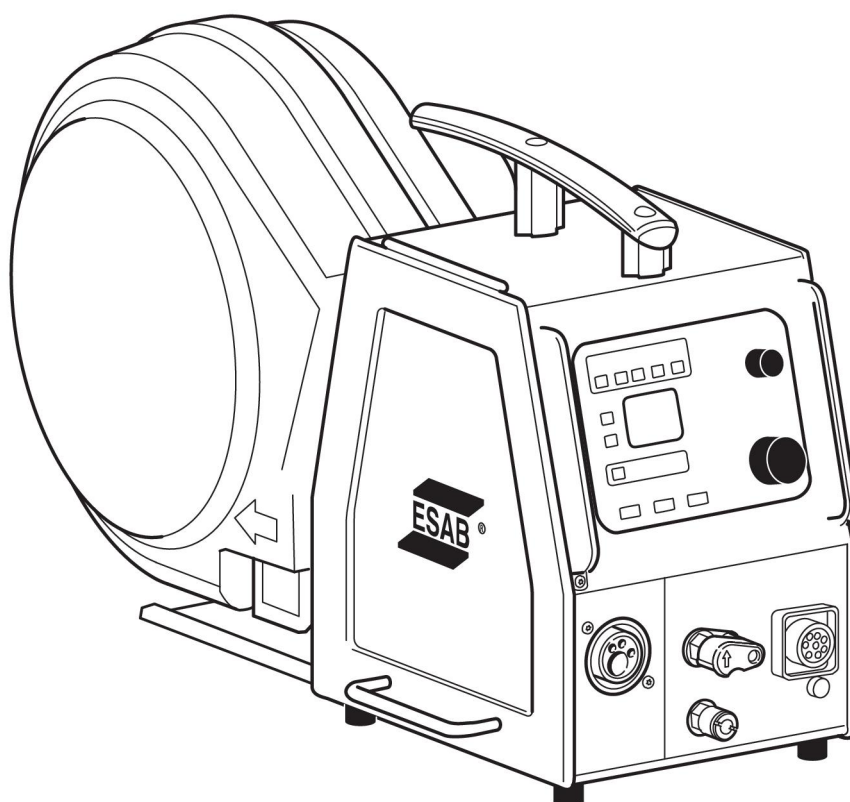




Aristo®, Origo™

Feed 3004, Feed 4804



Instruction manual



EU DECLARATION OF CONFORMITY

According to
The Low Voltage Directive 2014/35/EU, entering into force 20 April 2016
The EMC Directive 2014/30/EU, entering into force 20 April 2016
The RoHS Directive 2011/65/EU, entering into force 2 January 2013

Type of equipment

Wire Feeder

Type designation

Feed 3004/3004w	from serial number 540 xxx xxxx (2015 w/40)
Feed 3004/3004w, U6	from serial number 540 xxx xxxx (2015 w/40)
Feed 3004/3004w, MA23	from serial number 540 xxx xxxx (2015 w/40)
Feed 3004/3004w, MA24	from serial number 540 xxx xxxx (2015 w/40)
Feed 3004/3004w, MA25	from serial number 628 xxx xxxx (2016 w/28)
Feed 4804/4804w	from serial number 745 xxx xxxx (2007 w/45)
Feed 4804/4804w, U6	from serial number 745 xxx xxxx (2007 w/45)
Feed 4804/4804w, MA23	from serial number 745 xxx xxxx (2007 w/45)
Feed 4804/4804w, MA24	from serial number 745 xxx xxxx (2007 w/45)

Brand name or trade mark

ESAB

Manufacturer or his authorised representative established within the EEA

Name, address, and telephone No:

ESAB AB

Lindholmsallén 9, Box 8004, SE-402 77 Göteborg, Sweden

Phone: +46 31 50 90 00, Fax: +46 31 50 92 22

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

EN 60974-5:2013, Arc Welding Equipment – Part 5: Wire Feeders

EN 60974-10:2014, A1:2015 Arc Welding Equipment – Part 10: Electromagnetic Compatibility (EMC) requirements

Additional Information:

Restrictive use, Class A equipment, intended for use in location other than residential

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.

Date

Signature

Position

Gothenburg
2017-10-30


Stephen Argo

Global Director Equipment

CE 2017

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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



WARNING!

Wire feeders are intended to be used with power sources in MIG/MAG mode only.

If used in any other welding mode, such as MMA, the welding cable between wire feeder and power source must be disconnected, or else the wire feeder becomes live or energized.



WARNING!

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



ELECTRIC SHOCK - Can kill

- 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.



FIRE HAZARD

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

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

PROTECT YOURSELF AND OTHERS!



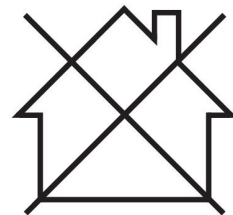
CAUTION!

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.

2 INTRODUCTION

The wire feed unit **Feed 3004** with control panel **U6**, **MA23**, **MA24** or **MA25 Pulse** is intended for MIG/MAG welding together with 400A, 500A and 600A CAN welding power sources.

The wire feed unit **Feed 4804** with control panel **U6**, **MA23** or **MA24** is intended for MIG/MAG welding together with 400A, 500A and 600A CAN welding power sources.

The wire feed units contain four-wheel drive wire feed mechanisms as well as control electronics.

They can be used together with wire on ESAB's MarathonPac™, or on wire bobbin (standard Ø 300 mm, accessory Ø 440 mm).

The wire feed unit can be installed either on the power source trolley, suspended above the workplace, on a counter balance device or on the floor with or without wheel set.

ESAB's accessories for the product can be found in chapter "ACCESSORIES" of this manual.

2.1 Equipment

The wire feed unit is supplied with:

- instruction manual for the wire feed unit
- instruction manual in English for the control panel
Instruction manuals in other languages can be downloaded from the Internet:
www.esab.com
- decal with recommended wear parts.

2.2 Control panel

The wire feed unit is supplied with one of the following control panels:



U6

Empty panel for use with double wire feed units or with use of control box U8₂.



MA23

Knobs for setting the voltage and the wire feed speed / current. Other parameters are controlled by pushbuttons, with text in the display panel.



MA24

Knobs for setting the voltage and the wire feed speed / current. Other settings with push buttons.



Knobs for setting the voltage / QSet™ and the wire feed speed / current. Other settings with push buttons.

MA25
Pulse



Knobs for setting the voltage / QSet™ and the wire feed speed / current. Other settings with push buttons.

See the separate instruction manual for a detailed description of the control panels.

3 TECHNICAL DATA

	Feed 3004	Feed 4804
Mains voltage	42 V 50-60 Hz	42 V 50-60 Hz
Power requirement	336 VA	378 VA
Motor current I_{\max}	8 A	9 A
Wire feed speed	0.8 - 25.0 m/min	0.8 - 25.0 m/min
Torch connection	EURO	EURO
Max. diameter wire bobbin	300 mm (*440 mm)	300 mm (*440 mm)
Wire dimension		
Fe	0.8 - 1.6 mm	0.8 - 2.4 mm
Ss	0.8 - 1.6 mm	0.8 - 2.4 mm
Al	1.0 & 1.6 mm	1.0 & 2.4 mm
Cored wire	0.9 - 1.6 mm	0.9 - 2.4 mm
Weight	15 kg	19 kg
Dimensions (l x w x h)	690 x 275 x 420 mm	690 x 275 x 420 mm
Operating temperature	-10 to +40°C	-10 to +40°C
Shielding gas	All types intended for MIG/MAG welding	All types intended for MIG/MAG welding
max pressure	0.5 MPa (5 bar)	0.5 MPa (5 bar)
Coolant	ESAB's ready mixed coolant	ESAB's ready mixed coolant
max pressure	0.5 MPa (5 bar)	0.5 MPa (5 bar)
Maximum permissible load at		
60% duty cycle	630 A	630 A
100% duty cycle	500 A	500 A
Enclosure class	IP23	IP23

*Accessories can be found in the "ACCESSORIES" chapter.

Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld or cut at a certain load without overloading. The duty cycle is valid for 40 °C / 104 °F, or below.

Enclosure class

The **IP** code indicates the enclosure class, i.e. the degree of protection against penetration by solid objects or water.

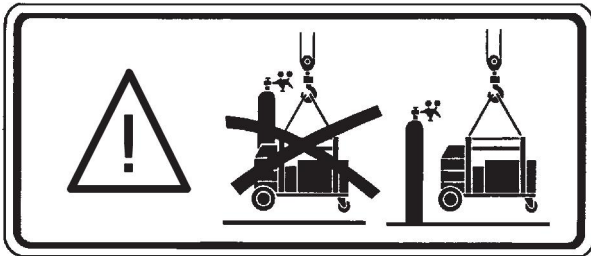
Equipment marked **IP23** is intended for indoor and outdoor use.

