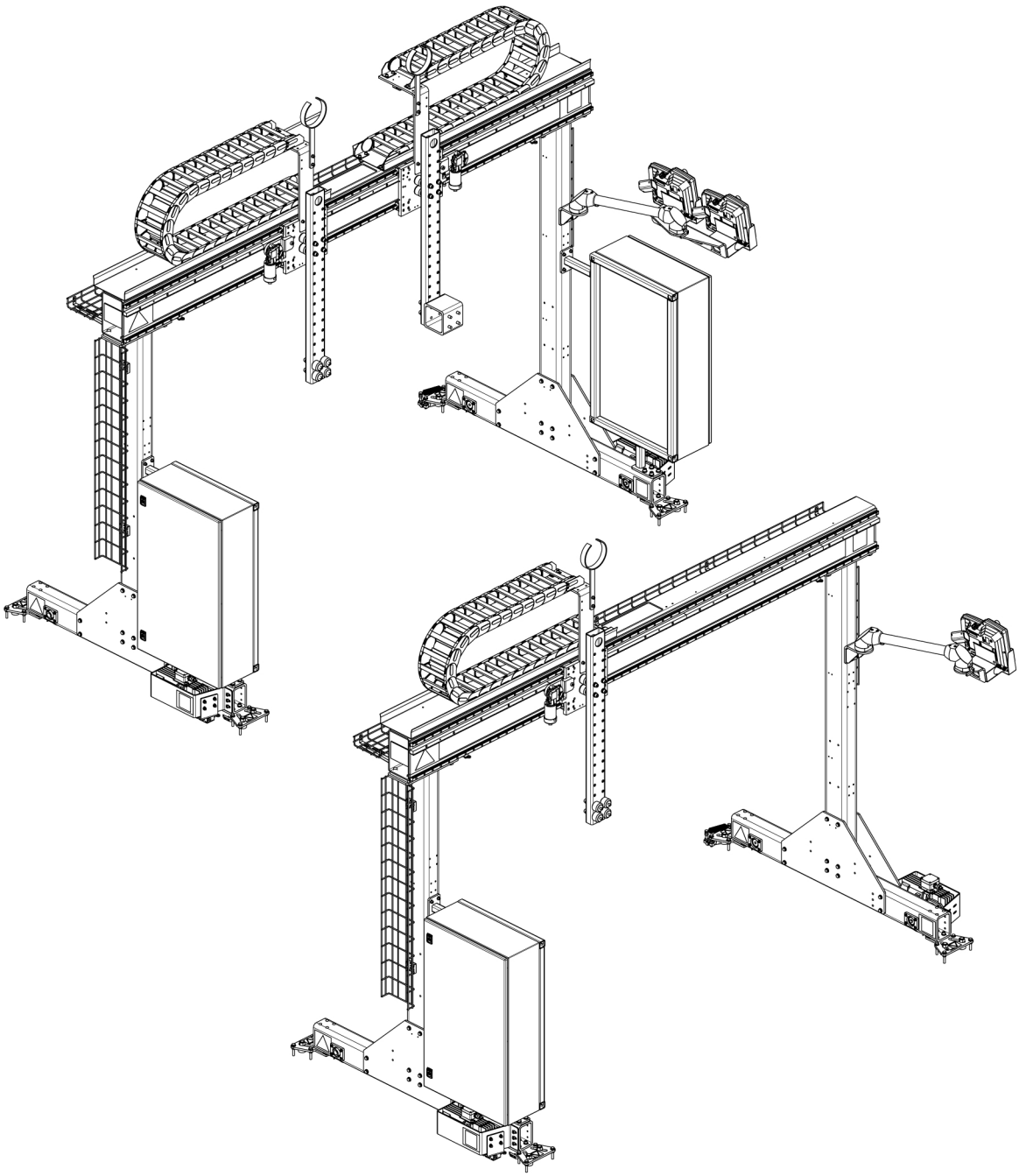
Mechtrac HD

Motor driven gantry



Instruction manual

Original instructions

0463 931 001 GB 20241114

Valid for: serial no. LX426-xxxx-xxxx

EU DECLARATION OF INCORPORATION OF PARTLY COMPLETED MACHINERY

According to:

The Machine Directive 2006/42/EC, Annex II 1B;
The Low Voltage Directive 2014/35/EU
The EMC Directive 2014/30/EU;
The RoHS Directive 2011/65/EU;

Type of equipment

Wheeled gantry, meant for welding application.

Type designation etc.

Mechtrac HD3	from serial no LX426 xxxx xxxx
Mechtrac HD4	from serial no LX426 xxxx xxxx

X and Y represents digits, 0 to 9 in the serial number, where YY indicates year of production.

Brand name or trade mark

ESAB

Manufacturer or his authorised representative established within the EEA

Name, address, telephone no:

ESAB AB
Lindholmsallén 9, Box 8004, SE-402 77 Göteborg, Sweden
Phone: +46 31 50 90 00

The following harmonised standard in force within the EEA has been used in the design:

EN ISO 12100:2010	Safety of machinery - General principles for design - Risk assessment and risk reduction
EN ISO 13857:2019	Safety of machinery — Safety distances to prevent hazard zones being reached by upper and lower limbs
EN ISO 13854:2019	Safety of machinery — Minimum gaps to avoid crushing of parts of the human body
EN ISO 13850:2015	Safety of machinery — Emergency stop function — Principles for design
EN 60204-1:2018	Safety of machinery - Electrical equipment of machines - Part 1: General requirements

Additional Information:

This is partly completed machinery must not be put into service until the final machinery into which it is to be incorporated complies with the provisions of Directive 2006/42/EC.
Both Mechtrac HD3 and Mechtrac HD4 has different variants with single boom carriage (only left) or dual boom carriage and welding heads.

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.

Place/Date

Gothenburg
2025-09-26

Signature

Cristiano Ferreira
R&D Director Automation

CE

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1 SAFETY

1.1 Meaning of symbols

As used throughout this manual: Means Attention! Be Alert!

DANGER!
Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

WARNING!
Means potential hazards which could result in personal injury or loss of life.

CAUTION!
Means hazards which could result in minor personal injury.

WARNING!
Before use, read and understand the instruction manual and follow all labels, employer´s safety practices and Safety Data Sheets (SDSs).

1.2 Safety precautions

Users of ESAB equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the equipment must be familiar with:
   - its operation
   - location of emergency stops
   - its function
   - relevant safety precautions
   - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
   - no unauthorised person is stationed within the working area of the equipment when it is started up
   - no-one is unprotected when the arc is struck or work is started with the equipment
3. The workplace must:
   - be suitable for the purpose
   - be free from drafts
4. Personal safety equipment:
   - always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves
   - do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns
5. General precautions:
   - make sure the return cable is connected securely
   - work on high voltage equipment **may only be carried out by a qualified electrician**
   - appropriate fire extinguishing equipment must be clearly marked and close at hand
   - lubrication and maintenance must **not** be carried out on the equipment during operation

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If equipped with ESAB cooler
Use ESAB approved coolant only. Non-approved coolant might damage the equipment and jeopardize product safety. In case of such damage, all warranty undertakings from ESAB cease to apply.

Recommended ESAB coolant ordering number: 0465 720 002.

For ordering information, see the "ACCESSORIES" chapter in the instruction manual.

WARNING!
Arc welding and cutting can be injurious to yourself and others. Take precautions when welding and cutting.

ELECTRIC SHOCK - Can kill

- Install and ground the unit in accordance with instruction manual.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing
- Insulate yourself from work and ground.
- Ensure your working position is safe

ELECTRIC AND MAGNETIC FIELDS - Can be dangerous to health

- Welders having pacemakers should consult their physician before welding. EMF may interfere with some pacemakers.
- Exposure to EMF may have other health effects which are unknown.
- Welders should use the following procedures to minimize exposure to EMF:
    - Route the electrode and work cables together on the same side of your body. Secure them with tape when possible. Do not place your body between the torch and work cables. Never coil the torch or work cable around your body. Keep welding power source and cables as far away from your body as possible.
    - Connect the work cable to the workpiece as close as possible to the area being welded.

FUMES AND GASES - Can be dangerous to health

- Keep your head out of the fumes
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area

ARC RAYS - Can injure eyes and burn skin

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing
- Protect bystanders with suitable screens or curtains

NOISE - Excessive noise can damage hearing

Protect your ears. Use earmuffs or other hearing protection.

MOVING PARTS - Can cause injuries

- Keep all doors, panels and covers closed and securely in place. Have only qualified people remove covers for maintenance and troubleshooting as necessary. Reinstall panels or covers and close doors when service is finished and before starting engine.

- Stop engine before installing or connecting unit.
- Keep hands, hair, loose clothing and tools away from moving parts.

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FIRE HAZARD

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby
- Do not use on closed containers.

HOT SURFACE - Parts can burn

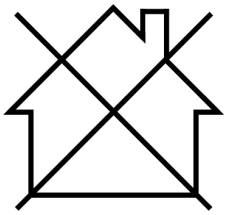
- Do not touch parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or insulated welding gloves to prevent burns.

MALFUNCTION - Call for expert assistance in the event of malfunction.

PROTECT YOURSELF AND OTHERS!

CAUTION!
This product is solely intended for arc welding.

CAUTION!
Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility of class A equipment in those locations, due to conducted as well as radiated disturbances.

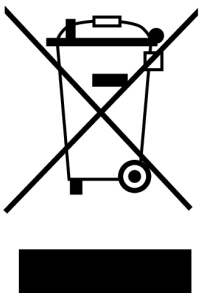


NOTE!
Dispose of electronic equipment at the recycling facility!

