

# ***RobustFeed PRO***



## **Spare parts list**

Spare parts may be ordered through your nearest ESAB dealer, see [esab.com](http://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.

For accessories to the product, see the instruction manual.

<b>Ordering no.</b>	<b>Denomination</b>	<b>Notes</b>
0445 800 880	RobustFeed PRO	With EURO connector
0445 800 881	RobustFeed PRO, Water	With EURO connector and including torch cooling system
0445 800 882	RobustFeed PRO Offshore	With EURO connector, including gas flow meter and heater
0445 800 883	RobustFeed PRO Offshore, Water	With EURO connector and including torch cooling system, including gas flow meter and heater
0445 800 884	RobustFeed PRO, Tweco	With Tweco 4 connector
0445 800 885	RobustFeed PRO Offshore, Tweco	With Tweco 4 connector, including gas flow meter and heater
0463 659 001	Spare parts list	RobustFeed PRO
0463 660 001	Service manual	RobustFeed PRO
0463 658 *	Instruction manual	CE
0463 691 *	Instruction manual	CSA

TABLE OF CONTENTS

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**SPARE PARTS HOUSING MODULE ..... 4**

**SPARE PARTS FEEDER MECHANISM MODULE ..... 6**

**SPARE PARTS INTERFACE MODULES ..... 8**

**SPARE PARTS BOBBIN HOLDER ..... 12**

**SPARE PARTS SYSTEM CONTROL MODULE ..... 14**

**SPARE PARTS WATER, GAS AND HEAT KIT MODULES ..... 16**

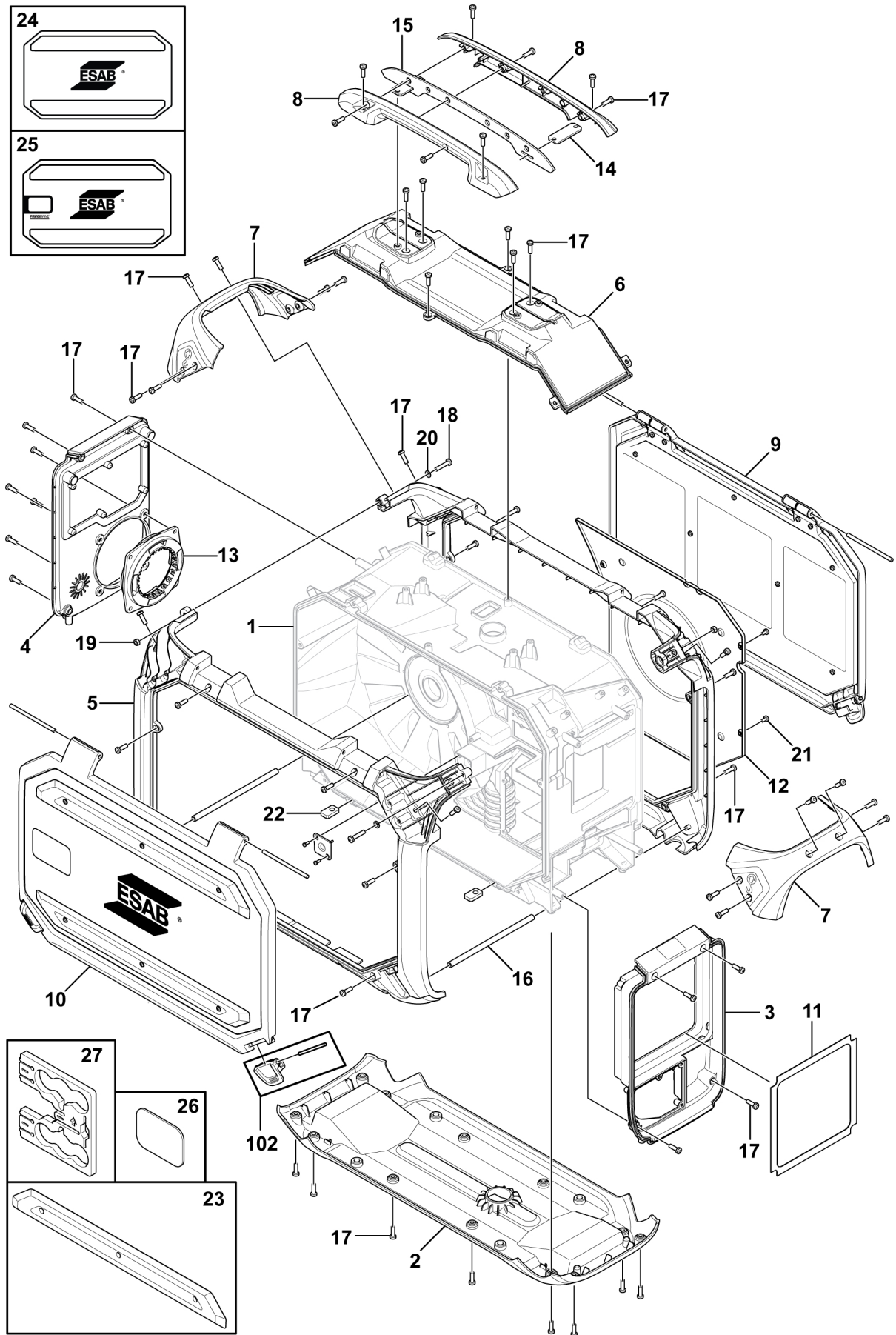
**WEAR PARTS ..... 19**

## SPARE PARTS HOUSING MODULE

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1		Inner frame		
2	1	0445 763 001	Bottom panel		
3	1	0445 764 001	Front panel		
4	1	0445 765 001	Rear panel		
5	2	0445 766 001	Outer frame		
6	1	0445 767 001	Top panel		
7	2	0445 768 001	Handle cover		
8	2		Top handle	See item 101.	
9	1	0445 780 880	Door complete right		
10	1	0464 694 880	Door left	The doors are supplied without internal decals. See item 103.	
11	1	0446 035 001	Gasket user interface		
12	1	0446 005 001	Cover panel		
13	1	0445 810 001	Strain relief inner part		
14	2		Handle bracket	See item 101.	
15	1		Top handle frame	See item 101.	
16	2		Hose 0.17 m, PVC, 9 mm outer diameter, 5 mm inner diameter		
17	57	0194 153 330	Screw Remform 5×16	See item 101.	
18	2		Screw MRT M5×25		
19	4		Nut 6K steel 8.8 M5		
20	4		Plain washer 5-200 HV-A2K		
21	4	0194 277 291	Screw MRT M4×8 Black		
22	4	0446 011 001	Rectangular nut		
23	4	0445 782 001	Bumper		
24	1	0445 786 001	Side decal right		
25	1	0445 786 003	Side decal left		
26	1	0445 832 001	Spool window		
27	1	0446 034 001	RF300 S+W parts storage foam		

