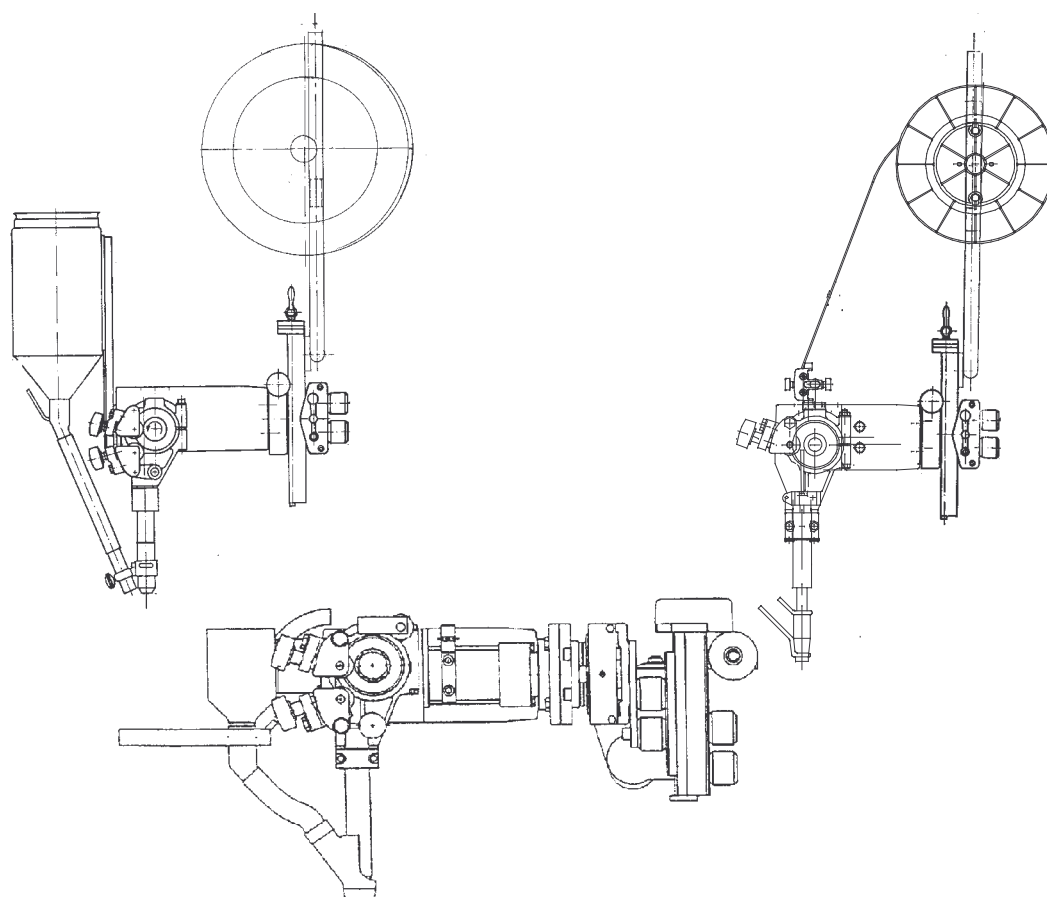


A6S Arc Master

A6S G Master

A6S Compact 500

***A6 SFE1/ A6 SFE2/ A6 SGE1/
A6 SFE1C***



Instruction manual

ENGLISH 4

Rights reserved to alter specifications without notice.



DECLARATION OF CONFORMITY

In accordance with
the LV-Directive 2006/95/EC, the Machinery Directive 2006/42/EC, the EMC Directive 2004/108/EC

Type of equipment

Feeder of welding wire in combination with movable Welding Automats and stationary Welding heads, used with control box PEK

Brand name or trade mark Fabrikatnamn eller varumärke

ESAB

Type designation etc.

