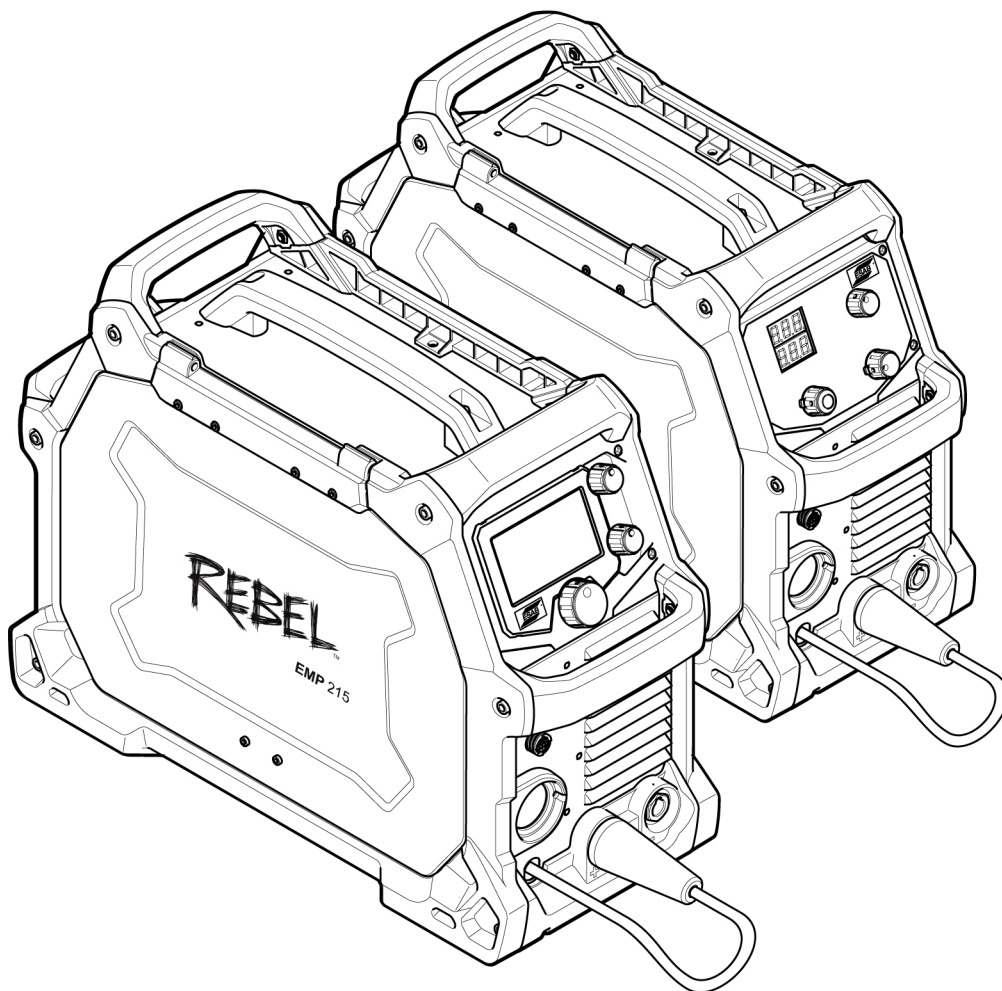




# ***EMS 215ic, EMP 215ic, EM 215ic***



## **Spare parts list**

<b>Ordering number</b>	<b>Product</b>	<b>Notes</b>
0558 102 239	EMS 215ic	Bobbin Ø4-8 in. (100-200 mm). CSA/Bayonet
0558 102 240	EMP 215ic	Bobbin Ø4-8 in. (100-200 mm). CSA/Bayonet
0558 102 436	EM 215ic	Bobbin Ø4-8 in. (100-200 mm). CSA/Bayonet
0700 300 985	EMP 215ic	Bobbin Ø100-200 mm (4-8 in.) CE, euro connection
0700 300 986	EM 215ic	Bobbin Ø100-200 mm (4-8 in.) CE, euro connection
0700 300 988	EMP 215ic	Bobbin Ø100–200 mm (4–8 in.) euro connection, for Middle East
0700 300 993	EMP 215ic	Bobbin Ø100-200 mm (4-8 in.) CE, euro connection, for Australia

Spare parts are to be ordered through the nearest ESAB agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