Item	Ordering no.	Denomination	Notes
101	0464 667 885	Top handle and frame kit	Including items 8 (2 pcs), 14 (2 pcs), 15 and 17 (8 pcs)
102	0464 663 079	Door lock kit	Including pin (1 pcs) and door lock (1 pcs)



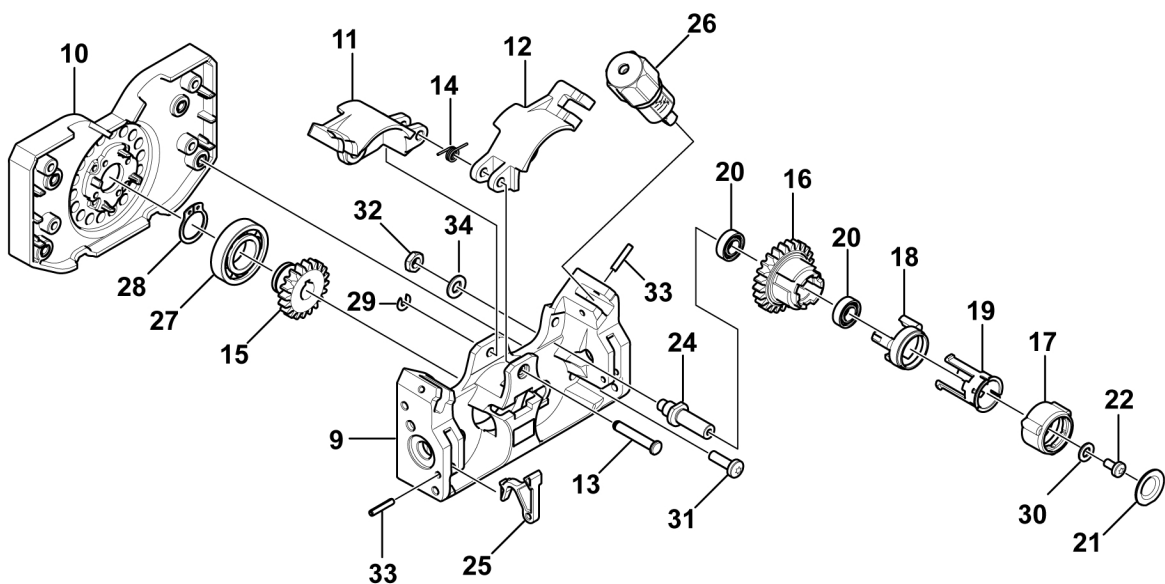
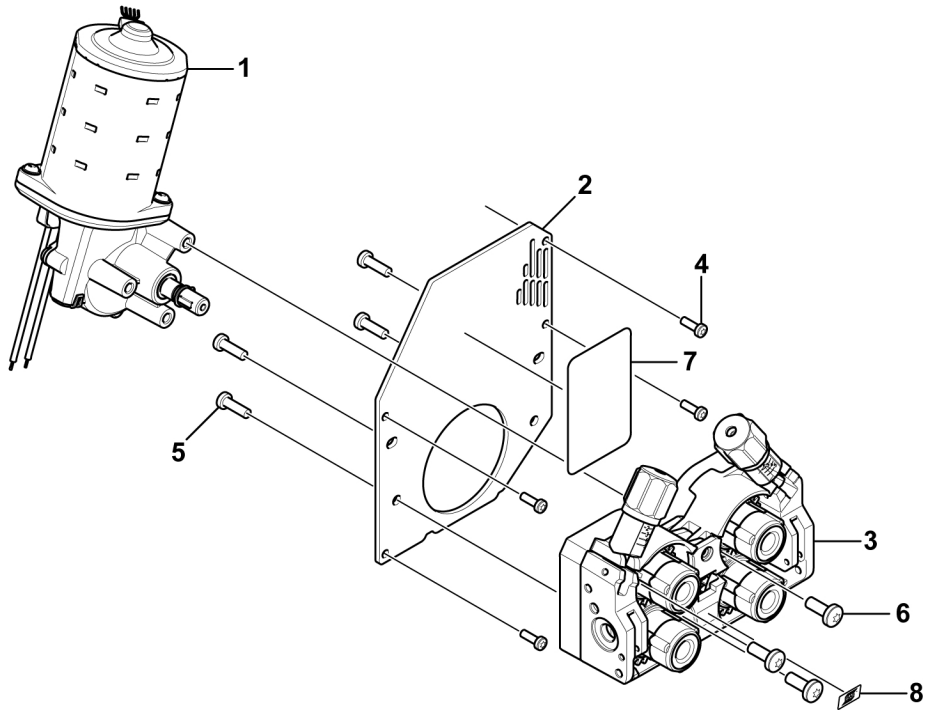
## SPARE PARTS FEEDER MECHANISM MODULE

