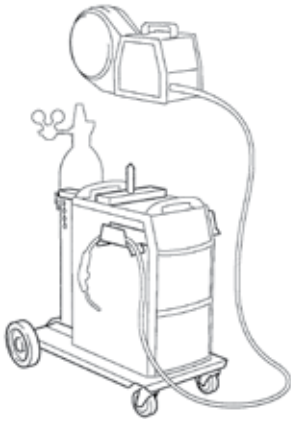
Analogue incl 5 m rubber cable with 12 plug (type C)

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



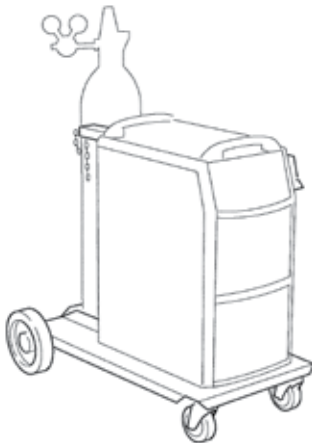
Trolley 2

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
Trolley 5.1

0460 330 880
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



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

* Separate fixing brackets to be ordered

TROLLEYS



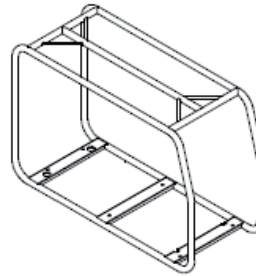
Trolley 13

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

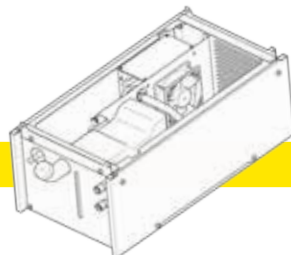
Cooling unit for water cooled torches for manual and mechanized solutions.



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® U8₂ CONTROLLER

A UNIVERSE OF POSSIBILITIES

DEVELOPED FOR DURABILITY

ESAB introduced the second generation of Aristo® U8₂ digital controllers offering improved welding capacity and operator convenience.

The new U8₂ 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® U8₂. 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 CO₂ 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 ₂	U8 ₂ 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® U8₂ 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® U8₂ 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® U8₂ 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® W8₂)
- 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



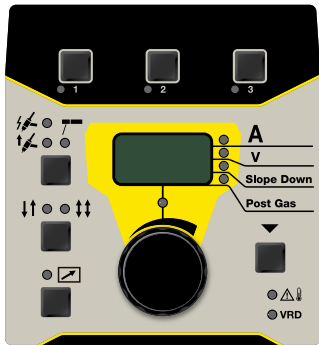
A34

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® U8₂ controller.

Aristo® Mig 5000i/U5000i - Integrated in power source or integration with existing power source by adding Mobile Back Pack, Aristo® W8₂ mounted on machine and U8₂ controller.

Origo™ / Aristo® Mig 4002c/5002c/6502c - Requires Mobile Back Pack, W8₂ mounted on the machine and U8₂ 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® U8₂ CONTROL PANEL

The Aristo® U8₂ 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. U8₂ 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 U8₂ see page 76.

ARISTO® W8₂ INTERFACE

Aristo® W8₂ robotic communication interface that gives you full connectivity to the robot and enables WeldCloud™ connectivity. W8₂ 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
Usable wire diameters, mm		
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 ₂ at 100%, A	480	600
CO ₂ 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 U8₂ controller.