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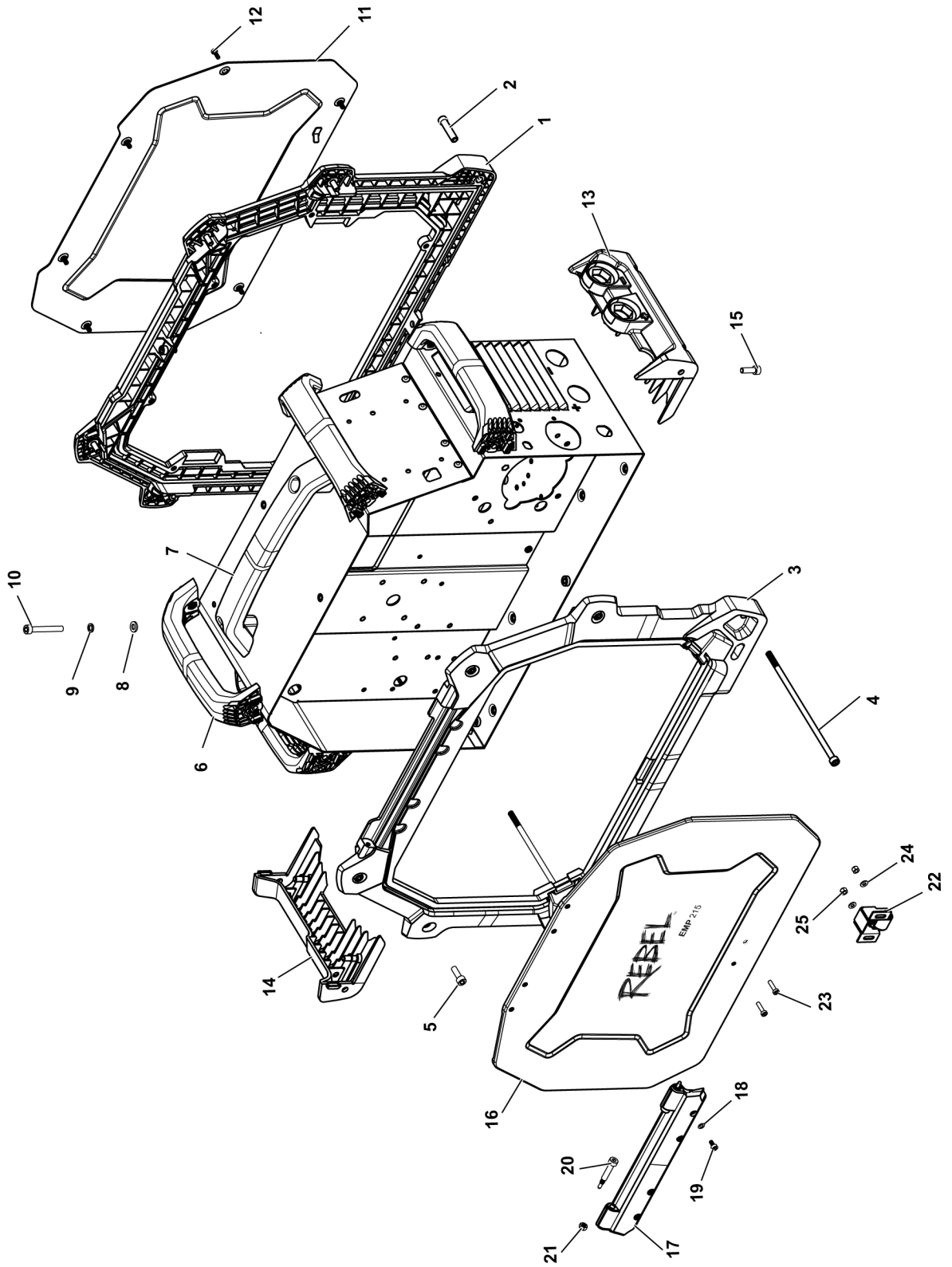
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**SPARE PARTS**


