



# *RobustFeed AVS*



## Instruction manual

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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



### WARNING!

These Safety Precautions are for your protection. They summarize precautionary information from the references listed in the Additional Safety Information section. Before performing any installation or operating procedures, be sure to read and follow the safety precautions listed below as well as all other manuals, material safety data sheets, labels, etc. Failure to observe Safety Precautions can result in injury or death.



### PROTECT YOURSELF AND OTHERS

**Some welding, cutting and gouging processes are noisy and require ear protection. The arc, like the sun, emits ultraviolet (UV) and other radiation and can injure the skin and eyes. Hot metal can cause burns. Training in the proper use of the processes and equipment is essential to prevent accidents. Therefore:**

1. Wear a welding helmet fitted with a proper shade of filter to protect your face and eyes when welding or watching.
2. Always wear safety glasses with side shields in any work area, even if welding helmets, face shields and goggles are also required.
3. Use a face shield fitted with the correct filter and cover plates to protect your eyes, face, neck and ears from sparks and rays of the arc when operating or observing operations. Warn bystanders not to look at the arc and not to expose themselves to the rays of the electric-arc or hot metal.
4. Wear flameproof gauntlet-type gloves, heavy long-sleeve shirt, cuffless pants, high-topped shoes, and a welding helmet or cap for protection, to protect against arc rays and hot sparks or hot metal. A flameproof apron may also be desirable as protection against radiated heat and sparks.
5. Hot sparks or metal can lodge in rolled up sleeves, trouser cuffs, or pockets. Sleeves and collars should be kept buttoned and open pockets eliminated from the front of the clothing.



6. Protect other personnel from arc rays and hot sparks with a suitable non-flammable partition or curtains.
7. Use goggles over safety glasses when chipping slag or grinding. Chipped slag may be hot and can fly for long distances. Bystanders should also wear goggles over safety glasses.



### **FIRES AND EXPLOSIONS**

**Heat from flames and arcs can start fires. Hot slag or sparks can also cause fires and explosions. Therefore:**

1. Protect yourself and others from flying sparks and hot metal.
2. Move all combustible materials well away from the work area or cover the materials with a protective non-flammable covering. Combustible materials include wood, cloth, sawdust, liquid and gas fuels, solvents, paints, and coating paper, etc.
3. Hot sparks or hot metal can fall through cracks or crevices in floors or wall openings and cause a hidden smoldering fire or fires on the floor below. Make certain that such openings are protected from hot sparks and metal.
4. Do not weld, cut, or perform other hot work until the work piece has been completely cleaned so that there are no substances on the work piece which might produce flammable or toxic vapors. Do not perform hot work on closed containers, they may explode.
5. Have fire extinguishing equipment handy for instant use, such as a garden hose, water pail, sand bucket, or portable fire extinguisher. Be sure you are trained in its use.
6. Do not use equipment beyond its ratings. For example, an overloaded welding cable can overheat and create a fire hazard.
7. After completing work, inspect the work area to make sure there are no hot sparks or hot metal that could cause a fire later. Use fire watchers when necessary.



### **ELECTRICAL SHOCK**

**Contact with live electrical parts and ground can cause severe injury or death. DO NOT use AC welding current in damp areas, if movement is confined, or if there is danger of falling. Therefore:**

1. Be sure the power source frame (chassis) is connected to the earth system of the input power.
2. Connect the workpiece to a good electrical earth.
3. Connect the work cable to the workpiece. A poor or missing connection can expose you or others to a fatal shock.
4. Use well-maintained equipment. Replace worn or damaged cables.
5. Keep everything dry, including clothing, work area, cables, torch/electrode holder and power source.
6. Make sure that all parts of your body are insulated from both the work piece and from the ground.
7. Do not stand directly on metal or the ground while working in tight quarters or a damp area; stand on dry boards or an insulating platform and wear rubber-soled shoes.
8. Put on dry, hole-free gloves before turning on the power.
9. Turn off the power, before removing your gloves.
10. Refer to ANSI/ASC Standard Z49.1 for specific grounding recommendations. Do not mistake the work lead for a earth cable.



### ELECTRIC AND MAGNETIC FIELDS

**May be dangerous. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding and cutting current creates EMF around welding cables and welding machines. Therefore:**

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



### FUMES AND GASES

**Fumes and gases, can cause discomfort or harm, particularly in confined spaces. Shielding gases can cause asphyxiation. Therefore:**

1. Keep your head out of the fumes. Do not breathe the fumes and gases.
2. Always provide adequate ventilation in the work area by natural or mechanical means. Do not weld, cut or gouge on materials such as galvanized steel, stainless steel, copper, zinc, lead beryllium or cadmium unless positive mechanical ventilation is provided. Do not breathe in the fumes from these materials.
3. Do not operate near degreasing and spraying operations. The heat or arc can react with chlorinated hydrocarbon vapors to form phosgene, a highly toxic gas, and other irritant gases.
4. If you develop momentary eye, nose or throat irritation while operating, this is an indication that the ventilation is not adequate. Stop work and take the necessary steps to improve ventilation in the work area. Do not continue to operate if physical discomfort persists.
5. Refer to ANSI/ASC Standard Z49.1 for specific ventilation recommendations.
6. **WARNING:** This product when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and in some cases cancer (California Health & Safety Code §25249.5 et seq.)



### CYLINDER HANDLING

**Cylinders, if mishandled, can rupture and violently release gas. A sudden rupture of cylinder valve or relief device can injure or kill. Therefore:**

1. Locate cylinders away from heat, sparks and flames. Never strike an arc on a cylinder.
2. Use the proper gas for the process and use the proper pressure reducing regulator designed to operate from the compressed gas cylinder. Do not use adapters. Maintain hoses and fittings in good condition. Follow the manufacturer's operating instructions for mounting a regulator to a compressed gas cylinder.
3. Always secure cylinders in an upright position, by chain or strap, to suitable hand trucks, undercarriages, benches, wall, post or racks. Never secure cylinders to work tables or fixtures where they may become part of an electrical circuit.
4. When not in use, keep cylinder valves closed. Have valve protection cap in place if regulator is not connected. Secure and move cylinders by using suitable hand trucks.



### MOVING PARTS

**Moving parts, such as fans, rotors and belts can cause injury. Therefore:**

1. Keep all doors, panels, guards, and covers closed and securely in place.
2. Stop the engine or drive systems before installing or connecting a unit.
3. Have only qualified people remove covers for maintenance and troubleshooting as necessary
4. To prevent accidental starting of equipment during service, disconnect negative (-) battery cable from battery.
5. Keep hands, hair, loose clothing and tools away from moving parts.
6. Reinstall panels or covers and close doors when service is finished and before starting engine.



### **WARNING! FALLING EQUIPMENT CAN INJURE**

- Only use lifting eye to lift unit. Do NOT use running gear, gas cylinders or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Keep cables and cords away from moving vehicles when working from an aerial location.



### **WARNING! EQUIPMENT MAINTENANCE**

**Faulty or improperly maintained equipment can cause injury or death. Therefore:**

1. Always have qualified personnel perform the installation, troubleshooting and maintenance work. Do not perform any electrical work unless you are qualified to perform such work.
2. Before performing any maintenance work inside a power source, disconnect the power source from the incoming electrical power.
3. Maintain cables, earthing wire, connections, power cord and power supply in safe working order. Do not operate any equipment in faulty condition.
4. Do not abuse any equipment or accessories. Keep equipment away from heat sources such as furnaces, wet conditions such as water puddles, oil or grease, corrosive atmospheres and inclement weather.
5. Keep all safety devices and cabinet covers in position and in good repair.
6. Use equipment only for its intended purpose. Do not modify it in any manner.

**CAUTION!  
ADDITIONAL SAFETY INFORMATION**

**For more information on safe practices for electric arc welding and cutting equipment, ask your supplier for a copy of “Precautions and Safe Practices for Arc Welding, Cutting and Gouging,” Form 52-529.**

The following publications are recommended:

- ANSI/ASC Z49.1 - “Safety in Welding and Cutting”
- AWS C5.5 - “Recommended Practices for Gas Tungsten Arc Welding”
- AWS C5.6 - “Recommended Practices for Gas Metal Arc welding”
- AWS SP - “Safe practices” - Reprint, Welding Handbook
- ANSI/AWS F4.1 - “Recommended Safe Practices for Welding and Cutting of Containers That Have Held Hazardous Substances”
- OSHA 29 CFR 1910 - "Safety and health standards"
- CSA W117.2 - "Code for safety in welding and cutting"
- NFPA Standard 51B, “Fire Prevention During Welding, Cutting, and Other Hot Work”
- CGA Standard P-1, “Precautions for Safe Handling of Compressed Gases in Cylinders”
- ANSI Z87.1, "Occupational and Educational Personal Eye and Face Protection Devices"

### 1.3 User responsibility

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 could result in injury to the operator and damage to the equipment.

1. Anyone who uses the equipment must be familiar with:
  - its operation
  - the location of emergency stops
  - its function
  - the relevant safety precautions
  - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
  - no unauthorized person is 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

**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.

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



**WARNING!**

Arc welding and cutting may cause injury 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 with pacemakers fitted should consult their doctor 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 the 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 ear defenders 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 a fire. Therefore, make sure 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.

**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.**

## 1.4 California proposition 65 warning



**WARNING!**

Welding or cutting equipment produces fumes or gases which contain chemicals known in the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)



**WARNING!**

This product can expose you to chemicals including lead, which are known to the state of California to cause cancer and birth defects or other reproductive harm. Wash hands after use.

For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

## 2 INTRODUCTION

The RobustFeed AVS (Arc Voltage Sensing) is a portable wire feeder. The unit is powered entirely on the arc voltage from a constant current (CC) or constant voltage (CV) welding power source. It operates with reversed polarity (Direct Current Electrode Positive - DCEP) or straight polarity (Direct Current Electrode Negative - DCEN).

The wire feed unit comes in different versions (see the "ORDERING NUMBERS" appendix).

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

It can be used together with standard Ø 200 mm and Ø 300 mm wire bobbin or with ESAB's Marathon Pac™ with a wire adapter to feed the wire.

The wire feed unit can be placed on a trolley, suspended above the workplace or on the floor (standing up or laying down and with or without a wheel set).

