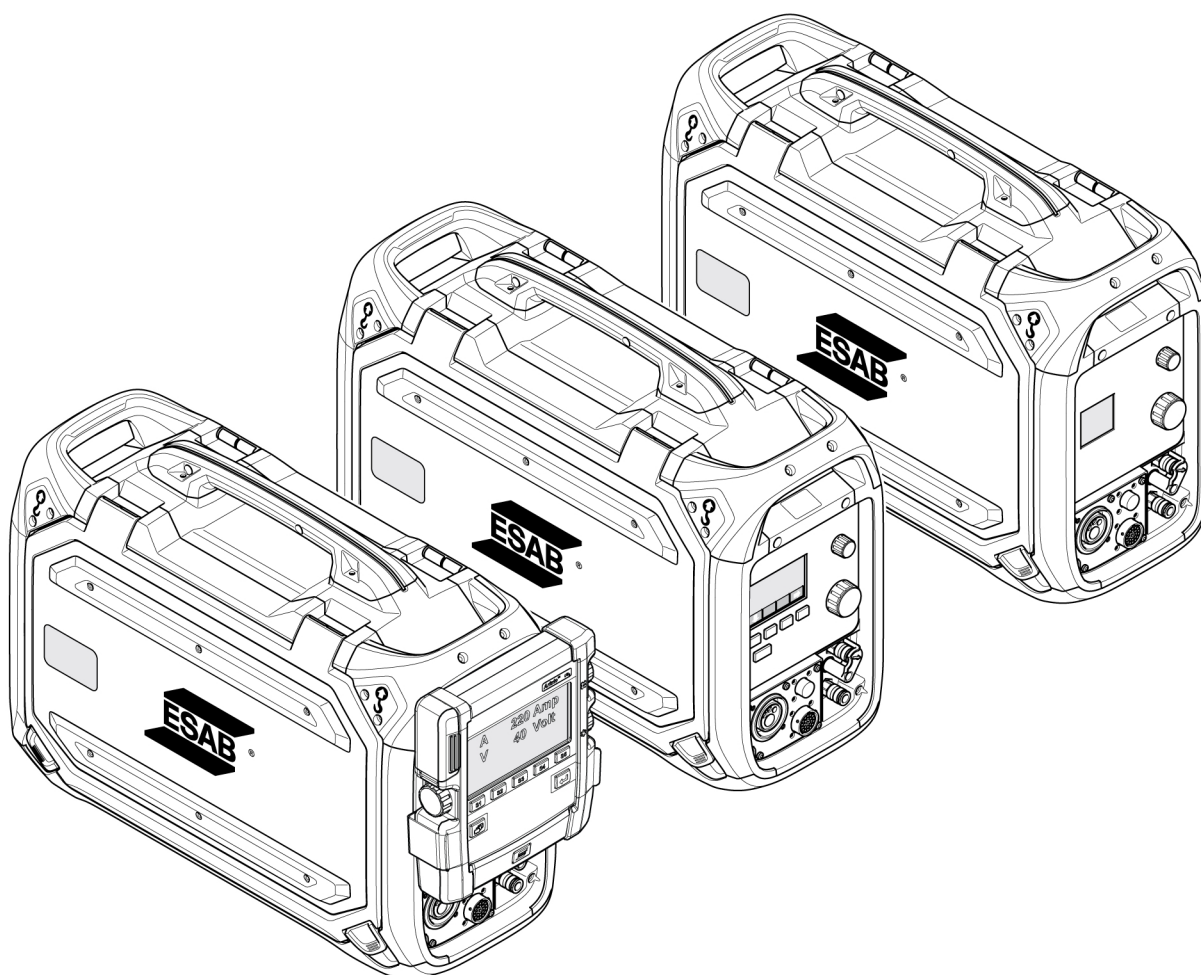


Aristo®

# ***RobustFeed U6, RobustFeed U82, RobustFeed Pulse***



## **Spare parts list**

<b>Ordering no.</b>	<b>Denomination</b>	<b>Note</b>
0445 800 887	RobustFeed U6, Offshore, Water	With EURO connector, torch cooling system, heater, gas flow meter and MMA
0445 800 888	RobustFeed U6, Offshore, Water, ELP, Push Pull	With EURO connector, torch cooling system, ELP, heater, gas flow meter and MMA
0445 800 889	RobustFeed U6, Offshore	With Tweco 4 connector, heater, gas flow meter and MMA
0445 800 890	RobustFeed U6, Offshore, Push Pull	With Tweco 4 connector, heater, gas flow meter and MMA
0445 800 895	RobustFeed U6, Offshore, Water, Push Pull, for North American market	With EURO connector, torch cooling system, heater and gas flow meter
0445 800 897	RobustFeed U6, Water	With EURO connector, torch cooling system
0445 800 891	RobustFeed Pulse, Offshore, Water	With EURO connector, torch cooling system, heater, gas flow meter and MMA
0445 800 892	RobustFeed Pulse, Offshore, Water, ELP, Push Pull	With EURO connector, torch cooling system, ELP, heater, gas flow meter and MMA
0445 800 893	RobustFeed Pulse, Offshore, Push Pull	With Tweco 4 connector, heater, gas flow meter and MMA
0445 800 894	RobustFeed Pulse, Water	With EURO connector, torch cooling system
0445 800 896	RobustFeed U82 Offshore, Water	CSA, U82 Plus included, flow meter, heater, MMA outlet, Water, ELP, 12 pole digital remote connector for U82 Plus
0445 800 898	RobustFeed U82 Offshore, Water	CE, U82 Plus included, flow meter, heater, MMA outlet, Water, ELP, 12 pole digital remote connector for U82 Plus
0445 800 899	RobustFeed U82 Water	CE, U82 Plus included, Water, ELP, 12 pole digital remote connector for U82 Plus
0445 800 900	RobustFeed U82 Push-Pull, Offshore, Water	CE, U82 Plus included, flow meter, heater, MMA outlet, Water, ELP, push-pull, Miggytrac/Railtrac, 12 pole digital remote connector for U82 Plus, 23 pole analogue remote connector
0445 800 901	RobustFeed U0 Water	CE, Water, ELP, For retrofit or dual WF, 12 pole digital remote connector
0445 800 903	RobustFeed U82 Push-Pull, Offshore, Water, VRD activated	CE, AU, with VRD activated, U82 Plus included, ELP, heater, flow meter, push-pull, Miggytrac/Railtrac, 12 pole digital remote connector for U82 Plus, 23 pole analogue remote connector
0445 800 904	RobustFeed U82 Push-Pull, Offshore, Water	CSA, U82 Plus included, flow meter, heater, MMA outlet, Water, ELP, push-pull, Miggytrac/Railtrac, 12 pole digital remote connector for U82 Plus, 12 pole digital remote connector for remote interface
0463 707 001	Service manual	Aristo® RobustFeed U6, RobustFeed U82, RobustFeed Pulse
0463 708 001	Spare parts list	Aristo® RobustFeed U6, RobustFeed U82, RobustFeed Pulse

<b>Ordering no.</b>	<b>Denomination</b>	<b>Note</b>
0446 253 *	Instruction manual	Aristo® RobustFeed U6, RobustFeed Pulse, CE
0463 739 *	Instruction manual	Aristo® RobustFeed U6, RobustFeed Pulse, CSA
0459 287 *	Instruction manual	Aristo® U6 control panel
0463 459 *	Instruction manual	MA25 Pulse control panel
0446 747 *	Instruction manual	RobustFeed U82, CE
0446 748 *	Instruction manual	RobustFeed U82, CSA

The three last digits in the document number of the manual show the version of the manual. Therefore they are replaced with \* here. Make sure to use a manual with a serial number or software version that corresponds with the product, see the front page of the manual.