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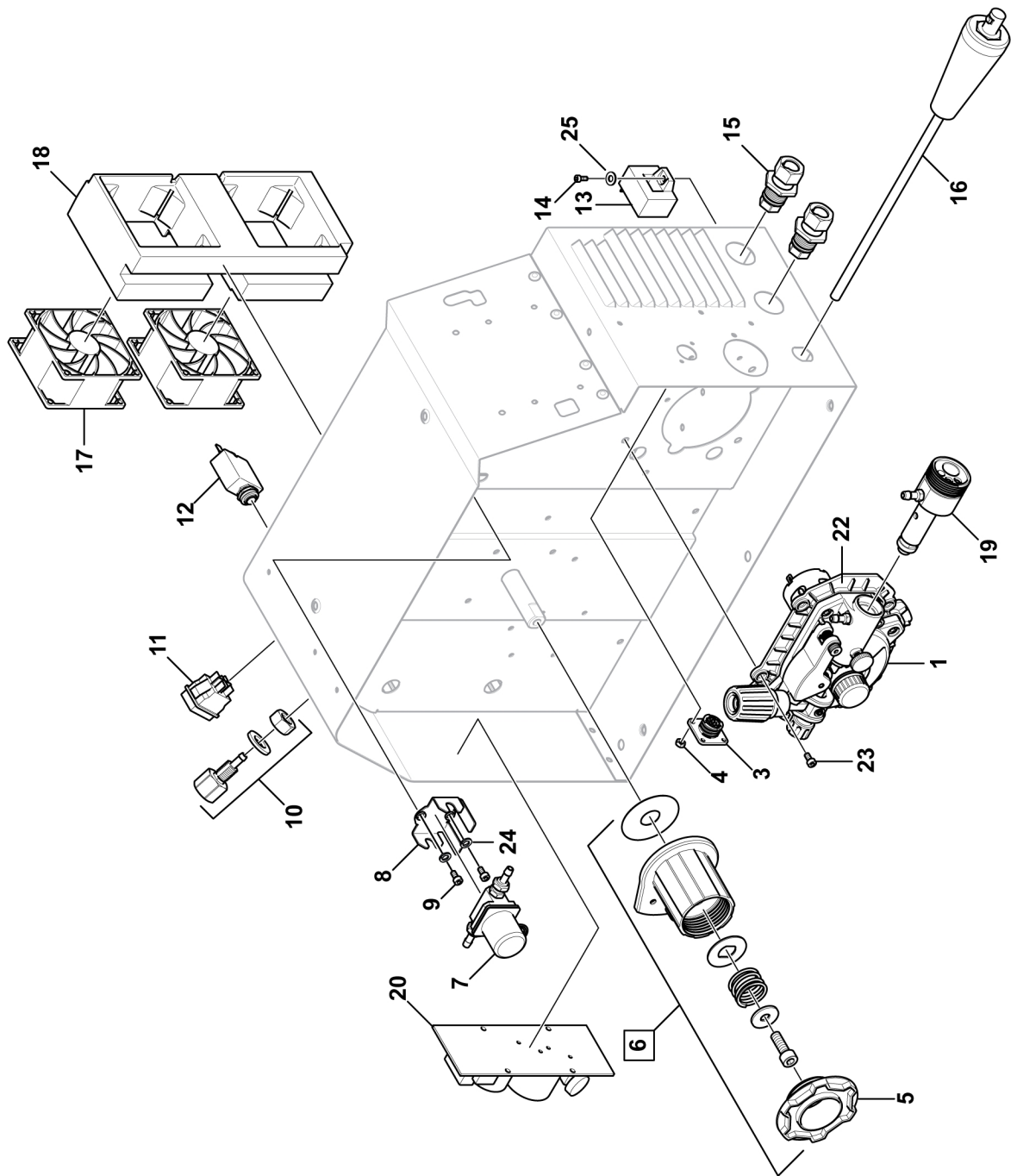
**Housing**

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 397	Side frame, power side	
2	2		Barrel nut	M6×35
3	1	0558 102 398	Side frame, spool side	
4	2	0558 102 664	Barrel bolt	M6×175
5	8		Socket head screw	M6×1×18
6	4	0558 102 399	Handle	
7	1	0558 102 400	Top handle	
8	2		Flat washer	M6
9	2		Washer split lock	M6
10	2		Socket head screw	M6×1×45
11	1	0558 102 401	Side door, power side with ESAB logo	CSA/CE (for CE, valid from CD22923370001)
		0464 581 001	Side door, power side with ESAB logo	CE
12	6		Socket head low profile screw	M4×10
13	1	0558 102 402	Front foot	
14	1	0558 102 403	Rear foot	
15	4		Socket head screw	M6×1×18
16	1	0558 102 404	Side door, spool side with Rebel logo (CSA)	Includes Weld Chart decal, QR code and Variant label
		0464 582 001	Side door, spool side with Rebel logo (CE)	
17	1	0558 102 406	Hinge	
18	4		Washer	M4×8
19	4		Cap screw	M4×8
20	2	0558 102 407	Hinge pin	
21	2		Lock nut	M5
22	1	0558 102 405	Roller latch assembly	
23	2		Screw	M4×16
24	2		Flat washer	M4×9
25	2		Lock nut	M4×0.7