A2 Multitrac, A2 Tripletrac, A2 S-series, A6 Mastertrac, A6 Mastertrac Tandem, A6 S- series

Manufacturer or his authorised representative established within the EEA

Name, address, telephone No, telefax No:

ESAB AB, Welding Equipment

Esabvägen, SE-695 81 LAXÅ, Sweden

Phone: +46 584 81 000, Fax: +46 584 411 924

The following harmonised standards in force within the EEA have been used in the design:

EN 60974-5, Arc welding equipment – Part 5: Wire feeders

EN 12100-2, Safety of machinery – Part 2: Technical principles

EN 60974-10, Arc welding equipment – Part 10: Electromagnetic compatibility (EMC) requirements

Additional information: Restrictive use, Class A equipment, intended for use in locations 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 / Datum
Laxå 2009-09-15

Signature / Underskrift

A handwritten signature in blue ink, appearing to read "Kent Eimbrodt", is written over a horizontal line.

Kent Eimbrodt
Clarification

Position / Befattning
Global Director
Equipment and Automation

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1 SAFETY

Users of ESAB welding 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 welding 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 welding 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 welding equipment must be familiar with:
 - its operation
 - location of emergency stops
 - its function
 - relevant safety precautions
 - welding
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
3. The workplace must:
 - be suitable for the purpose
 - be free from draughts
4. Personal safety equipment
 - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves. **Note!** *Do not use safety gloves when replacing wire.*
 - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. Protection against other risks
 - Dust particles of a certain size can be harmful to man. A ventilation system and extractor should therefore be provided to eliminate this risk.
6. 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, RISK OF CRUSHING!

Do not use safety gloves when replacing wire, feed rollers and wire bobbins.



WARNING



ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURER'S HAZARD DATA.

ELECTRIC SHOCK - Can kill

- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

FUMES AND GASES - Can be dangerous to health

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to keep fumes and gases 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.

FIRE HAZARD

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

NOISE - Excessive noise can damage hearing

- Protect your ears. Use ear defenders or other hearing protection.
- Warn bystanders of the risk.

MALFUNCTION

- Call for expert assistance in the event of malfunction.

READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.

PROTECT YOURSELF AND OTHERS!

2 INTRODUCTION

2.1 General

All the automatic welding machines included in this instruction manual are designed for SAW and MIG/MAG welding of butt and fillet joints.

ESAB's welding heads are of the **A6 S** type and are intended for use in combination with **PEK** and ESAB's welding power sources LAF and TAF.

The welding head can be positioned horizontally and vertically with the linear slides. The angular position is adjusted with the angular slide.

2.2 Definitions

SAW welding	The weld bead is protected by a cover of flux during the welding.
SAW Heavy duty	Permits welding with high current load and thick wire.
SAW Light duty	Permits welding with low current load and thin wire.
MIG/MAG welding	The weld bead is protected by shielding gas during welding.
Tandem welding	Welding with two welding heads.
Twinnarc welding	Welding with two wires in the same welding head.

2.3 Technical data

	A6 SFE1	A6 SFE1	A6 SFE2	A6 SGE1	A6 SFE1C
	SAW	SAW	SAW	MIG/MAG	SAW
	LD D20	HD D35	HD D35		
Rated load 100% 60 %	800 A 1000 A AC/DC	1500 A - AC/DC	1500 A - AC/DC	600 A - AC/DC	1500 A - AC/DC
Wire dimensions:					
solid single wire	1.6-4.0 mm	3.0-6.0 mm	3.0-6.0 mm	0.8-2.5 mm	- 4.0 mm
flux-cored wire	1.6-4.0 mm	3.0-4.0 mm	-	1.2-3.2 mm	-
twin wire	2x1.2-2.0 mm	2x2.0-3.0mm	2x2.0-3.0mm	-	-
Wire feed speed	0.2-4.0 m/min	0.2-4.0 m/min	0.2-4.0 m/min	0.2-15 m/min	0.2-4.0 m/min
Brake drum braking torque	1.5 Nm	1.5 Nm	1.5 Nm	1.5 Nm	1.5 Nm
Max weight, wire	2x30 kg	2x30 kg	4x30 kg	30 kg	2x30 kg
Flux hopper capacity (Must not be filled with preheated flux)	10 l	10 l	10 l	-	1 l
Weight (flux and wire excluded)	50 kg	50 kg	100 kg	15 kg	50 kg
Sideways tilt, max.	25°	25°	25°	25°	25°
Setting length of slide *					
manual	210 mm	210 mm	210 mm	210 mm	
motor-driven (with ball bearings)	300 mm	300 mm	300 mm	300 mm	60 mm
Continuous A-weighted noise pressure	68 dB	68 dB	68 dB	83 dB	68 dB

*) NB! Other lengths on request.