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.

The three last digits in the document number of the manual show the version of the manual. Therefore they are replaced with \* here. Make sure to use a manual with a serial number or software version that corresponds with the product, see the front page of the manual.

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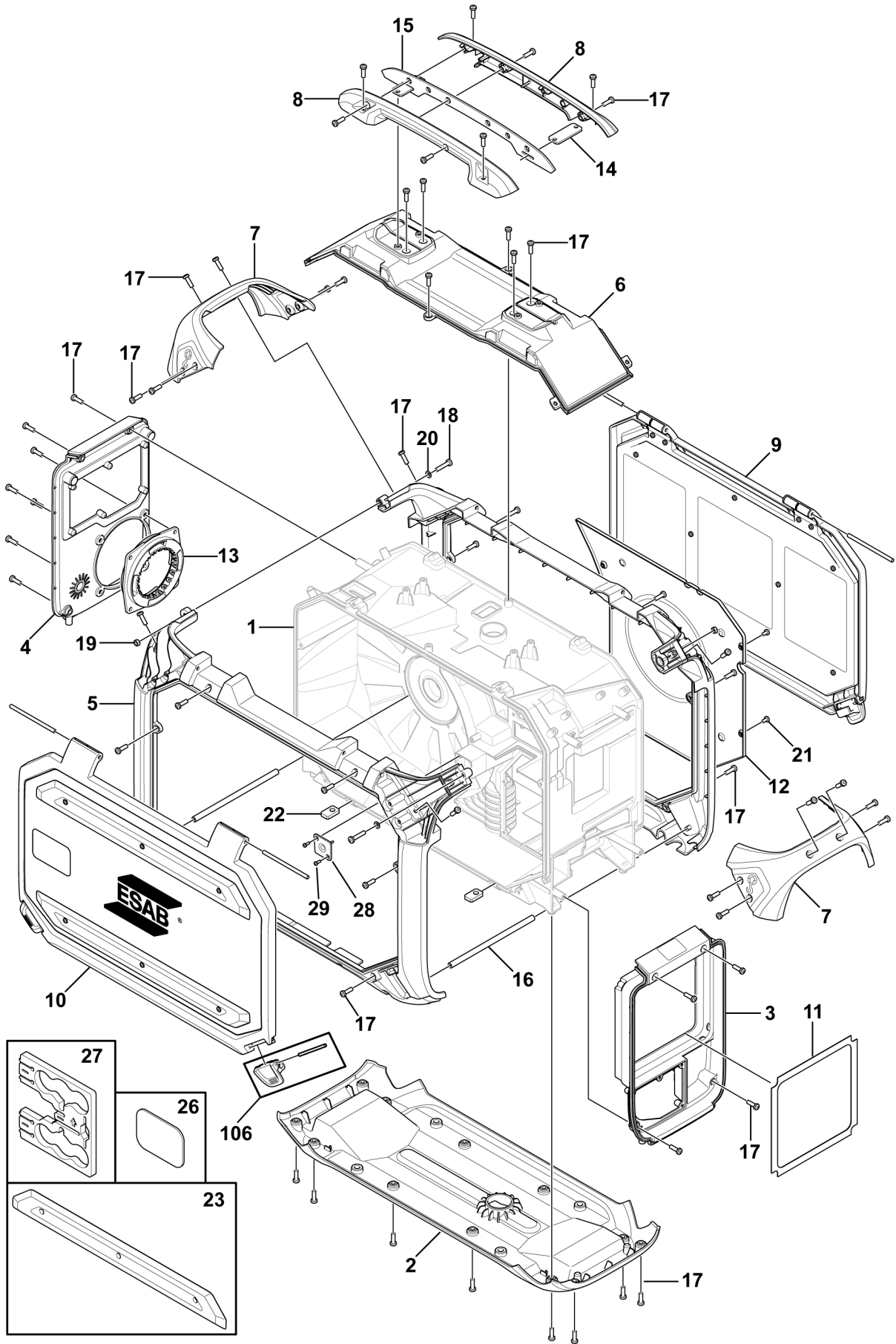
**SPARE PARTS HOUSING MODULE**


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Item	Qty	Ordering no.	Denomination	Notes
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 102, 103, 104 and 105.
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		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	
28	1	0445 777 001	Inductor cover	
29	2	0194 153 222	Screw Remform torx 3×8	

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 695 880	Decals synergic lines wear parts kit Pulse NAM	From MMC software version 1.09H.





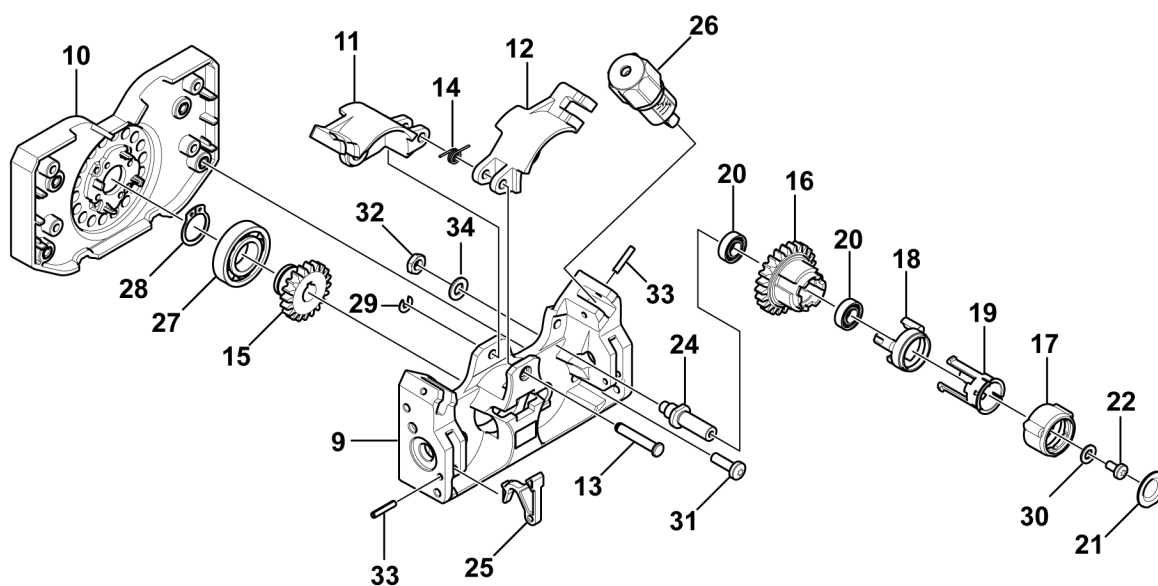
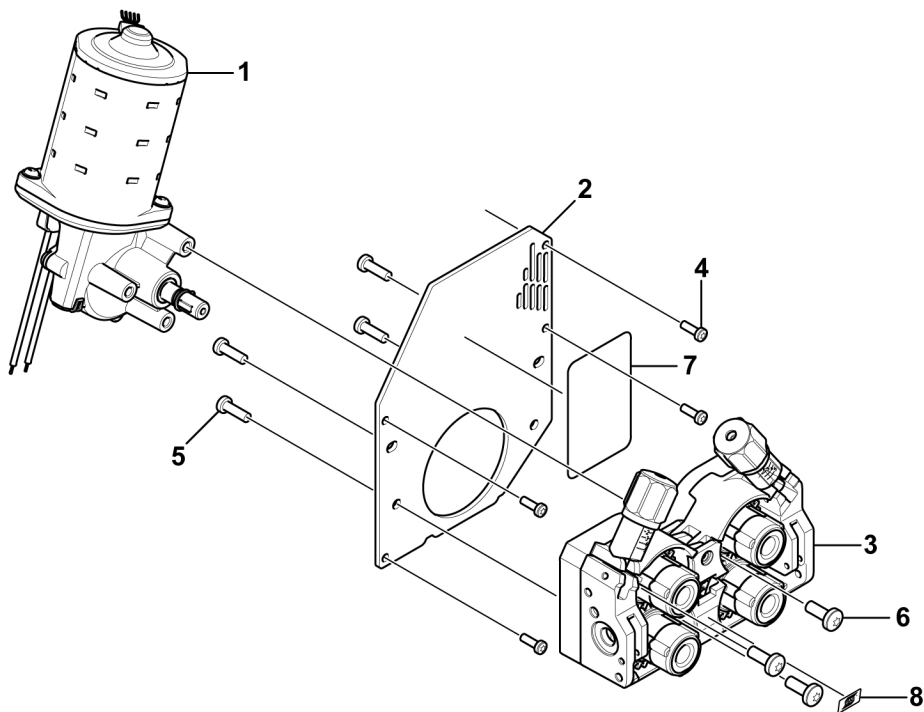
## SPARE PARTS FEEDER MECHANISM MODULE