4 INSTALLATION

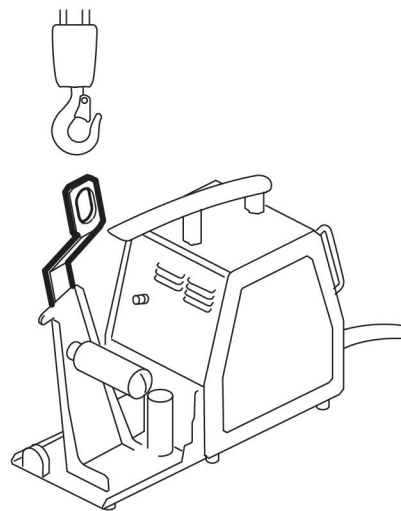
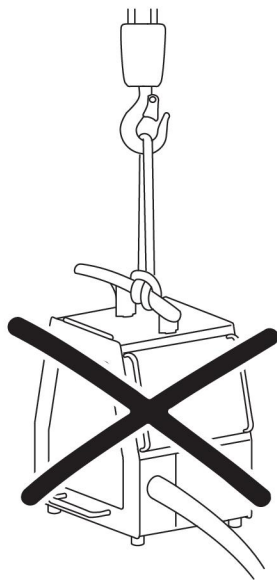
The installation must be carried out by a professional.

**WARNING!**

When welding in an environment with increased electrical danger, only power sources intended for this environment may be used. These power sources are marked with the symbol **S**.



4.1 Lifting instructions



Order number for lifting eyelet can be found in chapter "ACCESSORIES".

**NOTE!**

If another mounting device is used, this must be electrically insulated from the wire feed unit.

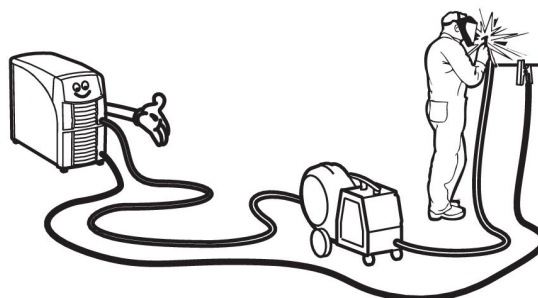
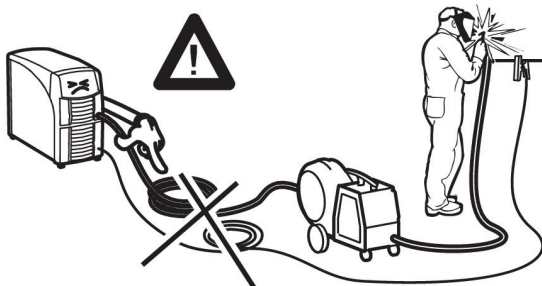
5 OPERATION

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!



NOTE!

When moving the equipment, use handle intended for transportation. Never pull the equipment by the welding torch.



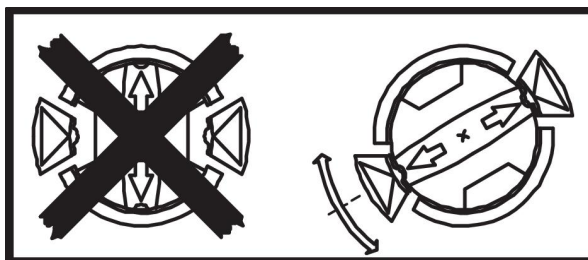
WARNING!

Assure that the side panels are closed during operation.



WARNING!

To prevent the reel from sliding off the hub: Lock the reel in place by turning the red knob as shown on the warning label attached next to the hub.



WARNING!

Rotating parts can cause injury, take great care.



WARNING!

There is a risk of tipping if the wire feed unit is fitted with a counterbalance arm. Secure the equipment, especially if used on an uneven or sloping surface.



WARNING!

Risk of crushing when replacing the wire bobbin! Do **not** use safety gloves when inserting the welding wire between the feed rollers.

5.1 Connections and control devices

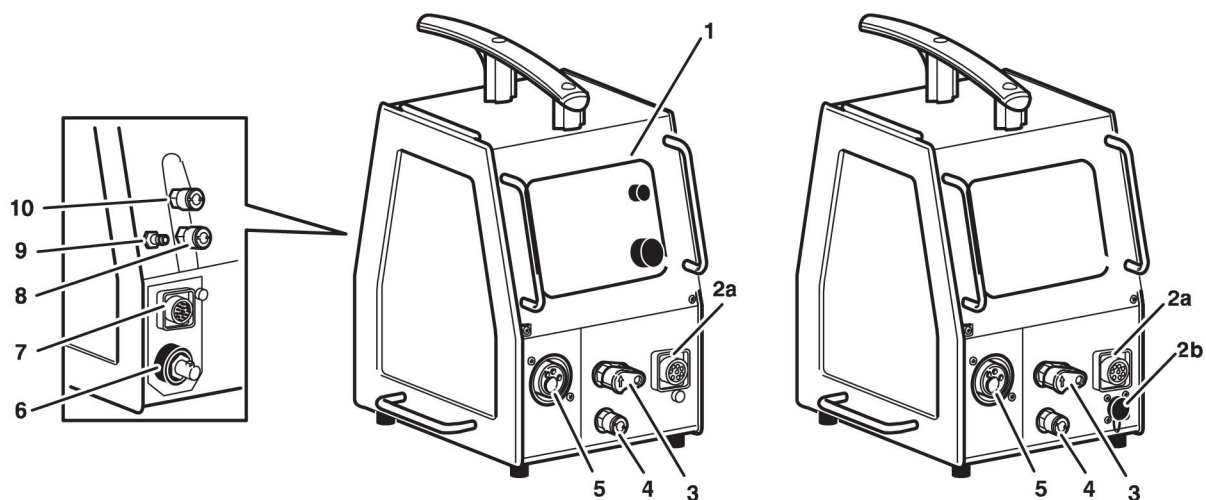
- | | | | |
|----|---|----|--|
| 1 | Control panel, (see separate instruction manual) | 6 | Connection for welding current from power source, (OKC) |
| 2a | Connection for remote control unit | 7 | Connection for control cable from power source or cooling unit |
| 2b | Connection for U8 ₂ | | |
| 3 | Connection BLUE, with ELP* for coolant to the welding torch | 8 | Connection RED, for coolant to cooling unit |
| 4 | Connection RED, for coolant from welding torch | 9 | Connection for shielding gas |
| 5 | Connection for welding torch | 10 | Connection BLUE, for coolant from cooling unit |



NOTE!

Display (digital instrument) and coolant connections only available on certain models.

* ELP = ESAB Logic Pump, see section "WATER CONNECTION".



5.2 Water connections

The wire feed unit with water connection is equipped with a detection system **ELP** (ESAB Logic Pump) which checks that the water hoses are connected. When connecting a water-cooled welding torch, the water pump starts.

Detection only works with power sources that are equipped with ELP.

5.3 Wire feed pressure

Start by making sure that the wire moves smoothly through the wire guide. Then set the pressure of the wire feeder's pressure rollers. It is important that the pressure is not too great.

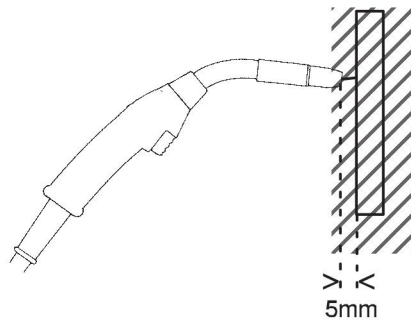


Fig 1

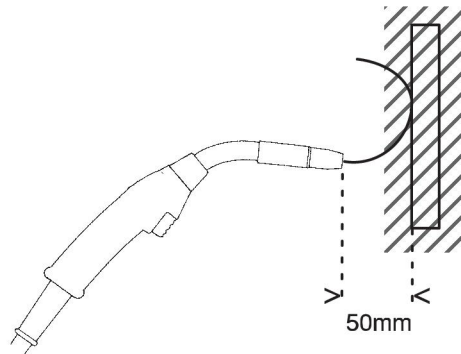


Fig 2

To check that the feed pressure is set correctly, you can feed out the wire against an insulated object, e.g. a piece of wood.

When you hold the torch approx. 5 mm from the piece of wood (fig. 1) the feed rollers should slip.

If you hold the torch approx. 50 mm from the piece of wood, the wire should be fed out and bend (fig. 2).

5.4 Replacing and inserting Feed 3004 wire

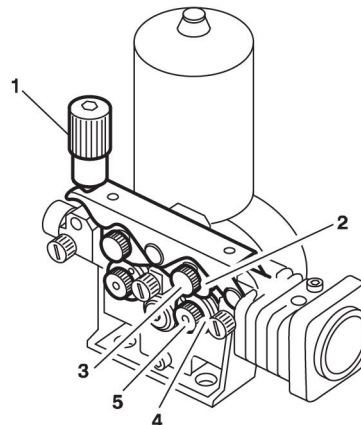
- Open the side panel.
- Disconnect the pressure sensor by folding it backwards, the pressure rollers slide up.
- If necessary, roll back the wire and remove the wire bobbin.
- Straighten out the new wire 10-20 cm. File away burrs and sharp edges from the end of the wire before inserting it into the wire feed unit.
- Make sure that the wire goes properly into the feed roller's track and into the outflow nozzle or wire guide.
- Secure the pressure sensor.
- Close the side panel.