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0465 827 881	Drive unit wire feeder		
2	1	0446 010 001	Adaptor plate		
3	1		Feeder mechanism	See item 204.	
4	4	0194 153 292	Screw Remform Torx 4×12		
5	4	0194 153 330	Screw Remform Torx 5×16		
6	3		Screw MRT M6×16		
7	1		Warning decal pinching		
8	1	0445 916 001	ESAB logo silver		
9	1		Front plate	See item 204.	
10	1		Back plate	See item 204.	
11	1	0445 818 002	Swing arm left	See item 204.	
12	1	0445 818 001	Swing arm right	See item 204.	
13	1		Swing arm shaft	See items 202 and 204.	
14	1	0445 839 001	Lift spring	See items 202 and 204.	
15	1	0445 820 001	Motor pinion	See items 203 and 204.	
16	4		Gear hub	See item 203.	
17	4		Bezel	See item 203.	
18	4		Driver	See item 203.	
19	4		Retainer	See item 203.	
20	8		Bearing 8×16×5	See item 203.	
21	4		Cover	See item 203.	
22	4		Screw MRT M4×8	See item 203.	
24	4	0445 841 001	Feed roll shaft		
25	2	0446 059 001	Nozzle lever		
26	2	0445 831 880	Tensioner unit assembly		
27	1		Bearing, 17×35×8 mm	See item 201.	
28	1		Lock ring Ø17	See item 201.	
29	1		Circlip Ø6/4	See item 202.	
30	4		M4 Washer	See item 203.	
31	4		Screw MRT M5×16		
32	4	0349 312 091	Hexagon thin nut		
33	4		Spring pin, Ø3×16, ISO 8752, DIN 1481	See item 204.	
34	4		Cup spring		

Item	Ordering no.	Denomination	Notes
201	0464 667 883	Bearing and lock ring kit	Including items 27 and 28
202	0464 667 887	Swing arm shaft kit	Including items 13, 14 and 29
203	0464 667 893	Gear hub complete kit	Including items 15–22 and 30
204	0464 667 886	Feeder mechanism kit	Including items 9–15 and 33

For feeder mechanism **wear** parts, see "*Wear parts*", page 19.



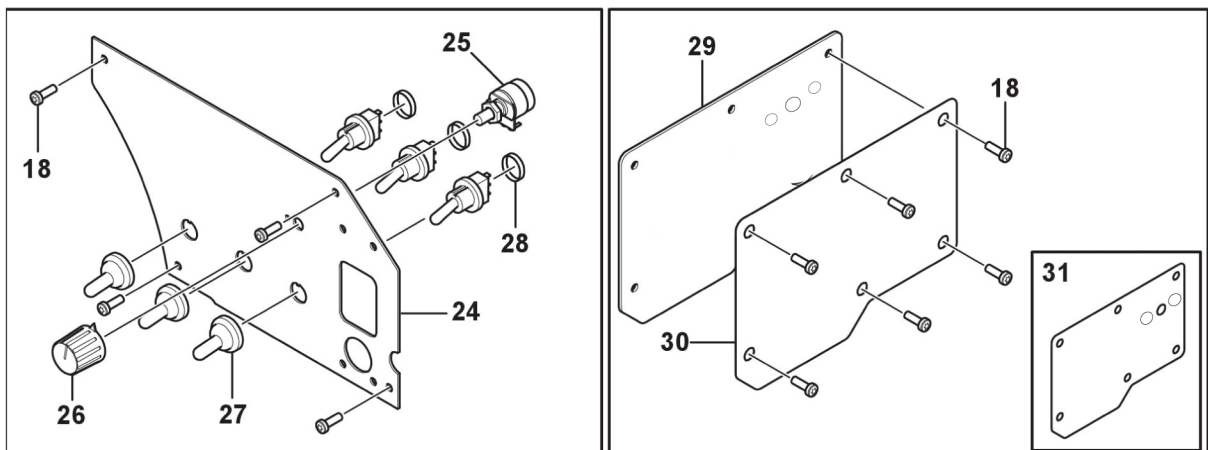
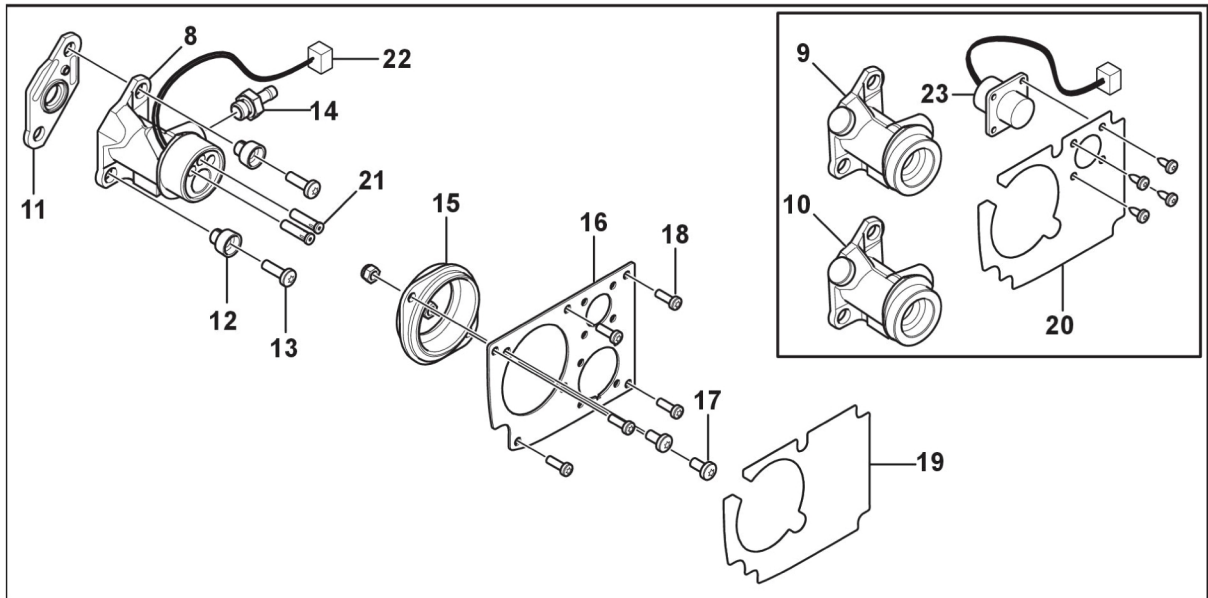
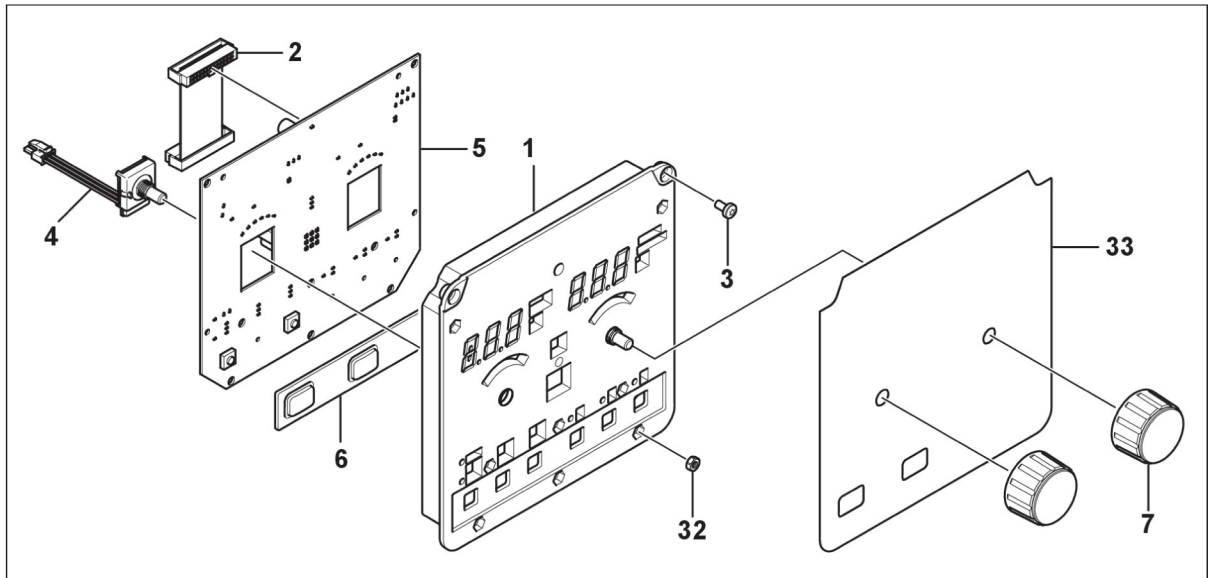
## SPARE PARTS INTERFACE MODULES