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0465 827 880	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 27.



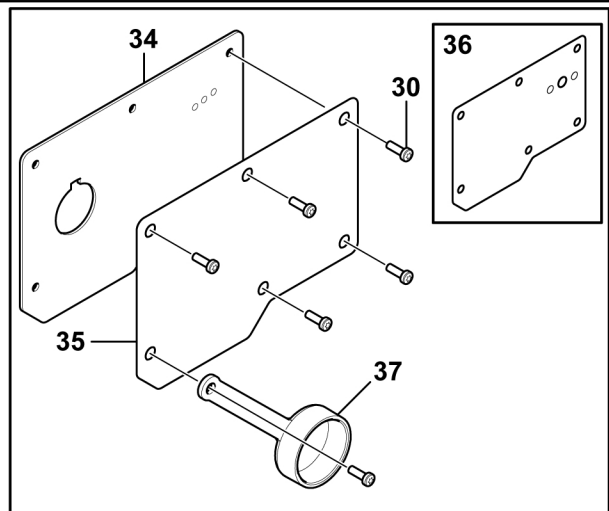
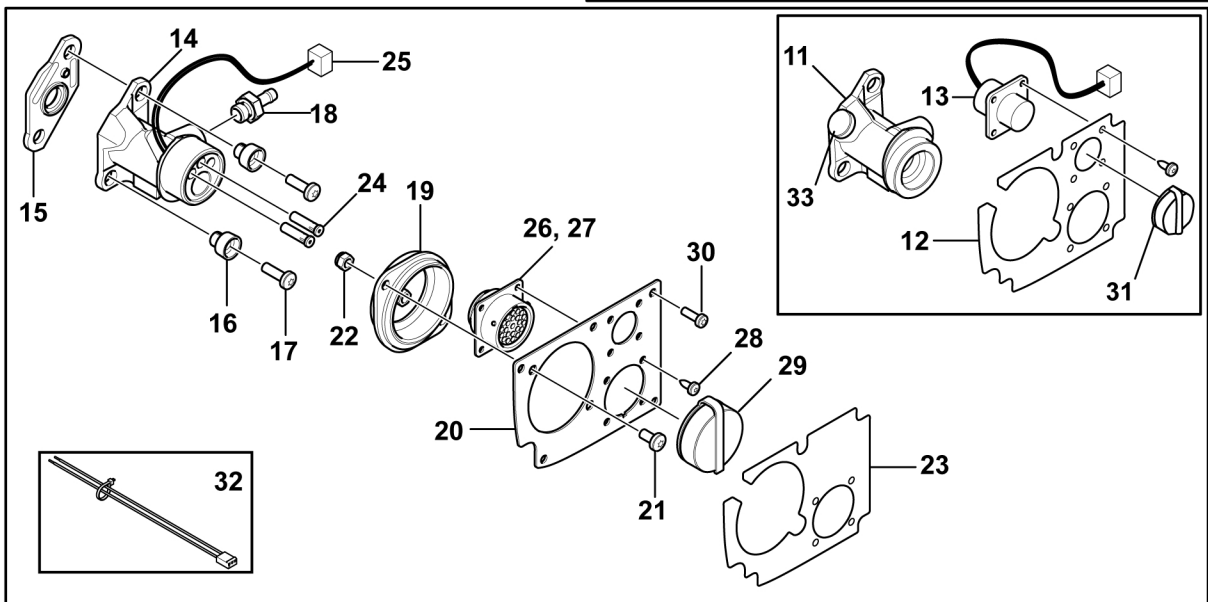
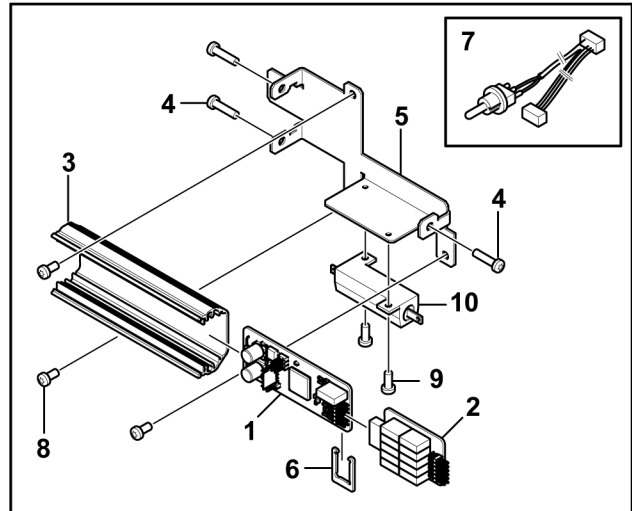
## SPARE PARTS REMOTE ADAPTOR, FRONT AND REAR INTERFACE MODULES

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

Item	Qty	Ordering no.	Denomination	Notes	C
<b>Remote adaptor:</b>					
1	1	0460 146 880	CAN adapter board	Only units with ordering no. 0445 800 888, 0445 800 892, 0445 800 900. Item 10 is included in drive unit harness (see " <i>SPARE PARTS FEEDER MECHANISM MODULE</i> ", page 8)	13AP9
2	1	0487 230 880	Filter board		13AP8
3	1	0459 516 004	U profile 110		
4	3		Screw MRT M4×16		
5	1	0446 252 001	Push Pull adaptor plate		
6	1	0459 593 002	Clamp narrow		
7	1	0459 625 887	Push Pull CAN cable assembly w/ remote switch		
		0459 625 888	Push Pull CAN cable assembly w/o remote switch		
8	3		Screw MRT M4×8 black		
9	2		Cross recessed tapping screw ST2, 9×9.5		
10	1	0194 632 001	Push-Pull resistor		
<b>Front interface module:</b>					
11	1		Tweco 4 connector	See item 302.	
12	1	0445 882 004	Front Overlay	Tweco with remote adaptor	
13	1	0446 020 882	Trigger cable harness	Tweco 4	
14	1		Euro connector	See item 301.	
15	1		Torch connector insulator	See item 301 and 302.	
16	2		Screw insulator	See item 301 and 302.	
17	2		Screw MRT M5×16	See item 301 and 302.	
18	1	0445 856 001	Brass fitting	Including O-ring	
19	1		Torch connector seat	See item 301 and 302.	
20	1	0446 003 001	Interface plate front	For <b>23 Pol connector</b> variants	
		0446 003 003	Interface plate front	For <b>12 Pol connector</b> variants	
		0446 003 884	Interface plate front assembly	For 23 and 12 Pol connector variants. Only units with ordering no. 0445 800 900 and 0445 800 903.	
		0446 003 885	Interface plate front assembly	For 12 Pol connector variants. Only units with ordering no. 0445 800 904.	
21	2		Screw MRT M5×10		