5.5 Replacing and inserting Feed 4804 wire

- Open the side panel.
- Press down and pull the pressure device towards you and up.
- Pull out the bogie.
- If necessary, roll back the wire and remove the wire bobbin.
- Straighten out the new wire 10-20 cm. File away burrs and sharp edges from the end of the wire before inserting it into the wire feed unit.
- Make sure that the wire goes properly into the feed roller's track and into the outflow nozzle or wire guide.
- Reinstall the bogie.
- Close the side panel.

5.6 Changing feed rollers on Feed 3004

- Open the side panel
- Disconnect the pressure sensor (1) by folding it backwards.
- Disconnect the pressure rollers (2) by turning the axle (3) 1/4 turn clockwise and pulling out the axle.
- The pressure rollers disconnect.
- Disconnect the feed rollers (4) by unscrewing the nuts (5) and pulling out the rollers.



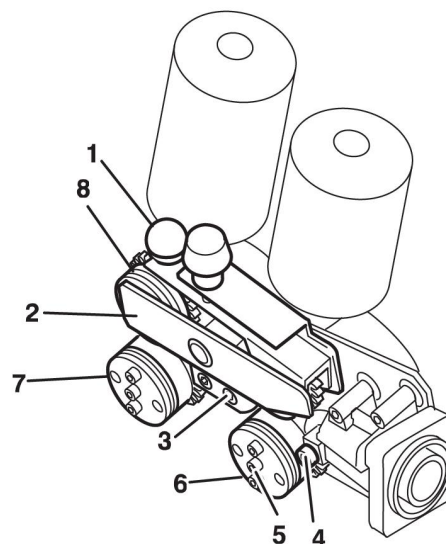
During installation, repeat the above in reverse order.

Choice of track in the feed rollers

Turn the feed roller with the dimensioning mark for the required track towards you.

5.7 Changing feed rollers on Feed 4804

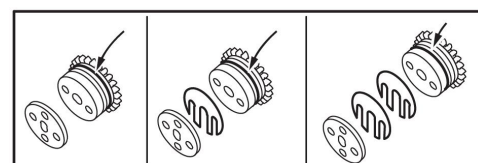
- Open the side panel.
- Press down and pull the pressure device (1) towards you and up.
- Pull out the bogie (2).
- Undo the socket head cap screws (3) on the holder for the intermediate nozzle and remove it.
- Undo the screw for the outflow nozzle (4) and push back the nozzle.
- Completely undo the socket head cap screw (5) in the centre.
- Undo the two outer socket head cap screws (6) 1/2 a turn.
- Pull out the feed rollers (7).



During installation, repeat the above in reverse order.

Choice of track in the feed rollers

Place no, one or two driving washers between the outer washer and the feed roller.



Groove 1 Groove 2 Groove 3



NOTE!

When replacing the pressure rollers (8), the entire bogie is replaced.

6 MAINTENANCE



NOTE!

Regular maintenance is important for safe and reliable operation.



CAUTION!

All warranty undertakings from the supplier cease to apply if the customer attempts any work to rectify any faults in the product during the warranty period.

6.1 Inspection and cleaning

Wire feed unit

Check regularly that the wire feed unit is not clogged with dirt.

- Cleaning and replacement of the wire feed unit mechanism's worn parts should take place at regular intervals in order to achieve trouble-free wire feed.



NOTE!

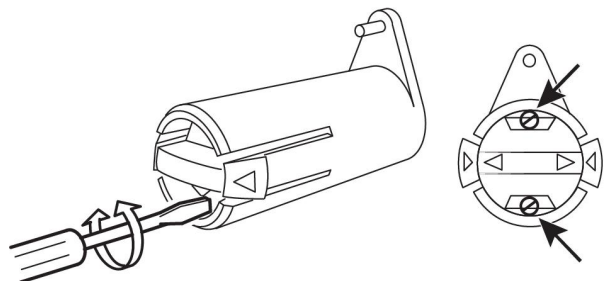
If pre-tensioning is set too hard, this can result in abnormal wear on the pressure roller, feed roller and wire guide.

The brake hub

The hub is adjusted when delivered, if readjustment is required, follow the instructions below. Adjust the brake hub so that wire is slightly slack when wire feed stops.

Adjusting the braking torque:

- Turn the red handle to the locked position.
- Insert a screwdriver into the springs in the hub.
- Turn the springs clockwise to reduce the braking torque
- Turn the springs counter-clockwise to increase the braking torque.



NOTE!

Turn both springs the same amount.

Welding torch

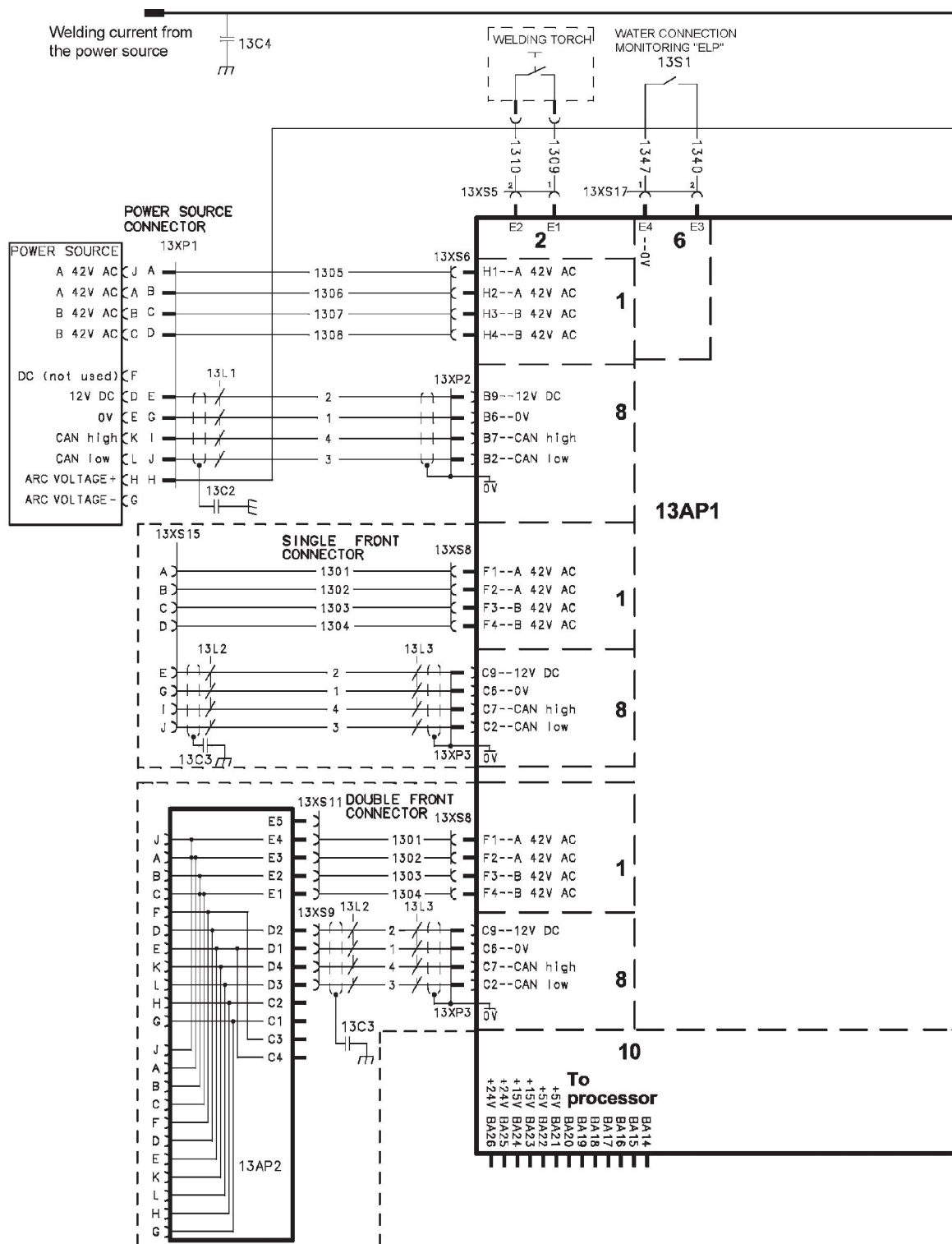
- The welding torch's wear parts should be cleaned and replaced at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean regularly and clean the contact tip.