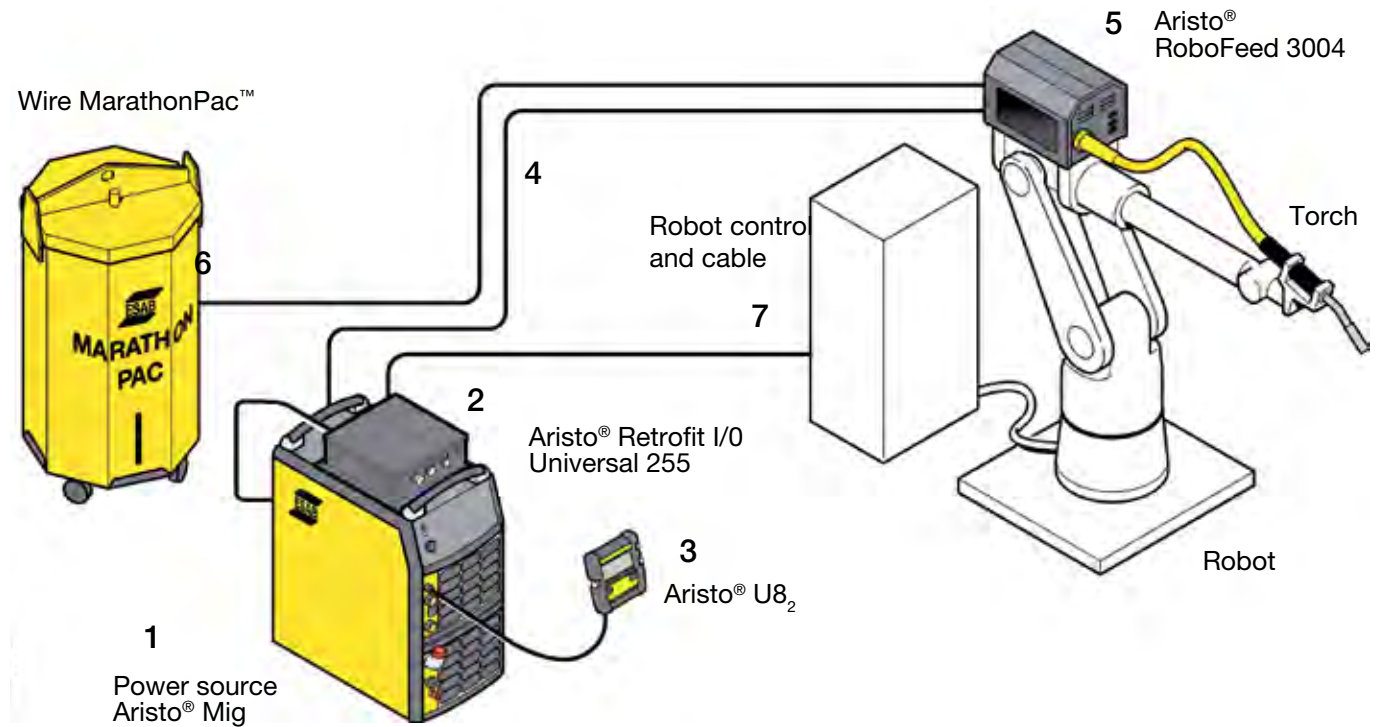
- Synergic lines are available for three AristoRod™ wire sizes and various shielding gases
- SAT™ produces flat welds with a good penetration and without undercut
- An additional advantage is the low heat input, resulting in less deformation



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
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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 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™ 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



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



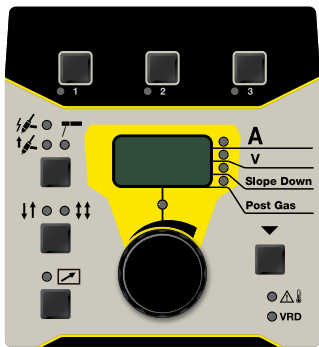
MOBILE SOLUTIONS FOR PROFESSIONAL WELDING



Technical data*	Renegade 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 ² (4x4 mm ² 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 mm² 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	0460 450 880
● Caddy® Tig 2200i TA33, with 3m welding cables and torch TXH 201, 4 m	0460 450 881
● Caddy® Tig 1500i TA34, with 3m welding cables and torch TXH 151, 4 m	0460 450 882
● Caddy® Tig 2200i TA34, with 3m welding cables and torch TXH 201, 4 m	0460 450 883
● Caddy® Tig 2200iw TA33, with cooling unit, 3m welding cables and torch TXH 251w, 4 m	0460 450 884
● Caddy® Tig 2200iw TA34, with cooling unit, 3m welding cables and torch TXH 251w, 4 m	0460 450 885

Ordering information, machines

Caddy® Tig 1500i, TA33 ●	0460 450 890
Caddy® Tig 2200i, TA33 ●	0460 450 891
Caddy® Tig 1500i, TA34 ●	0460 450 892
Caddy® Tig 2200i, TA34 ●	0460 450 893
Caddy® Tig 2200iw, TA33 water cooling ●	0460 450 894
Caddy® Tig 2200iw, TA34 water cooling ●	0460 450 895

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	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, 150 A, 3m cable ●●	0700 006 898
Electrode holder, 200 A, 3m cable ●●●●	0700 006 900
CoolMini cooling unit ●●	0460 144 880
Cooling unit mounting kit for Tig 2200i	0460 509 880



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 _{eff} , 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 mm² 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