SPARE PARTS REMOTE ADAPTOR, FRONT AND REAR INTERFACE MODULES

Item	Qty	Ordering no.	Denomination	Notes	C
22	2		Nut Loc - King 5 BH6		
23	1	0445 882 002	Front overlay	Euro with remote adaptor	
		0445 882 005	Front overlay Euro + Remote	Front overlay (Euro and Tweco)+ Remote U82. Only units with ordering no. 0445 800 900.	
24	2	0368 750 001	Insulating sleeve	Euro, See item 301.	
25	1	0458 710 893	Trigger cable harness	Euro, See item 301.	
	1	0458 710 894	Trigger cable harness	Only for variants equipped with ESAB LogicPump (ELP)	
26	1	0446 020 883	Push pull remote trigger harness	Tweco Push Pull	
		0446 020 887	Analogue remote harness, 23 pole Burndy	Only units with ordering nos. 0445 800 900 and 0445 800 903	
		0446 020 886	CAN-Bus harness, 12 pole Burndy	Only units with ordering nos. 0445 800 898, 0445 800 899, 0445 800 901 and 0445 800 904	
27	1	0459 683 881	Push Pull Remote cable assembly	Only units with ordering no. 0445 800 888, 0445 800 892, 0445 800 900	
28	4		Cross recessed tapping screw RTS ST3, 5×9.5		
29	1	0366 285 001	Protection cap	For 12 Pol connector variants variants	
		0455 516 001	Protection cap	For 23 Pol connector variants	
30	11	0194 153 292	Screw Remform Torx 4×12		
31	1	0366 285 001	Protection cap 12-pol. DTE 255		
32	1	0446 020 889	Control panel harness	Only units with ordering no. 0445 800 900	
33	1	0446 026 001	Thump screw		
<b>Rear interface module:</b>					
34	1	0446 004 001	Interface plate rear		
35	1	0445 881 002	Rear plate overlay heatkit	See item 901	
36	1	0445 881 001	Rear plate overlay	For units containing <b>no</b> heat kit and <b>no</b> MMA	
37	1	0446 232 001	OKC protection cap		
<b>Item</b>	<b>Ordering no.</b>	<b>Denomination</b>	<b>Notes</b>		
301	0464 680 880	Euro torch connector kit	Including items 14, 15, 16, 17, 19, 24, 25		
302	0464 667 899	Tweco 4 torch connector kit	Including items 11, 15, 16, 17, 19		



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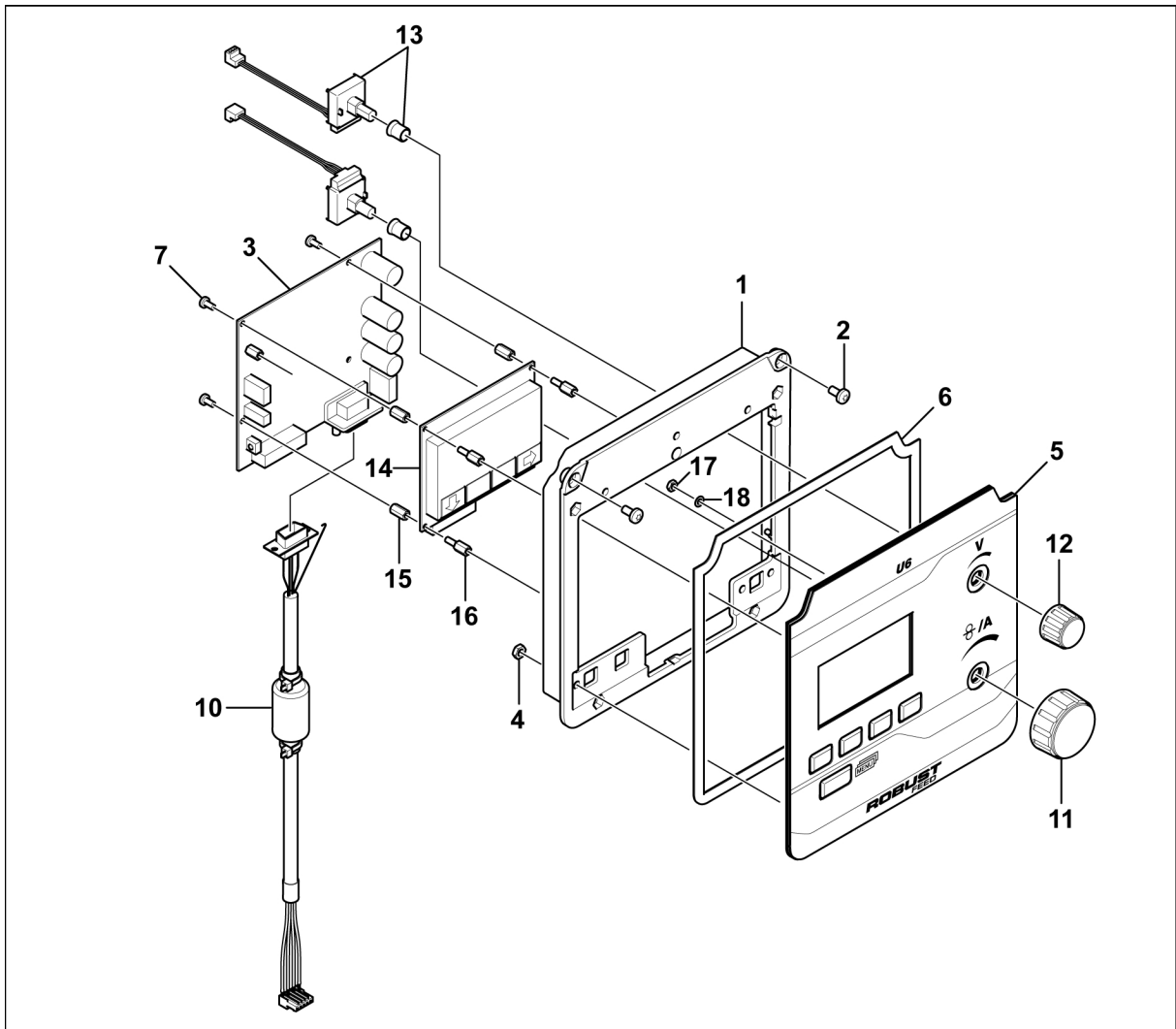
**SPARE PARTS CONTROL PANELS U6**


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

Item	Qty	Ordering no.	Denomination	Notes	C
1	1		External user interface frame U6/MA25	See item 401.	
2	2		Screw MRT M4×8		
3	1		Panel control board		13AP4
4	5		Nut M4	See item 401.	
5	1		RobustFeed U6 panel	See item 401.	
6	1		Adhesive U6/MA25	See item 401.	
7	4		Screw		
8	4	0194 153 292	Screw Remform Torx 4×12		
10	1	0458 681 926	CAN cable		
11	1	0446 203 001	Knob D36-1/4IN		
12	1	0446 204 001	Knob D21-1/4IN		
13	2	0193 912 001	Encoder		
14	1		Display 128×64 Aristo feed		
15	4		Screwed spacer sleeve		
16	4		Distance screw		
17	1		Nut ML6M 3 M3		
18	1		Washer BRB D6/3.2×0.5		