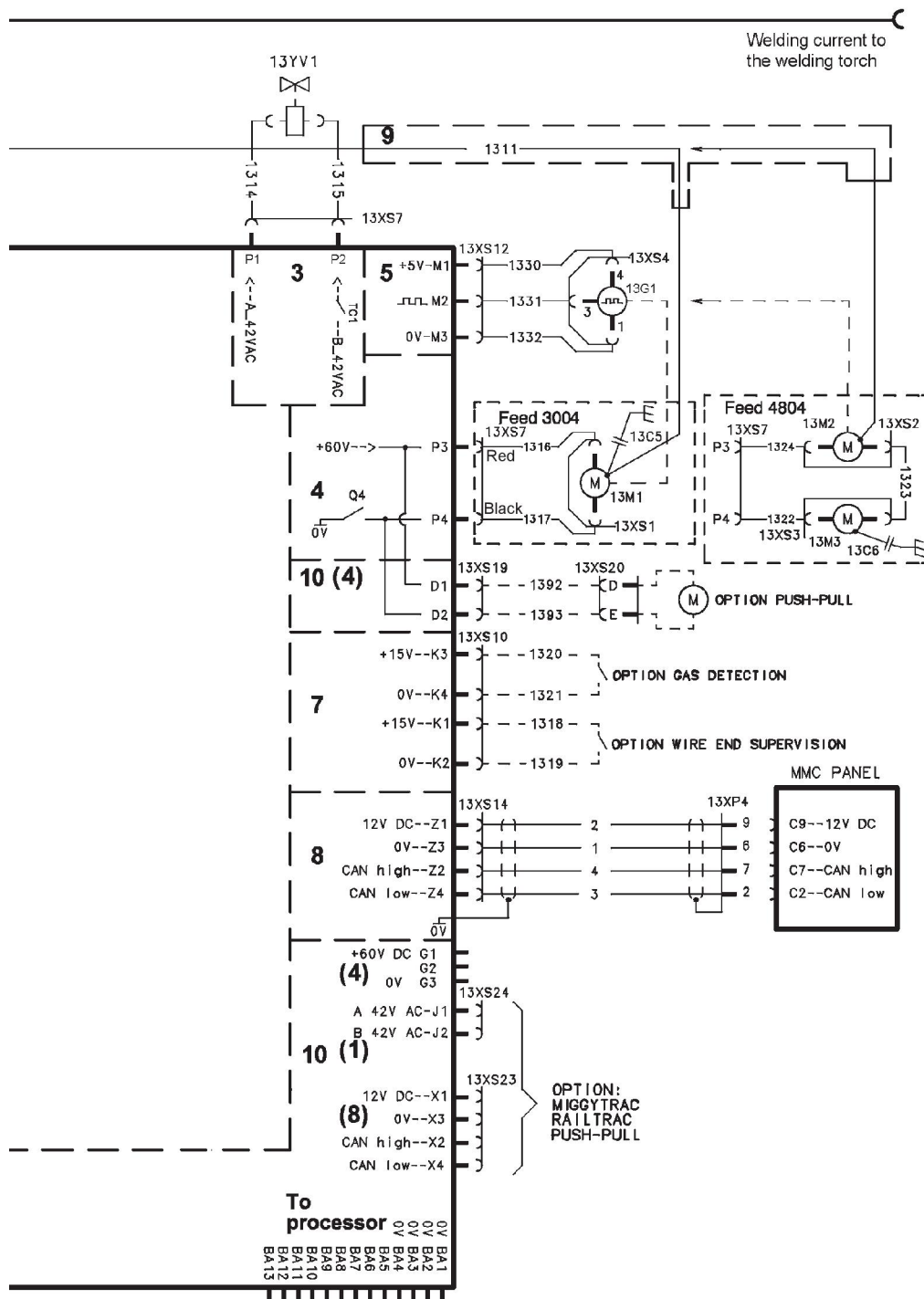
7 ORDERING SPARE PARTS

FEED 3004, Feed 4804 is designed and tested in accordance with the international and European standards IEC/EN 60974-5 and IEC/EN 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see the back cover of this document. 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.

DIAGRAM





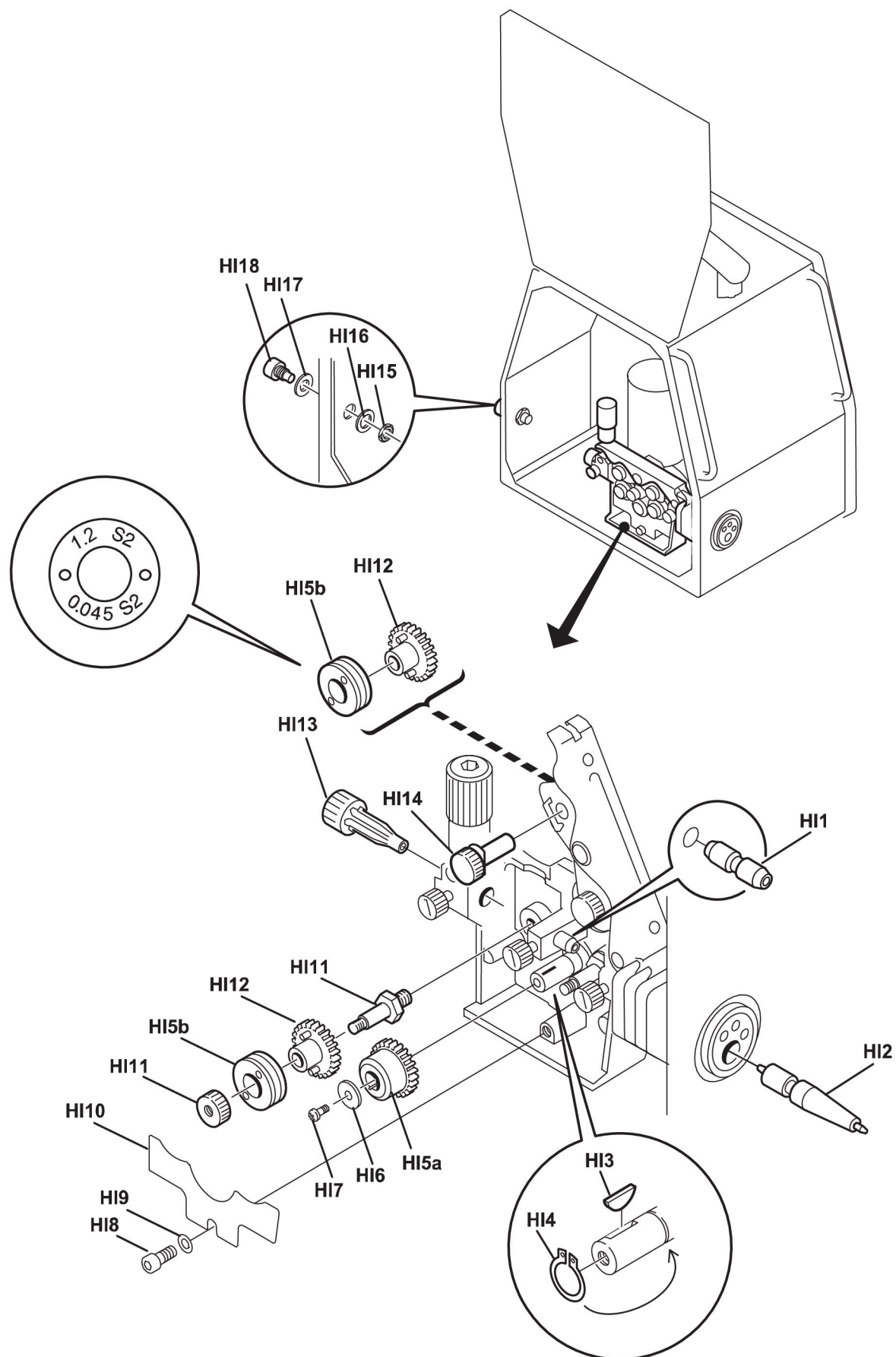
WEAR PARTS

Feed 3004

Item	Ordering no.	Denomination	Notes	Wire type	Wire dimensions
HI1	0455 072 002	Intermediate nozzle		Fe, Ss & cored	
	0456 615 001	Intermediate nozzle		Al	
HI2	0469 837 880	Outlet nozzle		Fe, Ss & cored	Ø 2.0 mm steel for 0.6-1.6 mm
	0469 837 881	Outlet nozzle		Al	Ø 2.0 mm plastic for 0.8-1.6 mm
HI3	0191 496 114	Key			
HI4	0215 701 007	Locking washer			
HI5a	0459 440 001	Motor gear euro	Drive gear		