In observance of European Directive 2012/19/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

As the person responsible for the equipment, it is your responsibility to obtain information on approved collection stations.

For further information contact the nearest ESAB dealer.



ESAB has an assortment of welding accessories and personal protection equipment for purchase. For ordering information contact your local ESAB dealer or visit us on our website.

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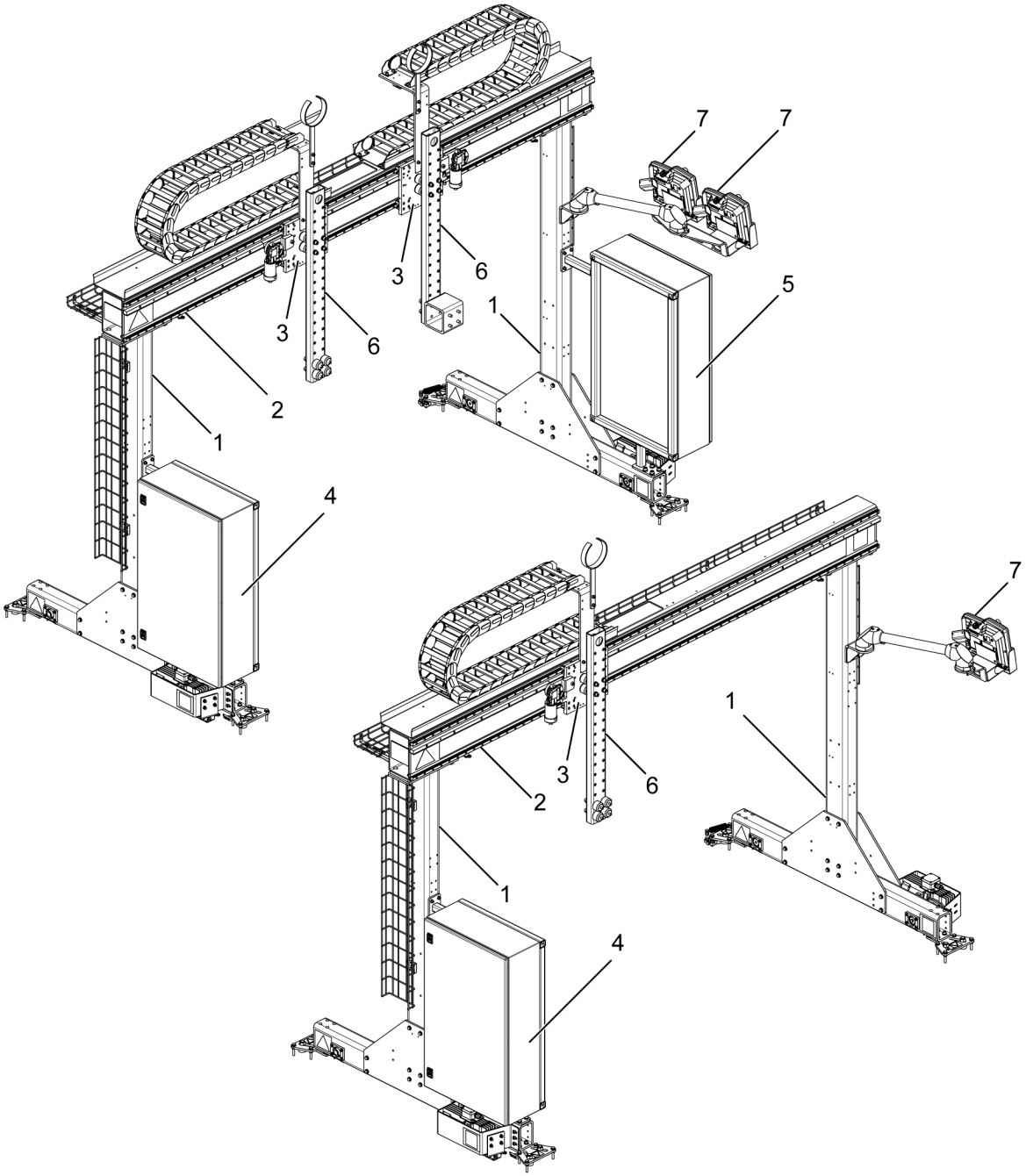
2 INTRODUCTION AND OVERVIEW

Mechtrac HD is a motor driven gantry for use together with ESAB's welding equipment and power sources. The product is available with two different boom lengths, **3 and 4 m**. Each of the boom length variants is available with **dual** boom carriages and welding heads as well as **single** boom carriage and welding head (only left).



1. Drive-kit (including gantry leg)
2. Horizontal boom
3. Boom carriage (left and right or only left respectively)
4. Cabinet B1
5. Cabinet B2
6. Arms for Mechtrac
7. EAC 30 control unit

The control of the travel motor is performed using the EAC 30 control unit.

For more information regarding the EAC 30 control unit, refer to the EAC 30 instruction manual.

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3 TECHNICAL DATA

Travel speed	0.2–2.0 m/min (7.9–78.7 in./min)
High travel speed gantry	400 cm/min (158 in./min)
Standard rail length	3.0 m (9.8 ft)
Maximum weight allowed:	
Per boom carriage	200 kg (440 lb)
Totally for Mechtrac HD	400 kg (880 lb)
Welding speed gantry	0.2–2 m/min (7.9–78.7 in./min)
Welding speed boom carriage	0.2–2 m/min (7.9–78.7 in./min)

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4 INSTALLATION

The installation must be carried out by a professional.

CAUTION!
This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.

Overal installation procedure:

PREPARATIONS → MECHANICAL ASSEMBLY → ELECTRICAL ASSEMBLY

4.1 Preparations

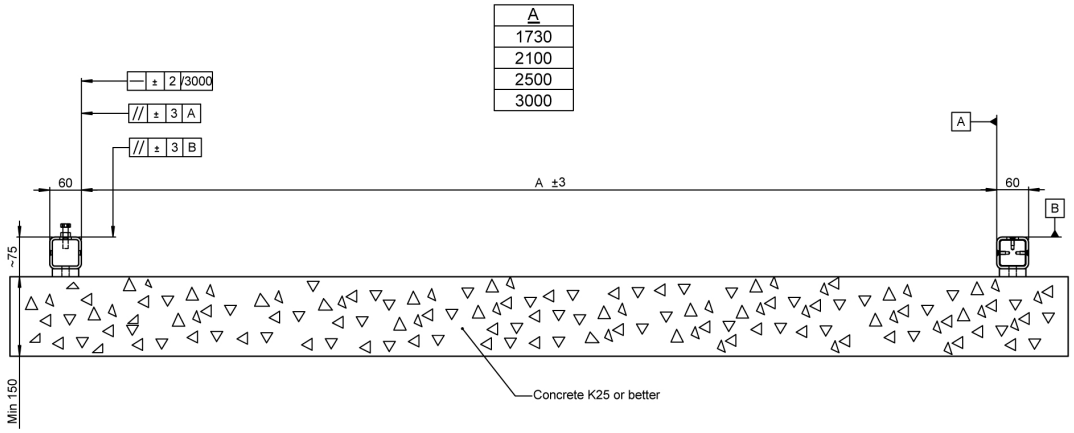
1) Make sure the correct rail is being used, refer to *"ACCESSORIES"*, page 30. The rail track width (the distance between the rails, measured from inside to inside of rails) should be as follows:

Mechtrac HD3	3000 mm
Mechtrac HD4	4000 mm

The rail should also meet the following requirements:

Homogeneous rod alternative square tube	
Minimum thickness of square tube material:	5 mm
Minimum rail width:	60 mm
Maximum rail width:	70 mm
Minimum rail height above floor or sleeper:	60 mm

2) Make sure the rail is in horizontal level and properly fixed to the floor, and also that the rail and the foundation meets other requirements according to the graphic below.