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1		External user interface frame	See item 304.	
2	1	0193 700 709	Ribbon cable with connectors		
3	2		Screw MRT M4×8		
4	2	0193 912 005	Encoder complete		
5	1	0440 227 881	Setting panel circuit board		1AP1
6	1		Key pad external, Pro	See item 304.	
7	2	0321 475 893	Knob D36-1/4IN		
8	1		Euro connector	See item 301.	
9	1		Tweco 4 connector	See item 302.	
10	1		Tweco 5 connector	See item 303.	
11	1		Torch connector insulator	See item 301, 302 and 303.	
12	2		Screw insulator	See item 301, 302 and 303.	
13	2		Screw MRT M5×16	See item 302 and 303.	
14	1	0445 856 001	Brass fitting	Including O-ring	
15	1		Torch connector seat	See item 301, 302 and 303.	
16	1	0446 003 001	Interface plate front		
17	2		Screw MRT M5×10		
18	15	0194 153 292	Screw Remform Torx 4×12		
19	1	0445 882 001	Front Overlay Euro		
20	1	0445 882 003	Front Overlay Tweco		
21	2	0368 750 001	Insulating sleeve	For Euro connector, see item 301.	
22	1	0446 020 880	Trigger cable harness	For Euro connector, see item 301.	
23	1	0446 020 881	Trigger cable harness	For Tweco 4 and 5 connectors	
24	1		Internal setting panel plate		
25	1	0446 016 880	Internal user interface cable harness		
26	1	0321 475 881	Knob with pointer		
27	3	0194 423 901	Sealing knitter		
28	3		Cable binder		
29	1	0446 004 001	Interface plate rear		
30	1	0445 881 001	Rear plate overlay		
31	1		Rear plate overlay heatkit	See item 601 in <i>"Spare parts water, gas and heat kit modules"</i> , page 16.	
32	8		Nut M4	See item 304.	