Item	Ordering number	Denomination	Wire type	Wire dimensions (mm)	Groove type	Roller markings
HI5b	0459 052 001	Feed/pressure rollers	Fe, Ss & cored	Ø 0.6 & 0.8 mm	V	0.6 S2 & 0.8 S2
	0459 052 002	Feed/pressure rollers	Fe, Ss & cored	Ø 0.8 & 1.0 mm	V	0.8 S2 & 1.0 S2
	0459 052 003	Feed/pressure rollers	Fe, Ss & cored	Ø 0.9/1.0 & 1.2 mm	V	1.0 S2 & 1.2 S2
	0459 052 013	Feed/pressure rollers	Fe, Ss & cored	Ø 1.4 & 1.6 mm	V	1.4 S2 & 1.6 S2
	0458 825 001	Feed/pressure rollers	Cored	Ø 0.9/1.0 & 1.2 mm	V-Knurled	1.0 R2 & 1.2 R2
	0458 825 010	Feed/pressure rollers	Cored	Ø 1.2/1.2 mm	V-Knurled	1.2 R2 & 1.4 R2
	0458 825 002	Feed/pressure rollers	Cored	Ø 1.2 & 1.4 mm	V-Knurled	1.2 R2 & 1.2 R2
	0458 825 003	Feed/pressure rollers	Cored	Ø 1.6 mm	V-Knurled	1.6 R2 & 2.0 R2
	0458 824 001	Feed/pressure rollers	Al	Ø 0.8 & 0.9/1.0 mm	U	0.8 A2 & 1.0 A2
	0458 824 002	Feed/pressure rollers	Al	Ø 1.0 & 1.2 mm	U	1.0 A2 & 1.2 A2
	0458 824 003	Feed/pressure rollers	Al	Ø 1.2 & 1.6 mm	U	1.2 A2 & 1.6 A2

Only use pressure and feed rollers marked **A2**, **R2** or **S2**.
The rollers are marked with wire dimension in mm, some are also marked with inch.

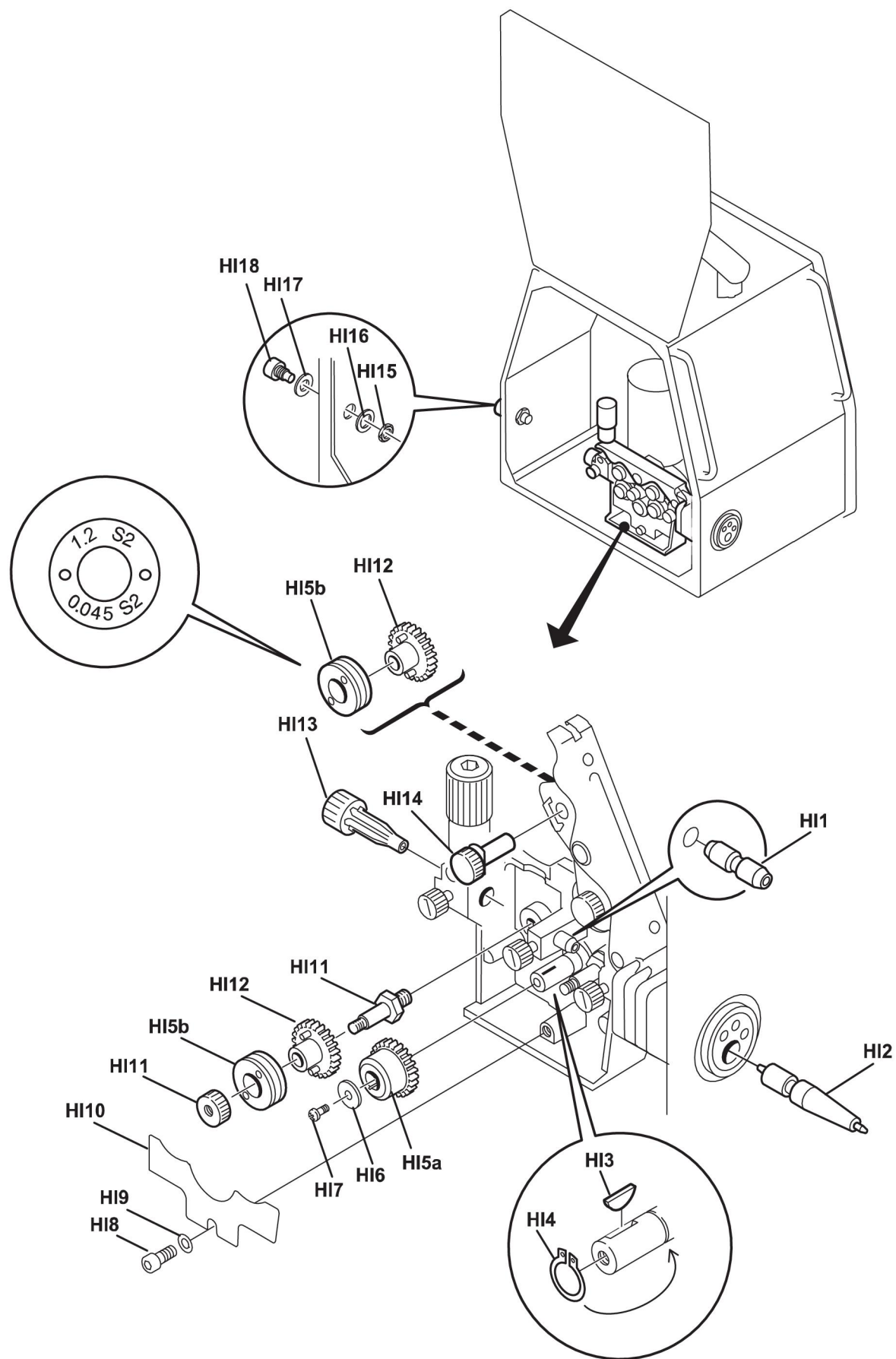


Item	Ordering no.	Denomination	Notes
HI6		Washer	Ø 16/5×1
HI7		Screw	M4×12
HI8		Screw	M6×12
HI9		Washer	Ø 16/8.4×1.5
HI10	0469 838 001	Cover	
HI11	0458 722 880	Axle and Nut	
HI12	0459 441 880	Gear adapter	
HI13	0455 049 001	Inlet nozzle	Ø 3 mm for 0.6-1.6 mm Fe, Ss, Al and cored wire
HI14	0458 999 001	Shaft	
HI15		Nut	M10
HI16	0458 748 002	Insulating washer	
HI17	0458 748 001	Insulating bushing	

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HI18	0156 602 001	Inlet nozzle	Fe, Ss, Al & cored	Ø 2 mm plastic for 0.6–1.6 mm

Welding with aluminium wire

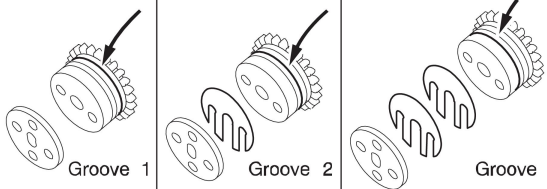
In order to weld with aluminium wire, proper rollers, nozzles and liners for aluminium wire **must** be used, It is recommended to use 3 m long welding torch for aluminium wire, equipped with appropriate wear parts.

