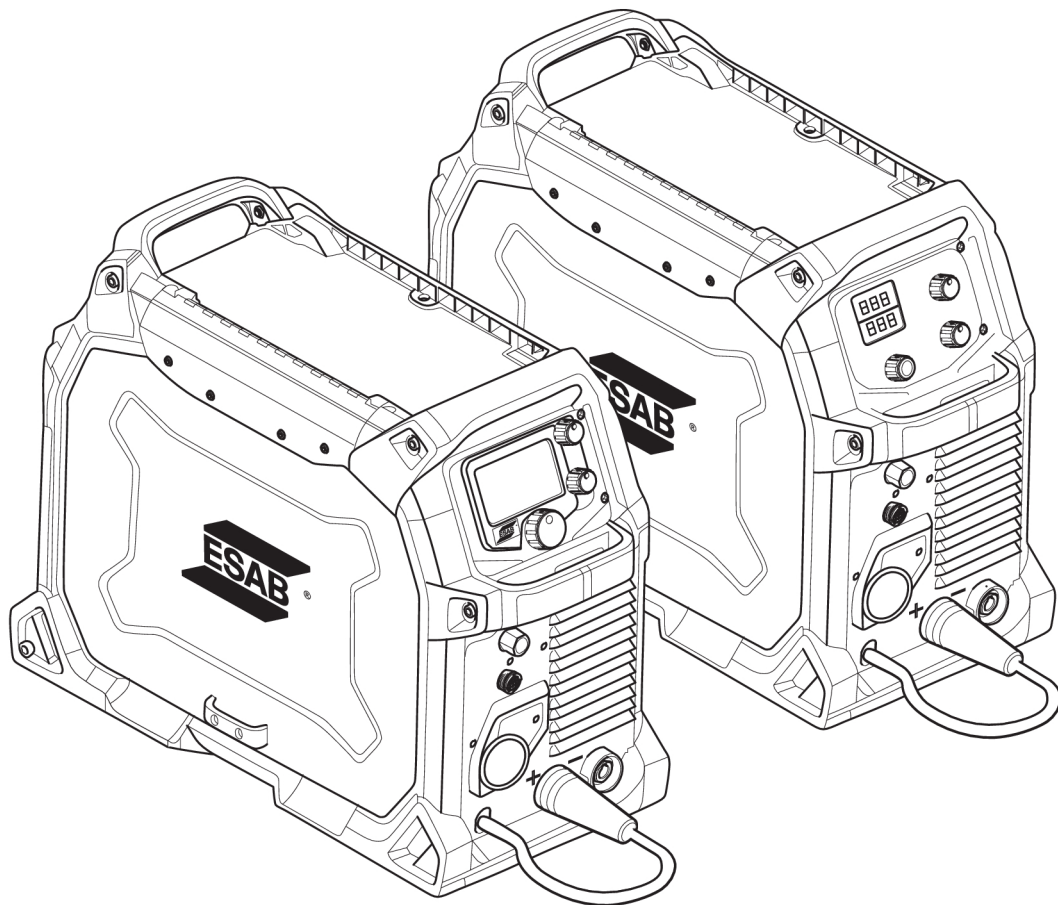


EMP 235ic, EM 235ic



Spare parts list

Ordering number	Product	Notes
0558 012 702	EMP 235ic	Bobbin Ø4–12 in. (100–300 mm) CSA, bayonet
0558 012 704	EMP 235ic with cart	Bobbin Ø4–12 in. (100–300 mm) CSA, bayonet
0558 012 700	EM 235ic	Bobbin Ø4–12 in. (100–300 mm) CSA, bayonet
0558 012 701	EM 235ic with cart	Bobbin Ø4–12 in. (100–300 mm) CSA, bayonet
0700 300 989	EMP 235ic	Bobbin Ø100–300 mm (4–12 in.) CE, Euro connector
0558 012 702MX	EMP 235ic MX	Bobbin Ø4–12 in. (100–300 mm) CSA, bayonet
0558 012 700MX	EM 235ic MX	Bobbin Ø4–12 in. (100–300 mm) CSA, bayonet
0700 300 994	EMP 235ic	Bobbin Ø100–300 mm (4–12 in.) CE, Euro connector

Spare parts may be ordered through your nearest ESAB dealer, see [esab.com](https://www.esab.com). When ordering, please state product type, serial number, denominations and ordering numbers according to the spare parts list. This facilitates dispatch and ensures correct delivery.