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 TA24 AC/DC	Tig 4300iw 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
Maximum current						
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

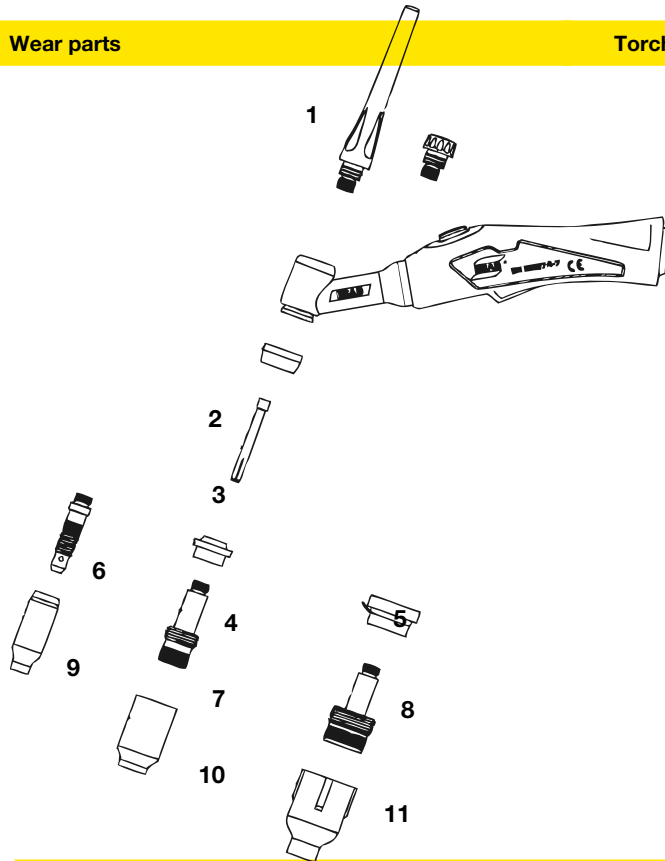
Wear parts

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	0365 310 046	0157 123 054	-
Ø 11,2	0365 310 047	0157 123 055	-
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	0157 123 061
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	0365 310 051	0157 123 029	0157 123 029
Medium	0365 310 050	0588 000 591	0588 000 591
Short	0365 310 049	0157 123 028	0157 123 028

Heat shield (2/4/5)

(2)	0366 960 017	0366 960 016	0366 960 018
(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	0365 310 030	0157 123 012	-
Ø 3,2	0365 310 091	0157 123 013	-
Ø 4,0	-	0157 123 014	-

Collet body, heavy duty (4)