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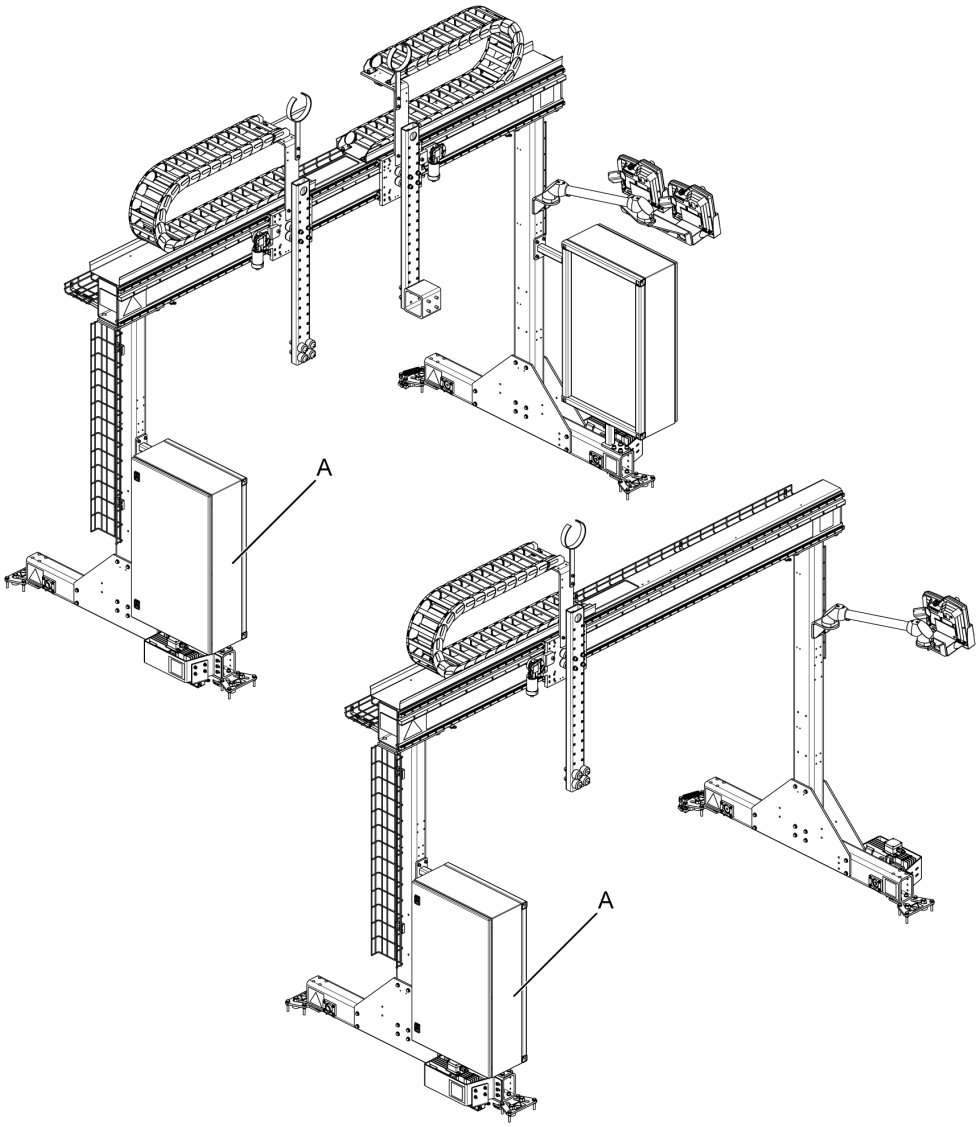
3) Plan and decide the orientation of the complete Mechtrac HD gantry in your factory layout, based on where connection possibilities for electrical power, compressed air etc. are located. Power supply, compressed air etc. and also floor cable chain, if included, is connected on the same side as control cabinet B1 (A) is located.



4) Unpack the Mechtrac HD (as delivered on a wooden platform). The Mechtrac HD gantry is delivered in theese three main modules:
   - Drive-kit Mechtrac HD, Left
   - Drive-kit Mechtrac HD, Right
   - Horizontal boom with boom carriage

5) Check that all items are supplied according to the packing list and that no visible damages exist. In the event of damage in transit, e.g. rust, dents or scratches, contact the forwarding agent.

6) Make sure an overhead crane and lifting straps are available (to be used for the mechanical erection of the gantry)!

7) Disconnect the voltage supply!

> **WARNING!**
> The voltage supply must be disconnected during installation.

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4.2 Mechanical assembly

WARNING!
Before the mechanical assembly according to this section is started, the steps according to *"Preparations"*, page 9 must be performed.

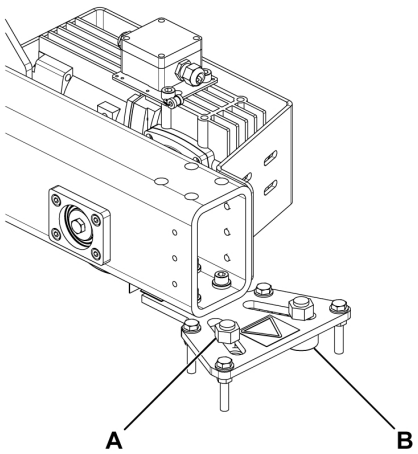
NOTE!
The graphics in this section show a Mechtrac HD for **dual** boom carriages and welding heads. The instructions and recommendations however, apply to Mechtrac HD for **both dual** boom carriages and **single** boom carriage.

1) Lift the horizontal boom (including the attached boom carriage/carriages) and place it temporarily on steady support jacks on the floor.

   NOTE!
   The horizontal boom is placed in the correct direction as packed from the factory!

2) Lift the Mechtrac HD **left** drive-kit and support it temporarily, to prevent it from falling down.

3) Loosen the locking nuts (A) for all four guide rollers (B) (at both ends of the drive-kit horizontal beam) and move the guide rollers to its outer position.



4) Place the left drive-kit on the requested rail. Make sure both wheels (front and rear) of the drive-kit are **on** the rail and **in line** with the rail. Using a spirit level, adjust the drive-kit so that the vertical beam is positioned vertically.

5) Fasten the guide rollers and remaining joints to the correct torques. Remove any support equipment used for temporary support of the drive-kit.

6) Lift the Mechtrac HD **right** drive-kit and fasten it **to the other rail**, in the same way as the left drive-kit (refer to items 2–5 above).

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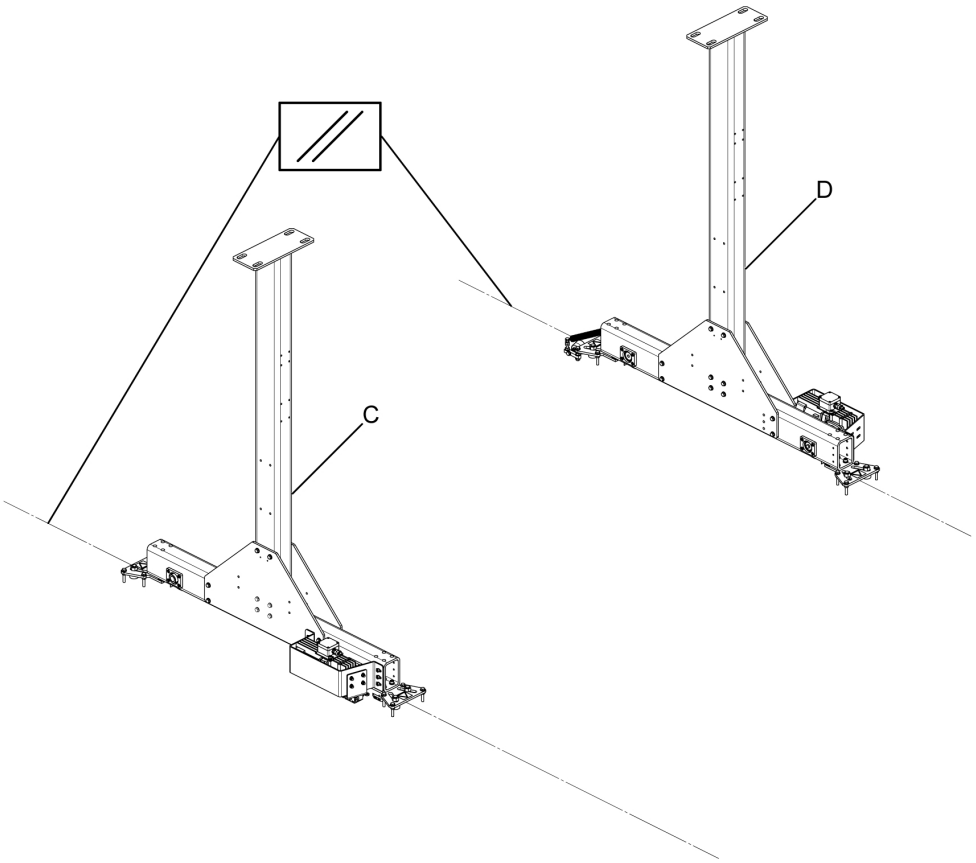
7) To facilitate assembly of the horizontal boom (including the boom carriage/carriages), make sure the **left** drive-kit (C) is in parallel with the **right** drive-kit (D).



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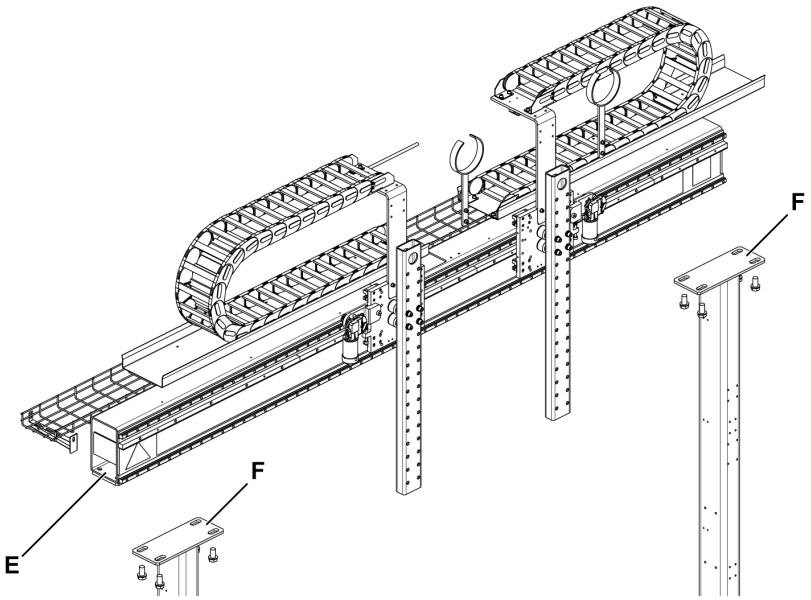
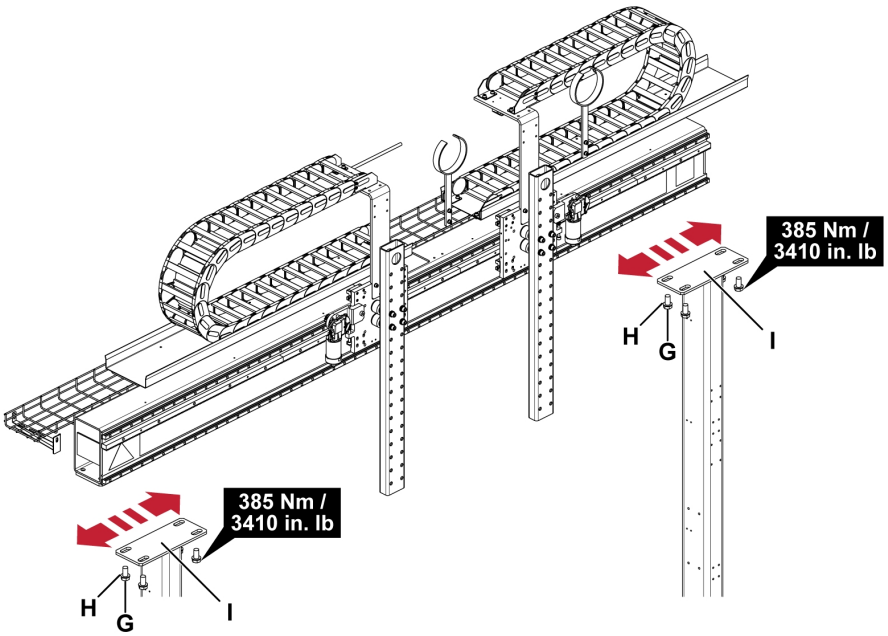
8) Lift the horizontal boom (E) (including the boom carriage/carriages) and place it, **in the correct direction** (i.e. with the boom carriage/carriages on the same side as Cabinet B1/B1 and B2), **on top of both the drive-kits** (F).