## Connections including drive system

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 408	Wire feeder mechanism	CSA, including motor and harness
		0464 583 880	Wire feeder mechanism	CE, including motor and harness
2	4		Screw	M6×14 mm
3	1	0558 102 409	Remote connection outlet with harness	8-pin connector
4	2		Nut	M3×0.5 mm
5	1	0558 102 410	Brake hub nut	
6	1	0558 102 411	Brake hub kit	
7	1	0558 102 412	Solenoid assembly with hoses	With gas valve, hose clamps and hoses
8	1	0558 102 413	Bracket for solenoid valve	
9	2		Screw	M4×8 mm
10	1	0558 102 414	Gas connector	CSA
		0464 587 880	Gas connector	CE
11	1	0558 102 415	Main supply switch	
12	1	0558 102 416	Circuit breaker	
13	1	0558 102 417	Current sensor	
14	1		Screw	M4×16 mm
15	2	0558 102 418	OKC contact female	
16	1	0558 102 419	Polarity changeover cable assembly	
17	2	0558 102 420	Fan and wire harness	Including wire harness
18	1	0558 102 421	Fan protection foam	
19	1	0464 588 880	Euro connection with harness	CE only
20	1	0464 589 880	EMI PCB assembly incl. wire harness	CE only
21	1	0558 102 442	Warning pinch-shock label	Not included in illustration
22	1	0558 102 820	EMP215, EMP235 WF isolator	
23	4		Screw	M5×10 mm
24	2		Split lock washer	M4
25	1		Flat washer	M4



## User interface

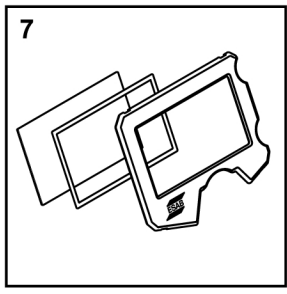
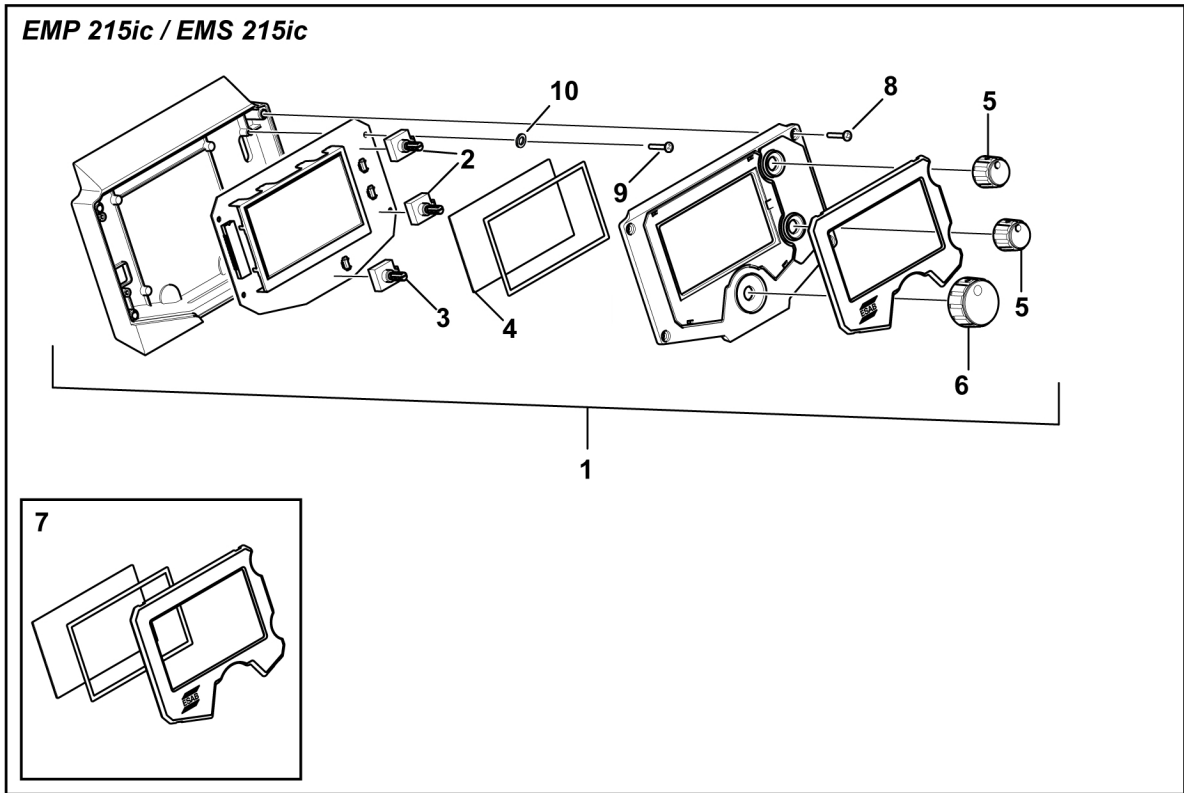
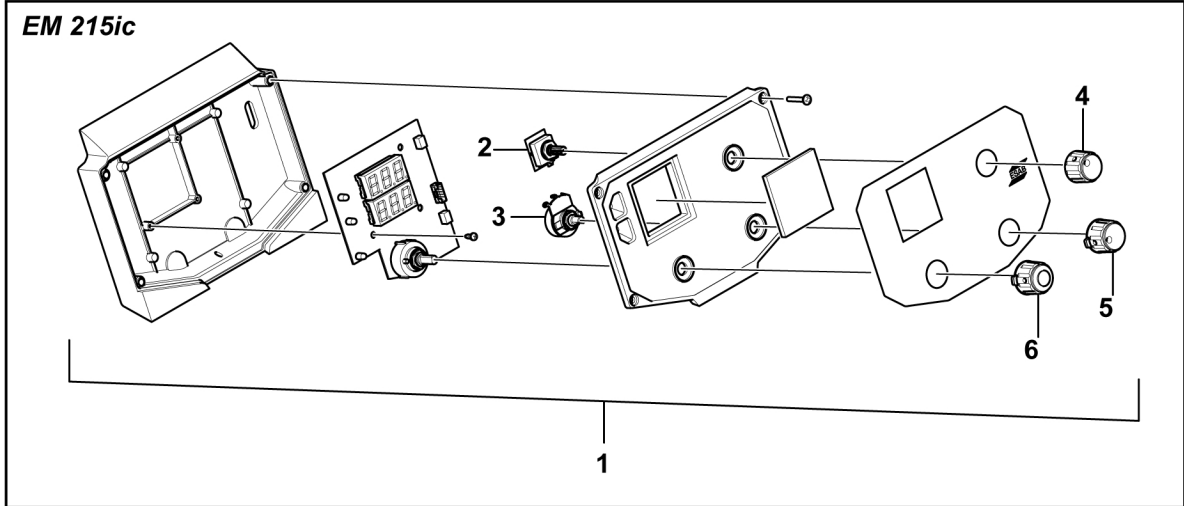
C = Component designation in circuit diagram