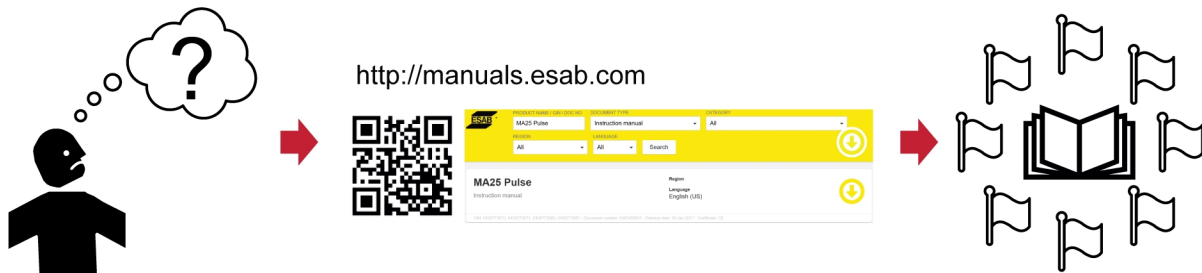
**ESAB accessories for the product can be found in the "ACCESSORIES" chapter of this manual.**

### 2.1 Equipment

The wire feed unit is supplied with:

- Instruction manual
- Drive rolls: 0.9/1.0 mm (0.040 in.) / 1.2 mm (0.045 in.)
- Wire guides: 0.6–1.6 mm (0.023–1/16 in.)
- Voltage pick up cable with clamp

Instruction manuals in other languages can be downloaded from the Internet: [manuals.esab.com](http://manuals.esab.com)



## 3 TECHNICAL DATA

RobustFeed AVS, Valid from serial no. OP139YY-XXXXXX	
<b>Power Supply voltage</b>	15-100 VDC
<b>Maximum weld voltage</b>	45 VDC
<b>Power requirement</b>	194 VA
<b>Rated supply current I<sub>1</sub></b>	4.3 A
<b>Settings data:</b>	
Wire feed speed	32–984 in./min (0.8–25.0 m/min)
Torch connection	EURO, Tweco 4
<b>Max. diameter wire bobbin</b>	12 in. (300 mm)
<b>Wire dimension:</b>	
Fe	0.6 - 2 mm (0.023 - 0.078 in.)
SS wire	0.6 - 1.6 mm (0.023 - 0.062 in.)
Cored wire	0.9 - 2.4 mm (0.035 - 0.093 in.)
<b>Weight</b>	
RobustFeed AVS CSA, W/O flowmeter with Tweco connector	40.1 lb (18.2 kg)
RobustFeed AVS CSA, with flowmeter with Tweco connector	40.5 lb (18.4 kg)
<b>Maximum weight wire spool</b>	44.1 lb. (20.0 kg)
<b>Dimensions (l×w×h) RobustFeed AVS</b>	23.4×9.8×16.9 in. (595×250×430 mm)
<b>Operating temperature</b>	-4 to +131 °F (-20 to +55 °C)
<b>Transport and storage temperature</b>	-40 to +176 °F (-40 to +80 °C)
<b>Shielding gas</b>	All types intended for MIG/MAG welding
<b>Maximum gas pressure</b>	5 bar (0.5 MPa)
<b>Permissible load at +40°C:</b>	
40% duty cycle	500 A / 39 V
60% duty cycle	450 A / 36 V
100% duty cycle	350 A / 31.5 V
<b>Enclosure class</b>	IP44



## 4 INSTALLATION

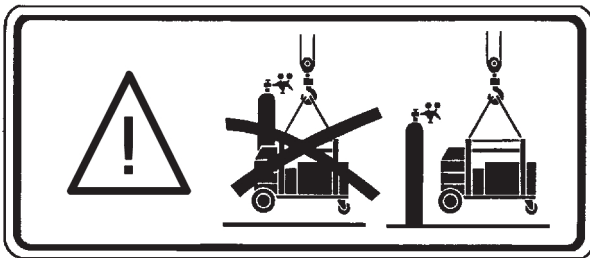
The installation must be carried out by a professional.

**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

**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.



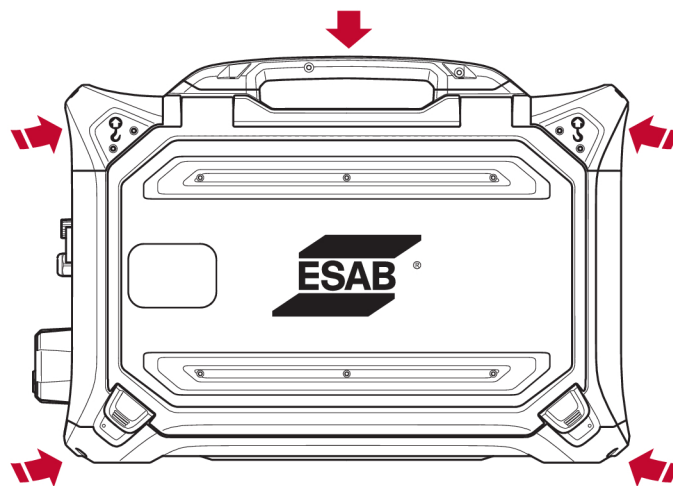
### 4.1 Lifting instructions

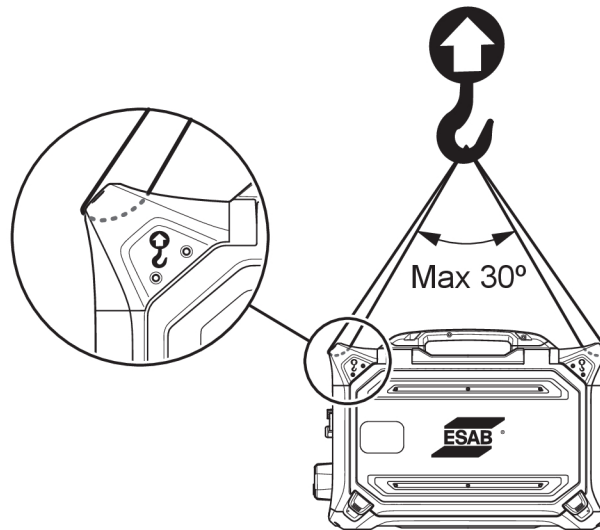
**CAUTION!**

Risk of crushing when lifting the wire feeder. Protect yourself and warn bystanders of the risk.

**CAUTION!**

To avoid personal injury and damage to the equipment, lift using the methods and attachment points detailed below.





**CAUTION!**

Do not place heavy objects on the wire feeder when lifting. Objects should not be secured. The lifting points are rated for a **maximum total weight of 90 lb / 40 kg** when lifted in the two outer upper lifting handles according to the graphic above!

The 90 lb / 40 kg approved weight consists of wire feeder plus accessories (standard feeder weight is 40.5 lb / 18.4 kg, for all weights see the TECHNICAL DATA chapter).

## 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!



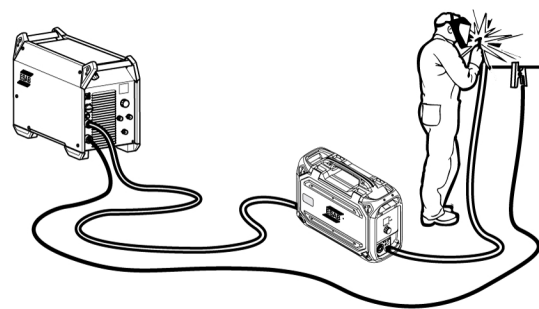
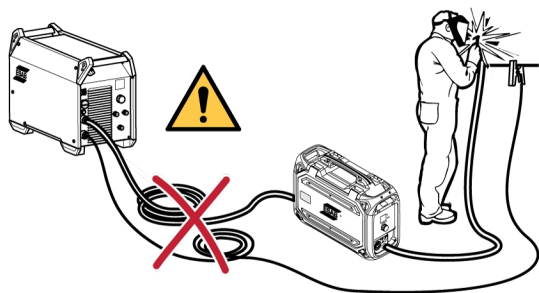
### WARNING!

To avoid shock, do not touch the electrode wire or parts in contact with it, or uninsulated cable or connections.



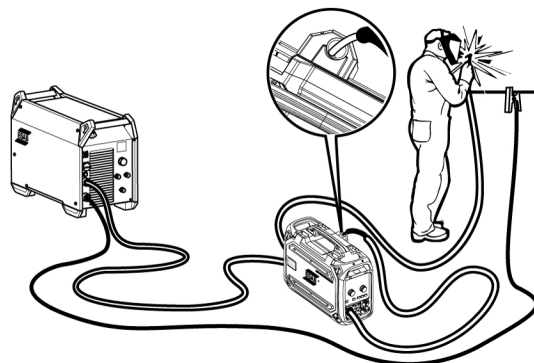
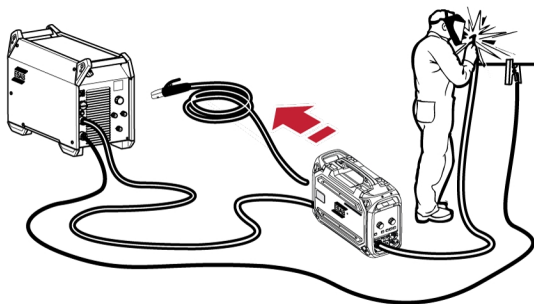
### NOTE!

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



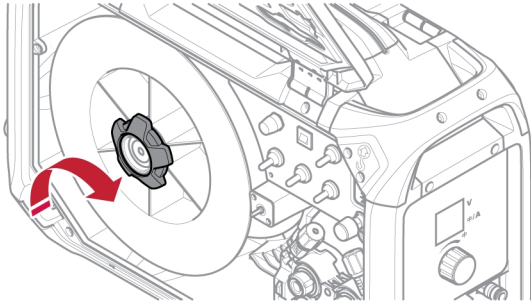
### WARNING!

Wire feeders are intended to be used with power sources in GMAW and SMAW mode. If used in GMAW, the SMAW holder must be disconnected from the wire feeder and the OKC must be covered. If used in SMAW, the GMAW torch must be isolated or kept in the torch holder if available, or else the torch/holder becomes live or energized.



### WARNING!

Make sure the side panels are closed during operation.



**WARNING!**

To prevent the reel from sliding off the brake hub, lock the reel in place by tightening the brake hub nut.



**NOTE!**

Replace the brake hub nut and the brake hub sleeve if they are worn out and don't lock properly.



**CAUTION!**

Before threading welding wire, make sure the chisel point and burrs have been removed from the end of the wire to prevent the wire from jamming in the torch liner.



**WARNING!**

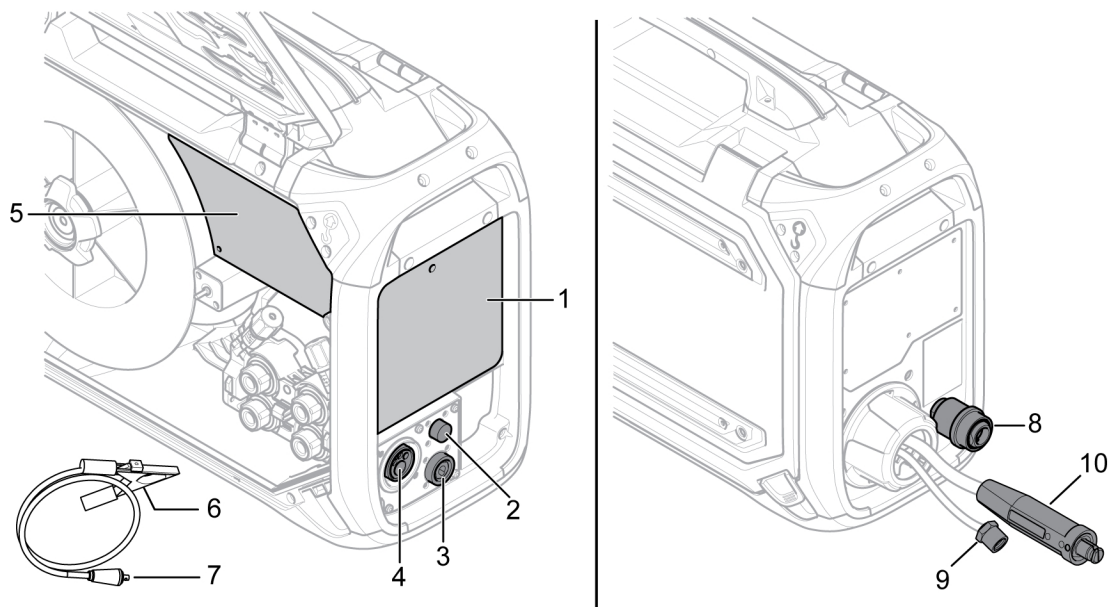
Rotating parts can cause injury, take great care.