9) Insert all eight M20×40 screws (G) and 36/21×3 washers (H), for connection of the horizontal boom to the drive-kits, but **do not tighten them yet**. If the distance between the rails is correct and both drive kits are placed in a perfect vertical level, the screw connections between boom and drive kits will fit well. Yet the welded steel plates (I) on top of each drive-kit leg, have a hole pattern that allows for some adjustments sideways.

10) Adjust all eight screw joints sideways and tighten the screws (G) to the specified torque according to the graphic below.



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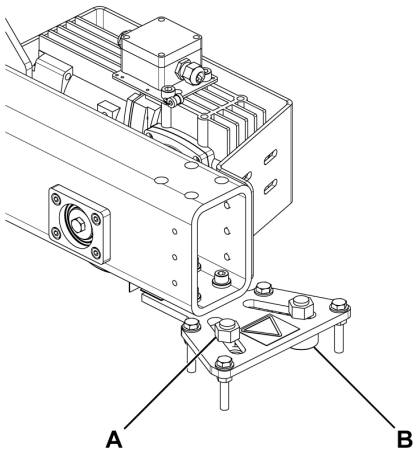
11) Adjust the guide rollers (B) so that they slightly touch the rail sides. Then tighten the nuts (A).



12) Remove all temporary support equipment.

4.3 Electrical assembly

WARNING!
Before the electrical assembly according to this section is started, the steps according to *"Mechanical assembly"*, page 11 must be performed.

1) Route the cables and the hoses for the gantry on the cable ducts on the horizontal boom and the two vertical beams. The cables and the hoses are located on the horizontal boom at delivery.

2) Perform all connections according to the electrical wiring diagram.

CAUTION!
All required cables must be connected before continuing according to the next step!

3) Connect mains to control cabinet B1.

4) Turn on the main switch (B11) located on control cabinet B1.

5) Make sure all emergency stop buttons are deactivated.

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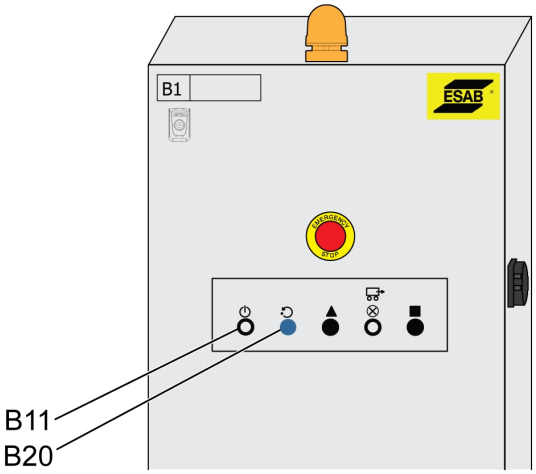
6) Reset the emergency stop circuit, by pressing the *Reset emergency stop* (B20) button on control cabinet B1.



The Mechtrac HD is now ready for operation.

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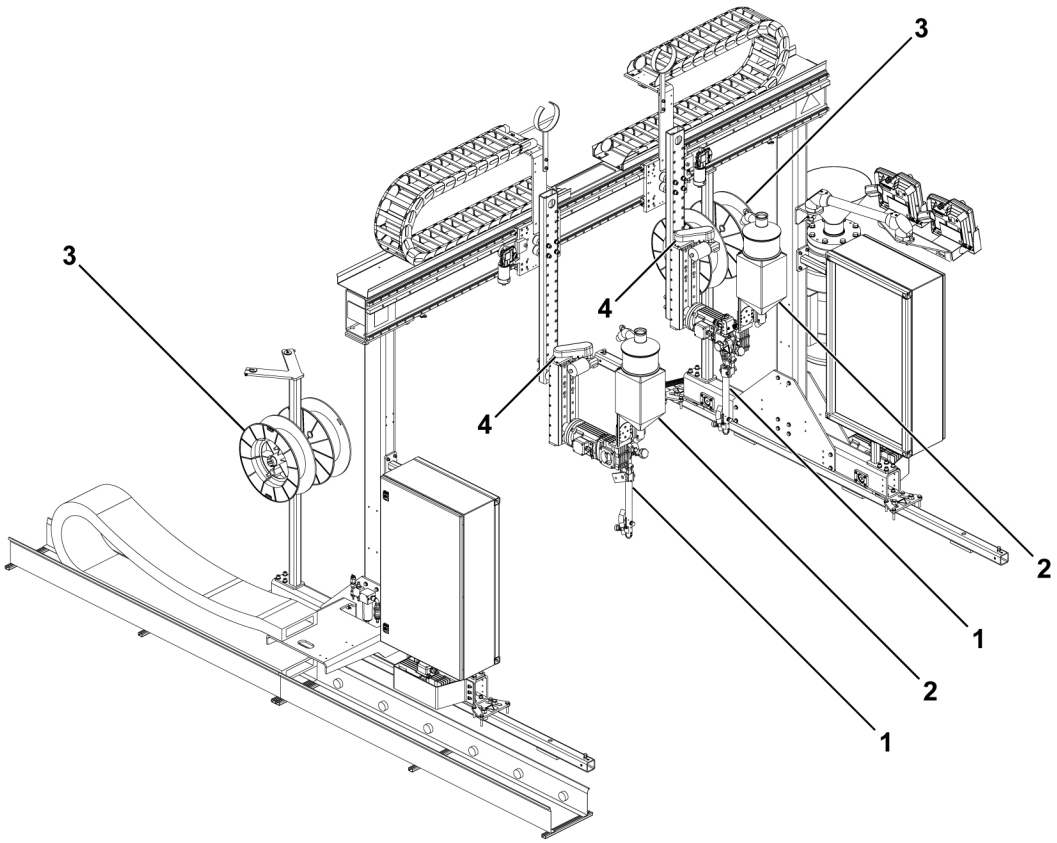
4.4 Installation of welding and flux equipment on the gantry

The graphic below shows an example of how to attach welding and flux equipment to the gantry.



1. Welding head
2. Flux container
3. Wire bobbin
4. Slide

WARNING!
The maximum weight allowed on the gantry is according to *"Technical data"*, page 8.

When necessary use a lifting strap for lifting the equipment.

4.5 Emergency stop circuit

For connection of the emergency stop circuit between the EAC 30 and the welding power source, refer to the electrical wiring diagram.

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5 CONFIGURATIONS

5.1 Configuration for control of boom carriage or gantry carriage

To configure the gantry for control of the **boom carriage** (transversal welding) or the **gantry carriage** respectively, enter the *MACHINE CONFIGURATION* menu in the EAC 30 control unit and proceed as follows below.

Configuration for control of boom carriage

1) Set *BOOM* to *ON*.

2) Select the *BOOM AXIS* menu.

MACHINE CONFIGURATION	
WIRE FEED AXIS 1►	
BOOM AXIS►	
CARRIAGE AXIS►	
EXTERNAL AXIS►	
TANDEM►	
PARALLEL POWERSOURCES►	
ICE WIRE FEED	*OFF*
BOOM	***ON***
CARRIAGE	
NODE ID SETTINGS►	
SYSTEM INFORMATION►	

3) In the *BOOM AXIS* menu, set the parameters for the boom carriage gears as follows:

CARRIAGE AXIS	
MOTOR	AM1767 KSV 4030/801, 10000 rpm
GEAR 1	ON
└ *N1*	125
└ *N2*	1
GEAR 2	ON
└ *N1*	1
└ *N2*	1
WHEEL DIAMETER	30 mm
ENCODER-PULSES	60 ppr

Configuration for control of gantry carriage

1) Set *CARRIAGE* to *ON*.

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2) Select the *CARRIAGE AXIS* menu.