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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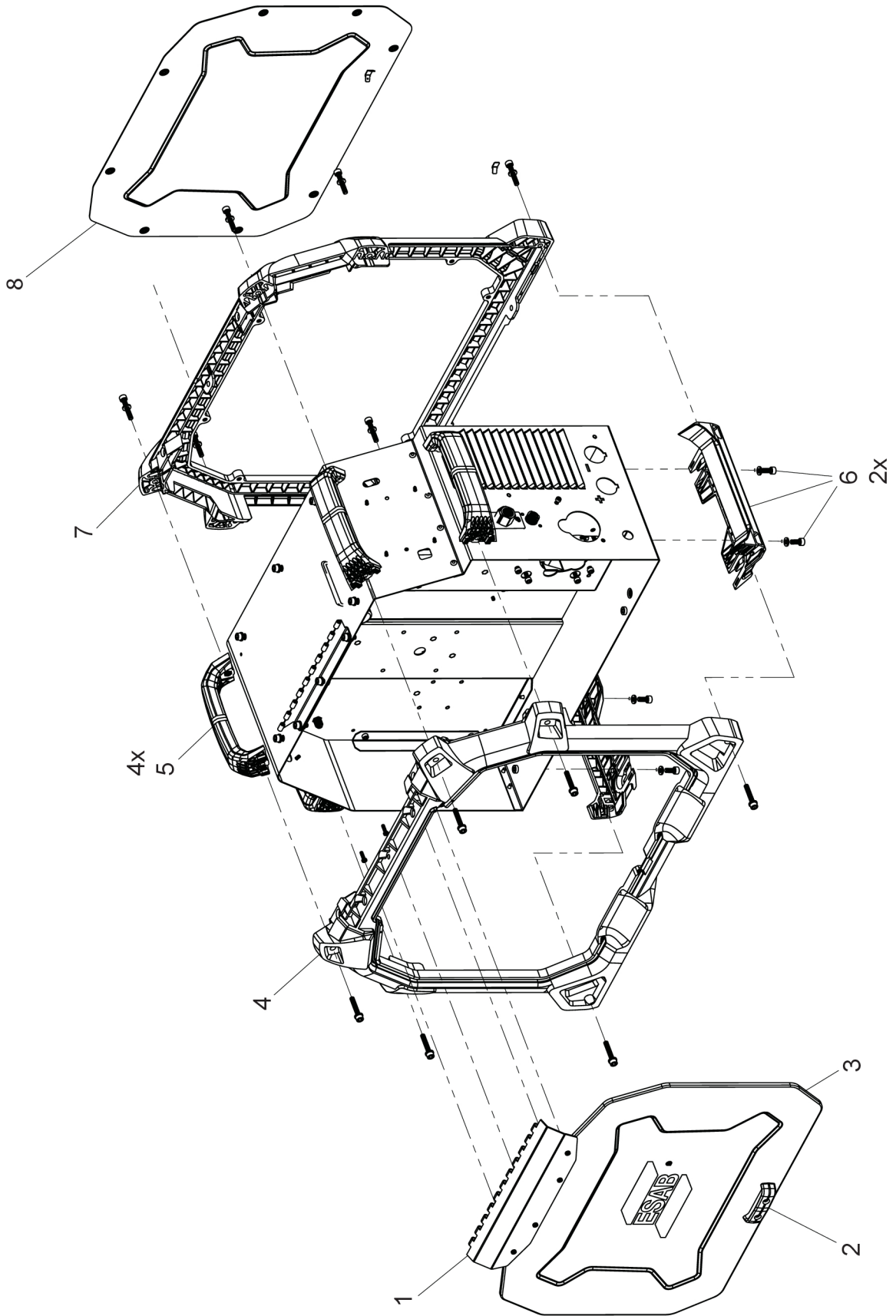
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SPARE PARTS

Housing

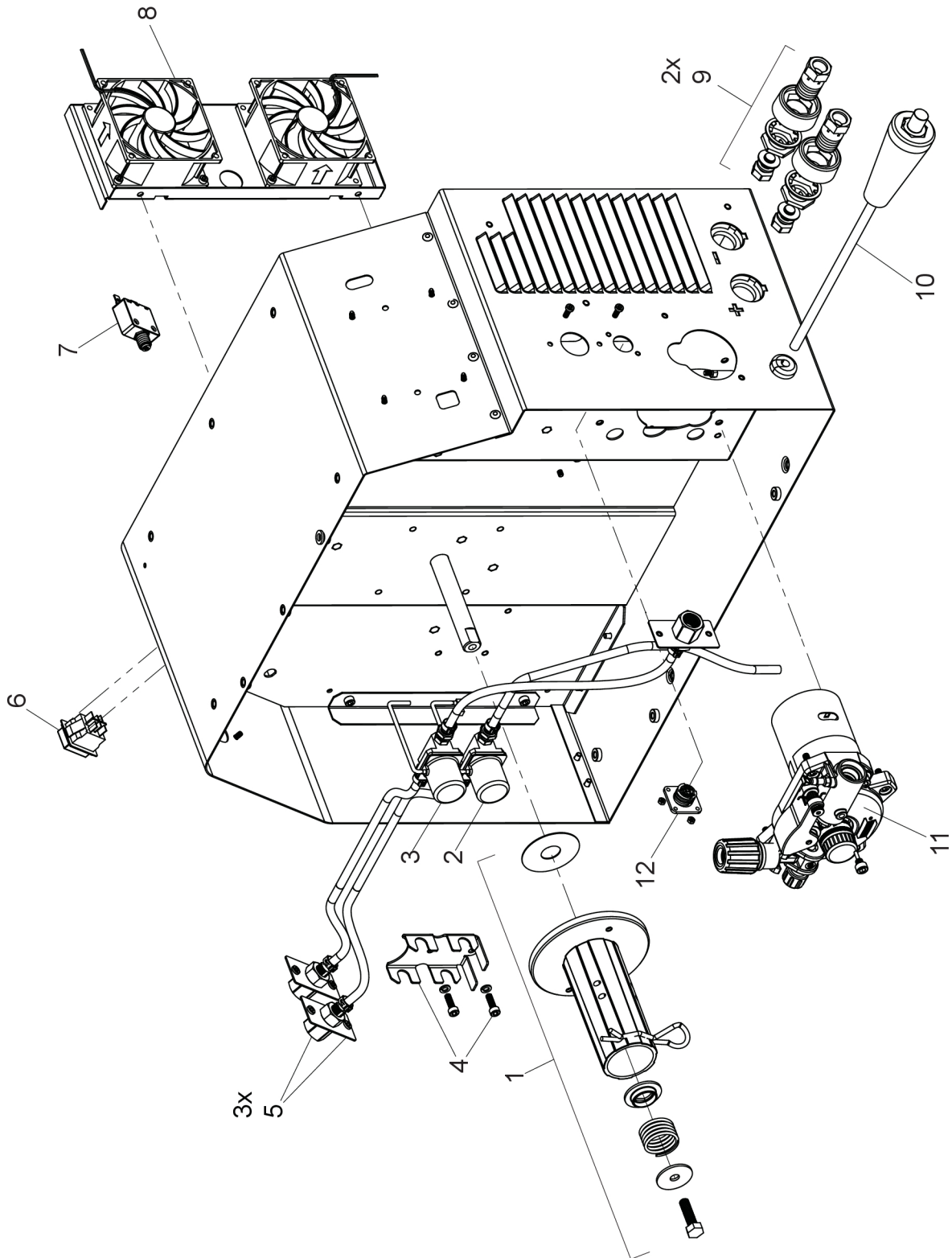
Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 537	Hinge	
2	1	0558 102 538	Door pull & latch	
3	1	0558 102 539	Side door, spool side	With ESAB logo
4	1	0558 102 544	Frame, spool Side	
5	4	0558 102 399	Handle	
6	2	0558 102 545	Foot	With 2× M6x20 screw
7	1	0558 102 546	Frame, power side	
8	1	0558 102 547	Side panel, power side	With ESAB logo