SPARE PARTS INTERFACE MODULES

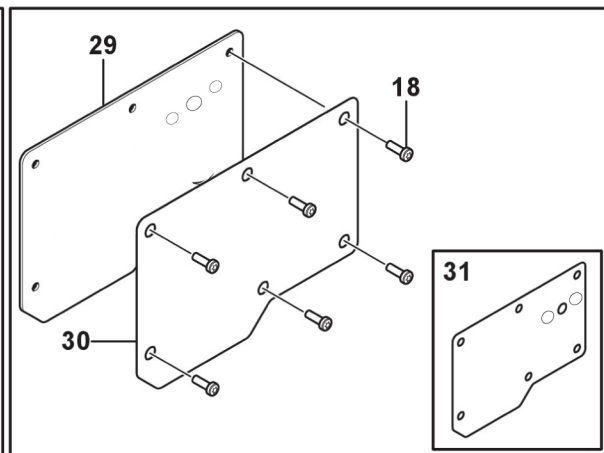
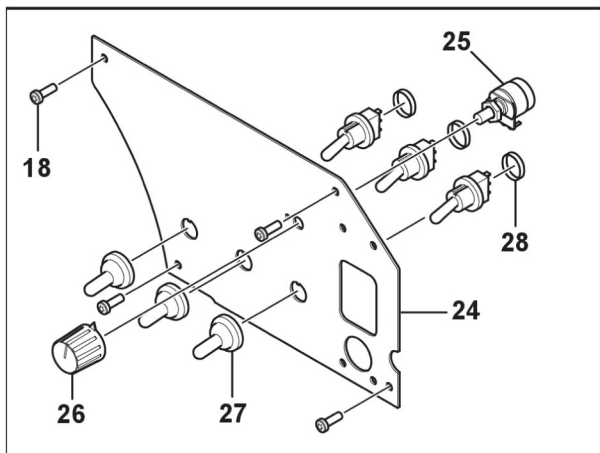
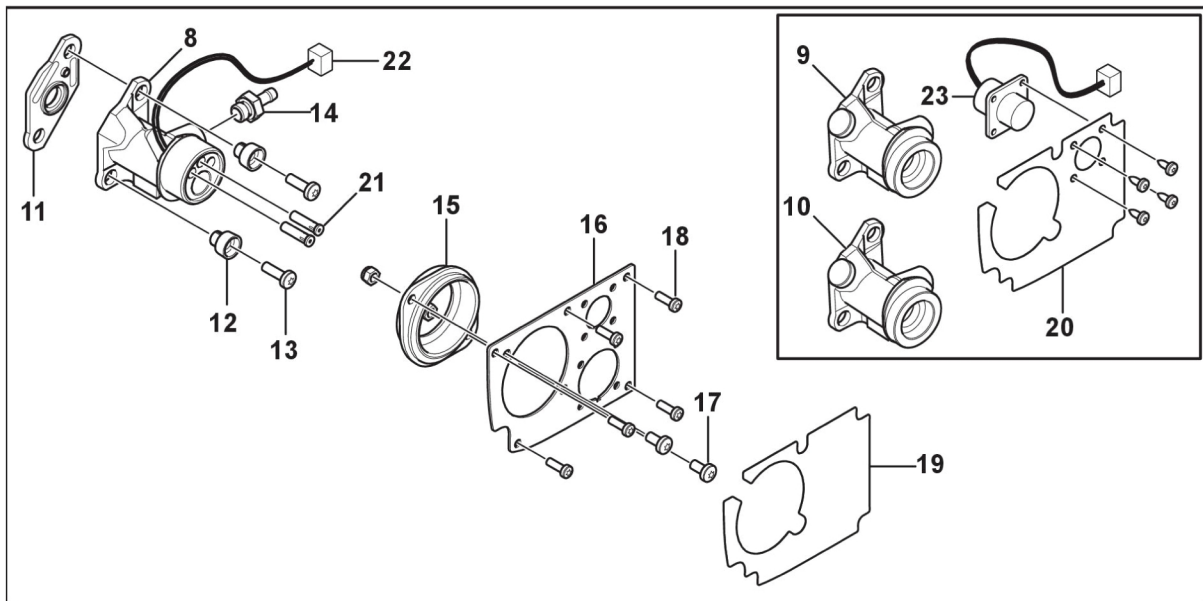
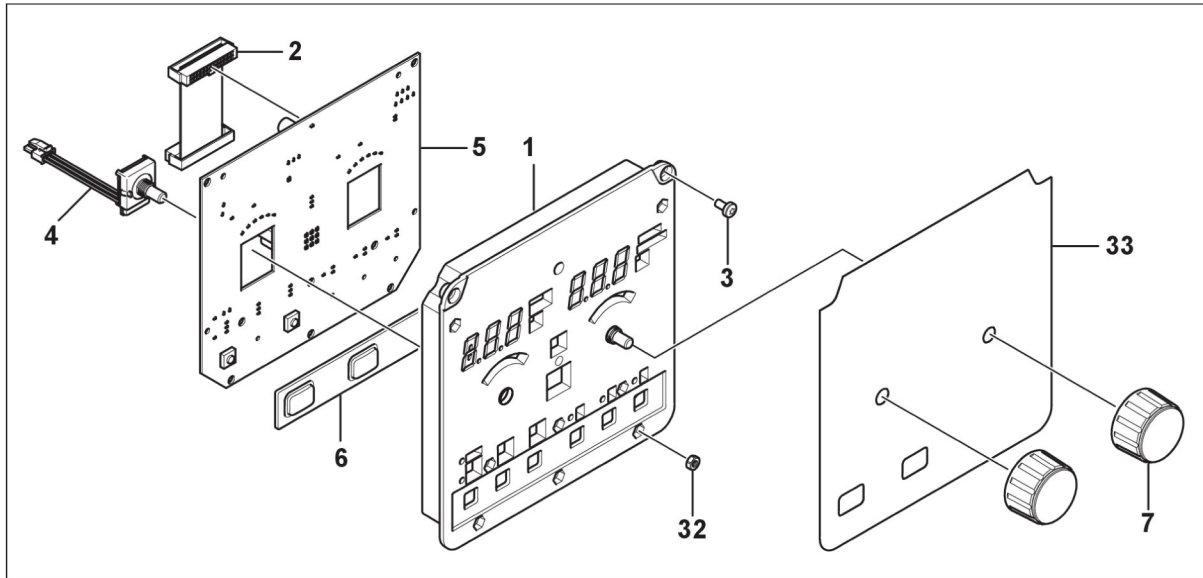
Item	Qty	Ordering no.	Denomination	Notes	C
33	1		Decal external user interface Pro	See item 304.	
34	1	0446 026 001	Thump screw		



SPARE PARTS INTERFACE MODULES

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<b>Item</b>	<b>Ordering no.</b>	<b>Denomination</b>	<b>Notes</b>
301	0464 667 884	Euro torch connector kit	Including items 8, 11, 12, 15, 21 and 22
302	0464 667 899	Tweco 4 torch connector kit	Including items 9, 11, 12 and 15
303	0464 667 900	Tweco 5 torch connector kit	Including items 10, 11, 12 and 15
304	0464 667 901	Frame external user interface kit	Including items 1, 6, 32 and 33