**WARNING!**

Secure the equipment, especially if used on an uneven or sloping surface.

## 5.1 Connections and control devices



- |  |  |
|--|--|
| 1. External control panel (see the "CONTROL PANEL" chapter)                      | 6. Connection for workpiece                                |
| 2. Connection for the Tweco trigger cable (only in combination with Tweco torch) | 7. Connection for feeder (3)                               |
| 3. Connection for Work lead / Voltage pick-up                                    | 8. Wire inlet for use with Marathon Pac™ (optional)        |
| 4. Connection for the welding torch (Euro or Tweco type)                         | 9. Connection for shielding gas                            |
| 5. Internal control panel (see the "CONTROL PANEL" chapter)                      | 10. Connection for welding current from power source (OKC) |



### WARNING!

The right and left side doors of the wire feed unit must be closed and locked when welding and/or wire feeding occurs. Never weld or feed the wire unless both doors are closed.

## 5.2 Starting procedure

- 1) For Constant Voltage (CV) set the desired arc voltage on the power source.
- 2) For Constant Current (CC) set the desired weld current on the power source.
- 3) On the RobustFeed AVS, set the desired wire feed speed with the knob for the wire feed speed and use the values shown by the display as guidance. A feeder in CV mode will deliver the actual wire feed speed / welding current while welding. A feeder in CC mode will deliver a wire feed speed that varies with changes in arc voltage. When not welding, the display will show what the wire feed speed will be at the displayed voltage.

For more information see section "Control panel".

## 5.3 Lighting inside the wire feed unit

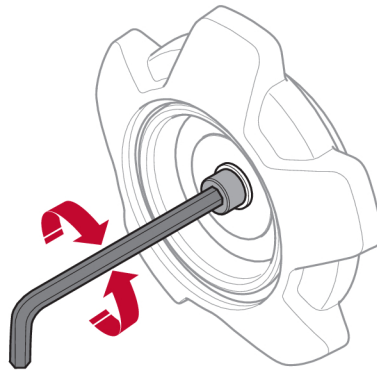
Lights are fitted inside the cabinet of the wire feed unit. The light located by the wire bobbin turns on automatically when welding starts or when the left side door is opened. The light is automatically turned off 4 minutes after welding has stopped or the side door has been closed. The light located by the feeder mechanism turns on automatically when the left side door is opened and turns off when the door is closed again. The lights automatically switch on when the feeder is started, when any of the parameters on the internal control panel are changed, when wire inching is performed and after welding tasks. The lights automatically switch off after a few minutes.

## 5.4 Bobbin brake

The bobbin brake force should be increased just enough to prevent wire feed overrun. The actual brake force required depends on the wire feed speed and the size and weight of the bobbin spool.

Do not overload the bobbin brake. If the brake force is too high, it may overload the motor, resulting in a lower-quality welding result.

The bobbin brake force is adjusted using the 0.236 in. (6 mm) hexagon Allen screw in the middle of the brake hub nut.



## 5.5 Changing and loading wire

- 1) Open the left door of the wire feeder.
- 2) Untighten and remove the brake hub nut and remove the old wire spool.
- 3) Insert a new wire spool into the feeder unit and straighten out the new welding wire 3.94–7.87 in. (10–20 cm). File away burrs and sharp edges from the end of the wire before inserting it into the feeder mechanism.
- 4) Lock the wire spool onto the brake hub by tightening the brake hub nut.
- 5) Thread the wire through the feeder mechanism (according to the illustration on the inside of the feeder unit).



### NOTE!

Replace the brake hub nut and the brake hub sleeve if they are worn out and do not lock properly.

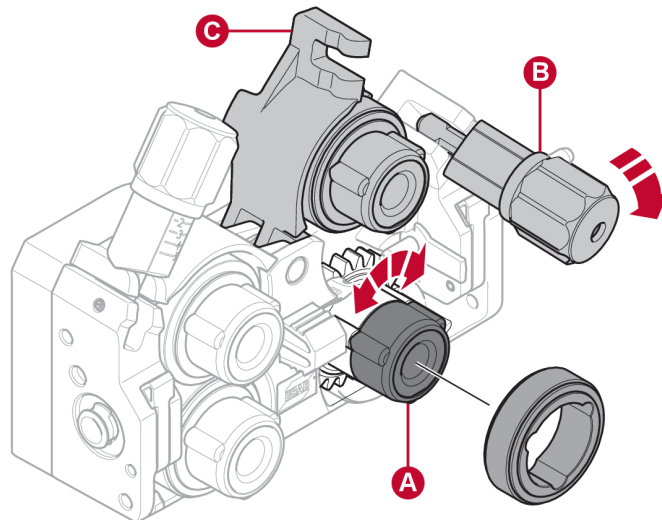
- 6) Close and lock the left door of the wire feeder

## 5.6 Changing feed rollers

When changing to a different type of wire, the feed rollers should also be changed to match the new type of wire. For more information about correct feed rollers depending on wire diameter and type, see the WEAR PARTS appendix. For tips about easy access to essential wear parts, see the "Wear parts storage compartment" section in this manual.

- 1) Open the left door of the wire feeder.
- 2) Unlock the feed rollers to be exchanged, by rotating the roller quick lock (A) for each roller.

- 3) Relieve the pressure on the feed rollers, by folding the tensioner units (B) down and thereby releasing the swing arms (C).

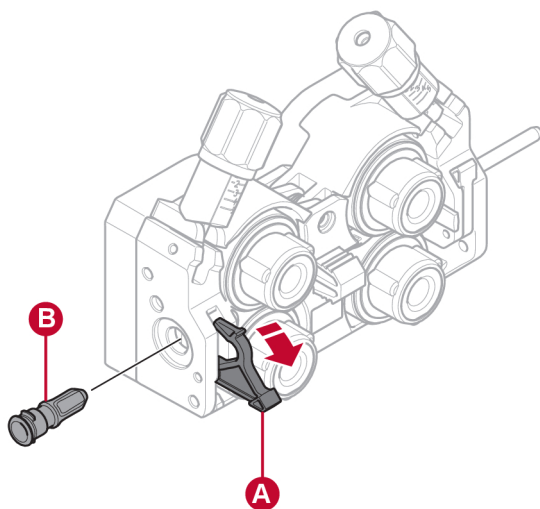


- 4) Remove the feed rollers and install the correct ones (according to the WEAR PARTS appendix).
- 5) Reapply the pressure on the feed rollers, by pushing the swing arms (C) down and secure them using the tensioner units (B).
- 6) Lock the rollers by rotating the roller quick locks (A).
- 7) Close and lock the left door of the wire feeder.

## 5.7 Changing the wire guides

When changing to a different type of wire, the wire guides may need to be changed to match the new type of wire. For information about the correct wire guides depending on wire diameter and type, see the "WEAR PARTS" appendix. (For a tip to easy access to necessary wear parts, see the "Wear parts storage compartment" section in this manual.)

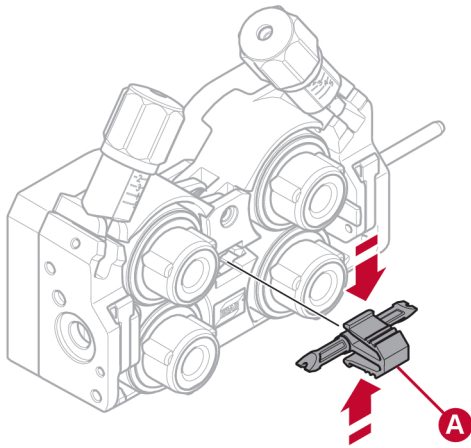
### 5.7.1 Inlet wire guide



- 1) Unlock the inlet wire guide quick lock (A) by folding it out.
- 2) Remove the inlet wire guide (B).
- 3) Fit the correct inlet wire guide (according to the WEAR PARTS appendix).

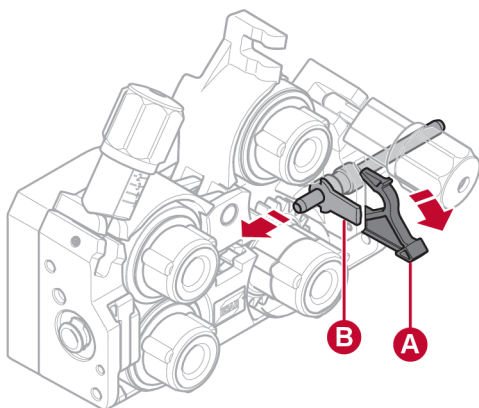
- 4) Lock the new inlet wire guide into place using the wire guide quick lock (A).

### 5.7.2 Middle wire guide



- 1) Apply a small amount of pressure to the middle wire guide clip and remove the middle wire guide (A).
- 2) Push in the correct type of wire guide (according to the WEAR PARTS appendix). The clip automatically locks the wire guide when in the correct position.

### 5.7.3 Outlet wire guide



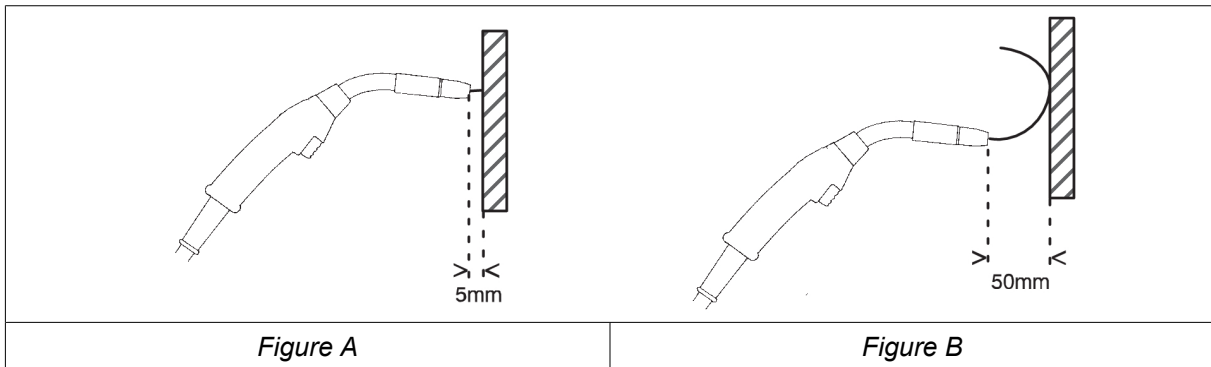
- 1) Remove the lower right feed roller (see the "Changing feed rollers" section).
- 2) Remove the middle wire guide (see the "Middle wire guide" section).
- 3) Unlock the outlet wire guide quick lock (A) by folding it out.
- 4) Remove the outlet wire guide (B).
- 5) Install the correct outlet wire guide (according to the WEAR PARTS appendix).
- 6) Lock the new outlet wire guide into place using the wire guide quick lock (A).
- 7) Reattach the second pair of feed rollers and reapply the roller pressure (see the "Changing feed rollers" section).