Connections including drive system - CSA

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 521	Brake hub kit	
2	1	0558 102 522	MIG gas solenoid system	
3	1	0558 102 523	TIG/Spool gun gas solenoid system	
4	1	0558 102 525	Bracket, gas solenoid mounting	
5	3	0558 102 524	Gas inlet/outlet, bulkhead fitting	
6	1	0558 102 415	Power switch	
7	1	0558 102 563	Circuit breaker	
8	2	0558 102 526	Fan assembly	
9	2	0558 102 527	Female OKC connector	
10	1	0558 102 528	Polarity change cable & male OKC connector	
11	1	0558 102 529	Wire drive assembly, bayonet connector	
12	1	0558 102 530	8 pin female remote receptacle & harness	

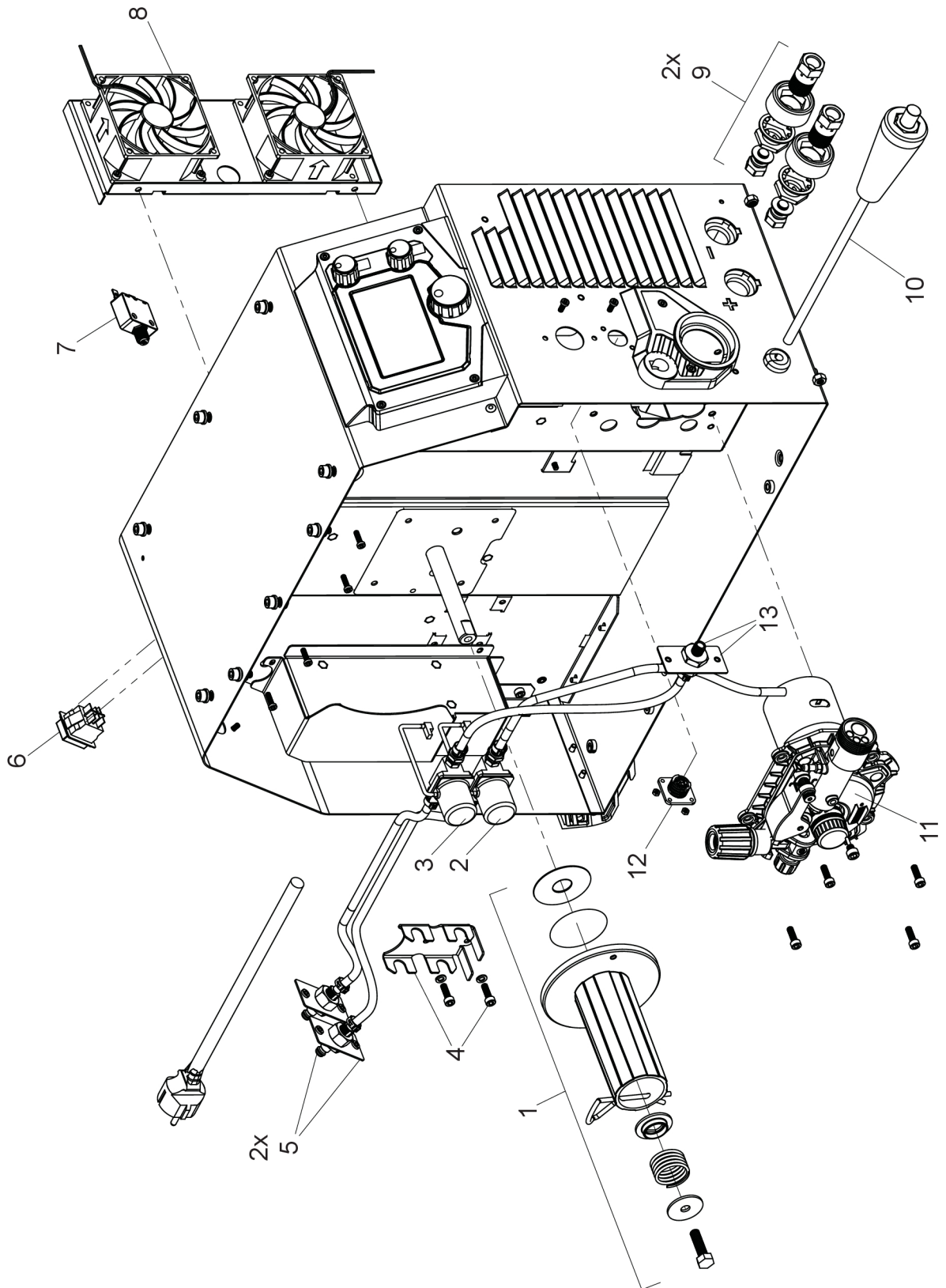
CSA



Connections including drive system - CE

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 521	Brake hub kit	
2	1	0464 620 880	MIG gas solenoid system	
3	1	0464 621 880	TIG/Spool gun gas solenoid system	
4	1	0558 102 525	Bracket, gas solenoid mounting	
5	2	0464 622 880	Gas inlet/outlet, bulkhead fitting	
6	1	0558 102 415	Power switch	
7	1	0558 102 563	Circuit breaker	
8	2	0558 102 526	Fan assembly	
9	2	0558 102 527	Female OKC connector	
10	1	0558 102 528	Polarity change cable & male OKC connector	
11	1	0464 623 880	Wire drive assembly, EURO connector	
12	1	0558 102 530	8 pin female remote receptacle & harness	
13	1	0464 637 880	Gas inlet/outlet bulkhead fitting - BSP	