2.4 Welding method

Submerged arc welding (SAW)

For SAW welding the **A6 SF** welding head is always used. It is available in the following designs:

- **Submerged-arc Light duty**

Submerged-arc light duty, with a $\varnothing$ 20 mm connector, which permits a load of up to 800 A (100%) or 1000 A (60%).

- **Submerged-arc Heavy duty**

Submerged-arc heavy duty, with a $\varnothing$ 35 mm connector, which permits a load of up to 1500 A.

Both versions can be equipped with feed rollers for single or twin wire welding (twin-arc). A special knurled feed roller is available for flux-cored wire, which guarantees even wire feed without the risk of deformation due to high feed pressure.

For work in confined spaces, (smaller than 50 cm), a special welding head of type **A6 SFE1C** is available, which can be installed on the Mastertrac as required.

Tandem welding (submerged-arc)

For tandem welding, a welding head of type **A6 SFE2** is always used, which must be connected to 2 welding power sources and 2 control boxes of type PEK.

The tandem welding head includes 2 single welding heads (A6 SF), each with its own contact tip. Each contact tip has a maximum rated load of 1500 A.

MIG/MAG welding

For MIG/MAG welding the **A6 SG** welding head is always used, permitting a max. load of 600 A. The welding head is water-cooled, with the cooling water supplied by hoses from connections intended for the purpose.

2.5 Equipment

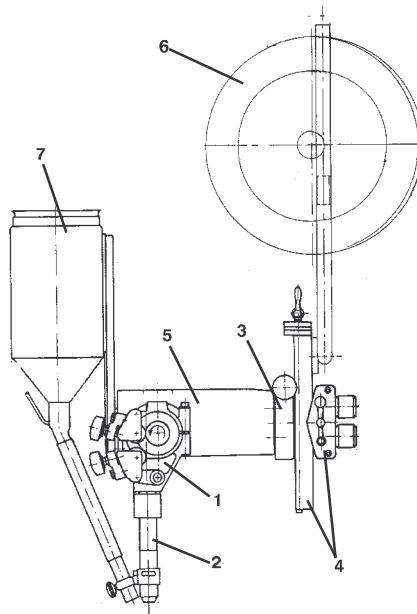
Included in a complete welding head are a feed motor (A6 VEC) to feed in the wire and contact equipment which supplies current to the wire and provides a good contact.

Contact equipment is available in several different versions.

- A6 SF is used for submerged-arc welding.
- A6 SG is used for MIG/MAG welding.

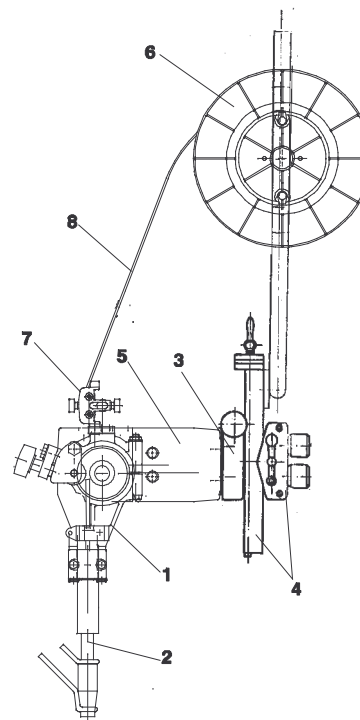
Example - A6 SFE1 and A6 SFE2

- 1 Straightener.
- 2 Contact equipment which consists of a contact tip, connector and flux tube.
- 3 Angular slide
- 4 Slide (motor-driven or manually operated)
- 5 Motor and gearbox (A6 VEC)
- 6 Wire drum
- 7 Flux hopper (may be fitted with a cyclone)