## 5.8 Roller pressure

The roller pressure should be adjusted separately on each tensioner unit, depending on the material and diameter of the wire used.

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 high.



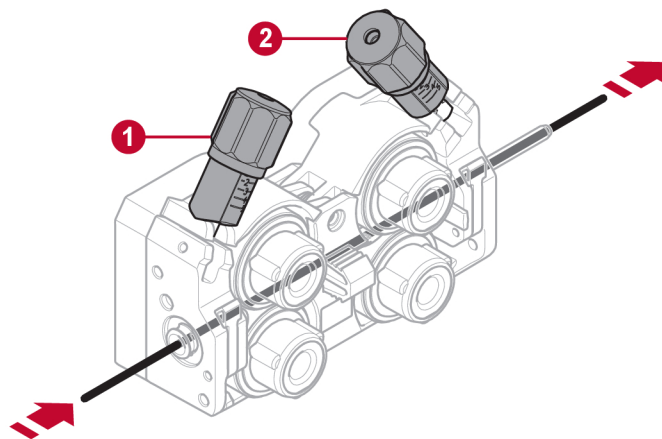
To check that the feed pressure is set correctly, you can feed out the wire against an insulated object, e.g. a piece of wood.

When you hold the welding torch approximately 0.197 in. (5 mm) from the piece of wood (figure A) the feed rollers should slip.

If you hold the welding torch approximately 0.969 in. (50 mm) from the piece of wood, the wire should feed out and bend (figure B).

The table below serves as a guideline showing approximate roller pressure settings for standard conditions with correct bobbin brake force. If the torch cables are long, dirty or worn, the pressure setting may need to be increased. Always check the roller pressure setting on a case-by-case basis by feeding out the wire against an insulated object as described above. A table showing approximate settings can also be found on the inside of the left door of the wire feeder.

		Wire diameter (in.) (mm)	.023 0.6	.030 0.8	.070 1.8	5/64 2.0	3/32 2.4
			<b>Pressure setting</b>				
<b>Wire material</b>	Fe, Ss	Tensioner unit 1	2.5				
		Tensioner unit 2	3–3.5				
	Cored	Tensioner unit 1			2		
		Tensioner unit 2			2.5–3		

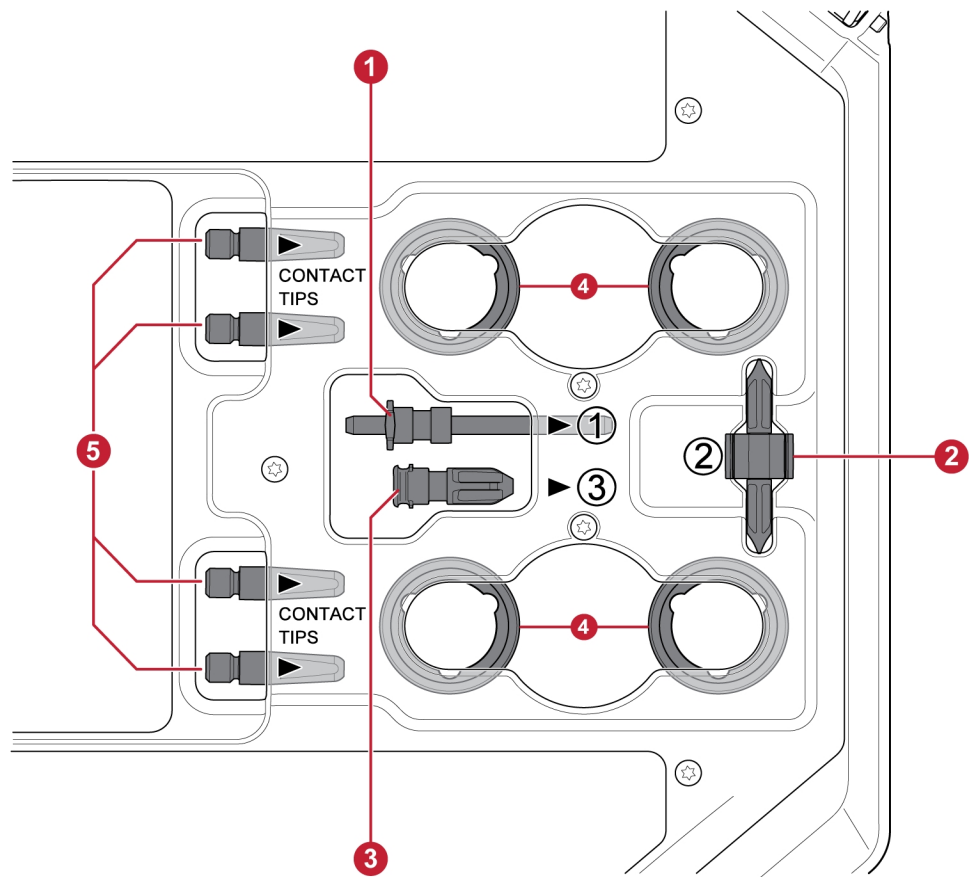


1. Tensioner unit 1

2. Tensioner unit 2

## 5.9 Wear parts storage compartment

A wear parts storage compartment is located on the inside of the left door of the wire feeder, providing easy access to an extra set of rollers and wire guides.



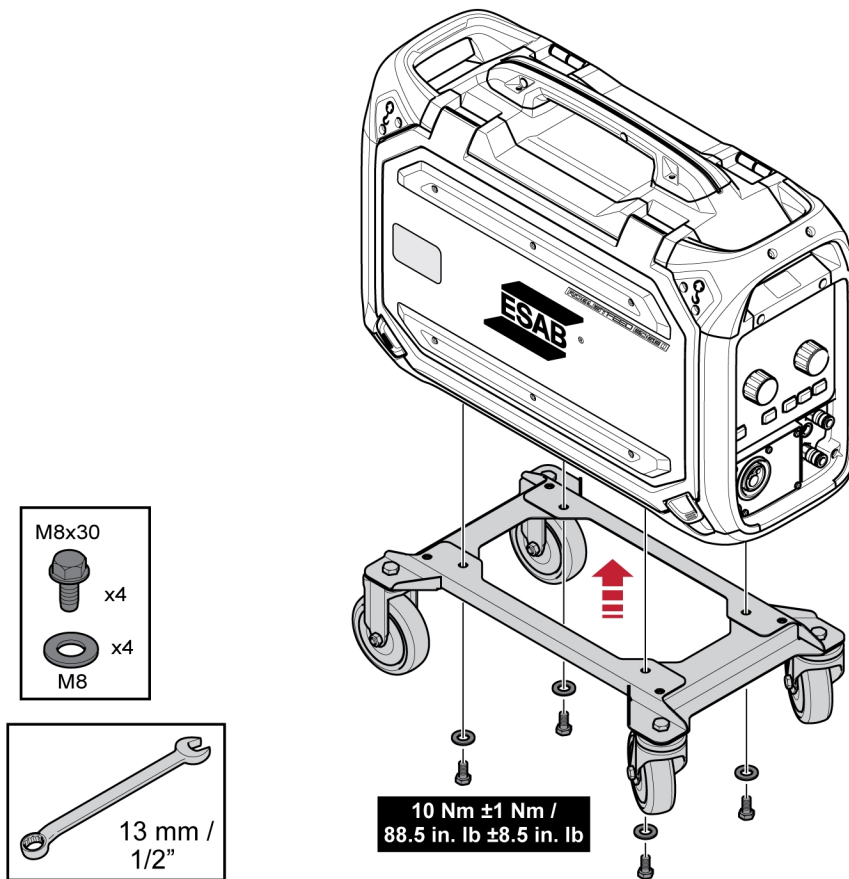
- |                      |   |
|----------------------|---|
| 1. Inlet wire guide  | 4. Feed rollers (×4 pcs.)                       |
| 2. Middle wire guide | 5. Contact tips for the welding torch (×4 pcs.) |
| 3. Outlet wire guide |   |

## 5.10 Attaching the wheel kit

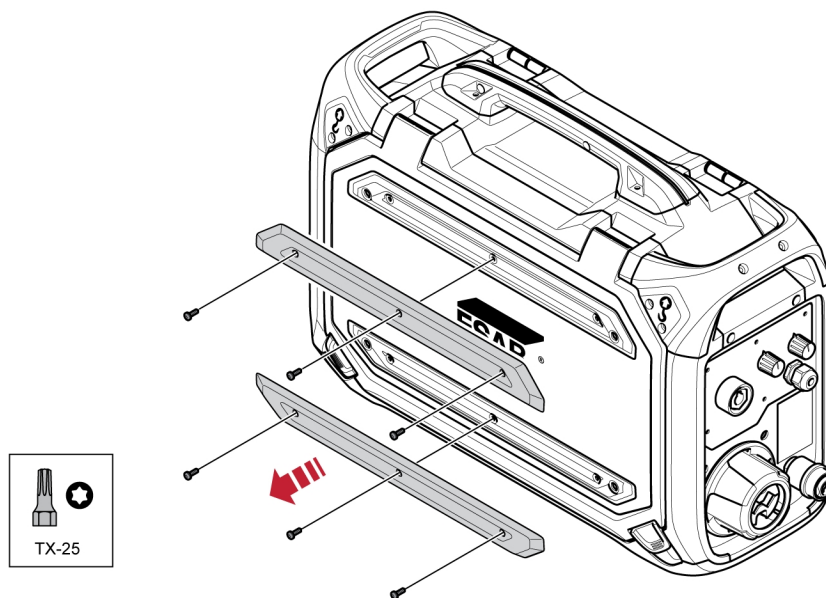
### 5.10.1 Attaching the wheels to the wheel kit frame

Before attaching the wire feed unit to the wheel kit, fasten the wheels to the frame by means of the M12 screws, washers and nuts, using a tightening torque of  $354 \pm 35.4$  in. lb ( $40 \pm 4$  Nm). The fixed wheels at the rear end should be positioned parallel to the frame.