MACHINE CONFIGURATION	
WIRE FEED AXIS 1►	
BOOM AXIS►	
CARRIAGE AXIS►	
EXTERNAL AXIS►	
TANDEM►	
PARALLEL POWERSOURCES►	
ICE WIRE FEED	*OFF*
CARRIAGE	***ON***
NODE ID SETTINGS►	
SYSTEM INFORMATION►	

3) In the *CARRIAGE AXIS* menu, set the parameters for the gantry carriage gears as follows:

CARRIAGE AXIS	
MOTOR	VEC 4000Par
GEAR 1	ON
└ *N1*	672
└ *N2*	1
GEAR 2	ON
└ *N1*	1
└ *N2*	1
WHEEL DIAMETER	148 mm
ENCODER-PULSES	32 ppr

5.2 Configuration for control of welding head gears

1) To configure the system for control of the welding head gears, enter the *WIRE FEED AXIS* menu in the *MACHINE CONFIGURATION* menu in the EAC 30 control unit and set the parameters according to *"Wire feed axis (referring to welding head)"*, page 19.

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5.3 EAC 30 configuration tables

Boom carriage (BOOM AXIS menu)

	USER DEF. AXIS
Motor	AM1767 KSV 4030/801, 10000 rpm
Gear 1	125:1
Gear 2	1:1
Diameter tooth wheel	30 mm (1.18 in.)
Pulse sensor	60 ppr

Gantry carriage (CARRIAGE AXIS menu)

	USER DEF. AXIS
Motor	VEC 4000Par
Gear 1	672:1
Gear 2	1:1
Diameter steel wheel	148 mm (5.83 in.)
Pulse sensor	32 ppr

Wire feed axis (referring to welding head)

	USER DEF. AXIS
Motor	VEC 4000
Gear 1	Gear ratio to be found in the manual for the welding head in question
Gear 2	1:1
Diameter feed rollers	Feed roller diameter to be found in the manual for the welding head in question
Pulse sensor	32 ppr

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6 OPERATION

General safety regulations for handling the equipment can be found in the "SAFETY" chapter of this manual. Read it through before you start using the equipment!

WARNING!
Electric shock! Do not touch the workpiece or the welding head during operation!

6.1 Operation general

The welding operation is controlled using the following units:

1. Control cabinet B1
2. Control cabinet B2
3. EAC 30

6.1.1 Starting the welding process

1) Turn on the main switch (B11) located on control cabinet B1.

2) Reset the emergency stop circuit, by pressing the *Reset emergency stop* (B20) button on control cabinet B1.

3) Turn on the main switch on the used welding power source.

6.2 Control cabinet B1

Control cabinet B1 is the main control cabinet, containing power distribution, emergency stop controls etc.

CAUTION!
Connections in the cabinet are only to be made by skilled personnel.

NOTE!
(B1), (B2), (B3) etc. = the component designation in the circuit diagram.

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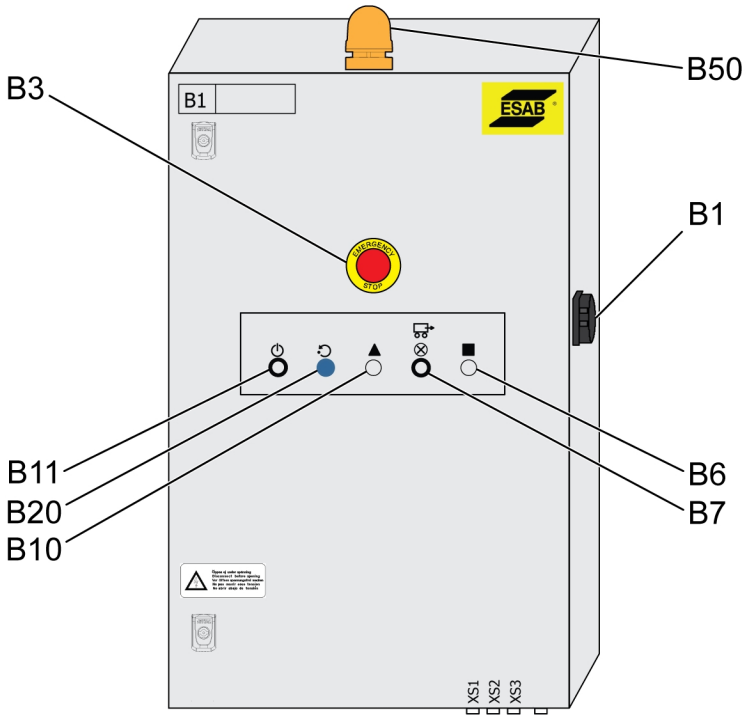

Main switch	B1	Switch ON/OFF
Emergency stop	B3	Emergency stop push button. Press once to activate the emergency stop.
Power on	B11	Power on button, containing indicator lamp showing that power is on
Square travel motion for gantry	B6	Press the button to drive the gantry in the square direction on the rail. The white lamp in the button is lit, as long as the transport motion is ongoing. This button is **also** used to control boom carriage no. 1, when **welding head no. 1** is used for **transversal** welding.
Triangle travel motion for gantry	B10	Press the button to drive the gantry in the triangle direction on the rail. The white lamp in the button is lit, as long as the transport motion is ongoing. This button is **also** used to control boom carriage no. 1, when **welding head no. 1** is used for **transversal** welding.
Stop	B7	Press to stop the transport of the gantry. If the transport is not stopped, using this button, the transport will continue until it is stopped by a limit switch.
Reset emergency stop	B20	Press to reset the emergency stop, after the cause for the emergency stop has been defined and taken care of.
Siren	B50	Siren to warn for high speed

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6.3 Switching between control of gantry and boom

Once the configuration according to *"Configuration for control of boom carriage or gantry carriage"*, page 17 has been performed, the EAC 30 control unit is used to switch function between **gantry** carriage and **boom** carriage as follows:

1) Select the preferred function, i.e. control of **gantry** carriage or **boom** carriage respectively, by pressing the switch button repeatedly.

   

   The selected function at present, i.e. **gantry** carriage  or **boom** carriage  , is indicated by means of the applicable icon being lit up brightly.

6.4 Emergency stop

Mechtrac HD is provided with an emergency stop system. Pressing an emergency stop button will immediately stop the machine.

Location of emergency stop buttons
Everyone in the vicinity of the welding equipment must be made aware of the placement of the emergency stops.

The emergency stops are placed on:

- The EAC 30 control unit
- Control cabinet B1

In the event of an emergency
Press the red emergency stop push-button immediately in the case of an emergency.

Reset emergency stop

> **CAUTION!**
> The cause of the abnormal function or signal must be defined and remedied before the emergency stop is reset!

To reset an emergency stop:

1. Find and eliminate the cause of the emergency stop.
2. Pull out the emergency stop button that has been activated.
3. Press the *Reset emergency stop* button (located on control cabinet B1).

6.5 Further information

For further detailed operating instructions, refer to the instruction manuals for each component (the EAC 30 control unit, the used welding head and the used welding power source respectively).

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7 MAINTENANCE

WARNING!
The mains supply must be disconnected during cleaning and maintenance.

CAUTION!
Only persons with the appropriate electrical knowledge (authorised personnel) may remove the safety plates.

CAUTION!
The product is covered by manufacturer's warranty. Any attempt to carry out repair work by non-authorised service centers or personnel will invalidate the warranty.

NOTE!
Regular maintenance is important for safe and reliable operation.

NOTE!
Perform maintenance more often during severe dusty conditions.

7.1 Checking of emergency stops

CAUTION!
The function of all emergency and safety devices is to be checked regularly, at least once every month, as well as after any work has been carried out on the equipment.

NOTE!
Any abnormal function or signal must be defined and remedied before the gantry is put into operation again.

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8 ORDERING SPARE PARTS

CAUTION!
Repair and electrical work should be performed by an authorised ESAB service technician.
Use only ESAB original spare and wear parts.

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see **esab.com**. When ordering, please state product type, serial number, designation and spare part number in accordance with the spare parts list. This facilitates dispatch and ensures correct delivery.