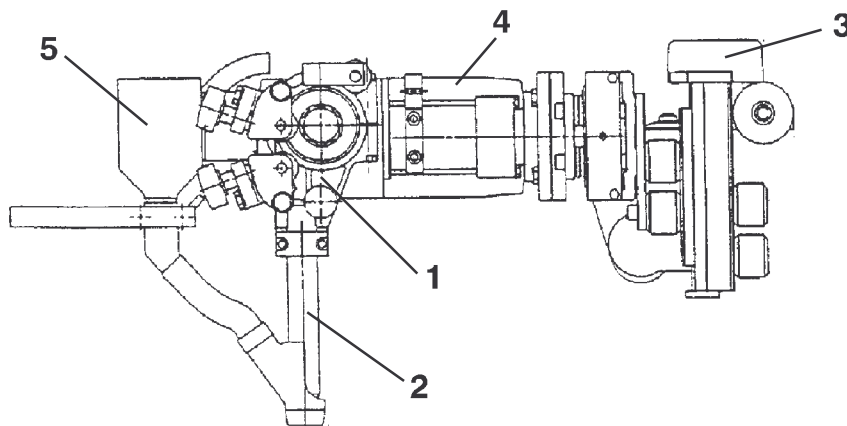
Example - A6 SGE1

- 1 Straightener.
- 2 Contact equipment which consists of a connector, gas nozzle and water hoses.
- 3 Angular slide.
- 4 Slide (motor-driven or manually operated)
- 5 Motor and gearbox (A6 VEC).
- 6 Wire drum.
- 7 Fine-wire straightener (Accessories).
- 8 Wire guide.



Example of the A6 SFE1C

- 1 Straightener.
- 2 Contact equipment, which consists of a contact tip, connector and flux tube.
- 3 Slide (motor-driven).
- 4 Motor and gearbox (A6 VEC).
- 5 Flux hopper (1 l).



Connection instructions for SAW and MIG/MAG welding appear from the system diagram on page 12.

3 INSTALLATION

3.1 General

Installation shall only be performed by qualified personnel.



WARNING

Rotating parts can cause injury, take great care.

3.2 Mounting

The automatic welding machines can easily be fitted with 4 screws M10x40 on a rail-borne carriage or on a column and boom unit.

3.3 Connections

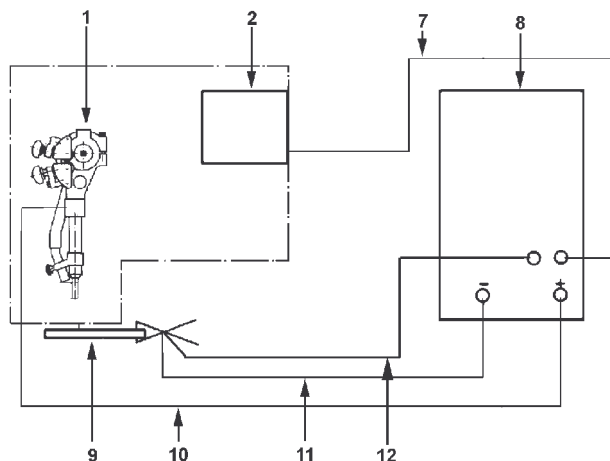
1. The connection of the PEK to the welding machine shall be done according to the connection instructions in the PEK service manual.

For further information, see instruction manual for the PEH, 0460 948 xxx, 0460 949 xxx, 0459 839 036.

2. Connect the A6 welding heads as follows:

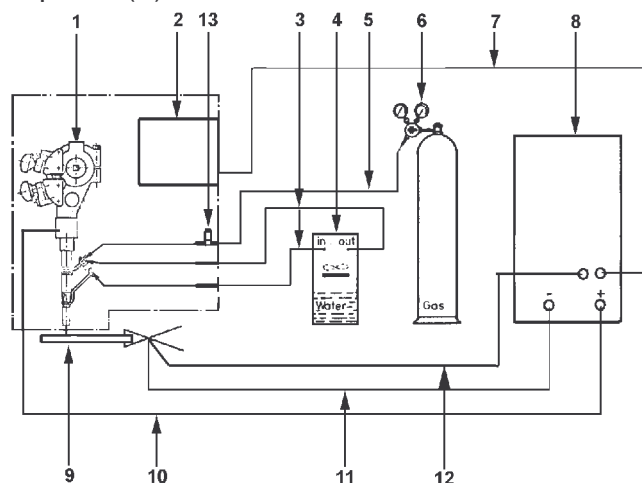
SUBMERGED ARC WELDING (SAW)