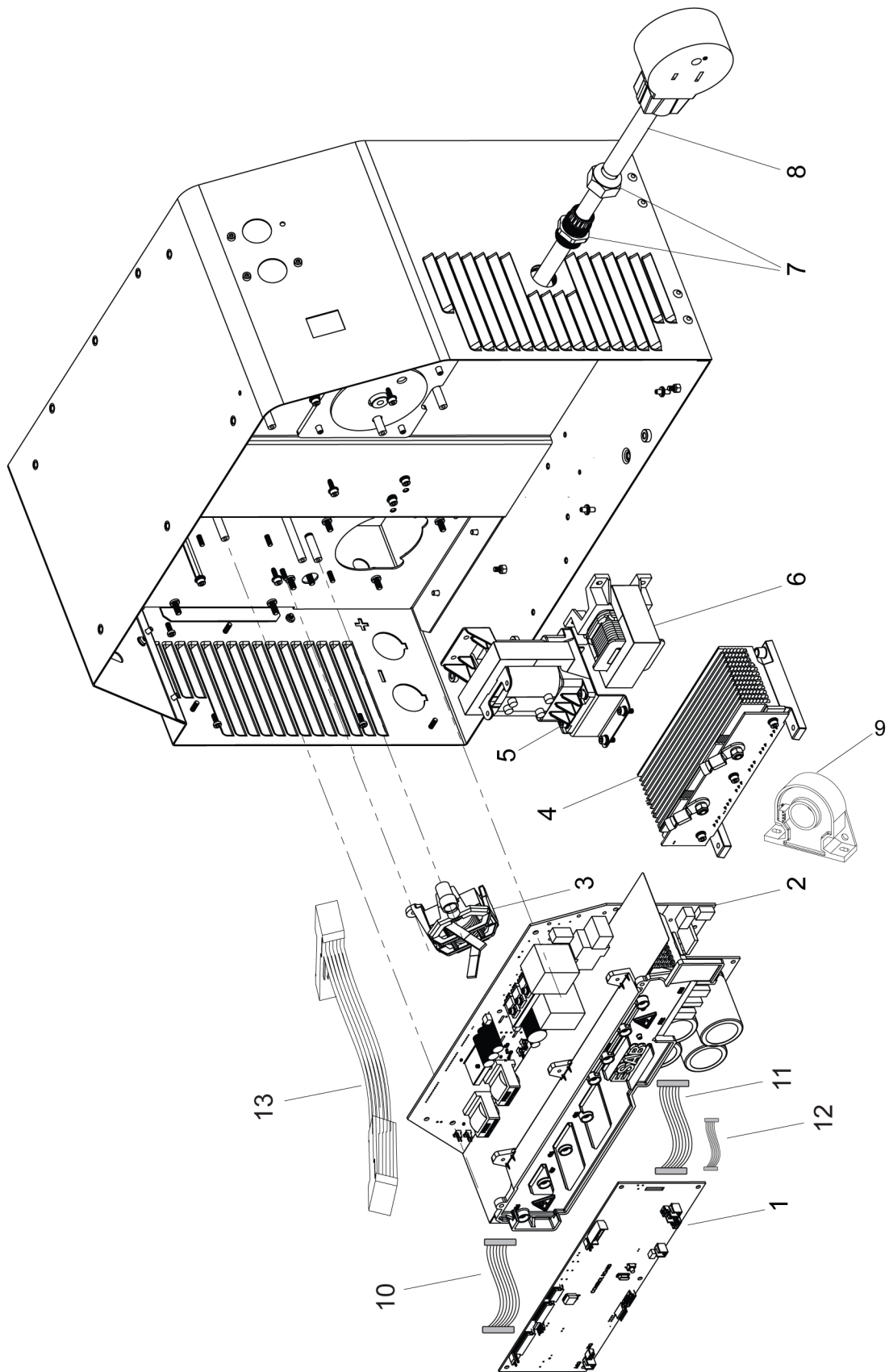
CE



Control modules - CSA

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 427	Control PCBA	PCB must be pre-configured before usage
2	1	0558 102 532	Power PCBA	
3	1	0558 102 430	Output inductor assembly	
4	1	0558 102 533	Output diode assembly	
5	1	0558 102 534	Main transformer assembly	With 3× NTC
6	1	0558 102 431	PFC inductor assembly	
7	1	0558 102 535	Strain relief, mains cable	
8	1	0558 102 536	Mains cable	With input power plug
9	1	0464 752 405	Current sensor	
10	1	0558 103 457	Wire Harness 1, Power PCB to Control PCB	CN2-CN2
11	1	0558 103 458	Wire Harness 2, Power PCB to Control PCB	CN1-CN17
12	1	0558 103 459	Wire Harness 3, Power PCB to Control PCB	CN4-CN19