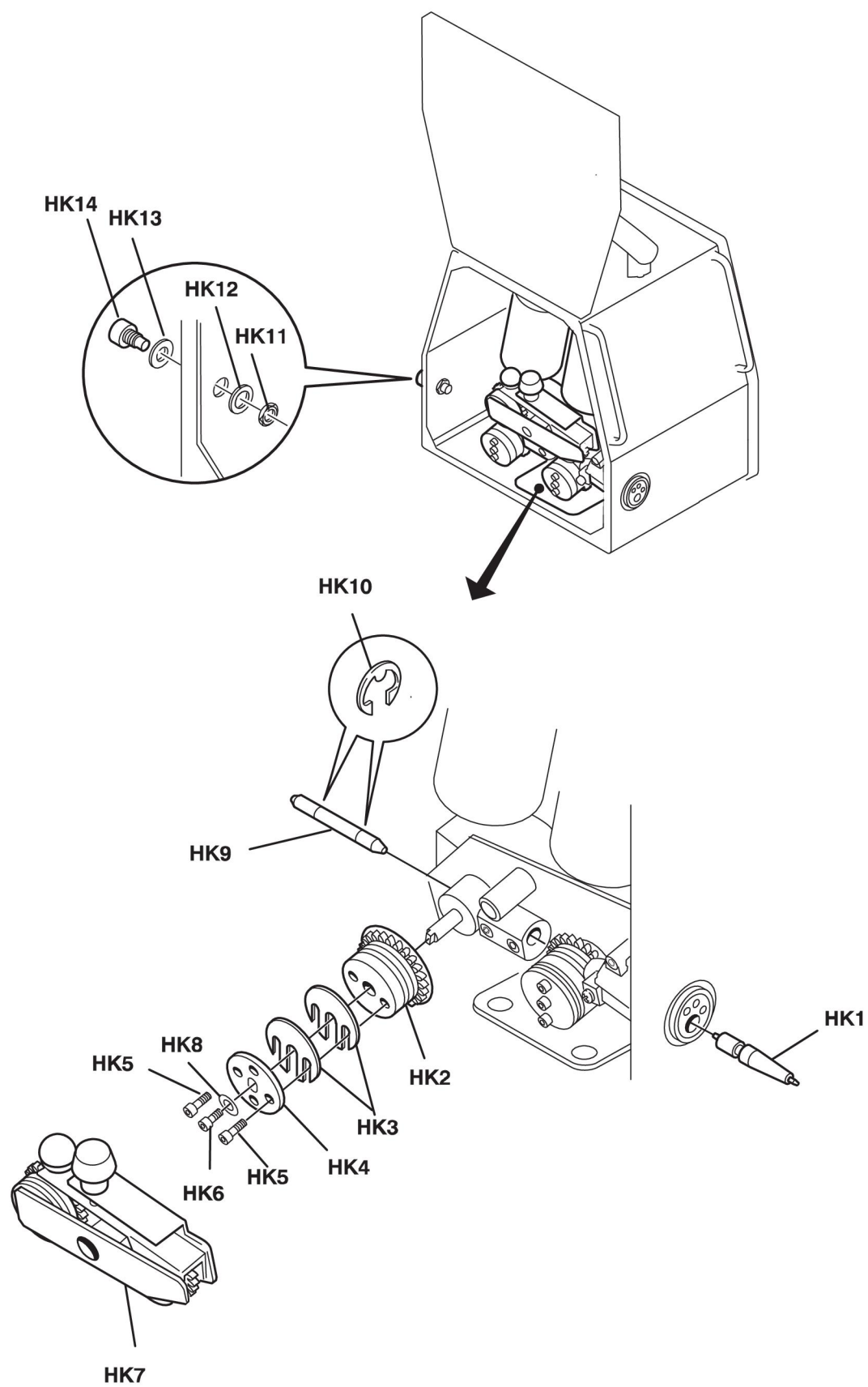


Feed 4804

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HK1	0469 837 880	Outlet nozzle	Fe, Ss & cored	Ø 2.0 mm steel for 0.6-1.6 mm
	0469 837 881	Outlet nozzle	Al	Ø 2.0 mm plastic for 1.0-1.6 mm
	0469 837 882	Outlet nozzle	Fe, Ss & cored	Ø 3.4 mm steel for 2.0-2.4 mm

Item	Ordering no.	Denomination	Wire type	Wire Ø mm	Groove 1	Groove 2	Groove 3	Groove type	Roller/Bogey markings
HK2	0366 966 880	Feed roller	Fe, Ss & cored	0.6-1.2	0.6-0.8	0.9-1.0	1.2	V	1
	0366 966 888	Feed roller	Fe, Ss & cored	0.9	0.9	0.9	0.9	V	.035"
	0366 966 881	Feed roller	Fe, Ss & cored	1.4-1.6	1.4-1.6	2.0	2.4	V	2
	0366 966 890	Feed roller	Fe, Ss & cored	1.6	1.6	1.6	1.6	V	1/16
	0366 966 889	Feed roller	Fe, Ss & cored	1.2	1.2	1.2	1.2	V	.045" / 7
	0366 966 900	Feed roller	Fe, Ss & cored	0.9-1.6	0.9-1.0	1.2	1.4-1.6	V	6
	0366 966 893	Feed roller	Cored	1.2	1.2	1.2	1.2	V-Knurled	.045"
	0366 966 882	Feed roller	Cored	1.2-2.0	1.2	1.4-1.6	2.0	V-Knurled	3
	0366 966 894	Feed roller	Cored	1.6	1.6	1.6	1.6	V-Knurled	1/16
	0366 966 883	Feed roller	Cored	2.4	2.4	not used	not used	V-Knurled	4
	0366 966 885	Feed roller	Al	1.2	1.2	1.2	1.2	U	U2
	0366 966 899	Feed roller	Al	1.0-1.6	1.0	1.2	1.6	U	U4

Item	Ordering no.	Denomination	Notes			
HK3	0156 707 001	Distance washer				
HK4	0156 707 002	Adjustment spacer				
HK5		Screw	M5×20			
HK6		Screw	M5×16			



HD = Heavy Duty

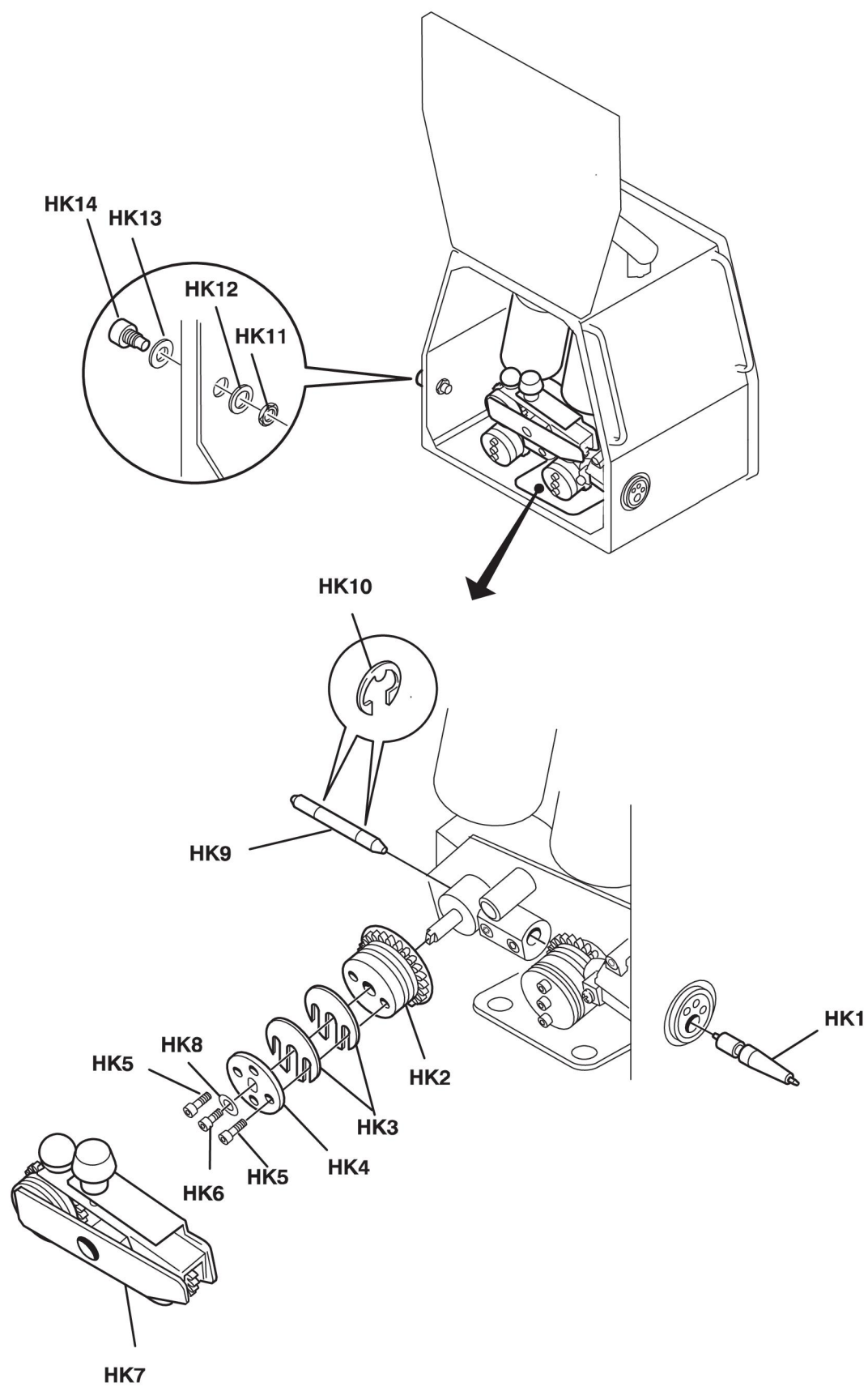
Item	Ordering no.	Denomination	Wire type	Wire dimensions (mm)	Groove type	Roller/Bogey markings
HK7	0366 902 880	Bogey (HD)	Fe, Ss & cored	Ø 0.6 - 1.2 mm	V	1
	0366 902 902	Bogey (HD)	Fe, Ss & cored	Ø 0.9	V	.035"
	0366 902 900	Bogey (HD)	Fe, Ss & cored	Ø 0.9 - 1.6 mm	V	6
	0366 902 881	Bogey (HD)	Fe, Ss & cored	Ø 1.4 - 2.4 mm	V	2
	0366 902 894	Bogey (HD)	Fe, Ss & cored	Ø 1.2 mm	V	.045" / 7
	0366 902 901	Bogey (HD)	Fe, Ss & cored	Ø 1.6 mm	V	1/16
	0366 902 903	Bogey (HD)	Cored	Ø 1.2 mm	V-Knurled	.045"
	0366 902 882	Bogey (HD)	Cored	Ø 1.2 - 2.0 mm	V-Knurled	3
	0366 902 904	Bogey (HD)	Cored	Ø 1.6 mm	V-Knurled	1/16
	0366 902 883	Bogey (HD)	Cored	Ø 2.4 mm	V-Knurled	4
	0366 902 899	Bogey (HD)	Al	Ø 1.0 - 1.6 mm	U	U4
	0366 902 886	Bogey (HD)	Al	Ø 1.2 mm × 3	U	-