### 5.10.2 Wire feed unit in vertical position

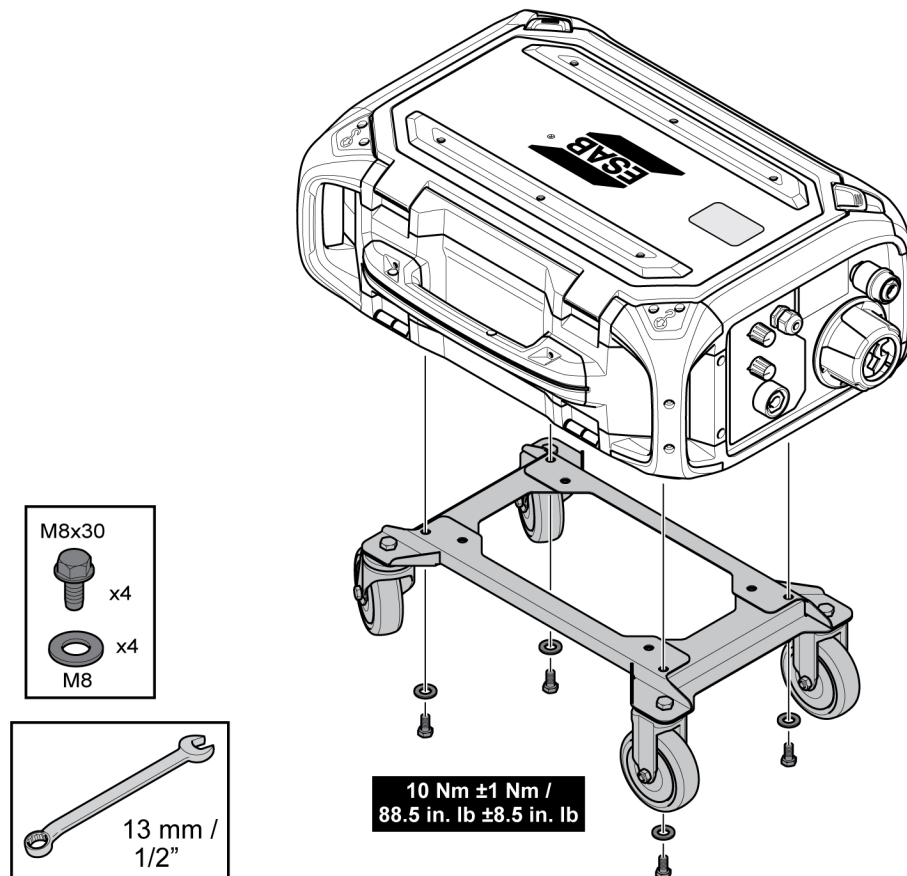


### 5.10.3 Wire feed unit in horizontal position



**NOTE!**

In order to attach the wire feeder to the wheel kit in the horizontal position, the two bumpers on the wire feeder door must be removed.



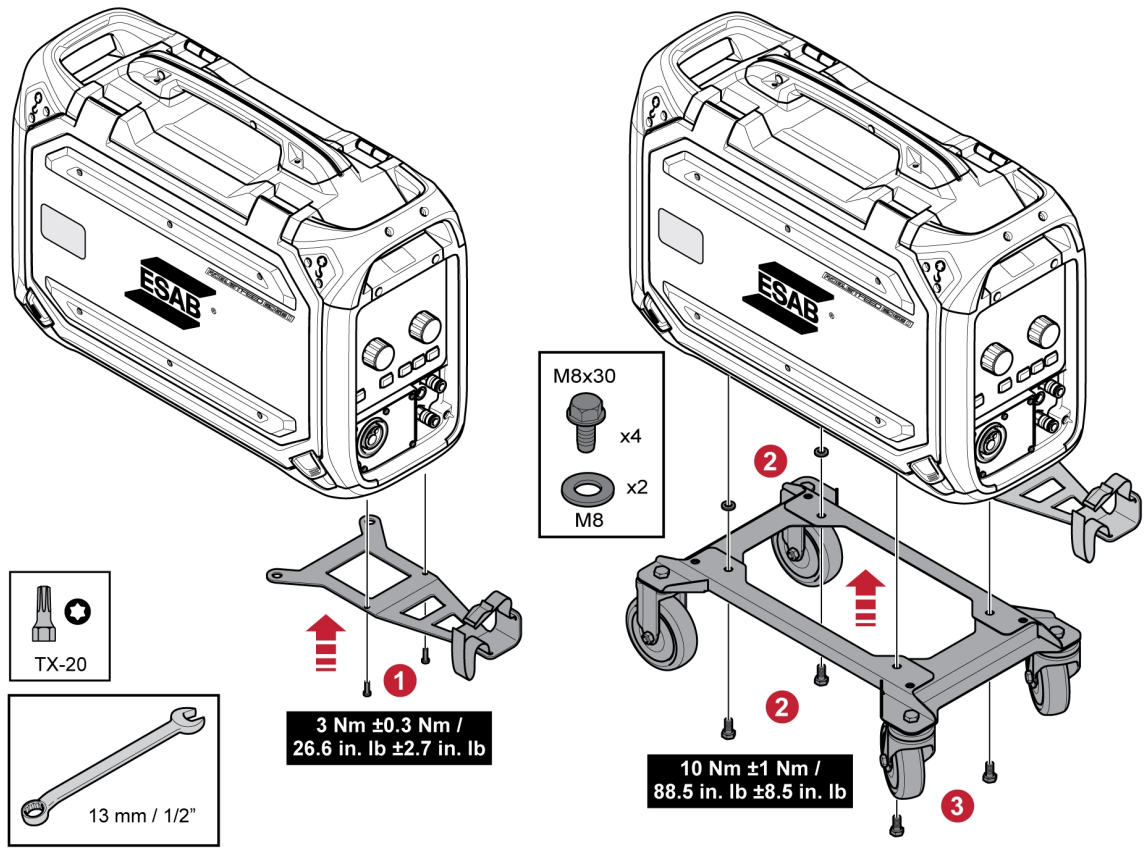
## 5.11 Attaching both the wheel kit and the torch strain relief accessory

- 1) If the torch strain relief accessory is to be used with the wheel kit when it is fitted in the vertical position, the assembly steps below must be completed in the following order:

Attach the torch strain relief to the wire feed unit, using the two Torx 5 screws.

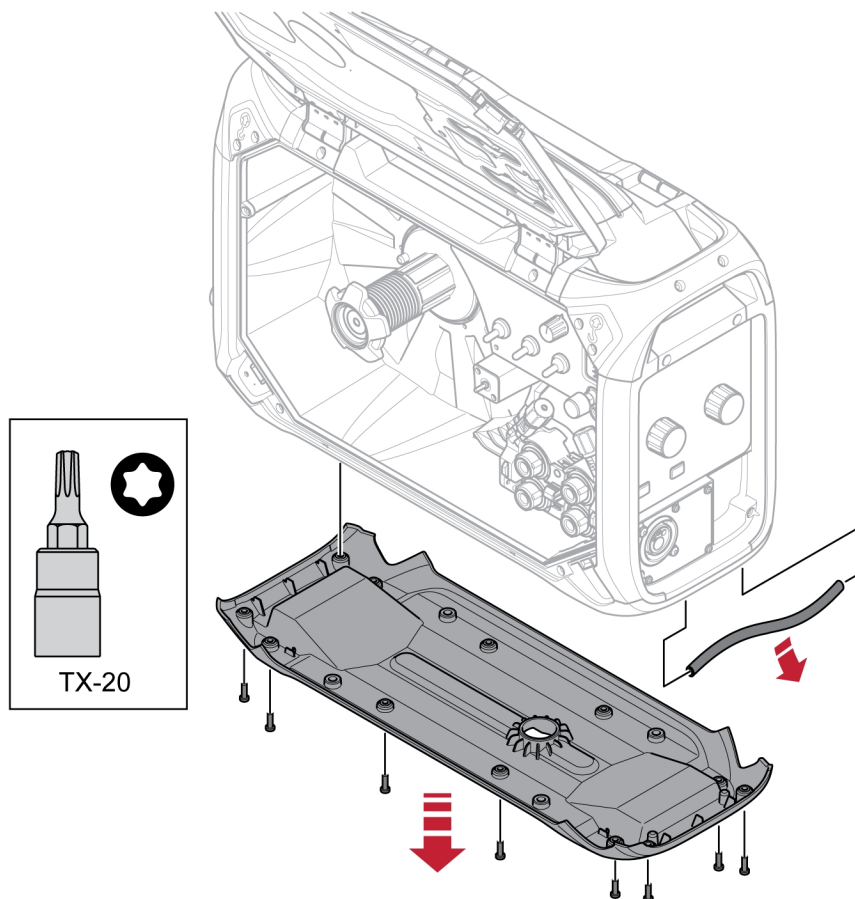
Attach the wheel kit to the wire feeder using the two screw joints near the rear end of the wire feeder. Ensure that the two distance washers are inserted between the wheel kit and the wire feeder.

Fasten the wheel kit and the torch strain relief to the wire feeder using the two screw joints located closer to the front end of the wire feeder.