- Connect the control cable (7) between the welding power source (8) and the PEK (2).
- Connect the return cable (11) between the welding power source (8) and the work piece (9).
- Connect the welding cable (10) between the welding power source (8) and the automatic welding machine (1).
- Connect the measuring cable (12) between the welding power source (8) and the work piece (9).



GAS METAL ARC WELDING (MIG/MAG)

- Connect the control cable (7) between the welding power source (8) and the PEK (2).
- Connect the return cable (11) between the welding power source (8) and the work piece (9).
- Connect the welding cable (10) between the welding power source (8) and the automatic welding machine (1).
- Connect the gas hose (5) between the reduction valve (6) and the gas valve on the automatic welding machine (13).
- Connect the hoses for cooling water (3) between the cooling unit (4) and the automatic welding machine (1).
- Connect the measuring cable (12) between the welding power source (8) and the work piece (9).



4 OPERATION

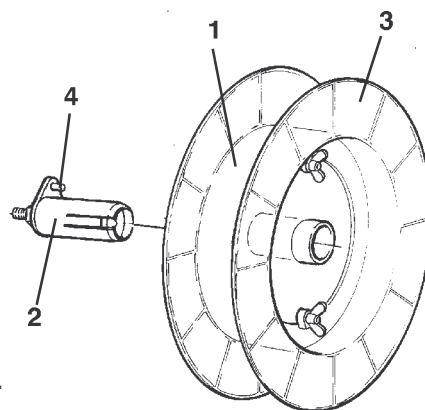
4.1 General

General safety regulations for the handling of the equipment can be found on page 5. Read through before you start using the equipment!

4.2 Starting work

Loading the welding wire

- Remove the wire drum (1) from the brake hub (2) and take off the side plate (3).
- Locate the wire reel on the wire drum (1).
- Cut off the binding wires from around the wire reel.
- Fit the side plate (3).
- Fit the wire drum (1) on the brake hub (2).
Check that the carrier (4) is in the correct position.



NOTE! The maximum angle for the wire bobbin is 25°. At extreme angles, wear will occur on the brake hub locking mechanism and the wire bobbin will slide off the brake hub.



WARNING

To prevent the reel 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.



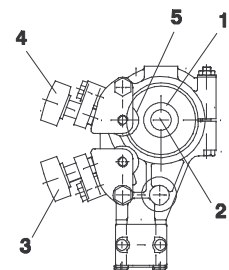
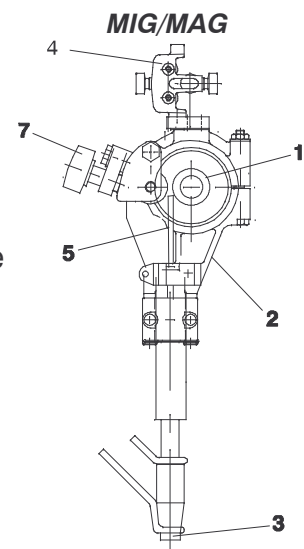
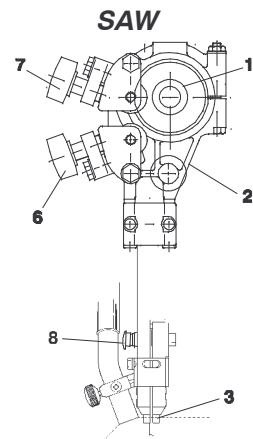
- Check that the feed roller (1) and contact jaw or contact tip (3) are of the correct dimension for the selected wire size.
- Pull the end of the wire through the straightener (2). For a wire diameter greater than 2 mm; straighten out 0.5 m of wire and feed it by hand down through the straightener.
- Locate the end of the wire in the feed roller (1) groove.
- Set the wire tension on the feed roller with the knob (7).
- **Note!** Do not tension more than is required to achieve an even feed.
- The pressure screw (8) must not be dismantled. (Applies to Submerged-arc Heavy duty).
- Feed the wire forward 30 mm below the contact tip by pressing  on the control box PEK.
- Direct the wire by adjusting the knob (6).