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HK8	0366 944 001	Washer		
HK9	0156 603 001	Intermediate nozzle	Fe, Ss & Al	Ø 2 mm plastic for 0.6-1.6 mm
	0156 603 002	Intermediate nozzle	Fe, Ss & Al	Ø 4 mm plastic for 2.0-2.4 mm
	0332 322 001	Intermediate nozzle	Cored	Ø 2.4 mm copper for 1.2-2.0 mm
	0332 322 002	Intermediate nozzle	Cored	Ø 4 mm copper for 2.4 mm

Item	Ordering no.	Denomination	Note
HK10	0215 702 708	Locking washer	
HK11		Nut	M10
HK12	0458 748 002	Insulating washer	
HK13	0458 748 001	Insulating bushing	

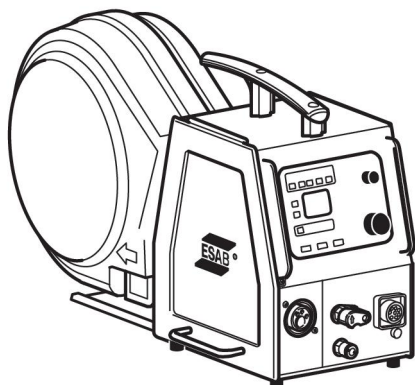
HD = Heavy Duty

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HK14	0156 602 001	Inlet nozzle	Fe, Ss, Al & Cored	Ø 2 mm plastic for 0.6-1.6 mm
	0156 602 002	Inlet nozzle	Fe, Ss, Al & Cored	Ø 4 mm plastic for 2.0-2.4 mm
	0332 318 001	Inlet nozzle (HD)	Fe, Ss & Cored	Ø 2.4 mm steel for 1.2-2.0 mm
	0332 318 002	Inlet nozzle (HD)	Fe, Ss & Cored	Ø 4 mm steel for 2.4 mm



ORDERING NUMBERS

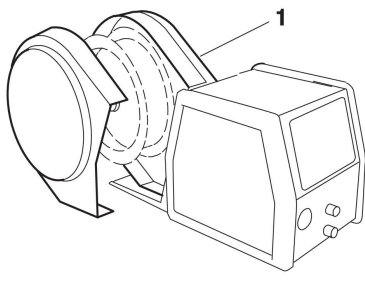
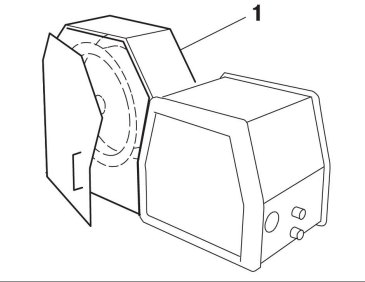
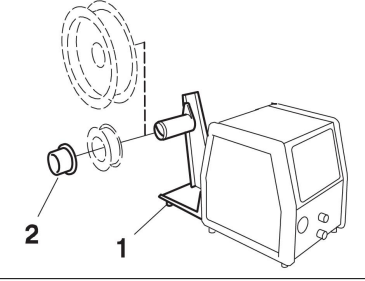
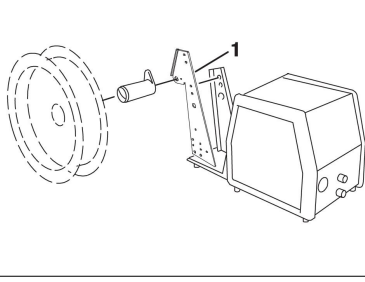
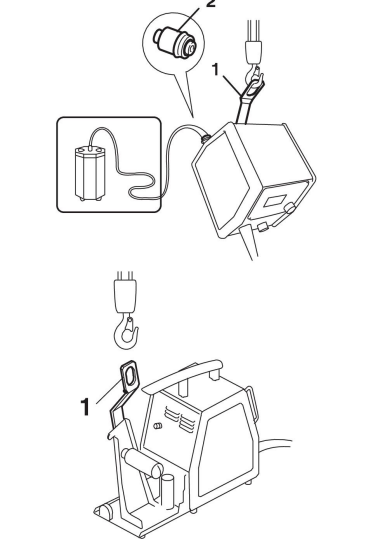
Feed 3004, Feed 4804

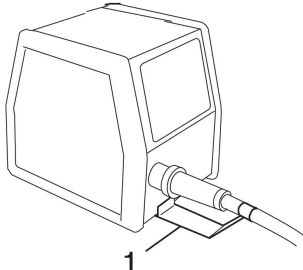
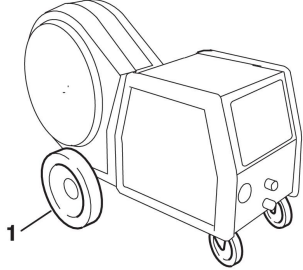
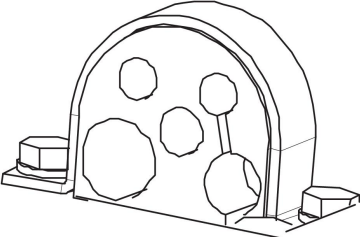
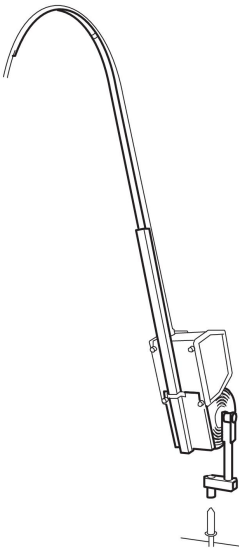



Ordering number	Denomination	Type
0460 526 881	Wire feed unit	Aristo™ Feed 3004
0460 526 886	Wire feed unit	Aristo™ Feed 3004, U6
0460 526 887	Wire feed unit	Origo™ Feed 3004, MA23
0460 526 889	Wire feed unit	Origo™ Feed 3004, MA24
0460 526 891	Wire feed unit with water	Aristo™ Feed 3004
0460 526 896	Wire feed unit with water	Aristo™ Feed 3004, U6
0460 526 897	Wire feed unit with water	Origo™ Feed 3004, MA23
0460 526 899	Wire feed unit with water	Origo™ Feed 3004, MA24
0460 526 991	Wire feed unit with water	Aristo™ Feed 4804
0460 526 996	Wire feed unit with water	Aristo™ Feed 4804, U6
0460 526 997	Wire feed unit with water	Origo™ Feed 4804, MA23
0460 526 999	Wire feed unit with water	Origo™ Feed 4804, MA24
0460 526 670	Wire feed unit	Feed 3004 MA25 Pulse AL
0460 526 671	Wire feed unit with water	Feed 3004w MA25 Pulse AL
0460 526 672	Wire feed unit	Feed 3004 MA25 Pulse Steel
0460 526 673	Wire feed unit with water	Feed 3004w MA25 Pulse Steel
0459 839 017	Spare parts list	Feed 3004, Feed 4804
0460 454	Instruction manual	Origo™ MA23, Origo™ MA24
0463 459	Instruction manual	MA25 Pulse
0459 287	Instruction manual	Aristo™ U6
0459 310	Instruction manual	Aristo™ U8

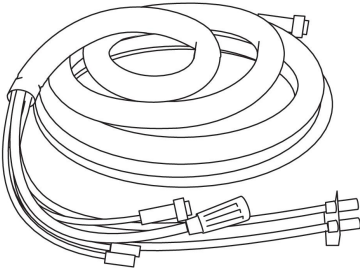
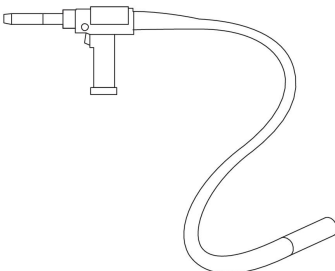
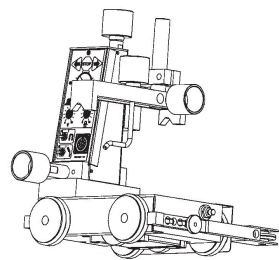
Technical documentation is available on the Internet at: www.esab.com

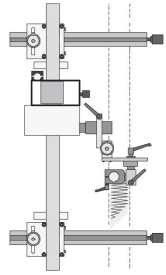

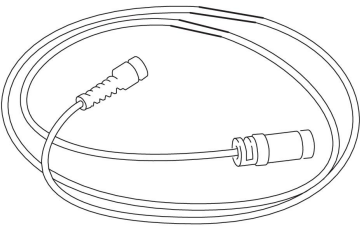
ACCESSORIES

0458 674 880	1 Bobbin cover, plastic 18 kg Ø 300 mm	
0459 431 880	1 Bobbin cover, metal 18 kg Ø 300 mm	
0458 704 880 0455 410 001	1 Bobbin holder 2 Adapter for 5 kg bobbin	
0459 233 880	1 Adapter for 440 mm bobbin	
0458 706 880 F102 440 880	1 Lifting eye 2 Quick connector MarathonPac™	