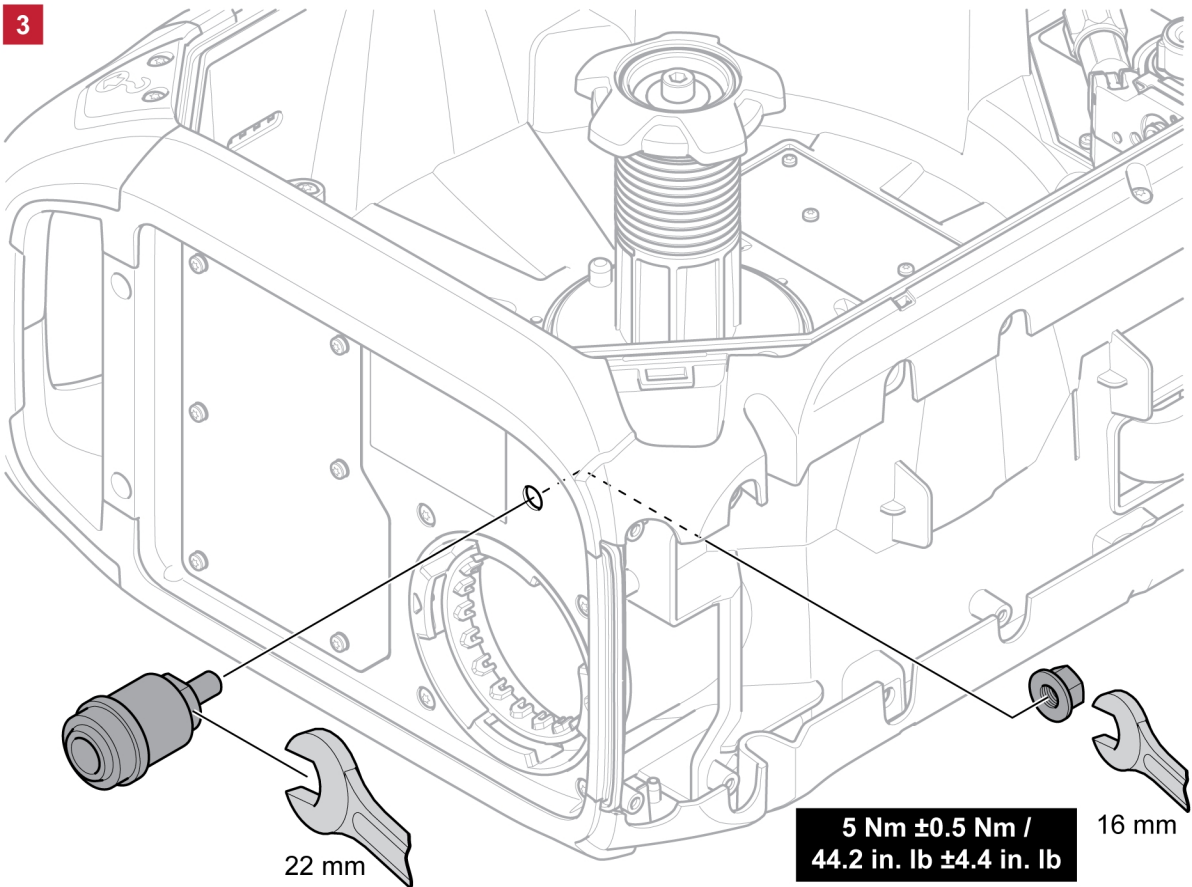
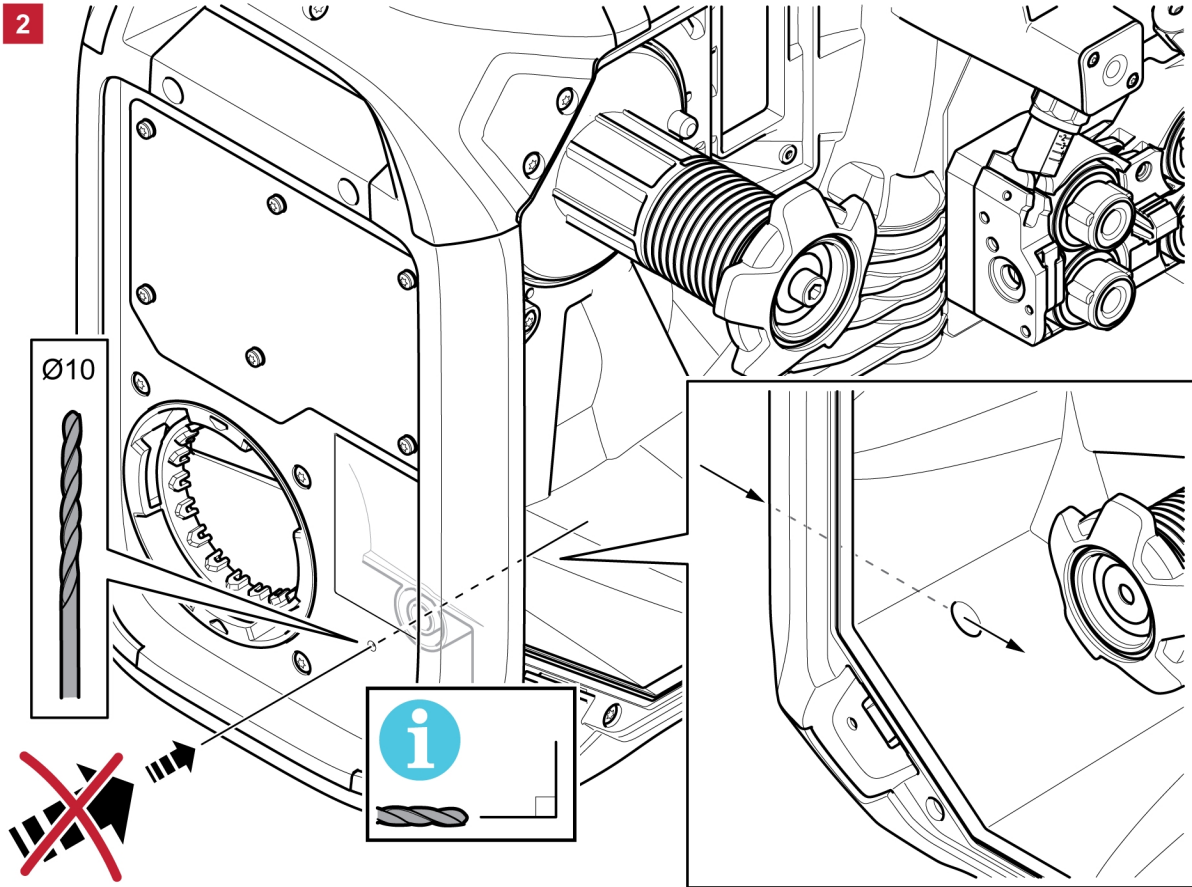