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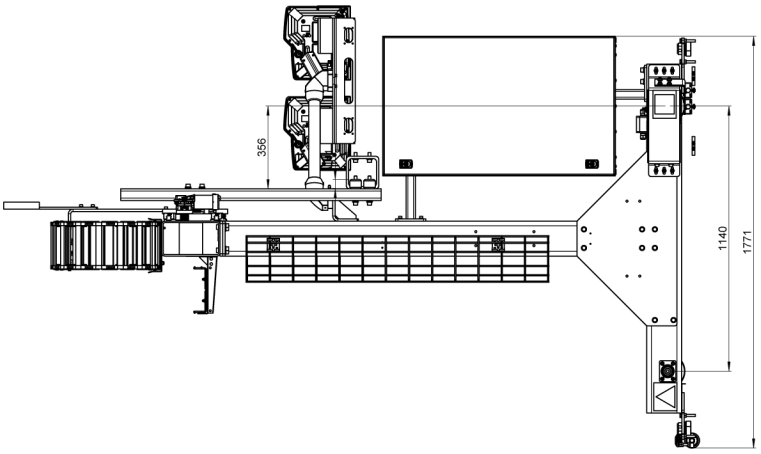
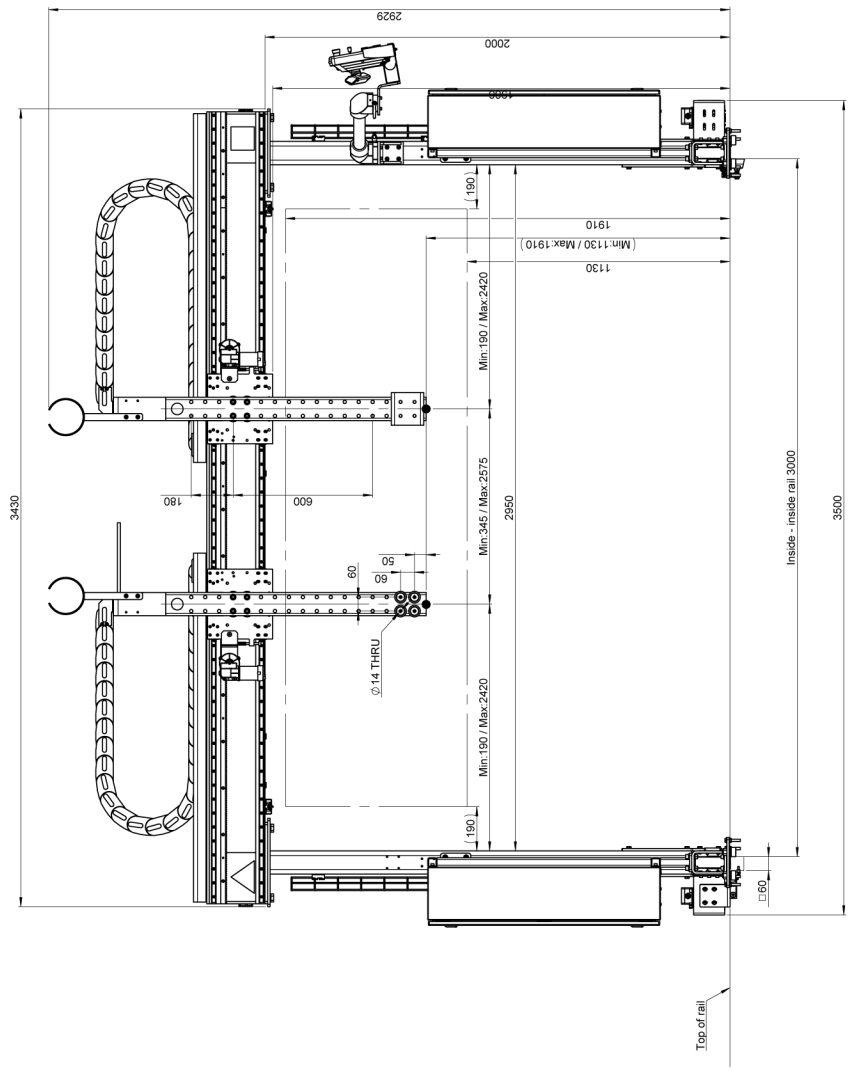
APPENDIX

DIMENSION DRAWINGS

Mechtrac HD3, Dual (0912 350 880)





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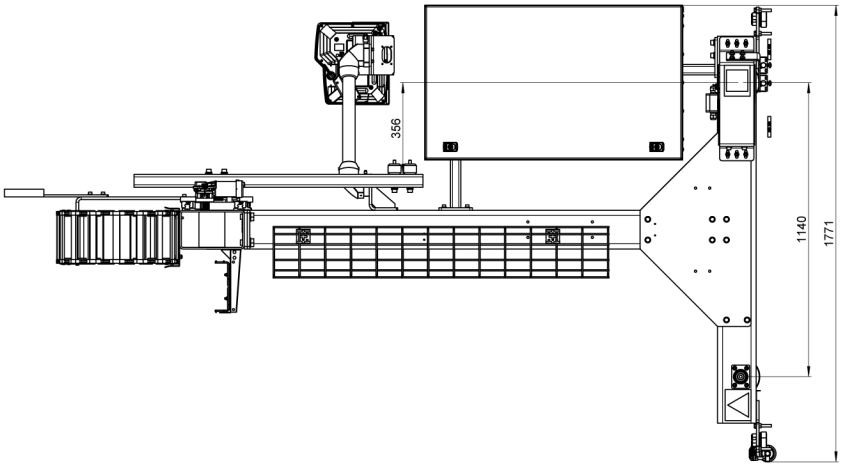
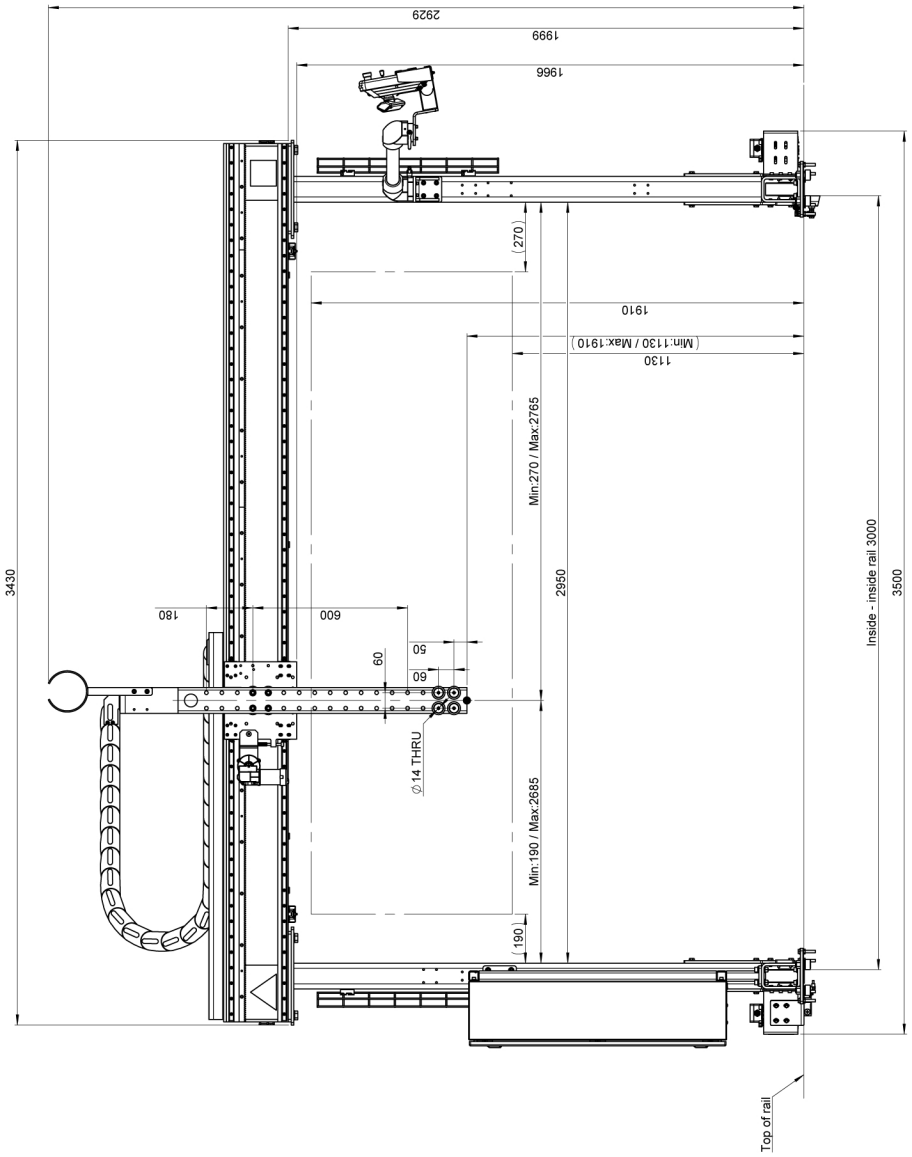
Mechtrac HD3, Single (0912 350 881)





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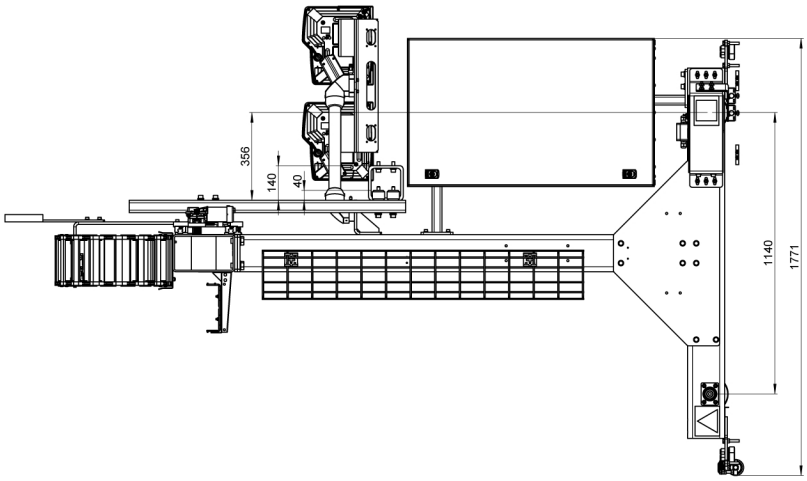
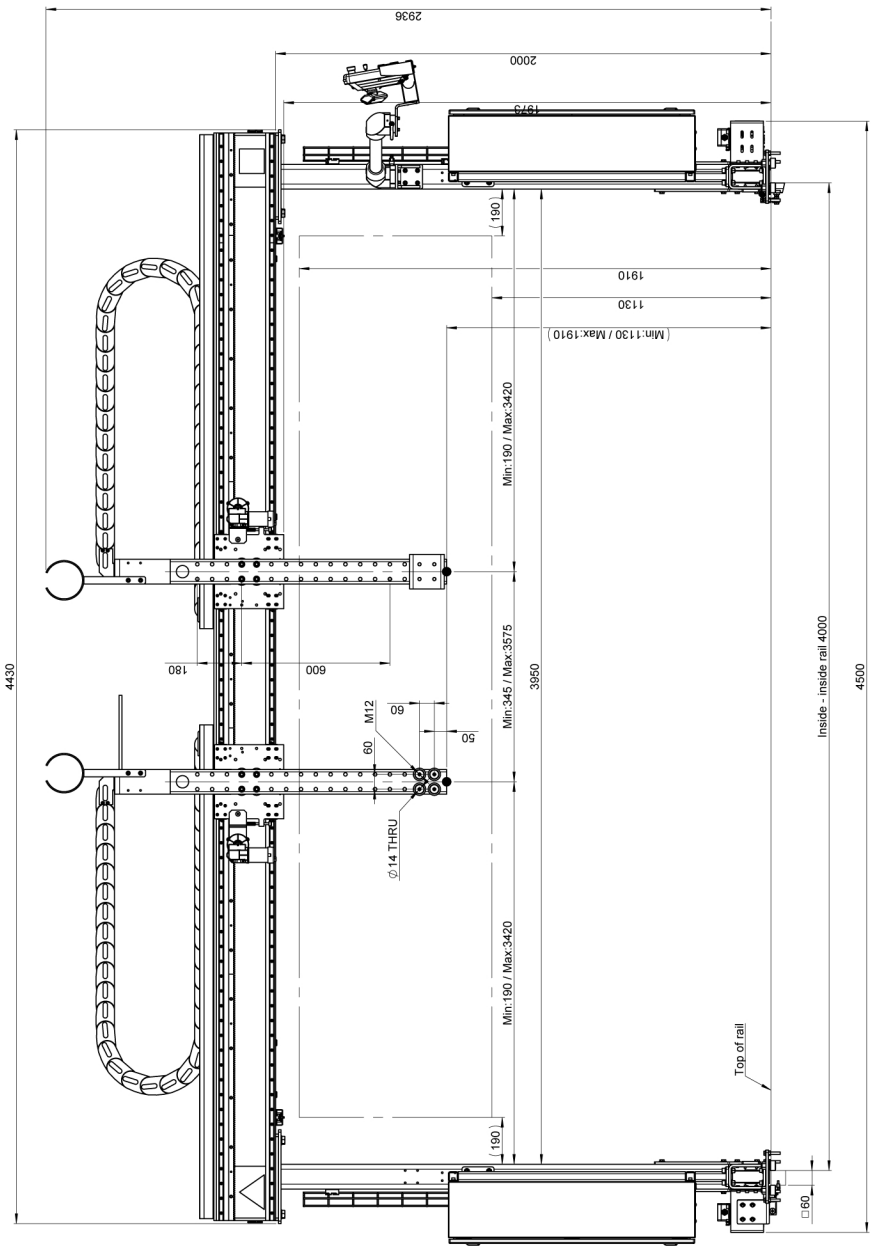
Mechtrac HD4, Dual (0912 351 880)