0457 341 881	1 Strain relief for welding torch	
0458 707 880	1 Wheel kit for feed	
0459 234 880	Strain relief bracket for connection set	
0458 705 880 0458 705 882	Counter balance device (includes mast and counter balance) for 300 mm bobbin for 440 mm bobbin	
0459 491 880	Remote control unit MTA1 CAN MIG/MAG: wire feed speed and voltage MMA: current and arc force TIG: current, pulse and background current	

0459 491 882	Remote control unit M1 10Prog CAN Choice of one of 10 programs MIG/MAG: voltage deviation TIG and MMA: current deviation	
0459 960 880	Remote cable CAN 4 pole - 10 pole 5 m	
0459 960 980	5 m HD Remote cable CAN 4 pole - 12 pole, only for empty panels together with U8	
0459 554 880	5 m	
0459 554 980	5 m HD	
0459 681 880	Remote adapter kit For Miggytrac / Railtrac	
0459 681 881	For MXH 300wPP / MXH 400wPP / PSF RS3	
0459 020 883	Connection kit For MXH 300wPP / MXH 400wPP	

	Connection set, 70 mm² 10 pole cable plug - 10 pole cable socket	
0459 528 780	1.7 m	
0459 528 781	5 m	
0459 528 782	10 m	
0459 528 783	15 m	
0459 528 784	25 m	
0459 528 785	35 m	
	Connection set water, 70 mm² 10 pole cable plug - 10 pole cable socket	
0459 528 790	1.7 m	
0459 528 791	5 m	
0459 528 792	10 m	
0459 528 793	15 m	
0459 528 794	25 m	
0459 528 795	35 m	
	Connection set, 95 mm² 10 pole cable plug - 10 pole cable socket	
0459 528 980	1.7 m	
	Connection set water, 95 mm² 10 pole cable plug - 10 pole cable socket	
0459 528 990	1.7 m	
	Welding torch MXH 300 PP, only for Feed 3004	
0700 200 017	6.0 m	
0700 200 018	10.0 m	
0700 200 020	10.0 m 45°	
	Welding torch MXH 400w PP, only for Feed 3004	
0700 200 015	6.0 m	
0700 200 016	10.0 m	
0700 200 019	10.0 m 45°	
More information at the nearest ESAB agency	Miggytrac 1001, Miggytrac 2000 Equipment for mechanized welding	

More information at the nearest ESAB agency	Railtrac 1000 Equipment for mechanized welding	
0460 820 880 0460 820 881	Control panel U8₂ Control panel U8₂ Plus	
0460 877 891	Extension cable for U8₂ (connectors included) 7.5 m, 12 poles	

Information on Miggytrack and PSF welding torches can be found in separate brochures.

ESAB subsidiaries and representative offices

Europe

AUSTRIA

ESAB Ges.m.b.H
Vienna-Liesing
Tel: +43 1 888 25 11
Fax: +43 1 888 25 11 85

BELGIUM

S.A. ESAB N.V.
Heist-op-den-Berg
Tel: +32 15 25 79 30
Fax: +32 15 25 79 44

BULGARIA

ESAB Kft Representative Office
Sofia
Tel: +359 2 974 42 88
Fax: +359 2 974 42 88

THE CZECH REPUBLIC

ESAB VAMBERK s.r.o.
Vamberk
Tel: +420 2 819 40 885
Fax: +420 2 819 40 120

DENMARK

Aktieselskabet ESAB
Herlev
Tel: +45 36 30 01 11
Fax: +45 36 30 40 03

FINLAND

ESAB Oy
Helsinki
Tel: +358 9 547 761
Fax: +358 9 547 77 71

GREAT BRITAIN

ESAB Group (UK) Ltd
Waltham Cross
Tel: +44 1992 76 85 15
Fax: +44 1992 71 58 03

ESAB Automation Ltd
Andover

Tel: +44 1264 33 22 33
Fax: +44 1264 33 20 74

FRANCE

ESAB France S.A.
Cergy Pontoise
Tel: +33 1 30 75 55 00
Fax: +33 1 30 75 55 24

GERMANY

ESAB Welding & Cutting GmbH
Langenfeld
Tel: +49 2173 3945-0
Fax: +49 2173 3945-218

HUNGARY

ESAB Kft
Budapest
Tel: +36 1 20 44 182
Fax: +36 1 20 44 186

ITALY

ESAB Saldatura S.p.A.
Bareggio (Mi)
Tel: +39 02 97 96 8.1
Fax: +39 02 97 96 87 01

THE NETHERLANDS

ESAB Nederland B.V.
Amersfoort
Tel: +31 33 422 35 55
Fax: +31 33 422 35 44

NORWAY

AS ESAB
Larvik
Tel: +47 33 12 10 00
Fax: +47 33 11 52 03

POLAND

ESAB Sp. z o.o.
Katowice
Tel: +48 32 351 11 00
Fax: +48 32 351 11 20

PORTUGAL

ESAB Lda
Lisbon
Tel: +351 8 310 960
Fax: +351 1 859 1277

ROMANIA

ESAB Romania Trading SRL
Bucharest
Tel: +40 316 900 600
Fax: +40 316 900 601

RUSSIA

LLC ESAB
Moscow
Tel: +7 (495) 663 20 08
Fax: +7 (495) 663 20 09

SLOVAKIA

ESAB Slovakia s.r.o.
Bratislava
Tel: +421 7 44 88 24 26
Fax: +421 7 44 88 87 41

SPAIN

ESAB Ibérica S.A.
San Fernando de Henares
(MADRID)
Tel: +34 91 878 3600
Fax: +34 91 802 3461

SWEDEN

ESAB Sverige AB
Gothenburg
Tel: +46 31 50 95 00
Fax: +46 31 50 92 22

ESAB International AB

Gothenburg
Tel: +46 31 50 90 00
Fax: +46 31 50 93 60

SWITZERLAND

ESAB Europe GmbH
Baar
Tel: +41 1 741 25 25
Fax: +41 1 740 30 55

UKRAINE

ESAB Ukraine LLC
Kiev
Tel: +38 (044) 501 23 24
Fax: +38 (044) 575 21 88

North and South America

ARGENTINA

CONARCO
Buenos Aires
Tel: +54 11 4 753 4039
Fax: +54 11 4 753 6313

BRAZIL

ESAB S.A.
Contagem-MG
Tel: +55 31 2191 4333
Fax: +55 31 2191 4440

CANADA

ESAB Group Canada Inc.
Mississauga, Ontario
Tel: +1 905 670 0220
Fax: +1 905 670 4879

MEXICO

ESAB Mexico S.A.
Monterrey
Tel: +52 8 350 5959
Fax: +52 8 350 7554

USA

ESAB Welding & Cutting
Products
Florence, SC
Tel: +1 843 669 4411
Fax: +1 843 664 5748

Asia/Pacific

AUSTRALIA

ESAB South Pacific
Archerfield BC QLD 4108
Tel: +61 1300 372 228
Fax: +61 7 3711 2328

CHINA

Shanghai ESAB A/P
Shanghai
Tel: +86 21 2326 3000
Fax: +86 21 6566 6622

INDIA

ESAB India Ltd
Calcutta
Tel: +91 33 478 45 17
Fax: +91 33 468 18 80

INDONESIA

P.T. ESABindo Pratama
Jakarta
Tel: +62 21 460 0188
Fax: +62 21 461 2929

JAPAN

ESAB Japan
Tokyo
Tel: +81 45 670 7073
Fax: +81 45 670 7001

MALAYSIA

ESAB (Malaysia) Snd Bhd
USJ
Tel: +603 8023 7835
Fax: +603 8023 0225

SINGAPORE

ESAB Asia/Pacific Pte Ltd
Singapore
Tel: +65 6861 43 22
Fax: +65 6861 31 95

SOUTH KOREA

ESAB SeAH Corporation
Kyungnam
Tel: +82 55 269 8170
Fax: +82 55 289 8864

UNITED ARAB EMIRATES

ESAB Middle East FZE
Dubai
Tel: +971 4 887 21 11
Fax: +971 4 887 22 63

Africa

EGYPT

ESAB Egypt
Dokki-Cairo
Tel: +20 2 390 96 69
Fax: +20 2 393 32 13

SOUTH AFRICA

ESAB Africa Welding & Cutting
Ltd
Durbanvill 7570 - Cape Town
Tel: +27 (0)21 975 8924

Distributors

*For addresses and phone
numbers to our distributors in
other countries, please visit our
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