13	1	0558 103 460	Wire Harness, Control PCB to HMI	CN6-CN3

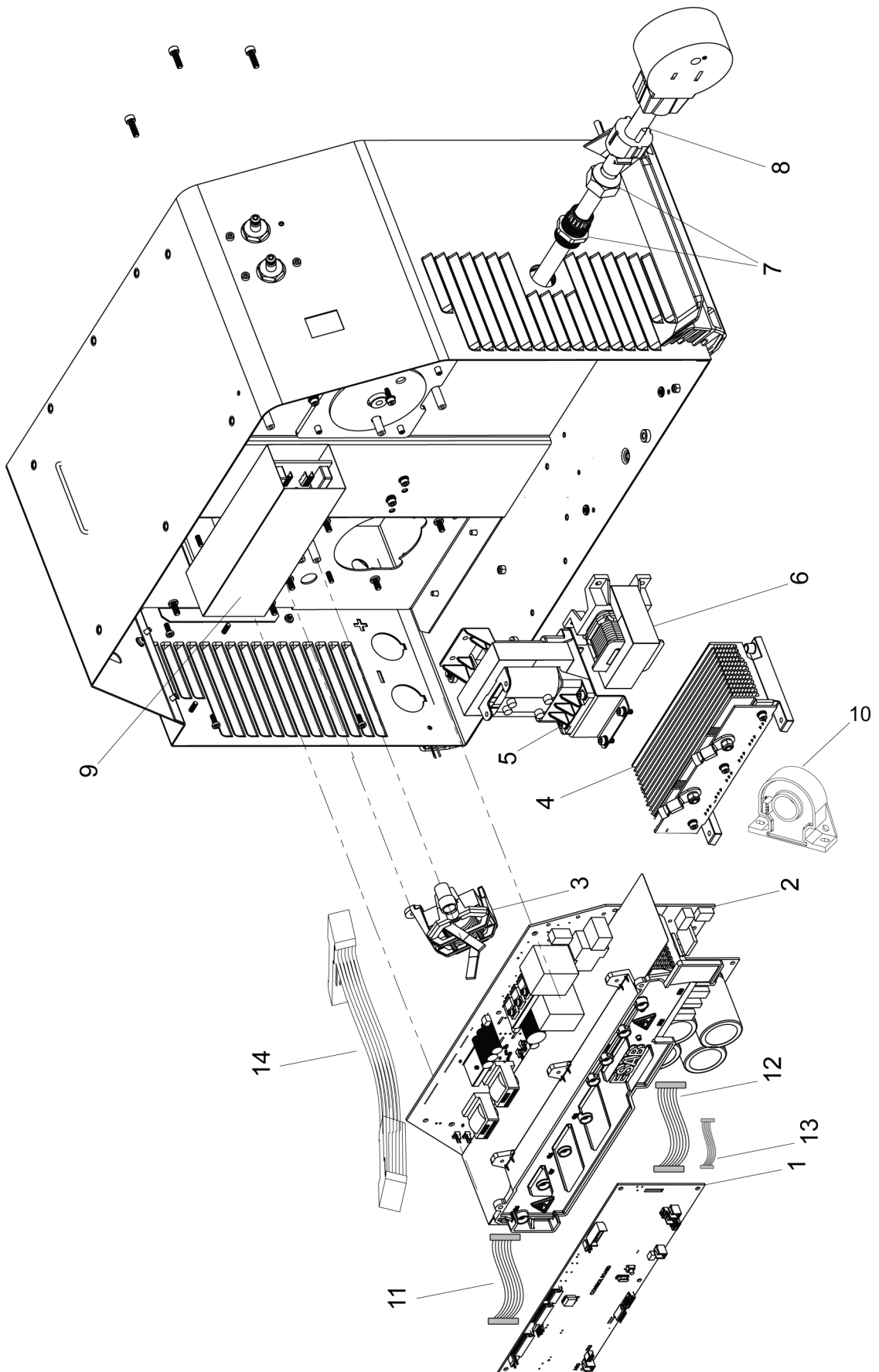
CSA



Control modules - CE

Item	Qty	Ordering no.	Denomination	Notes
1	1	0464 592 880	Control PCBA	PCB must be pre-configured before usage
2	1	0464 624 880	Power PCBA	
3	1	0558 102 430	Output inductor assembly	
4	1	0558 102 533	Output diode assembly	
5	1	0464 625 880	Main transformer assembly	With 3× NTC
6	1	0558 102 431	PFC inductor assembly	
7	1	0464 626 880	Strain relief, mains cable	
8	1	0464 627 880	Mains cable	With input power plug
9	1	0464 589 880	EMI PCBA	
10	1	0464 752 405	Current sensor	
11	1	0558 103 457	Harness	CN2-CN2
12	1	0558 103 458	Harness	CN1-CN17
13	1	0558 103 459	Harness	CN4-CN19
14	1	0558 103 456	Harness	CN6-CN3