For fine wire, the special fine wire straightener (4) is used for both single and twin wire.

Ensure that the straightener is correctly adjusted so that the wire emerges straight out through the contact jaws or contact tip.

Always use a guide tube (5) to ensure even feeding of fine wire (1.6 - 2.5 mm).

For MIG/MAG welding with wire sizes < 1.6 mm, use a guide spiral, which is inserted in the guide tube (5).



Changing the feed roller

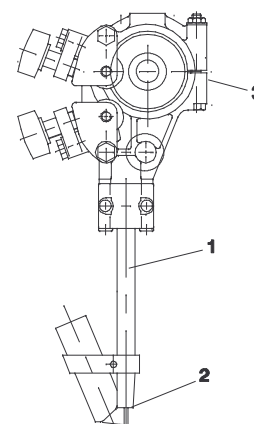
- **Single wire**
 - Release the knobs (3) and (4).
 - Release the hand wheel (2).
 - Change the feed roller (1). The rollers are marked with their respective wire sizes.
- **Twin wire (Twin-arc)**
 - Change the feed roller (1) with twin grooves in the same way as for single wire.
 - **NOTE!** The pressure roller (5) must also be changed. A special spherical pressure roller for twin wire replaces the standard pressure roller for single wire.
 - Assemble the pressure roller with special stub shaft (order no. 146 253-001).
- **Flux-cored wire** (for knurled rollers)
 - Change the feed roller (1) and pressure roller (5) in pairs for the wire size to be used. **NOTE!** A special stub shaft is required for the pressure roller (order no. 0212 901 101).
 - Tighten the pressure screw (4) with moderate pressure to ensure that the flux-cored wire does not deform.

Contact equipment for submerged-arc welding

- **For single wire 3.0 - 4.0 mm. Light duty (D20)**

Use the straightener (3), connector (1) D20 with contact tip (2) (M12 thread).

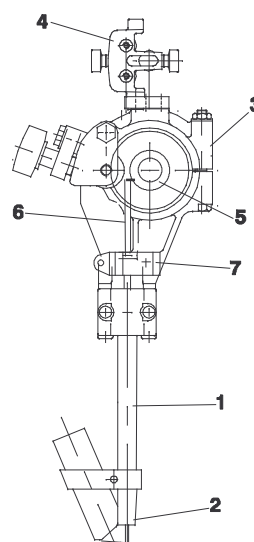
- Tighten the contact tip (2) with a key in order to ensure that a good contact is achieved.



- **For single wire 1.6 - 2.5 mm Submerged-arc. Light duty (D20)**

Use the straightener (3), connector (1) D20 with contact tip (2) (M12 thread) and separate fine wire straightener (4) with guide tube (6).

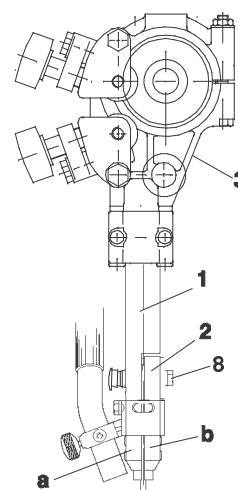
- Fit the clamp (7) with guide tube (6) in the M12 hole on the straightener (3). The guide tube (6) should bottom on the contact tip (2).
- If necessary, cut the guide tube (6) to length so that the feed roller (5) runs freely.
- Fit the fine wire straightener (4) on the upper side of the clamp for the straightener (3).



- **For single wire 3.0 - 6.0 mm. Heavy duty (D35)**

Use the straightener (3), connector (1) D35 with contact jaws (2).

- Fit one of the contact jaws with the M5 bolts provided, in the fixed contact tip (a).
- Fit the other contact jaw in the free half of the two-piece connector (b) under the bolt (8) and tighten down hard to ensure that a good contact is achieved between the contact jaws and the wire.