### EM 215ic

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 486	User interface complete	
2	1	0558 102 423	Knob encoder with retaining ring	
3	1	0558 102 487	WF Pot Assembly	
4	1	0558 102 440	Knob, small	
5	2	0558 102 489	WF Pot Knob	
6	1	0558 102 488	Process Select Knob	

### EMP 215ic, EMS 215ic

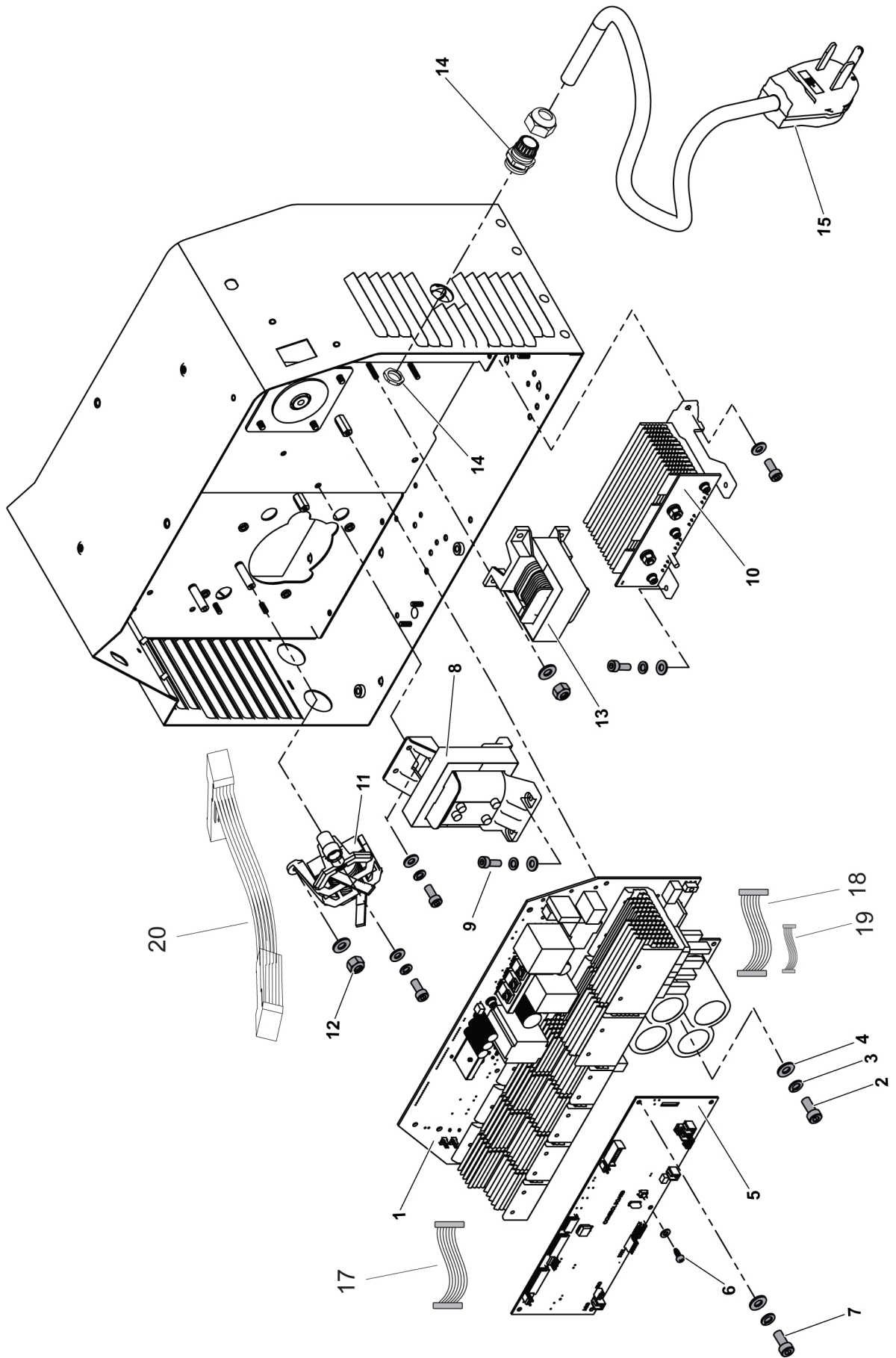
Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 422	EMP215ic panel assembly	CSA
	1	0464 590 880	EMP215ic panel assembly	CE