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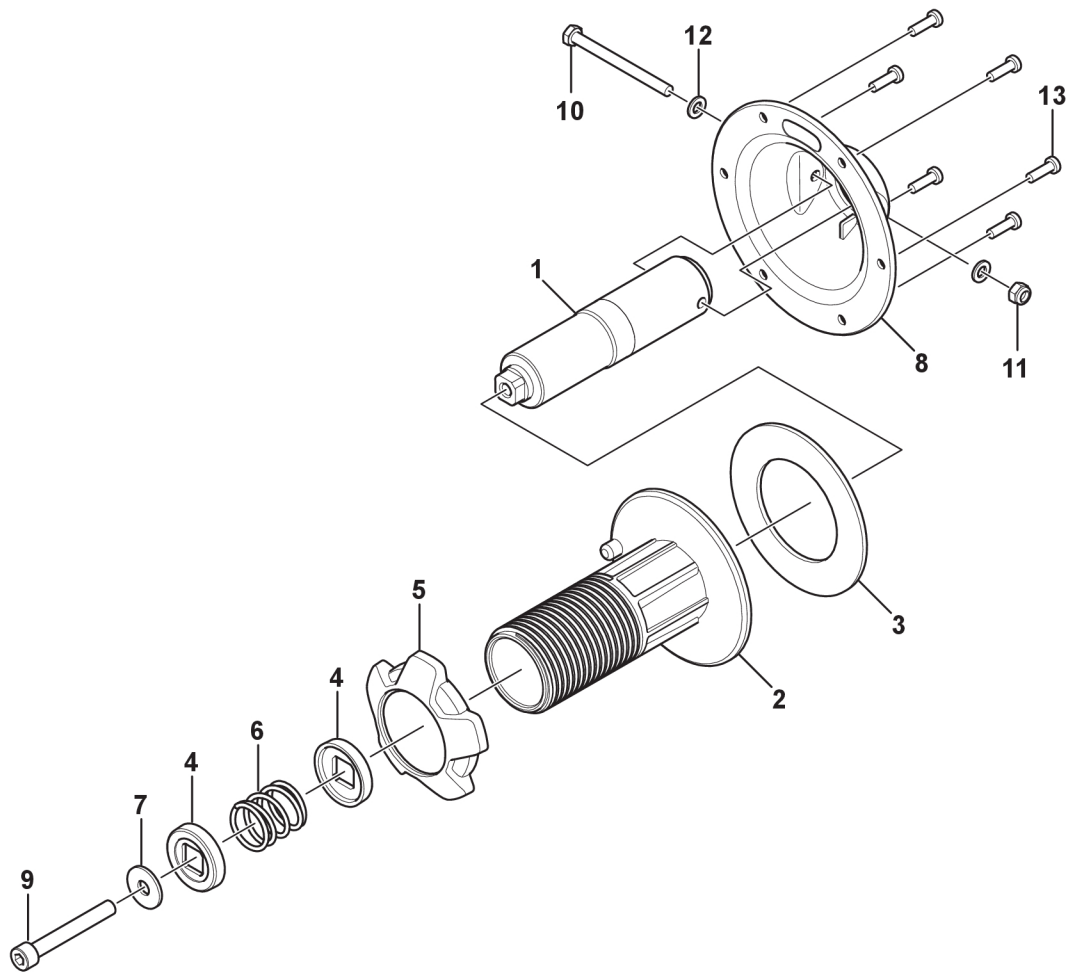
**SPARE PARTS BOBBIN HOLDER**


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**C = component designation in the circuit diagram**

Item	Qty	Ordering no.	Denomination	Notes	C
1	1		Brake hub axle	See item 401.	
2	1	0445 794 001	Brake hub sleeve		
3	1	0445 613 001	Brake hub friction pad	See item 401. Tape included	
4	2		Brake hub spring seat	See item 402.	
5	1	0445 779 001	Brake hub nut		
6	1		Brake hub spring	See item 402.	
7	1		Washer RB 24×8.4×2	See item 402.	
8	1	0446 006 001	RF300 bobbin console		
9	1		Screw MC6S M8×60	See item 402.	
10	1		Screw M6S M6×70	See item 401.	
11	1		Nut LOC-KING 6 BH6	See item 401.	
12	2		Washer BRB D12/6.4×1.5		
13	6	0194 153 330	Screw Remform Torx 5×16		

Item	Ordering no.	Denomination	Notes
401	0464 667 881	Brake hub axle kit	Including items 1, 3, 10 and 11
402	0464 667 882	Brake hub spring seat kit	Including items 4, 6, 7 and 9