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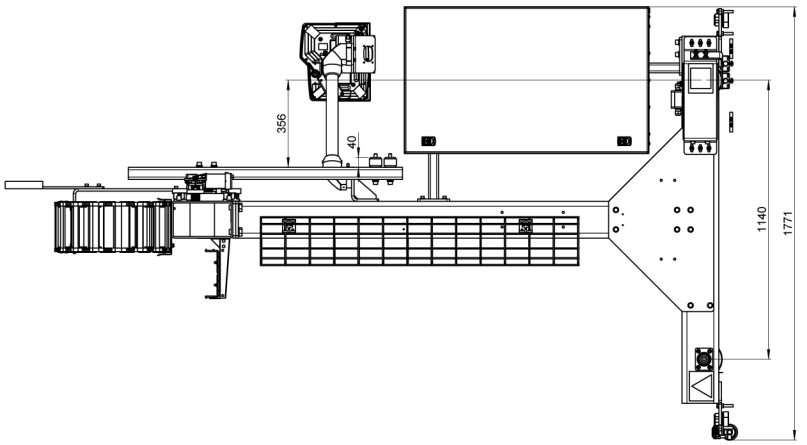
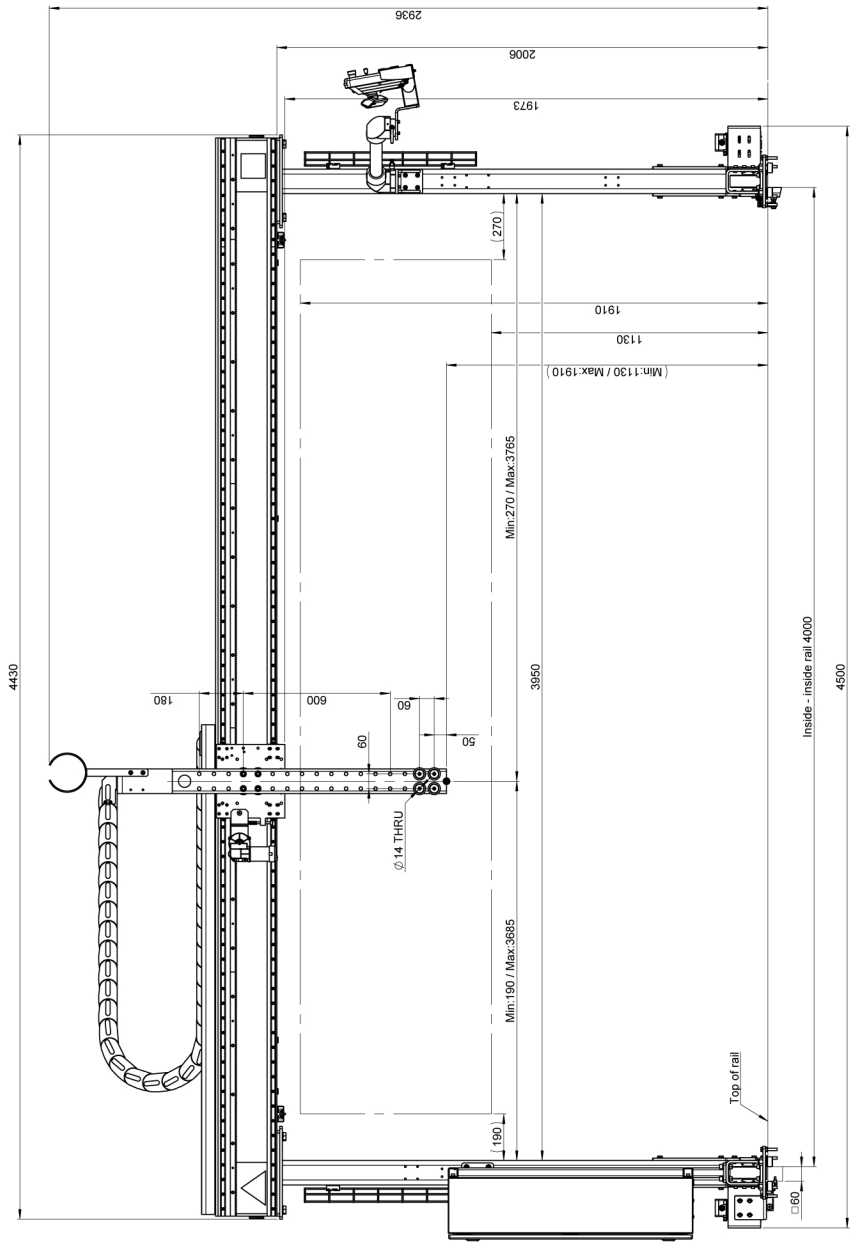
Mechtrac HD4, Single (0912 351 881)





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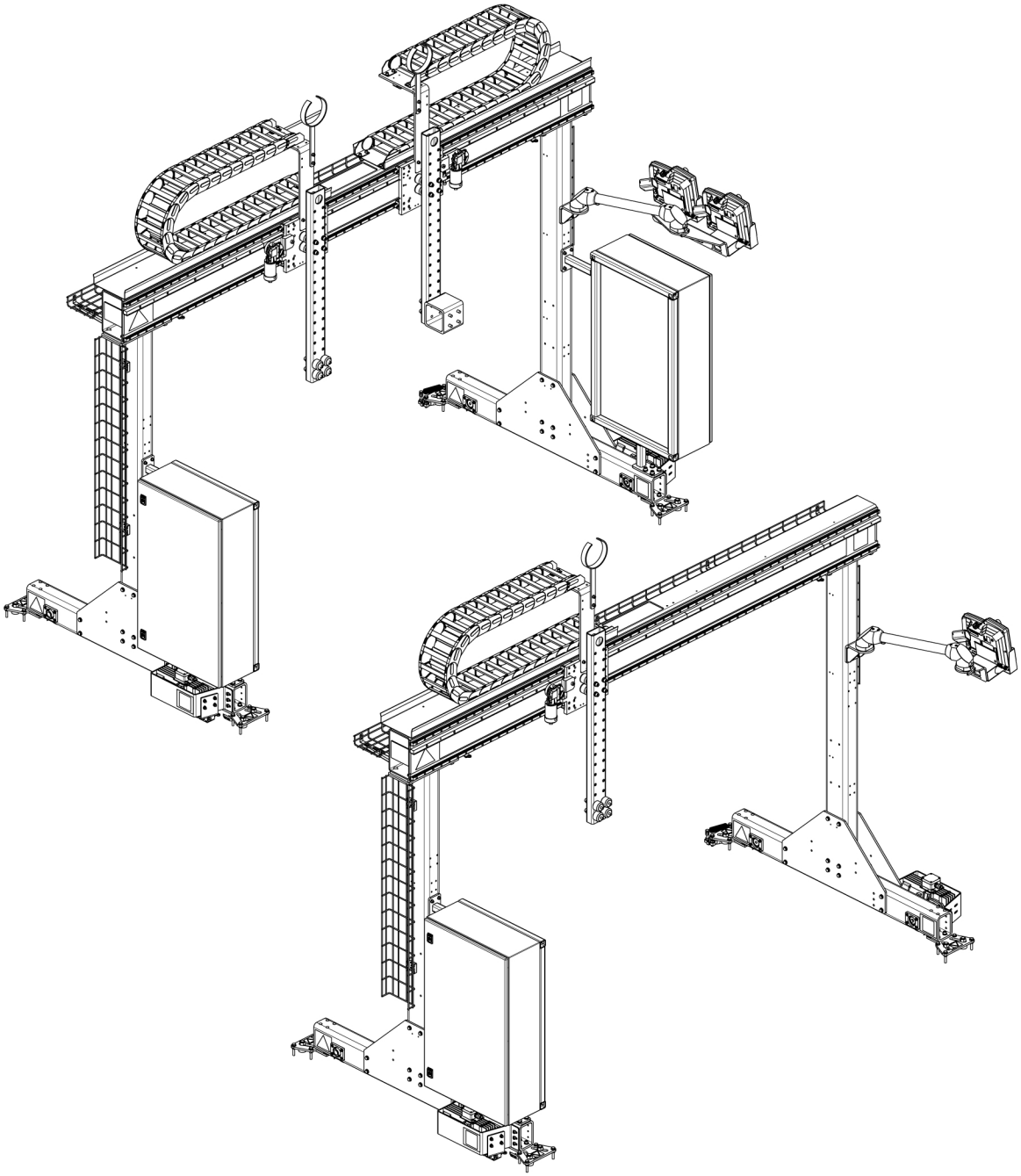
ORDERING NUMBERS