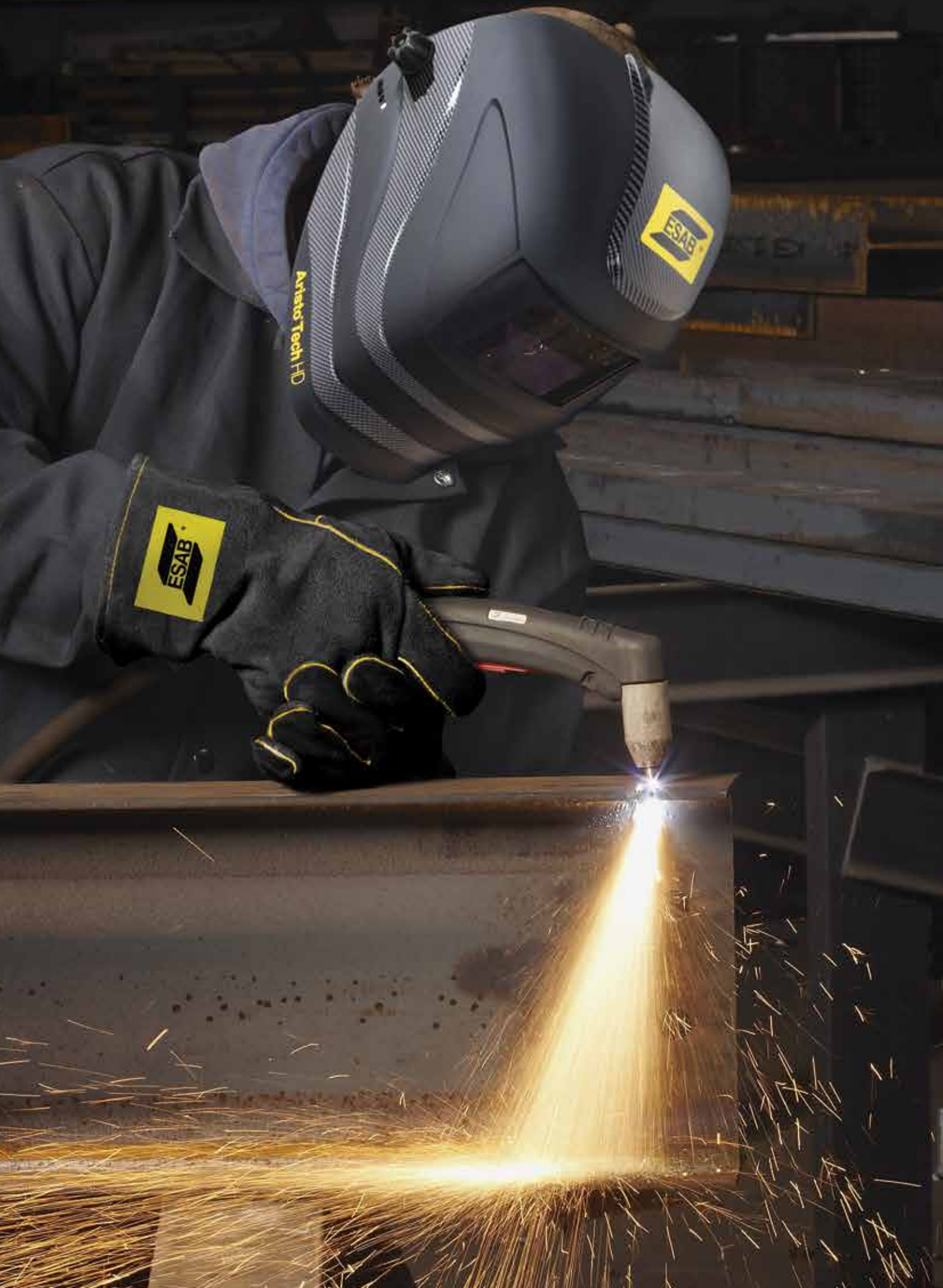
Ø 2,4	-	-	0157 123 077
Ø 3,2	-	-	0157 123 078
Ø 4,0	-	-	0157 123 079
Ø 4,8	-	-	0157 123 074

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	0365 310 039	0157 123 017	-
Ø 3,2	0365 310 090	0157 123 018	-
Ø 4,0 - 4,8	-	0157 123 019	-
Ø 0,5 - 2,4	-	-	0157 123 081
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	0559 156 304
Cutmaster 60i 3ph with SL60QD 1Torch 50 ft. (15.2 m) 75° Head	0559 156 314
Cutmaster 60i 3ph Power Supply Only	0559 356 304

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™ 40	Cutmaster™ 60	Cutmaster™ 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			
Recommended cut, mm	12	20	25
Maximum cut, mm	22.2	32	38
Pierce rating, mm	6	12	15

Ordering information

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

Delivery includes

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

Accessories

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

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



Cutmaster™ 100

Technical data	Cutmaster™ 100	Cutmaster™ 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
Performance		
Recommended cut, mm	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

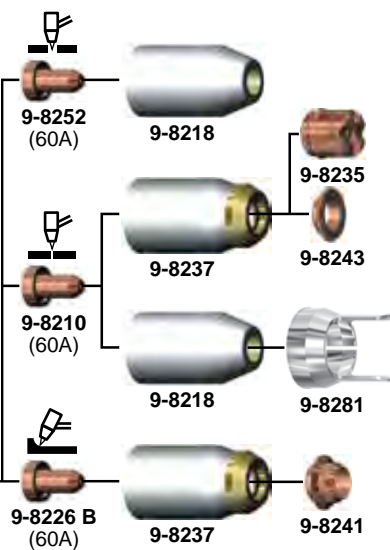
9-8215

9-8213

9-8226 B (60A)

9-8237

9-8241



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



Maximum life shield cup

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
Technical data*	1Torch
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
Technical data*	1Torch
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 ₂ , N ₂ /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

Although every effort is made to ensure the accuracy of information contained within this brochure, in the interest of continuous improvement ESAB reserves the right to change the specifications given or design of any of its products without prior notice. ESAB provides no warranty, express or implied, as to the accuracy, reliability or completeness of the information and ESAB accepts no liability for any loss whether direct, indirect or consequential arising from the information contained within this brochure.