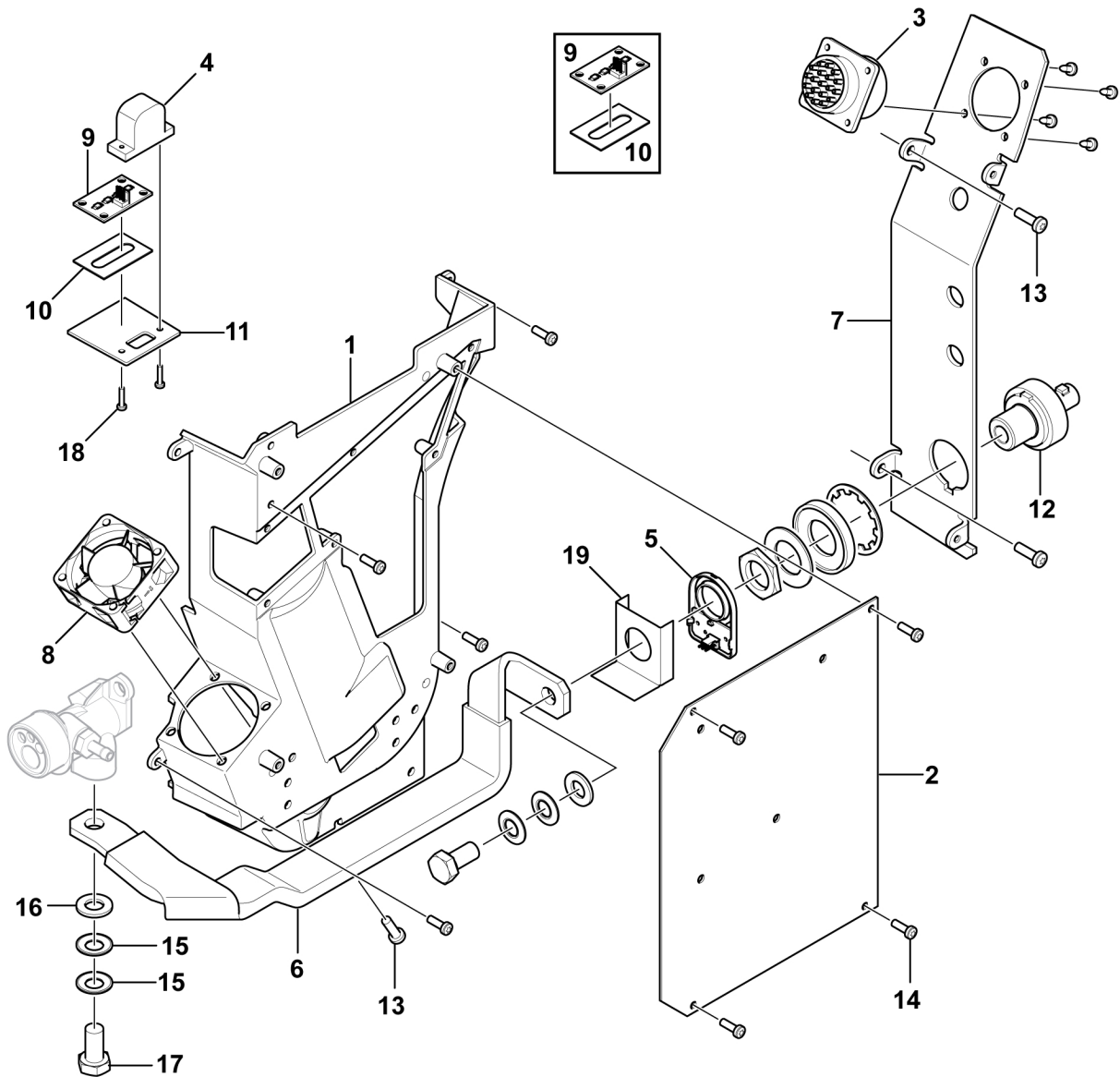


## SPARE PARTS SYSTEM CONTROL MODULE

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0445 776 001	Multi consol		
2	1	0440 232 880	Control circuit board		13AP1
3	1	0446 019 880	Signal cable harness		
4	1		USB complete	See item 502.	
5	1		Reed switch complete	See item 503.	
6	1		Torch copper bar	See item 501.	
7	1	0446 002 001	Interface plate internal		
8	1	0446 037 880	Fan complete		
9	2		LED circuit board	See item 502.	13AP2, 13AP3
10	2		Adhesive gasket	See item 502.	
11	1		Lighting window front	See item 502.	
12	1	0160 609 881	Machine connection, DINSE		
13	4	0194 153 330	Screw Remform 5×16		
14	8	0194 153 292	Screw Remform Torx 4×12		
15	4		Cup spring	See item 501.	
16	2		Washer 8-200 10,5 A2K	See item 501.	
17	2		Screw M6S M10×20 8.8 FZB	See item 501.	
18	2		Screw MRT M2.5×12	See item 502.	
19	1		Reed switch protection	See item 503.	

Item	Ordering no.	Denomination	Notes
501	0464 667 888	Torch copper bar kit	Including items 6, 15, 16 and 17
502	0464 667 902	LED circuit board kit	Including items 4, 9 (2 pcs), 10 (2 pcs), 11 and 18 (2 pcs)
503	0464 667 894	TMR sensor complete kit	Including items 5 and 19



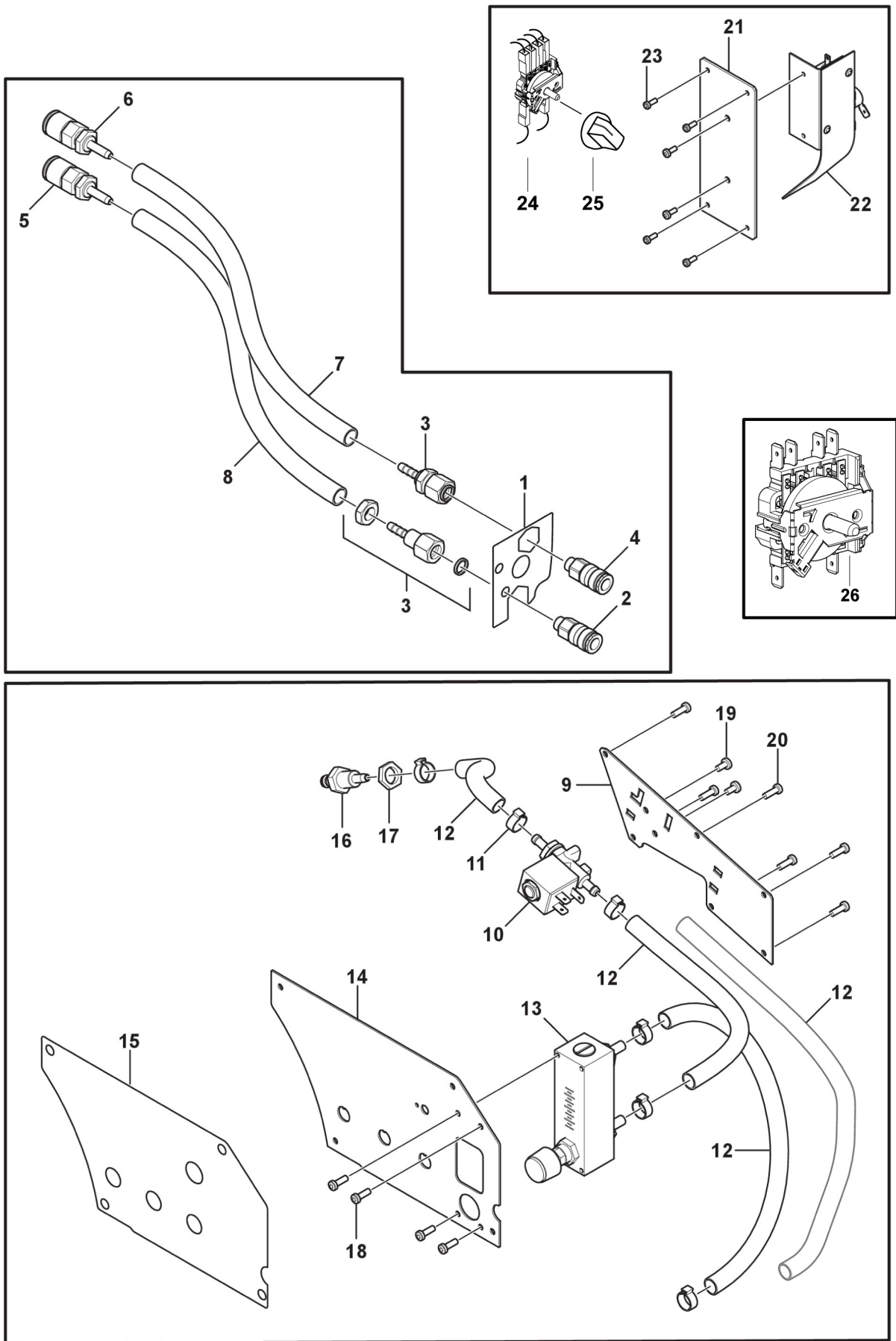
## SPARE PARTS WATER, GAS AND HEAT KIT MODULES