	1	0558 102 485	EMS215ic panel assembly	CSA
2	2	0558 102 423	Encoder for small knob	
3	1	0558 102 424	Encoder for large knob	
4	1	0558 102 438	Replaceable display lens	
5	2	0558 102 440	Knob, small	
6	1	0558 102 441	Knob, large	
7	1	0558 102 437	EMP215ic lens assembly kit	CSA
	1	0558 102 484	EMS215ic lens assembly kit	
8	4		Screw	M4×22
9	4		Screw	M3×8
10	4		Flat washer	M3



## Control modules

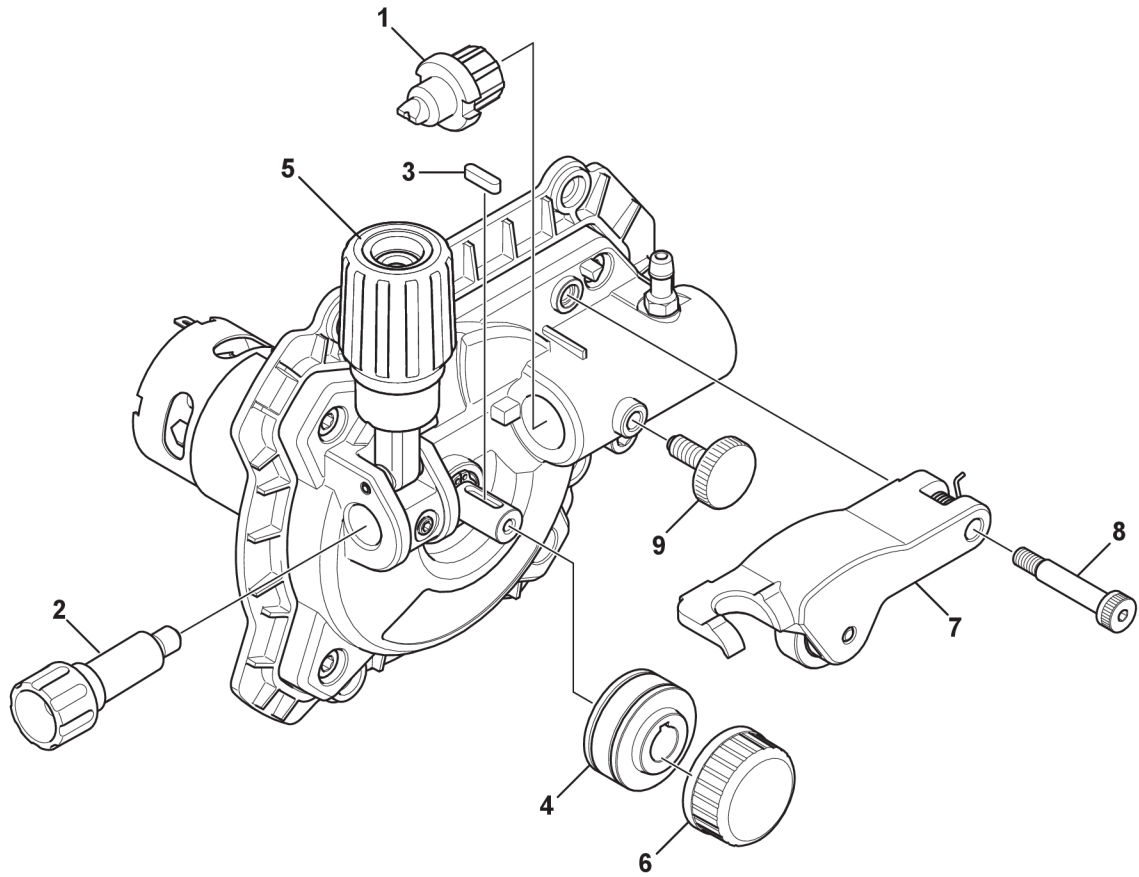
C = Component designation in circuit diagram