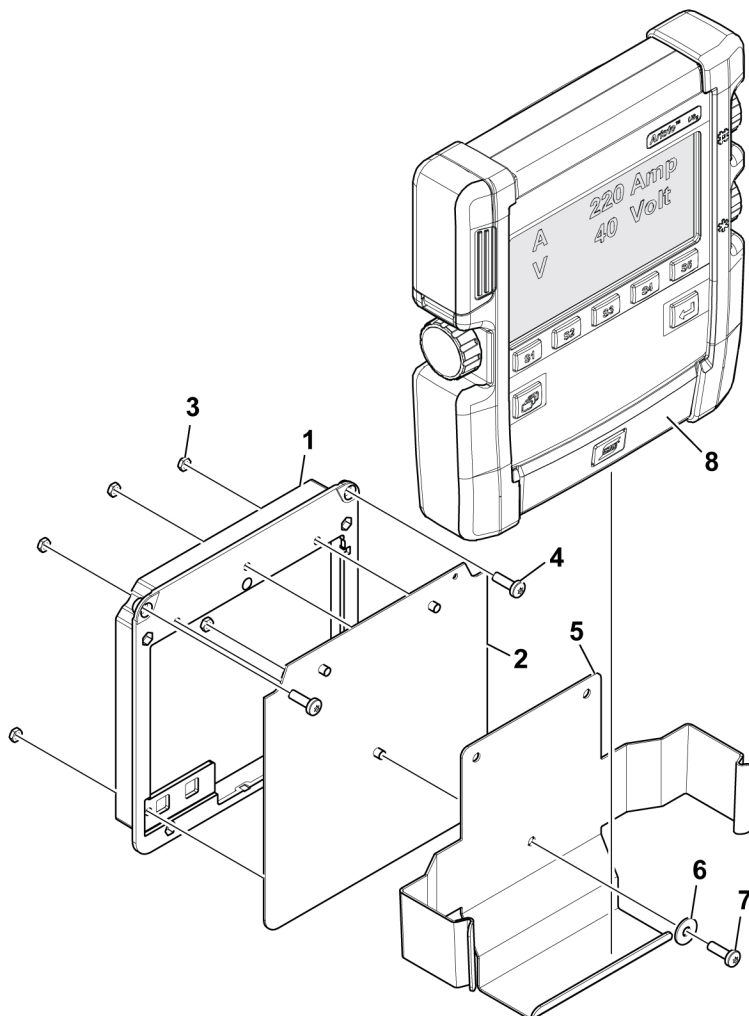
Item	Ordering no.	Denomination	Notes
401	0464 680 881	Frame external user interface kit	Including items 1, 4, 5 and 6
402	0464 682 880	Complete RobustFeed U6 user interface panel kit configured for North America	Including items 1–18, with synergic group 6 activated
403	0464 683 880	Complete RobustFeed U6 user interface panel kit configured for Europe and others	Including items 1–18, with synergic group 0 activated



SPARE PARTS CONTROL PANELS U82

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

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0445 793 002	External user interface frame U6/MA25		
2	1	0446 919 880	RF U0 blank plate		
3	5		Nut 6K steel 8.8 M4		
4	2		Screw MRT M4×8 black		
5	1	0460 964 001	Bracket Aristo U82		
6	3		Screwed spacer sleeve M5×12		
7	3		Screw MRT M5×8 black		
8	1	0460 820 881	Control panel Aristo® U82 Plus*	For Spares of Control panel Aristo® U82 Plus* refer 0459 839 037. Including Item 5.	

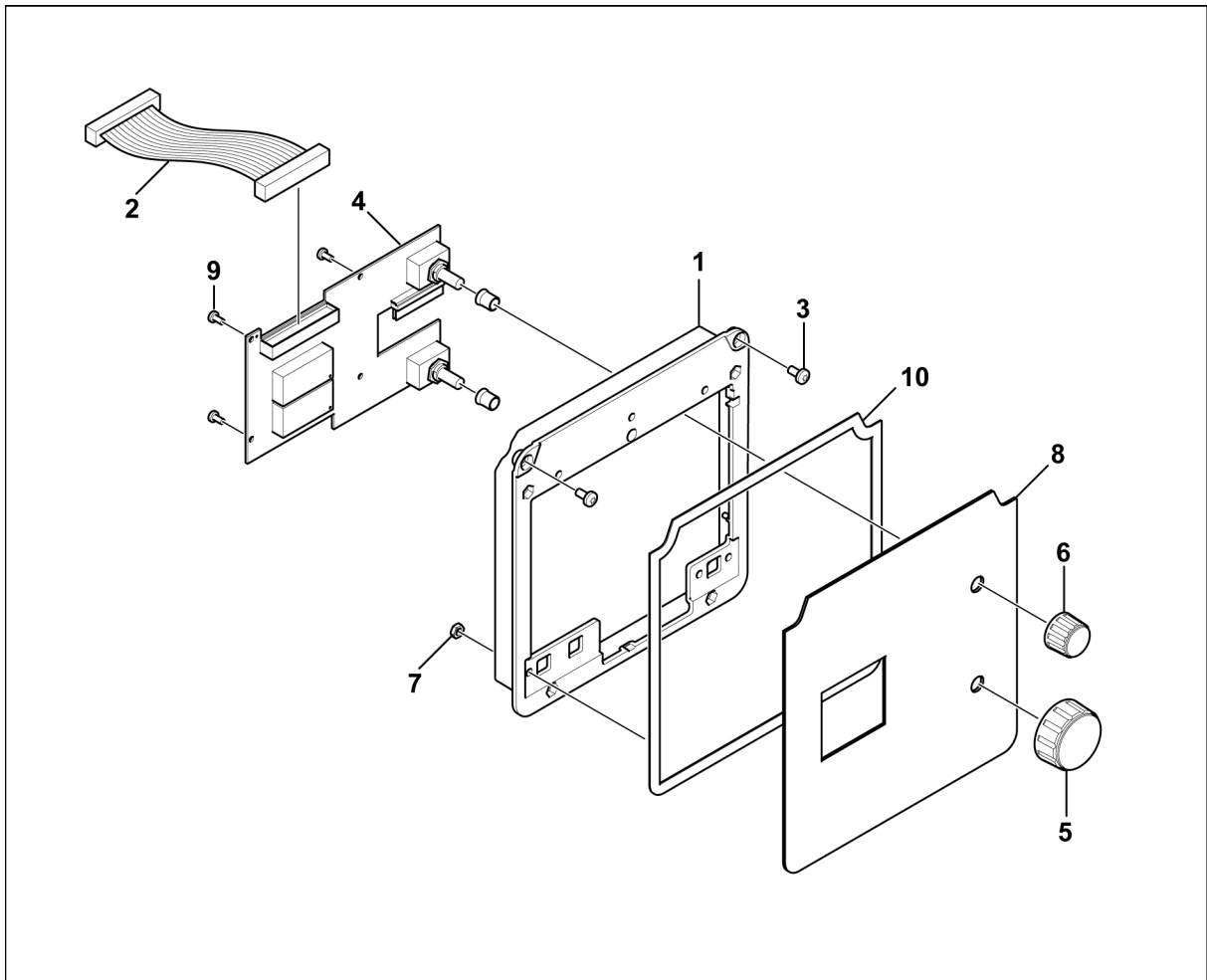


## SPARE PARTS CONTROL PANELS MA25 PULSE

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1		External user interface frame U6/MA25	See items 601, 602 and 603.	
2	1	0193 700 722	Ribbon cable with connectors (34-pol)	See items 602 and 603.	
3	2		Screw MRT M4×8	See items 602 and 603.	
4	1	0487 273 880	Printed circuit board seven segment display	See items 602 and 603.	13AP4
5	2	0446 203 001	Knob D36-1/4IN	See items 602 and 603.	
6	1	0446 204 001	Knob D21-1/4IN	See items 602 and 603.	
7	5		Nut M4	See items 601, 602 and 603.	
8	1		RobustFeed MA25 panel (including decal for external user interface)	See items 601, 602 and 603.	
9	3		Cross recessed pan head screw	See items 602 and 603.	
10	1		Adhesive U6/MA25	See items 601, 602 and 603.	