Item	Qty	Ordering no.	Denomination	Notes
1	1	0445 778 002	Water outlet overlay	
2	2	0445 745 003	Quick connector brass	
3	2	0445 746 001	Brass fitting IN DN-1006	
5	2	0446 967 002	Quick connector 3/16	
6	4	0368 978 005	Hose clamp 10.0/9.5	
7	0.33 m	0457 290 033	Hose D5×1.5 mm PVC blue	
8	0.36 m	0349 487 059	Hose D5×1.5 mm PVC red	
9	1		Gas adaptor plate	
10	1	0193 054 009	Solenoid valve	
11	4/6		Hose clamp	Qty dependent on inclusion of rotameter. See item 602.
12	–		Gas hose	In units <b>with</b> rotameter, 0.635 m of hose is needed. In units <b>without</b> rotameter, 0.46 m of hose is needed. See item 602.
13	1	0445 013 881	Gas flow meter	
14	1	0445 846 002	Internal user interface Pro	With rotameter.
15	1	0445 846 001	Internal user interface Pro	Without rotameter.
16	1		Nipple	See item 603.
17	1		Coupler nut LPH35	See item 603.
18	4		Screw MRT M4x12	Only in wire feed unit with rotameter.
19	2		Screw MRT M4×8	
20	6	0194 153 292	Screw Remform Torx 4×12	
21	1		Heater plate	See item 601.
22	1		Heater	See item 601.
23	4		Screw Remform Torx 3×8	See item 601.
24	1		Heat kit cable harness	See item 601.
25	1	0446 091 001	Knob	See item 601.
26	1	A000 100 331	Switch	

SPARE PARTS WATER, GAS AND HEAT KIT MODULES



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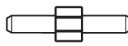

Item	Ordering no.	Denomination	Notes
601	0464 667 897	Heater and rear interface module	Including items 21–25 and also rear interface module (see " <i>Spare parts interface modules</i> ", page 8), For unit including heat kit
602	A000 100 627	Switch Retrofit kit	Including ON/OFF switch, cable harness, interface plate and rear plate overlay heat kit.  Kit 602 is only suited to replace the switch for feeders anufactured before OP422-xxx-xxxx.





## WEAR PARTS




## Fe, Ss and cored wire

Wire diameter (in.) (mm)	.023 0.6	.030 0.8	.040 0.9/1.0	.045 1.2	.052 1.4	1/16 1.6	.070 1.8	5/64 2.0	 <b>Feed roller</b>
<b>V-groove</b> 	X	X							0445 850 001
		X	X						0445 850 002
			X						0445 850 003
			X	X					<b>0445 850 004</b>
				X					0445 850 005
					X	X			0445 850 006
								X	0445 850 007






Inlet wire guide 	Middle wire guide 	Outlet wire guide 
0445 822 001 (2 mm)	0446 080 882	0445 830 883 (Tweco) 0445 830 881 (Euro)

## Cored wire – Different wire guides dependent on wire diameter!

Wire diameter (in.) (mm)	.040 0.9/1.0	.045 1.2	.052 1.4	1/16 1.6	.070 1.8	5/64 2.0	3/32 2.4	 <b>Feed roller</b>
<b>V-K-knurled</b> 	X	X						0445 850 030
		X						0445 850 031
		X	X					0445 850 032
					X			0445 850 033
						X		0445 850 034
							X	0445 850 035
								X

	Inlet wire guide 	Middle wire guide 	Outlet wire guide 
<b>Wire diameter 0.040–1/16 in. 0.9–1.6 mm</b>	0445 822 001 (2 mm)	0446 080 882	0445 830 883 (Tweco) 0445 830 881 (Euro)
<b>Wire diameter 0.070–3/32 in. 1.8–2.4 mm</b>	0445 822 002 (3 mm)	0446 080 883	0445 830 884 (Tweco) 0445 830 882 (Euro)

**Al wire**

Wire diameter (in.) (mm)	.023 0.6	.030 0.8	.040 0.9/1.0	.045 1.2	.052 1.4	1/16 1.6	.070 1.8	 <b>Feed roller</b>
<b>U-groove</b> 		<b>X</b>	<b>X</b>					0445 850 050
			<b>X</b>	<b>X</b>				0445 850 051
				<b>X</b>		<b>X</b>		0445 850 052
<b>Inlet wire guide</b> 	<b>Middle wire guide</b> 			<b>Outlet wire guide</b> 				
0445 822 001 (2 mm)	0446 080 881			0445 830 886 (Tweco) 0445 830 885 (Euro)				





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