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 426	PCB Power board assembly	CSA
	1	0464 591 880	PCB Power board assembly	CE
2	7		Screw	M4×8
3	16		Split lock washer	M4
4	28		Flat washer	M4
5	1	0558 102 427	PCB Control board complete	CSA (PCB must be pre-configured before usage)
	1	0464 592 880	PCB Control board complete	CE (with software)
6	3		Screw	M4×1.46×10
7	5		Screw	M4×10
8	1	0558 102 428	Main transformer with NTC (3x)	
9	6		Screw	M4×12
10	1	0558 102 429	Output diode assembly	
11	1	0558 102 430	Output inductor assembly	
12	6		Nut	M4×0.7
13	1	0558 102 431	PFC inductor assembly	
14	1	0558 102 432	Strain relief assembly	
15	1	0558 102 433	Mains cable complete	CSA only
16	1	0558 102 434	Warning label	Not included in illustration
17	1	0558 103 457	Wire Harness 1, Power PCB to Control PCB	CN2-CN2
18	1	0558 103 458	Wire Harness 2, Power PCB to Control PCB	CN1-CN17
19	1	0558 103 459	Wire Harness 3, Power PCB to Control PCB	CN4-CN19
20	1	0558 103 456	Wire Harness, Control PCB to HMI	CN6-CN3