CE



User interface

EM 235ic - CSA

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 549	User interface complete assembly	
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	1	0558 102 489	Knob, WFS	
6	1	0558 102 488	Process select knob	

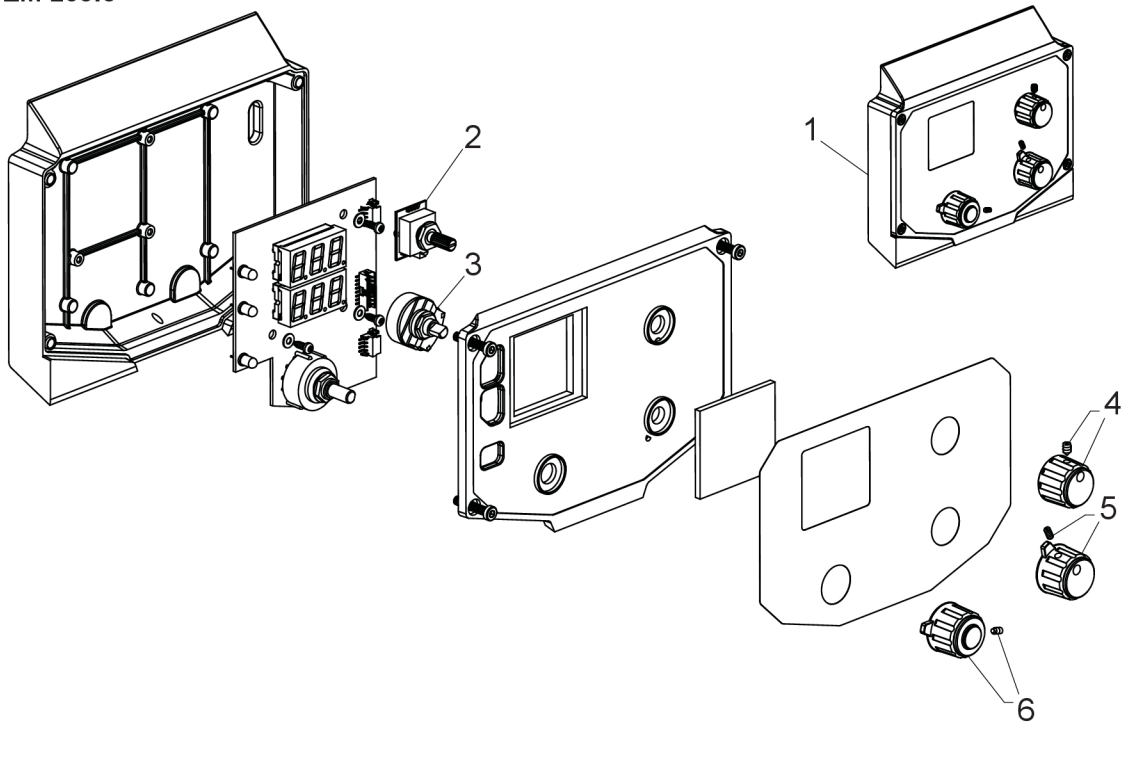
EMP 235ic - CSA

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 548	User interface complete assembly	
2	1	0558 102 437	EMP 235ic lens assembly kit	
3	1	0558 102 438	Replaceable display lens	
4	2	0558 102 423	Encoder for small knob	
5	1	0558 102 424	Encoder for large knob	
6	2	0558 102 440	Knob, small	
7	1	0558 102 441	Knob, large	