## 5.12 Marathon Pac™ installation

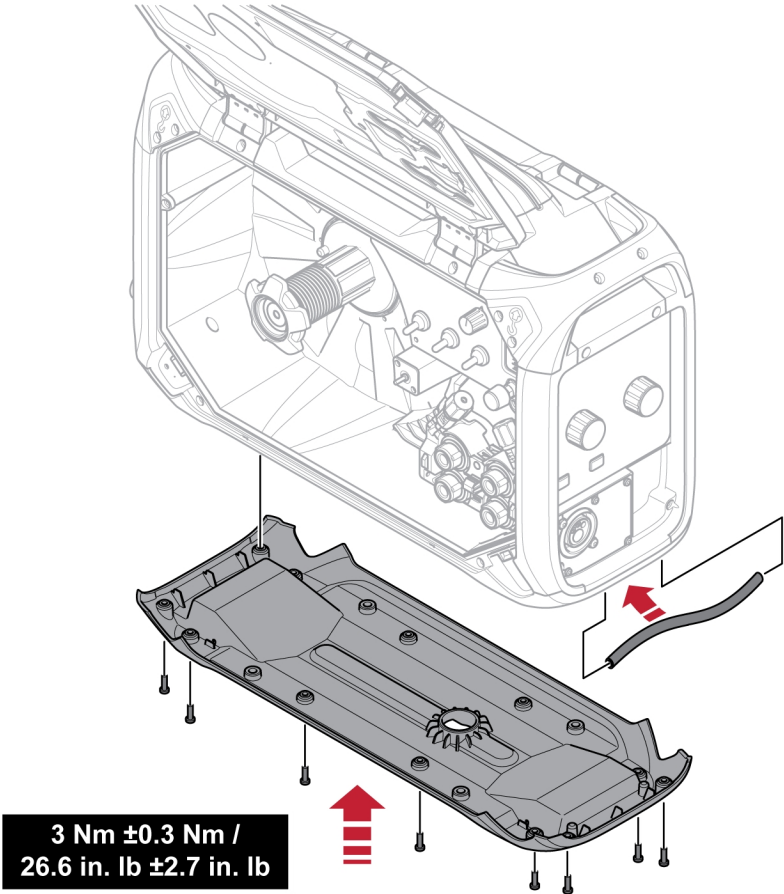
1





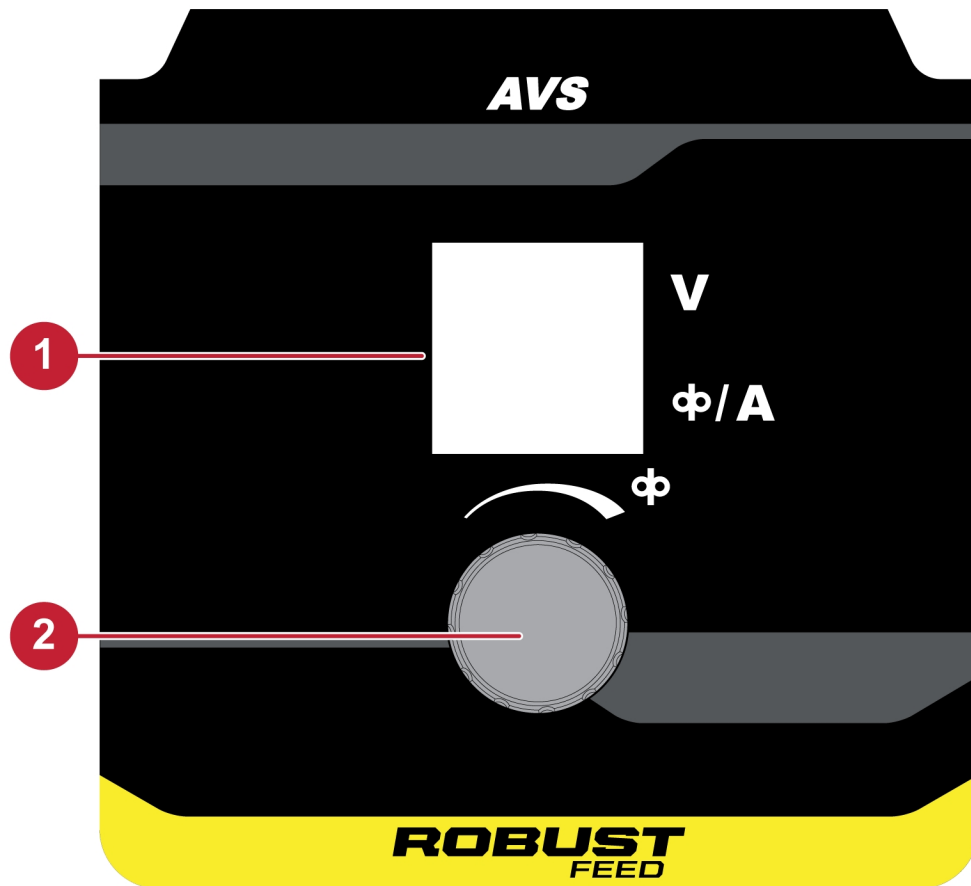


4



## 6 CONTROL PANEL

### 6.1 External control panel

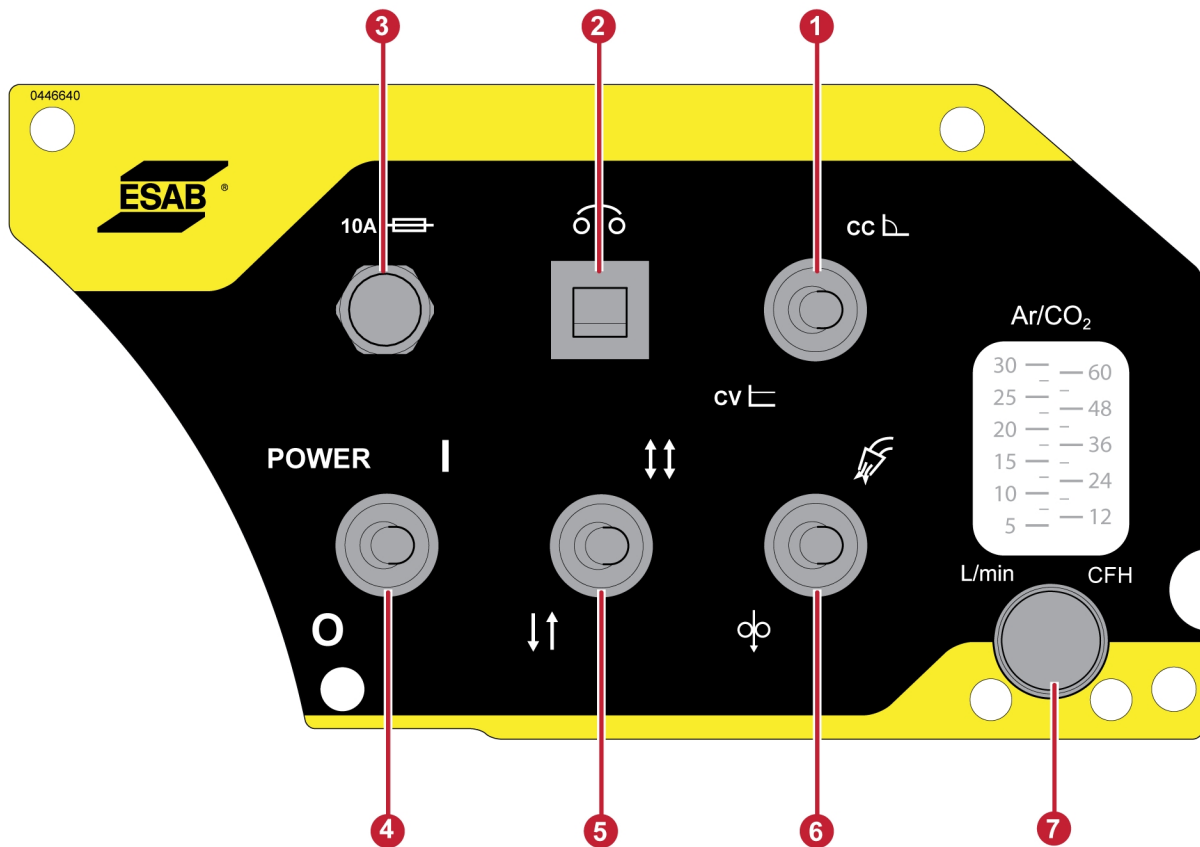


1. Display

2. Knob for setting the wire feed speed



## 6.2 Internal control panel



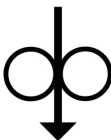
1. CC/CV switch
2. Circuit breaker
3. Main fuse, 10 A
4. Power switch
5. 2-stroke or 4-stroke selection switch
6. Gas purging / Wire inching switch
7. Knob for setting the gas flow rate (optional)

## 6.3 Function explanation



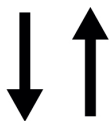
### Gas purging

Gas purging is used when measuring the gas flow or to flush any air or moisture from the gas hoses before welding starts. Gas purging takes place for as long as the button is held depressed and takes place without voltage or wire feed starting.



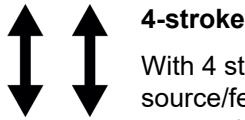
### Wire inching

Wire inching is used when feeding wire without applying a welding voltage. The wire is fed as long as the button is depressed.

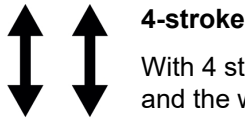


### 2-stroke

With 2-stroke, gas pre-flow starts when the welding torch trigger switch is pressed. The welding process then starts. Releasing the trigger switch stops welding entirely and starts gas post-flow.

**4-stroke**

With 4 stroke, the torch trigger can be released once the arc is established, the power source/feeder will continue to weld until the trigger is pressed and released again, or the arc established signal is lost by manually breaking the arc. The trigger will not be locked unless the arc is established before the trigger is released.

**4-stroke**

With 4 stroke, the gas pre-flow starts when the welding torch trigger switch is pressed in and the wire feed starts when it is released. The welding process continues until the switch is pressed in again, when the switch is released the wire feed then stops the gas post-flow starts.

**Power switch**

The power switch (0/I) on the internal panel starts the wire feeder when the feeder is connected to the power source and the work piece. The power source must be turned on with the contactor closed.

**CC/CV switch**

The CC/CV switch is used to set CC or CV mode. CC mode is used for constant current power sources. CV mode is used for constant voltage power sources. The selected mode also affects the functions of the wire feeder as shown below:



Mode	Display	Knob for setting the wire feed speed
CC	Wire feed speed and arc voltage shown. While welding, current shown	Controls the arc voltage / Wire speed feed increase with increased voltage
CV	Wire feed speed shown	Controls the welding current

**Circuit breaker, 5 A**

This resettable 5-ampere circuit breaker, in series with motor armature, protects the control board from damage if the motor stalls.

**Setting the gas flow**

The gas flow is adjusted using the knob on the internal control panel. The present gas flow rate is given on the gas flow meter above the knob.

**NOTE!**

The reading on the flow meter scale will only be correct if the wire feeder is in upright position.

**Wire feed speed (Arc voltage control)**

The wire feed speed is controlled by the knob for wire feed speed on the front of the wire feeder.

When the wire feeder is connected to a constant voltage (CV) type of power source, the knob for wire feed speed controls the welding current. Turning the knob clockwise increases the welding current; turning it counterclockwise decreases the welding current.

When the wire feeder is connected to a constant current (CC) type of power source, the knob for wire feed speed controls the arc voltage. Turning the knob clockwise increases the arc voltage; turning it counterclockwise decreases the arc voltage. The actual wire feed speed for any given setting varies with the arc voltage. Increasing the arc voltage causes an increase in the wire feed speed.

When the CV/CC switch inside the RobustFeed AVS, is set to "CV", the "Preset" wire feed speed will be shown on the display. The wire speed will not vary with changes in the arc voltage.

When the CV/CC switch is set to "CC", the wire feed speed and voltage will be shown on the display. The wire speed shown is the speed that will result from the displayed voltage.

**Display for wire feed speed / weld current and voltage**

The digital display shows the wire feed speed (in/min or m/min) / weld current and voltage. It also enables the welder to preset wire feed speed and power source voltage.

**6.4 Operating procedures****6.4.1 Weld data table**

The voltage (V) and current (A) values presented in the tables below are the arc voltage and the weld current. Values of current (A) that may flow through the wire feeder may not be higher than rated values of the unit.

**Flux Core E70T-1 and 2**

Diameter	Wire Feed Speed (inch/min) / (m/min)								
	150 / 3.8	200 / 5.1	250 / 6.35	300 / 7.6	350 / 8.9	400 / 10.2	450 / 11.4	500 / 12.7	600 / 15.2
.045"		29 V 150 A		29 V 210 A		30 V 250 A		33 V 290 A	34 V 330 A
.052"	25 V 155 A		30 V 300 A						
1/16"	27 V 190 A		30 V 300 A	33 V 365 A	33 V 410 A				

**Metal Core**

Diameter	Wire Feed Speed (inch/min) / (m/min)						
	200 / 5.1	250 / 6.35	300 / 7.6	350 / 8.9	400 / 10.2	450 / 11.4	500 / 12.7
.045"			28 V 250 A	29 V 260 A	30 V 270 A	32 V 300 A	32 V 350 A
.052"		29 V 275 A	29 V 300 A	30 V 325 A			
1/16"	30 V 300 V	30 V 350 A	32 V 400 A				

**Steel Solid Wire**

Diameter	Wire Feed Speed (inch/min) / (m/min)								
	200 / 5.1	250 / 6.35	300 / 7.6	350 / 8.9	400 / 10.2	450 / 11.4	500 / 12.7	550 / 14.0	600 / 15.2
.035"					25 V 180 A	25 V 200 A	26 V 215 A	27 V 230 A	28 V 245 A
.045"			25 V 260 A	26 V 280 A	27 V 300 A	28 V 320 A	30 V 340 A		
1/16"	26 V 290 A	27 V 340 A	30 V 400 A						

### 6.4.2 RobustFeed AVS with CC Power Sources

- 1) Select the weld current/arc voltage needed for the wire type and diameter to be welded, see section "Weld data table" in this chapter.
- 2) Set the power supply current with the knob for setting the current on the front panel of the power source.
- 3) Set the wire feed speed value taken from the weld data table using the knob for setting the wire feed speed on the wire feeder.
- 4) Strike an arc and adjust it to the desired wire speed with the knob for setting the wire feed speed.

### 6.4.3 RobustFeed AVS with CV power sources

- 1) Select the arc voltage/weld current needed for the wire type and diameter to be welded, see section "Weld data table" in this chapter.
- 2) Set the power supply voltage with the knob for setting the voltage on the power source or use the optional remote voltage control in the wire feeder.
- 3) Read the wire feed speed at the top of the column in the "Weld data table" for the chosen wire type, diameter, and arc voltage/weld current.
- 4) Use the "Weld data table" to determine the position of the knob for setting the wire feed speed on the wire feeder.
- 5) Strike an arc and adjust the arc length as needed with the knob for setting the wire feed speed.

**NOTE!**

It is NOT RECOMMENDED to use the CV switch setting when using a CC power source. Extreme wire feed speed sensitivity exists that makes it difficult to set a stable welding condition. The arc stability is very dependent on maintaining constant "Tip To Work" (TTW) distance which is almost impossible to control when welding manually. CV setting is only recommended for use with CV power sources.

**NOTE!**

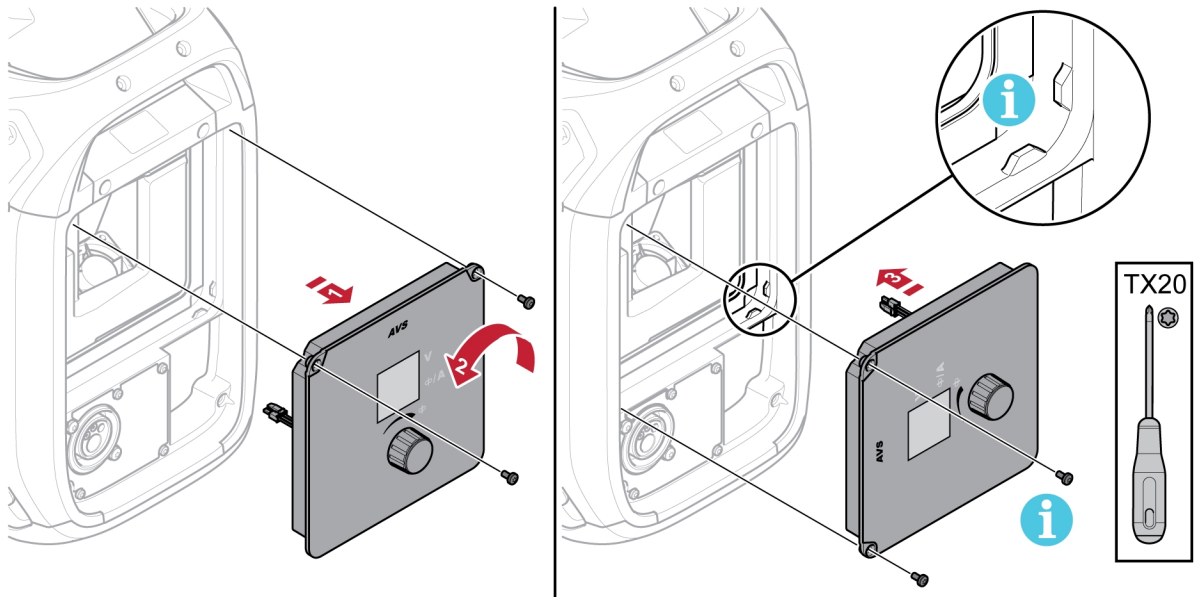
On many CV power sources, the actual welding arc voltage is less than the "Open Circuit Voltage" (OCV) set on the power source front panel. Therefore, an extra 3 to 6 volts may be added to the power source front panel setting to achieve the actual arc voltage needed or shown in the tables.