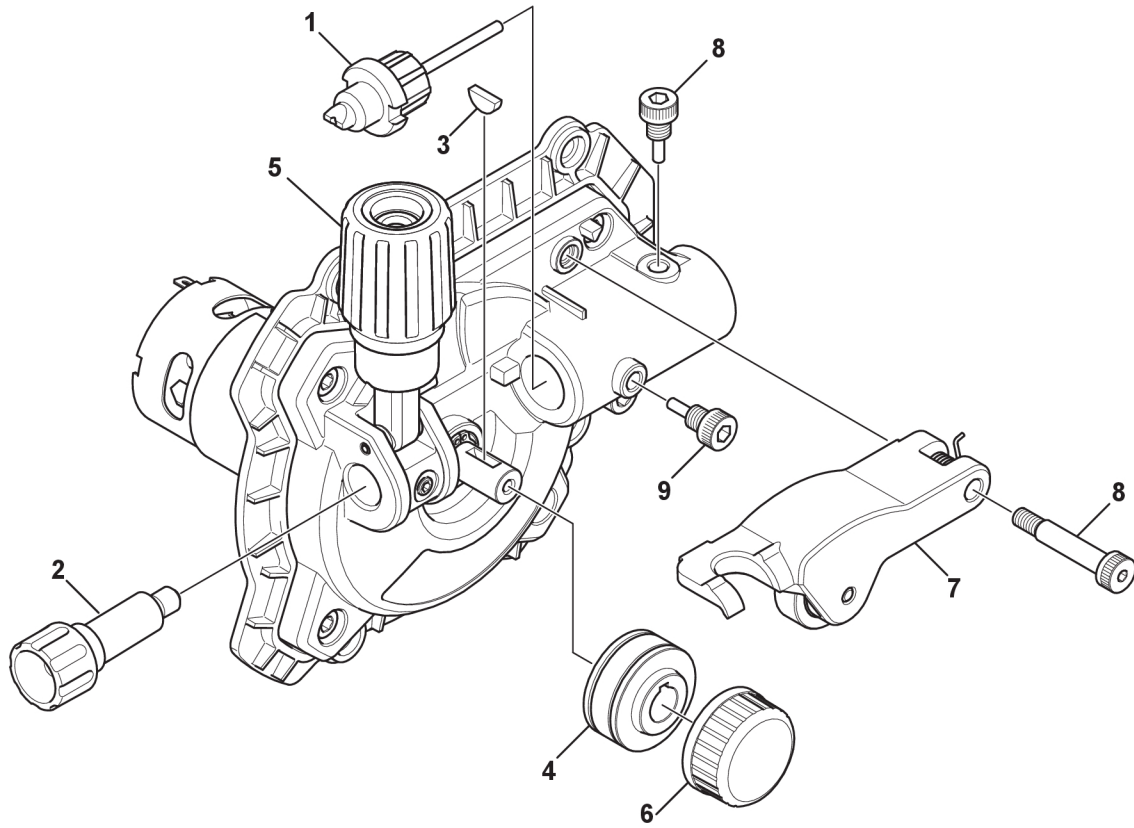
## WEAR PARTS - CSA

Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 326	Wire outlet guide	Fe/SS/Flux Cored	0.030 in. / 0.035 in. / 0.045 in. (0.8 mm / 0.9 mm / 1.2 mm)
	0558 102 327	Wire outlet guide	Fe/SS/Flux Cored	0.024 in. (0.6 mm)
2	0558 102 328	Wire inlet guide	Fe/SS/Flux Cored	0.024 in. / 0.030 in. / 0.035 in. / 0.045 in. (0.6 mm / 0.8 mm / 0.9 mm / 1.2 mm)
3	0558 102 334	Key-drive shaft	N/A	N/A
4	7977036	Feed roll "V" groove	Fe/SS	0.024 in. / 0.030 in. (0.6 mm / 0.8 mm)
	W4014800	Feed roll "V" groove	Fe/SS	0.024 in. / 0.035 in. (0.6 mm / 0.9 mm)
	7977732	Feed roll "V" knurled	Flux Cored	0.030 in. / 0.035 in. (0.8 mm / 0.9 mm)
	7044277	Feed roll "V" knurled	Flux Cored	0.045 in. (1.1 mm)
5	0558 102 329	Locking knob (Wire tension)	N/A	N/A
6	0558 102 518	Feed roller retaining knob		
7	0558 102 331	Pressure arm complete assembly	N/A	N/A
8	0558 102 330	Screw	N/A	N/A
9	0558 102 333	MIG gun locking knob	N/A	N/A



## WEAR PARTS - CE

Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 460	Wire outlet guide steel	Fe/SS/Flux Cored	0.8 mm / 0.9 mm / 1.0 mm (0.031 in. / 0.035 in. / 0.040 in.)
	0558 102 461	Wire outlet guide steel	Fe/SS/Flux Cored	0.6 mm (0.024 in.)
	0464 598 880	Wire outlet guide teflon	Aluminium	1.0 mm – 1.2 mm (0.040 in. – 0.045 in.)
2	0558 102 328	Wire inlet guide	Fe/SS/Flux Cored	0.6 mm / 0.8 mm / 0.9 mm / 1.2 mm (0.023 in. / 0.030 in. / 0.035 in. / 0.045 in.)
3	0191 496 114	Key-drive shaft crescent	N/A	N/A
4	0367 556 001	Feed roll "V" groove	Fe/SS/Flux Cored	0.6 mm / 0.8 mm (0.023 in. / 0.030 in.)
	0367 556 002	Feed roll "V" groove	Fe/SS/Flux Cored	0.8 mm / 1.0 mm (0.030 in. / 0.040 in.)
	0367 556 003	Feed roll "V" groove	Fe/SS/Flux Cored	1.0 mm / 1.2 mm (0.040 in. / 0.045 in.)
	0367 556 004	Feed roll "U" groove	Aluminium	1.0 mm / 1.2 mm (0.040 in. / 0.045 in.)
5	0558 102 329	Locking knob (Wire tension)	N/A	N/A
6	0558 102 518	Feed roller retaining knob		
7	0558 102 331	Pressure arm complete assembly	N/A	N/A
8	0558 102 330	Screw	N/A	N/A
9	0558 102 459	Euro adapter locating screw	N/A	N/A





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