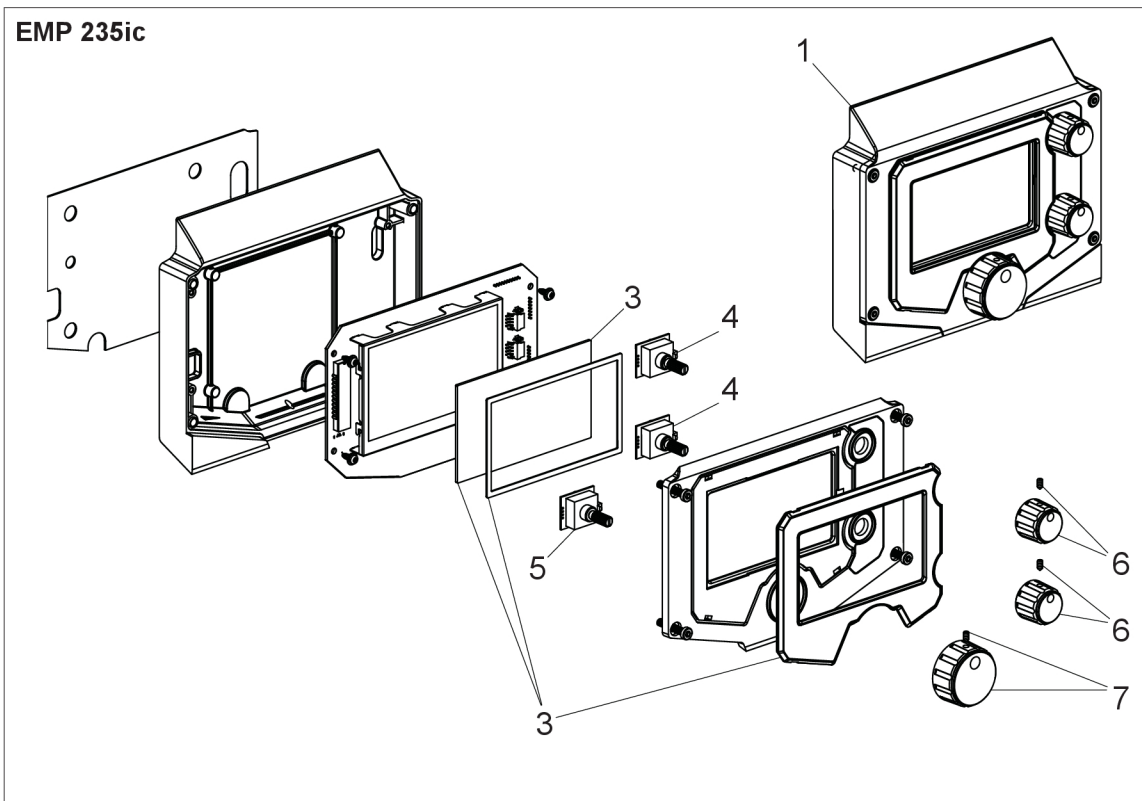
EMP 235ic - CE

Item	Qty	Ordering no.	Denomination	Notes
1	1	0464 628 880	User interface complete assembly	
2	1	0558 102 437	EMP 235ic lens assembly kit	
3	1	0558 102 438	Replaceable display lens	
4	2	0558 102 423	Encoder for small knob	
5	1	0558 102 424	Encoder for large knob	
6	2	0558 102 440	Knob, small	
7	1	0558 102 441	Knob, large	