Ordering number	Denomination	Type	Notes
0912 350 880	Mechtrac HD3	For dual boom carriages and welding heads (left and right)	
0912 350 881	Mechtrac HD3	For single boom carriage and welding head (left)	
0912 351 880	Mechtrac HD4	For dual boom carriages and welding heads (left and right)	
0912 351 881	Mechtrac HD4	For single boom carriage and welding head (left)	
0463 934 001	Spare parts list		

Technical documentation is available on the Internet at: **www.esab.com**

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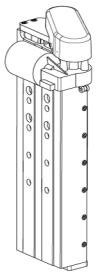
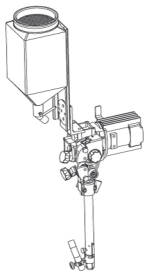
ACCESSORIES

Welding head modules:		
	Motorised slides:	
0334 333 883	240 mm	
0334 333 884	300 mm	
0334 333 885	420 mm	
0278 300 180	**Insulator**	
	Manual round slides:	
0334 170 880	Manual round slide, without handwheel	
0671 171 580	Manual round slide, with handwheel	
	Feed units:	
0912 360 880	SAW Twin wire right-hand assembled, Gear ratio 115:1	
0912 360 881	SAW Single wire right-hand assembled, Gear ratio 115:1, 4000 rpm	
0912 360 882	SAW Single wire right-hand assembled, Gear ratio 74:1, 4000 rpm	
0912 360 883	SAW Single wire right-hand assembled, Gear ratio 156:1, 4000 rpm	
0912 360 884	SAW Single wire right-hand assembled, Gear ratio 74:1, 8000 rpm	
0912 361 880	SAW Twin wire left-hand assembled, Gear ratio 115:1	
0912 361 881	SAW Single wire left-hand assembled, Gear ratio 115:1, 4000 rpm	
0912 361 882	SAW Single wire left-hand assembled, Gear ratio 74:1, 4000 rpm	
0912 361 883	SAW Single wire left-hand assembled, Gear ratio 156:1, 4000 rpm	
0912 361 884	SAW Single wire left-hand assembled, Gear ratio 74:1, 8000 rpm	

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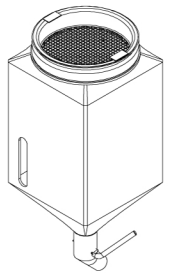
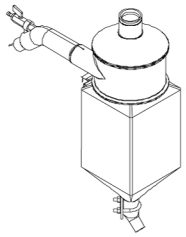
0147 649 881	**Flux hopper** 10 l	
	OPC super Mechtrac HD units:	
0912 522 880	Dual OPC super kit	
0912 522 881	Single OPC super kit	
0912 522 882	Dual OPC super kit without flux inlet	
0912 522 883	Single OPC super kit without flux inlet	
0912 730 880	**Mechanical option for flux suction OPC** (Order 2 pieces when using dual welding heads.)	
0912 577 880	**Electrical option for flux suction OPC** (Option 30 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 577 881	**Flux down** (Option 40 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0333 225 882	**Mechanical option for TPC with heater**	
0912 577 889	**Electrical option for TPC with heater** (option 220 according to electrical diagram)	
0333 225 884	**Mechanical option for TPC with low-level sensor**	
0912 577 890	**Electrical option for TPC with low-level sensor** (option 230 according to electrical diagram)	
0333 225 886	**Mechanical option for TPC with heater and low-level sensor**	
0417 142 900	**Mechanical option for GMH** (Order 2 pieces when using dual welding heads.)	
0912 577 882	**Electrical option for GMH** (Option 60 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0810 904 881	**Mechanical option for inductive sensor** (Order 2 pieces when using dual welding heads.)	
0912 577 883	**Electrical option for inductive sensor** (Option 62 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	

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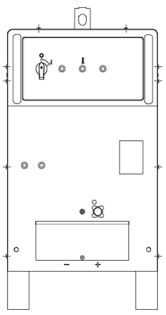
0912 435 880	**Mechanical option for gas** (Order 2 pieces when using dual welding heads.)	
0912 577 884	**Electrical option for gas** (Option 70 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 728 880	**Mechanical option for flow sensor** (Order 2 pieces when using dual welding heads.)	
0912 577 885	**Electrical option for flow sensor** (Option 72 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 577 886	**Shift transversal welding** (Option 80 according to electrical diagram)	
0912 577 888	**Camera system** (Option 190 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 733 880	**Mounting kit for camera system** (Order 2 pieces when using dual welding heads.)	
0822 640 880	**Bracket with slide cross** (Order 2 pieces when using dual welding heads.)	
0912 577 891	**ICE** (Option 251 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
  0912 577 892 0912 578 892	**WeldCloud:** (Option 280 according to electrical diagram) Dual Single	
0460 512 880	**LAF 631** Welding power source	

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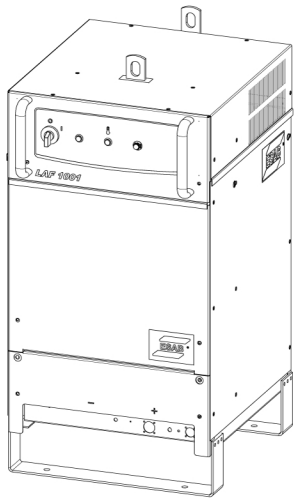
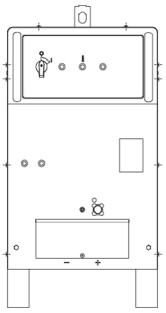
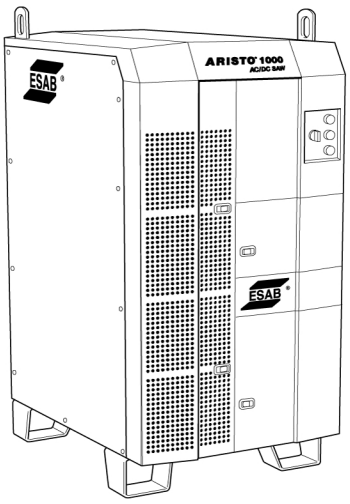
0460 513 880	**LAF 1001** Welding power source	
0460 513 881	**LAF 1001M** Welding power source	
0460 514 880	**LAF 1251** Welding power source	
0460 514 881	**LAF 1251M** Welding power source	
0462 100 880	**Aristo 1000 AC/DC SAW** Welding power source	

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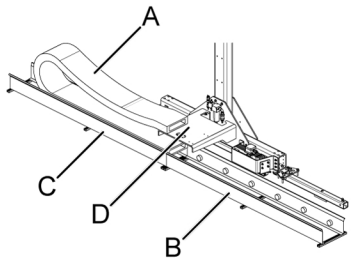
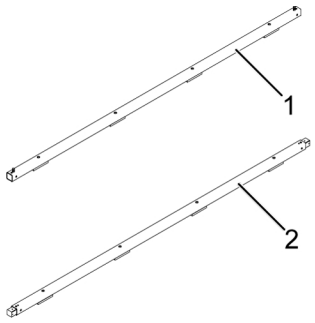
	Floor cable chain (A)	
0417 981 005	For 5 m travel	
0417 981 010	For 10 m travel	
0417 981 015	For 15 m travel	
0417 981 020	For 20 m travel	
0417 981 025	For 25 m travel	
0417 981 030	For 30 m travel	
0417 981 035	For 35 m travel	
0417 981 040	For 40 m travel	
0417 981 045	For 45 m travel	
0417 981 050	For 50 m travel	
0417 981 101	**Guide groove with rollers** (B)	
0417 981 102	**Guide groove without rollers** (C)	
0912 352 880	**Attachment for cable chain** (D)	
0413 768 xxx *)	**Welding cable** (W20, W120, W220, W320)	
0413 768 xxx *)	**Return cable** (W18, W218)	
0820 129 8xx *)	**Reference cable** (W19,W219)	
0912 582 8xx *)	**Control cable set** (W15, W16, W215, W216) (consisting of cables 0460 910 98x and 0802 803 028)	

*) "x" Denotes total length of each cable type,
Order two cable sets when using dual welding heads.

0806 707 880	**Rail (Basic)** (1)	
0806 707 881	**Rail (Extension)** (2)	

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