### 6.4.4 Shutdown

- 1) Release the torch trigger switch to break the arc.
- 2) When leaving the equipment unattended, always turn off and disconnect all power to the equipment and turn off the shielding gas supply at the source.

## 6.5 Rotating the control panel

To use the wire feeder in the horizontal position, the external control panel may be rotated 90°.



- 1) Remove the two screws for the control panel and remove the panel.
- 2) Rotate the control panel 90° counter-clockwise.
- 3) Attach the control panel, ensuring that the small tabs are in the correct position.
- 4) Fasten the screws.

## 7 MAINTENANCE

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**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.

### 7.1 Inspection, cleaning and replacement

**Wire feed mechanism**

Regularly check that the wire feed unit is not clogged with dirt.

- Cleaning and replacement of worn parts in the mechanism of the wire feed should take place at regular intervals in order to achieve trouble-free wire feeding. Note that if pretensioning is set too hard, this can result in abnormal wear on the pressure roller, feed roller, and wire guide.
- Cleaning of the liners and other mechanical parts of the wire feed mechanism should be carried out at regular intervals or if the wire feed seems slow. Use compressed air for this task.
- Changing nozzles
- Checking the driving wheel
- Changing the cog-wheel package

**Bobbin holder**

- Inspect at regular intervals that the brake hub sleeve and the brake hub nut are not worn out and that they lock properly. Replace if necessary.

**Welding torch**

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

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## 8 TROUBLESHOOTING

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Perform these checks and inspections before contacting an authorized service technician.

<b>Fault symptom</b>	<b>Corrective actions</b>
The welding equipment is not working properly	Check that the main power supply switch is turned on.
	Check that the operating controls are at required settings.
	Check all power cables and connections for evidence of overheating or sparking.
Gas leakage	Check all gas hoses, connections, flowmeters and regulators for possible sources of breakdown or intermittent failure.
The trigger lock does not lock ON	Check that the trigger lock is ON and then release the trigger after the arc is established.
The wire feed is slow/stiff when moving through the wire feed mechanism.	Clean the liners and other mechanical parts of the wire feeding mechanism with pressurized air.

## 9 ORDERING SPARE PARTS

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**CAUTION!**

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

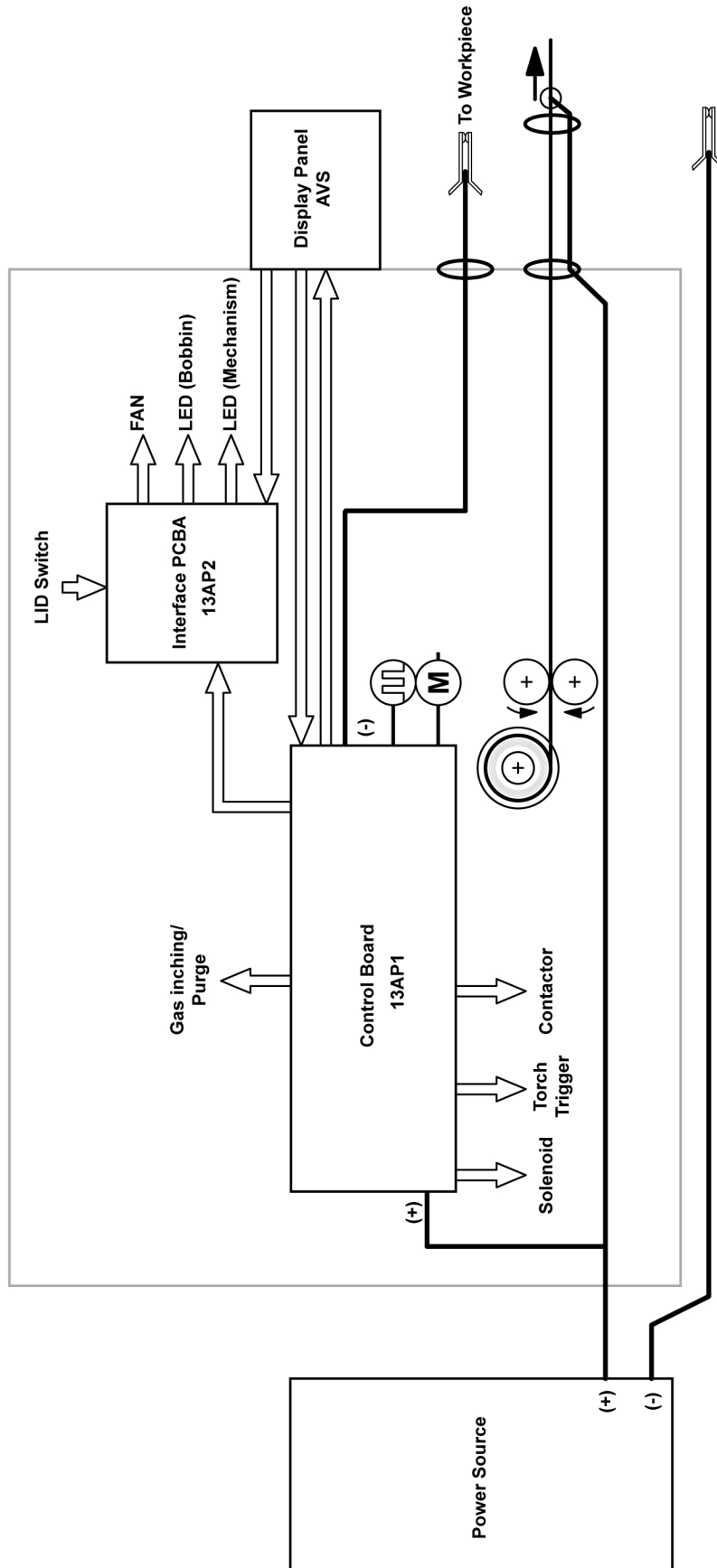
RobustFeed AVS is designed and tested in accordance with the international and European standards **EN IEC 60974-5** and **EN IEC 60974-10 Class A**, Canadian standard **CAN/CSA-E60974-5** and US standard **ANSI/IEC 60974-5**. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the mentioned standards.

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.



# APPENDIX

## WIRING DIAGRAM



## ORDERING NUMBERS





Ordering number	Denomination	Notes
0446 700 882	RobustFeed AVS W/O Rotameter	with Tweco connector
0446 700 883	RobustFeed AVS with Rotameter	with Tweco connector
0446 680 *	Instruction manual	CSA


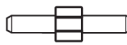

The three last digits in the document number of the manual show the version of the manual. Therefore they are replaced with \* here. Make sure to use a manual with a serial number or software version that corresponds with the product, see the front page of the manual.

Technical documentation is available on the Internet at: [www.esab.com](http://www.esab.com)



## WEAR PARTS


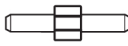

### Fe, Ss and cored wire

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
<b>V-groove</b> 	<b>X</b>	<b>X</b>							0445 850 001
		<b>X</b>	<b>X</b>						0445 850 002
			<b>X</b>						0445 850 003
			<b>X</b>	<b>X</b>					<b>0445 850 004</b>
				<b>X</b>					0445 850 005
					<b>X</b>	<b>X</b>			0445 850 006
								<b>X</b>	0445 850 007

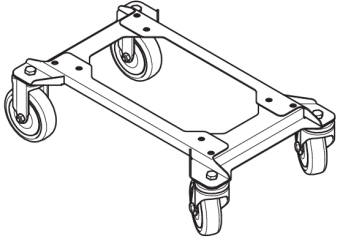
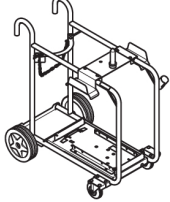
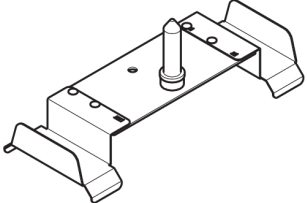

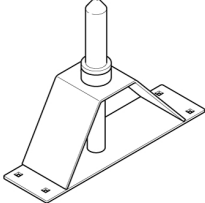
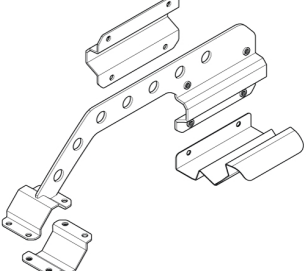
Inlet wire guide 	Middle wire guide 	Outlet wire guide 
0445 822 001 (2 mm)	0446 080 882	0445 830 883 (Tweco) 0445 830 881 (Euro)

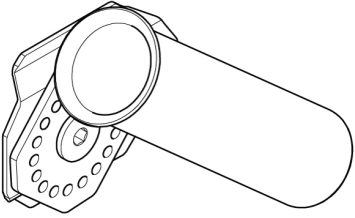
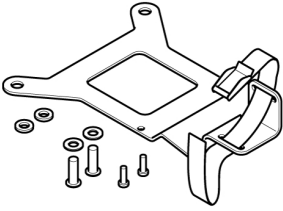
### Cored wire – Different wire guides dependent on wire diameter!

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
<b>V-K-knurled</b> 	<b>X</b>	<b>X</b>						0445 850 030
		<b>X</b>						0445 850 031
		<b>X</b>	<b>X</b>					0445 850 032
					<b>X</b>			0445 850 033
						<b>X</b>		0445 850 034
							<b>X</b>	0445 850 035
								<b>X</b>

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

## ACCESSORIES

0446 081 880	<b>Wheel kit</b>	
0349 313 450	<b>Trolley</b> (compatible with RobustFeed and Warrior™ Feed 304)	
0349 313 100	<b>RF retrofit kit</b> (for use with existing Warrior™ trolley with ordering no. 0465 510 880)	
F102 440 880	<b>Quick connector Marathon Pac™</b>	
0465 508 880	<b>Guide pin extension kit</b> For the feeder assembled with the wheel kit	
0446 956 880	<b>Boom adaptor kit</b> including a stopper for RobustFeed door  For assembly instructions, refer to the Boom adaptor assembly instruction manual	

0446 958 880	<b>Torch holder</b> For assembly on the RobustFeed For assembly instructions, refer to the Torch holder assembly instruction manual	
0446 082 880	<b>Torch strain relief</b>	



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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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