EM 235ic

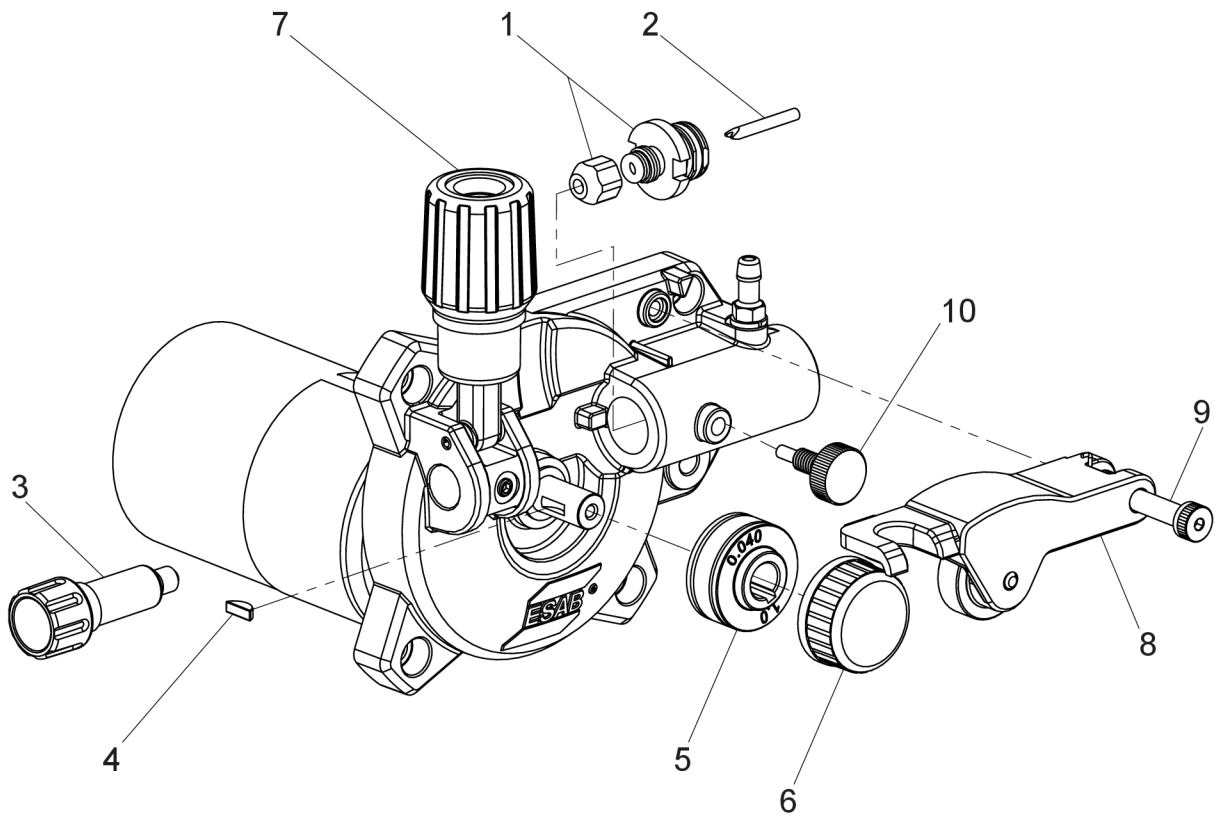


EMP 235ic



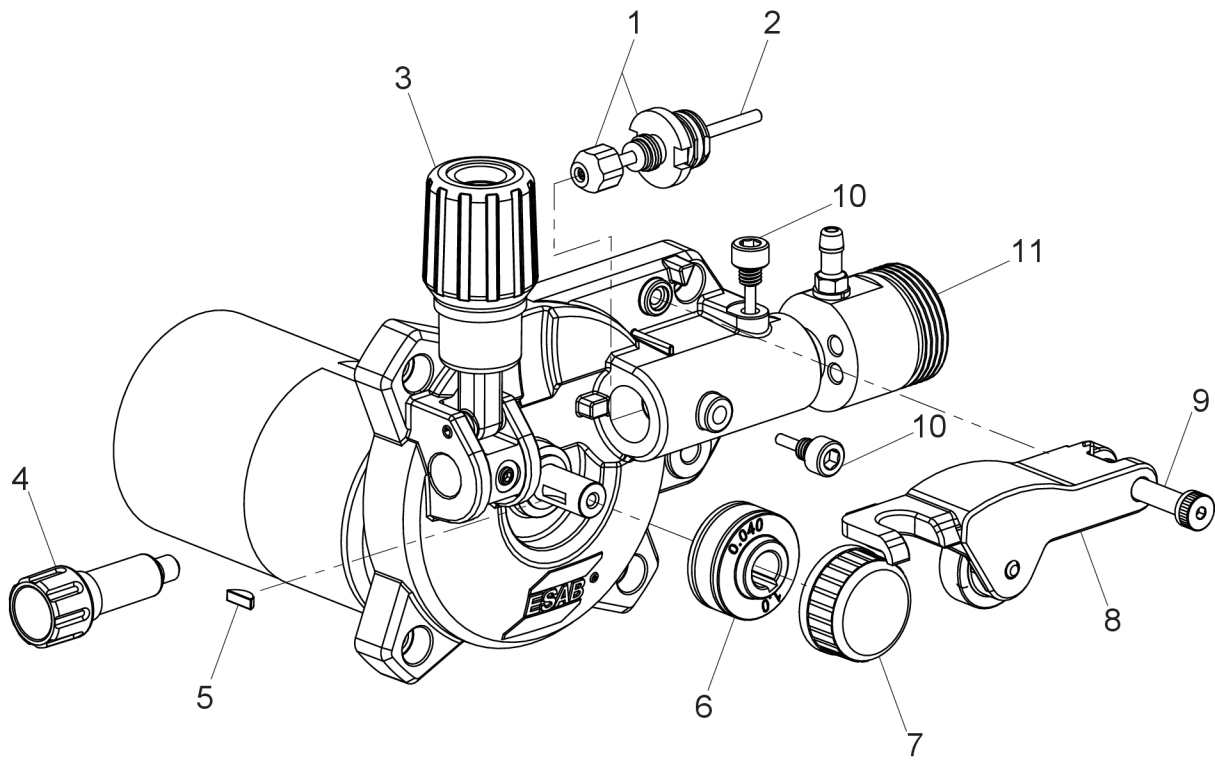
WEAR PARTS - CSA

Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 515	Brass outlet assembly	N/A	N/A
2	0558 102 516	Wire outlet guide	Fe/SS/Flux Cored	0.024 in. / 0.030 in. (0.6 mm / 0.8 mm)
	0558 102 517	Wire outlet guide	Fe/SS/Flux Cored	0.035 in. / 0.052 in. (0.9 mm / 1.3 mm)
3	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)
4	0558 102 457	Crescent Woodruff key	N/A	N/A
5	7977036	Feed roll "V" groove	Fe/SS	0.024 in. / 0.030 in. (0.6 mm / 0.8 mm)
	7977660	Feed roll "V" groove	Fe/SS	0.035 in. / 0.045 in. (0.9 mm / 1.2 mm)
	7977732	Feed roll "V" knurled	Flux Cored	0.030 in. / 0.035 in. (0.8 mm / 0.9 mm)
	704277	Feed roll "V" knurled	Flux Cored	0.045 in. (1.2 mm)
	7977731	Feed roll "U"	Alum	0.030 in. / 0.035 in. (0.8 mm / 0.9 mm)
	7977264	Feed roll "U"	Alum	0.040 in. / 3/64 in. (1.0 mm / 1.2 mm)
6	0558 102 518	Locking knob	N/A	N/A
7	0558 102 329	Wire tension knob	N/A	N/A
8	0558 102 331	Pressure arm complete assembly	N/A	N/A
9	0558 102 550	Shoulder screw	N/A	N/A
10	0558 102 333	MIG torch locking knob	N/A	N/A



WEAR PARTS - CE

Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 515	Brass outlet assembly	N/A	N/A
2	0464 635 880	Wire outlet guide steel	Fe/SS/Flux Cored	1.0 mm – 1.2 mm (0.040 in. – 0.045 in.)
	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.)
	0464 598 880	Wire outlet guide teflon	Aluminium	1.0 mm – 1.2 mm (0.040 in. – 0.045 in.)
3	0558 102 329	Wire tension knob	N/A	N/A
4	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.)
5	0558 102 457	Crescent Woodruff key	N/A	N/A
6	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.)
	0367 556 006	Feed roll "knurled"	Cored	1.0 mm / 1.2 mm (0.040 in. / 0.045 in.) 1.4 mm / 1.6 mm (0.055 in. / 0.062 in.)
7	0558 102 518	Locking knob	N/A	N/A
8	0558 102 331	Pressure arm complete assembly	N/A	N/A
9	0558 102 550	Shoulder screw	N/A	N/A
10	0558 102 459	Euro adapter locating screw	N/A	N/A
11	0464 636 880	Euro adapter assembly	N/A	N/A





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