- **For flux-cored wire 1.6 mm - 4.0 mm (D20 and D35) (Accessories)**

If contact jaws (D35) are used, the contact jaws must not be tightened too hard in order that the flux-cored wire is not deformed. Ensure that good contact is achieved with the wire.

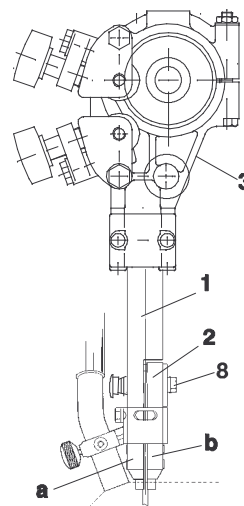
- **Adjustment of the wire for tandem welding**

- The distance between the first and second wire must not be so great that the slag gets time to solidify between the wires.
- Ensure that good flux coverage is achieved between the first and second wires.

- **For twin wires 2 x 2.0 - 3.0 Heavy Twin (D35) (Accessories)**

Use the straightener (3), connector (1) D35 with contact jaws (2).

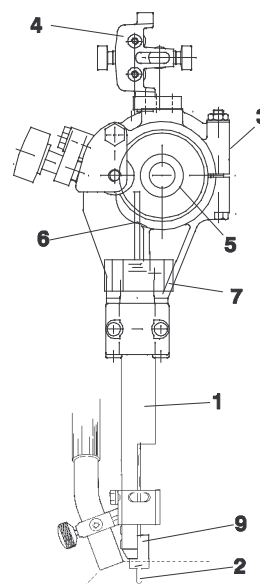
- Fit the first contact jaw with the M5 bolts supplied, in the fixed connector (a).
- Fit the other contact jaw in the free half of the two-piece connector (b) under the bolt (8) and tighten down hard to ensure that a good contact is achieved between the contact jaws and the wire.



- **For twin wire 2 x 1.2 - 2.0 mm, Light Twin (D35) (Accessories)**

Use the straightener (3), connector (1) D35 with twin adapter (9) and 2 contact tips (2) (M6 threads) and separate fine wire straightener (4) with two guide tubes (6). For twin wire < 1.6 mm, insert a guide spiral into each guide tube.

- Fit the twin adapter (9) for M6 contact tips (2) with the M5 bolts in the fixed half of the two-piece connector (1).
- Fit the clamp (7) with guide tube (6) in the M12 hole on the standard straightener (3). The guide tube should bottom on the twin adapter (9) for the contact tip (2).
- Tighten the contact tip (2) with a key to ensure that a good contact is achieved.
- If necessary, cut the guide tube (6) to length so that the feed roller (5) runs freely.



- **Adjustment of the wires for Twin-arc welding:**

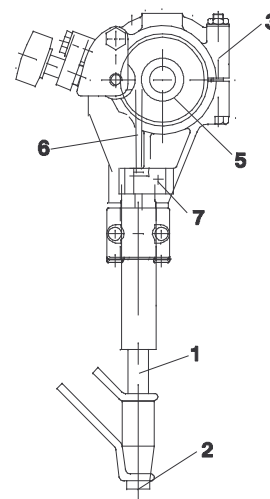
- Position the wires in the joint so as to achieve optimal weld quality by rotating the connector. The two wires can be rotated so that they are positioned one after the other along the line of the joint, or in any position up to 90° across the joint, i.e. one wire on each side of the joint.

Contact equipment for MIG/MAG welding.

- **For single wire 1.6 - 2.5 mm (D35)**

Use the straightener (3), connector (1) D35 with contact tip (2) (M10 thread).

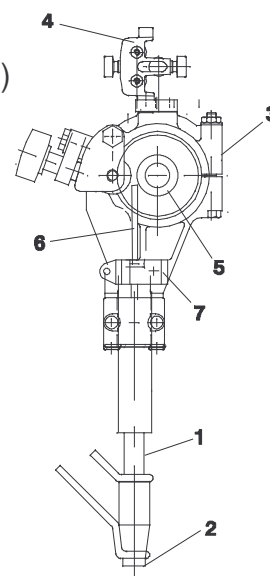
- Tighten the contact tip (2) with a key to ensure that a good contact is achieved.
- Fit the clamp (7) with guide tube (6) in the M12 hole on the standard straightener (3). The guide tube (6) should bottom on the contact tip (2).
- If necessary, cut the guide tube (6) to length so that the feed roller (5) runs freely.