Item	Ordering no.	Denomination	Notes
601	0464 680 882	Frame external user interface kit	Including items 1, 7, 8 and 10
602	0464 684 880	Complete MMC with weld data unit kit configured for North America	Configured with Machine ID 55, including items 1–10 and Weld data board/MMC (see item 25 at " <a href="#">SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES</a> ", page 20)
603	0464 685 880	Complete MMC with weld data unit kit configured for Europe and others	Configured with Machine ID 54, including items 1–10 and Weld data board/MMC (see item 25 at " <a href="#">SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES</a> ", page 20)
604	0464 687 880	Weld data board 13AP3 kit configured for North America	Configured with Machine ID 55, including Weld data board/MMC (see item 25 at " <a href="#">SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES</a> ", page 20)
605	0464 688 880	Weld data board 13AP3 kit configured for Europe and others	Configured with Machine ID 54, including Weld data board/MMC (see item 25 at " <a href="#">SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES</a> ", page 20)



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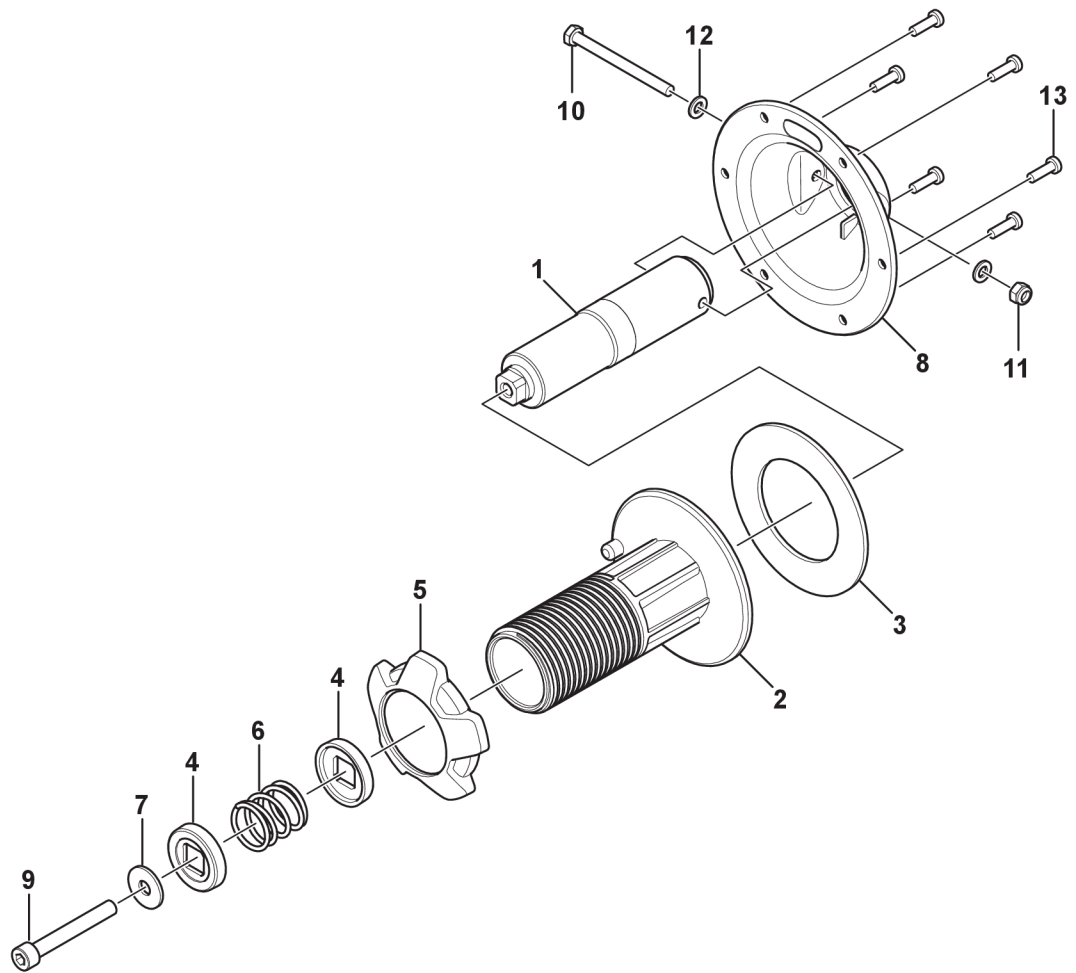
**SPARE PARTS BOBBIN HOLDER**


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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 701.	
2	1	0445 794 001	Brake hub sleeve		
3	1	0445 613 001	Brake hub friction pad	See item 701. Tape included.	
4	2		Brake hub spring seat	See item 702.	
5	1	0445 779 001	Brake hub nut		
6	1		Brake hub spring	See item 702.	
7	1		Washer RB 24×8.4×2	See item 702.	
8	1	0446 006 001	RF300 bobbin console		
9	1		Screw MC6S M8×60	See item 702.	
10	1		Screw M6S M6×70	See item 701.	
11	1		Nut LOC-KING 6 BH6	See item 701.	
12	2		Washer BRB D12/6.4×1.5		
13	6	0194 153 330	Screw Remform Torx 5×16		

Item	Ordering no.	Denomination	Notes
701	0464 667 881	Brake hub axle kit	Including items 1, 3, 10 and 11
702	0464 667 882	Brake hub spring seat kit	Including items 4, 6, 7 and 9



## SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES

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

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0445 776 002	Multi consol		
2	1	0487 187 893	Control board		13AP1
3	1	0440 355 880	Interface board		13AP2
4	1		TMR sensor complete	See item 804.	
5	1		Torch copper bar	See item 801.	
6	1	0446 002 003	Interface plate internal		
7	1	0446 037 880	Fan complete		
8	2		LED illumination circuit board	See item 803.	13AP5, 13AP6
9	2		Adhesive gasket	See item 803.	
10	1		Lighting window front	See item 803.	
11	1	0160 609 881	OKC machine connector, DINSE		
12	4	0194 153 330	Screw Remform Torx 5×16		
13	6		Cup spring	See item 801 and 802.	
14	3		Washer 8-200 10,5 A2K	See item 801 and 802.	
15	2		Screw M6S 10×20	See item 801 and 802.	
16	1		Screw M6S 10×25	See item 802.	
17	1		OKC copper bar	See item 802.	
18	1		Reed switch protection	See item 804.	
19	1	0160 362 881	OKC machine contact 50 mm <sup>2</sup>		
20	1	0446 143 880	Signal cable harness U6	For RobustFeed U6	
		0446 143 881	Signal cable harness MA25	For RobustFeed Pulse	
21	1	0446 139 881	Interconnection cable harness		
39	4		Screw RTS 200 ST3 5×9		
23	1	0446 236 001	Circuit board mounting bracket	For RobustFeed Pulse	
24	1	0446 281 001	Insulation sheet	For RobustFeed Pulse	
25	1		Weld data board/MMC	For RobustFeed Pulse. Included in kit 602, 603, 604 and 605, see <i>"SPARE PARTS CONTROL PANELS MA25 PULSE"</i> , page 16	13AP3
26	1	0446 141 881	Remote connector harness	Only for non push pull variants	

SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES

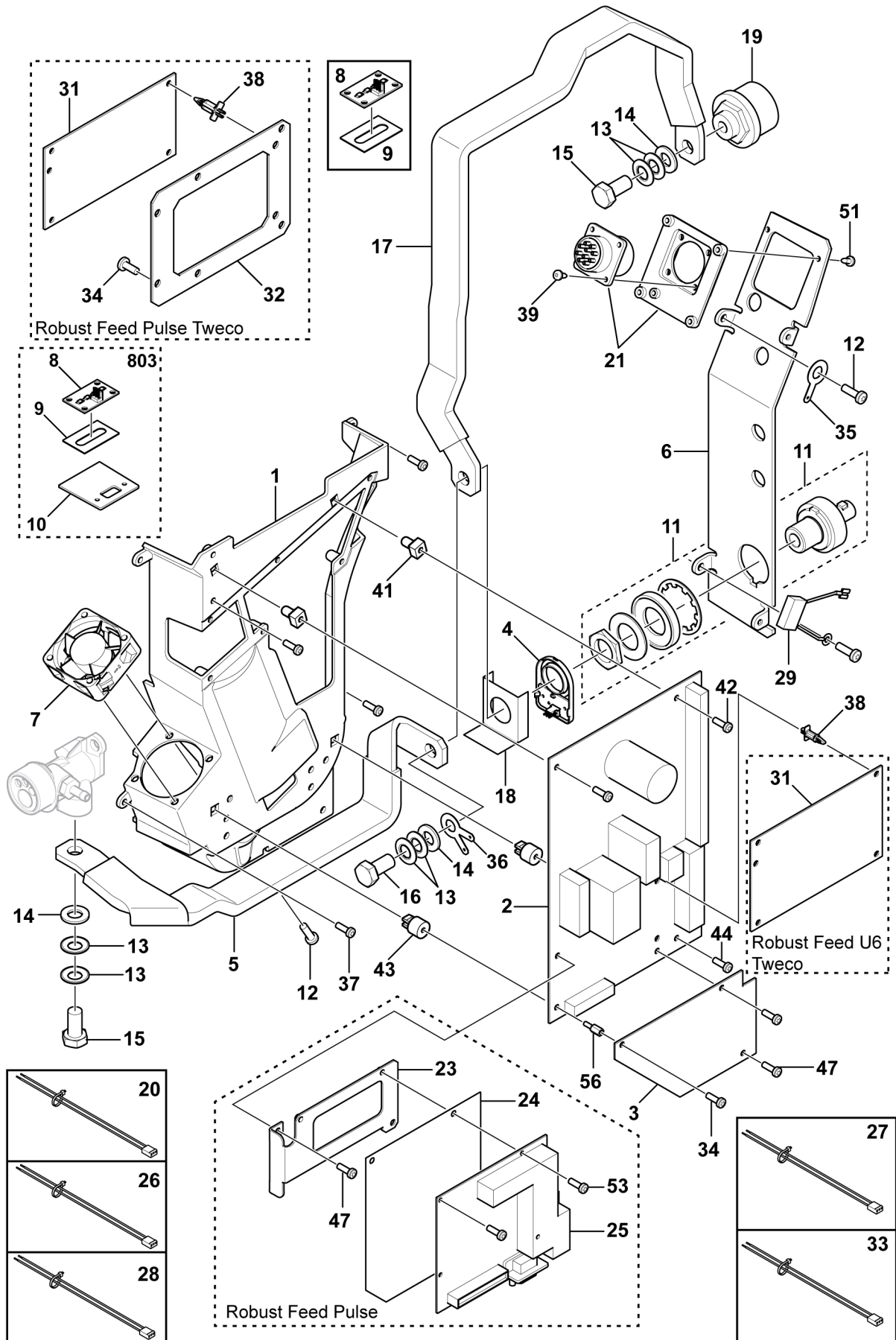
Item	Qty	Ordering no.	Denomination	Notes	C
27	1	0446 144 880	Board supply harness	Tweco push-pull, U6	
		0446 144 882		Tweco push-pull, Pulse	
33	1	0446 144 881	Board supply harness		
28	1	0446 251 880	Proximity sensor harness		
29	1	0467 911 886	Capacitor		
31	1	0558 038 431	Push Pull board	Only for Tweco push pull variants	13AP10
38	8		Spacer 12.7		
32	1	0446 296 001	PP board mounting bracket	Only for Tweco push pull variants	
34	5		Screw MRT M4×8 black		
35	1	0191 548 005	Flat pin connector		
36	1	0349 312 952	Flat pin connector	M10 6.3×0.8	
37	4		Screw Remform Torx 4×12 black		
40	1	0458 681 927	CAN cable	Only for RobustFeed Pulse	
41	2	0194 019 005	Spacer 6.4		
42	2	0193 517 342	Screw RX-PT 8-16×12		
43	2	0194 297 001	Spacer 9.5		
44	1	0193 517 283	Screw RX-PT 6-19×16		
45	1	0459 734 002	Spacer (SELF-TP) Aristo MIG	M4×12, Only for RobustFeed Pulse	
46	1		Spacer 12.7		
47	3		Screw MRT FZB	M4×8	
48	1/2		Distance screw	M4×15, Qty dependent on U6 or Pulse	
49	1		Distance screw	M4×20	
50	1/3		Nut 6K Steel 8.8 M4	Qty dependent on U6 or Pulse	
51	4		Cross recessed head tapping screw		
52	2		Distance screw	M4×5, Only for RobustFeed Pulse	
53	2		Screw MRT FZB	M4×6, Only for RobustFeed Pulse	
55	2		Plain washer 4-200 HV-A2K	Only for RobustFeed Pulse	
56	1	0459 734 001	Spacer (SELF-TP) Aristo MIG	M4×15, Only for RobustFeed U6	

Item	Ordering no.	Denomination	Notes
801	0464 667 888	Torch copper bar kit	Including items 5, 13, 14 and 15
802	0464 680 883	OKC copper bar kit	Including items 13, 14, 15, 16 and 17

SPARE PARTS SYSTEM CONTROL AND PUSH PULL MODULES

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<b>Item</b>	<b>Ordering no.</b>	<b>Denomination</b>	<b>Notes</b>
803	0464 680 886	LED illumination circuit board kit	Including items 8 (2 pcs), 9 (2 pcs) and 10
804	0464 667 894	TMR sensor complete kit	Including items 4 and 18



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


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Item	Qty	Ordering no.	Denomination	Notes
<b>Water Module B</b>				
1	1	0445 778 001	Water outlet overlay	
43	1	0445 778 002	Water outlet overlay	with water
44	1	0445 778 003	Water outlet overlay	with water ELP
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	
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	4	0368 978 005	Hose clamp 10.0/9.5	with water ELP
10	1	0458 364 001	Micro switch mech control 2/4	with water ELP
11	1	0458 365 001	Spring	with water ELP
12	1	0458 366 001	Water lock cam	with water ELP
13	1	0458 367 001	Water lock bushing	with water ELP
14	1	0458 368 001	Water lock outlet	with water ELP
15	1		Screw IN6 8.8 M5×35	with water ELP
16	1		Washer D16/5×1 Origmag	M5, with water ELP
17	1		Nut locking 5 BH6	M5, with water ELP
18	2		Screw MRT M3×16 black	with water ELP
19	2		Washer BRB D6/3.2×0.5	3.2 mm, with water ELP
20	2		Nut 6K steel 8.8	M3, with water ELP
<b>Gas Module</b>				
21	1	0446 007 001	Gas adaptor plate	
22	1	0193 054 002	Solenoid valve	
23	4/6		Hose clamp	Qty dependent on inclusion of rotameter. See item 903.
24	–		Gas hose	In units with rotameter, 0.635 m of hose is needed. In units without rotameter, 0.46 m of hose is needed. See item 903.
25	1	0445 013 881	Gas flow meter	
26	1	0446 132 001	Internal overlay setting panel plate	For 0445 800 887, 0445 800 889 and 0445 800 890
27	1	0446 132 002	Internal overlay setting panel plate	For 0445 800 888 and 0445 800 895

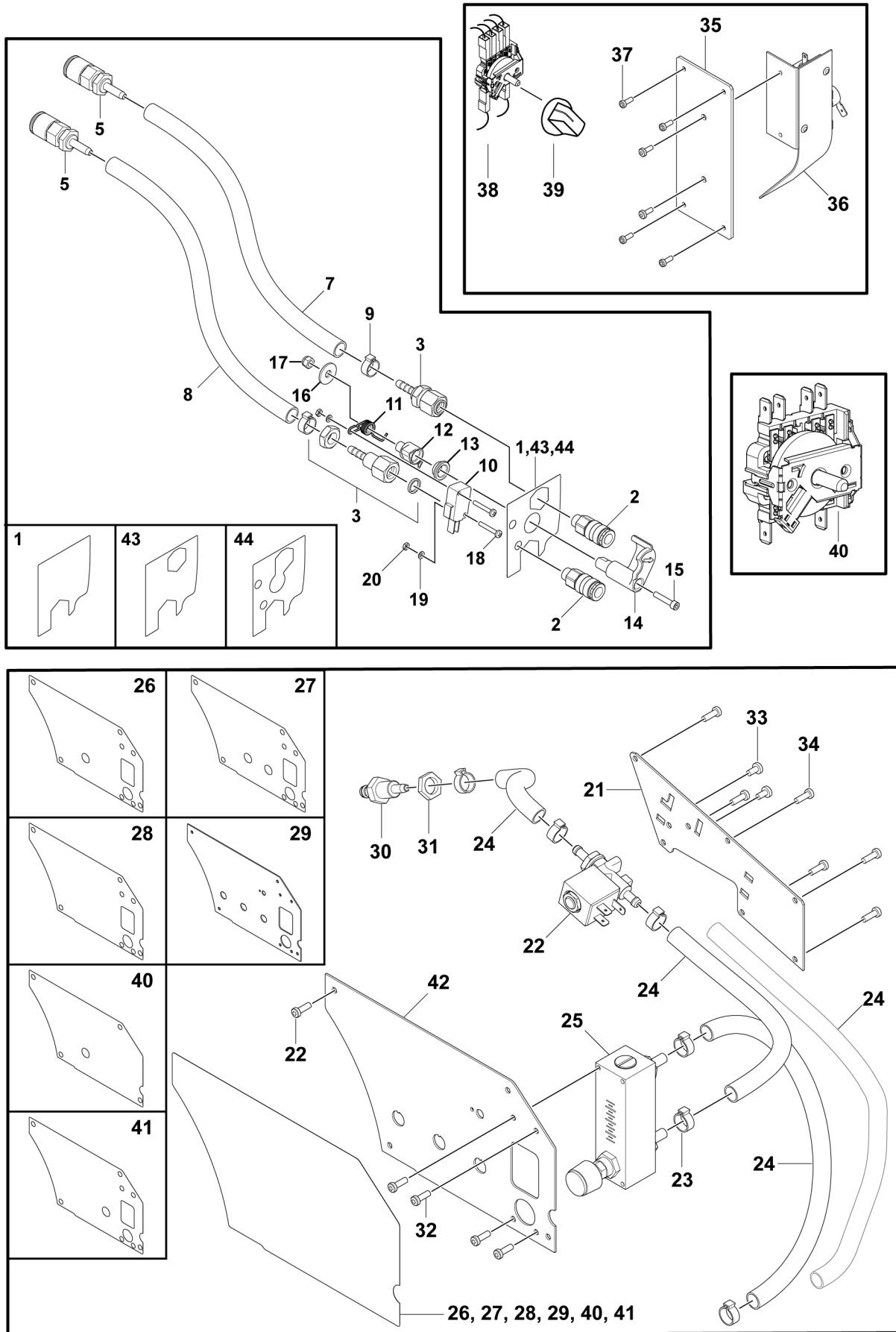
SPARE PARTS WATER, GAS AND HEAT KIT MODULES

Item	Qty	Ordering no.	Denomination	Notes
28	1	0446 132 003	Internal overlay setting panel plate	For 0445 800 891, 0445 800 893, 0445 800 896, 0445 800 898, 0445 800 900, 0445 800 904
29	1	0446 132 004	Internal overlay setting panel plate	For 0445 800 894 (without rotameter, Pulse), 0445 800 796, 0445 800 798, 0445 800 800, 0445 800 804
40	1	0446 132 005	Internal overlay setting panel plate	For 0445 800 897 (without rotameter, U6)
41	1	0446 132 006	Internal overlay setting panel plate	For 0445 800 892
42	1	0445 747 001	Internal setting panel plate	
30	1		Nipple	See item 902.
31	1		Coupler nut LPH35	See item 902.
32	4		Screw MRT M4x12	Only in unit with rotameter
33	2		Screw MRT M4x8	
34	10	0194 153 292	Screw Remform Torx 4x12	

**Heater Module**


35	1		Heater plate	See item 901.
36	1		Heater	See item 901.
37	4		Screw Remform Torx 3x8	See item 901.
38	1		Heat kit cable harness	See item 901.
39	1	0446 091 001	Knob	See item 901.
40	1	A000 100 331	Switch	See item 901 and 904.




Item	Ordering no.	Denomination	Notes
901	0464 680 885	Heater and rear interface module	Including items 35 - 39 and also rear interface module (see <i>"SPARE PARTS REMOTE ADAPTOR, FRONT AND REAR INTERFACE MODULES"</i> , page 10), For unit including heat kit
902	0464 693 880	Nipple kit gas module	Including item 30 and 31
903	0464 663 080	Gas hose with clamp kit	Including items 23 (6 pieces) and 24 (0.635 m)
904	A000 100 628	Switch Retrofit kit	Including items - A000 100 331, 0446 004 001 and 0445 881 002.  Kit 904 is only suited to replcae the switch for feeders manufactures before OP422.




## 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	○ Feed roller
V-groove 	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	○ Feed roller
V-K-knurled 	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 
Wire diameter 0.040–1/16 in. 0.9–1.6 mm	0445 822 001 (2 mm)	0446 080 882	0445 830 883 (Tweco) 0445 830 881 (Euro)
Wire diameter 0.070–3/32 in. 1.8–2.4 mm	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	○ Feed roller
U-groove 		X	X					0445 850 050
			X	X				0445 850 051
				X		X		0445 850 052

WEAR PARTS

<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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ESAB AB, Lindholmsallén 9, Box 8004, 402 77 Gothenburg, Sweden, Phone +46 (0) 31 50 90 00

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