- **For single wire < 1.6 mm (D35)**

Use the straightener (3), connector (1) D35 with contact tip (2) (M12 thread), fine wire straightener (4) with guide tube (6) and guide spiral, which is inserted in the guide tube (6).

- Fit the clamp (7) with guide tube (6) in the M12 hole on the standard straightener (3). The guide tube (6) should bottom on the contact tip (2).
- If necessary, cut the guide tube (6) to length so that the feed roller (5) runs freely.
- Fit the fine wire straightener (4) on the upper side of the clamp for the straightener (3).
- Connect the cooling water and gas (MIG/MAG welding).



Filling of flux (Submerged arc welding)

- Close the flux valve on the flux hopper.
- Remove the cyclone on the flux recovery unit, if fitted.
- Fill with flux .

NOTE! The flux powder must be dry.

- Position the flux tube so that the flux hose does not become kinked.
- Adjust the height of the flux nozzle above the weld so that the correct amount of flux is delivered.
The flux coverage should be high enough to prevent the arc from burning through.

4.3 Conversion of A6 SFE1 (Submerged arc welding) to MIG/MAG welding

Assemble the conversion kit according to the instructions provided.

4.4 Conversion of A6 SFE1 / A6 SFE2 (Submerged arc welding) to Twin-arc

Assemble the conversion kit according to the instructions provided.

5 MAINTENANCE

5.1 General

NB! Before doing any kind of maintenance work, make sure the mains is disconnected.

For the maintenance of the PEK, see the instruction manual, 0460 948 xxx, 0460 949 xxx, 0459 839 036.

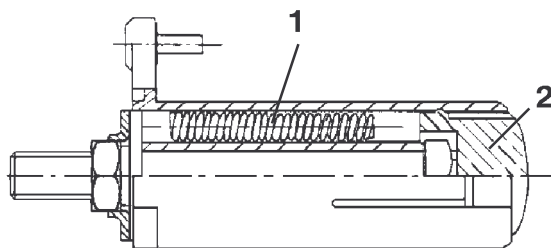
5.2 Daily

- Clean flux and dirt off moving parts of the welding machine.
- Check that the contact tip and all electric cables are connected.
- Check that all bolted joints are tight and that guides and drive rollers are not worn or damaged.
- Check the brake hub braking torque. It should not be so low, that the wire reel continues to rotate when wire feed is stopped, and it should not be so great that the feed rollers slip. As a guide, the braking torque for a 30 kg wire reel should be 1.5 Nm.

Adjusting the braking torque:

- Set the locking button (2) to the locked position.
- Insert a screwdriver into the hub springs.
- Turning the springs (1) clockwise reduces the braking torque.
- Turning the springs anticlockwise increases the torque.

NOTE! Turn the springs by the same amount.



5.3 Regularly

- Check the carbon brushes of the wire feed motor every three months. Replace when they are worn down to 6 mm.
- Check the slides and lubricate if they bind.
- Check the wire guides, drive rollers and contact tip of the wire feed unit. Replace any worn or damaged components, (see spare parts list on page 25).

6 FAULT TRACING

- Equipment**
- Instruction manual for control box PEK, 0460 948 xxx, 0460 949 xxx, 0459 839 036.
 - Operating manual for motor with gear A6 VEC, order no. 0443 393 xxx.
- Check**
- that the power source is connected for the correct mains supply
 - that all three phases are live (phase sequence is not important)
 - that welding cables and connections are not damaged
 - that the controls are correctly set
 - that the mains supply is disconnected before starting repairs

POSSIBLE FAULTS

1. Symptom **Current and voltage readings show large fluctuations**

Cause 1.1 Contact jaws or nozzle are worn or wrong size.

Action Replace contact jaws or nozzle.

Cause 1.2 Feed roller pressure is too low.

Action Increase pressure on feed rollers.

2. Symptom **Wire feed is irregular**

Cause 2.1 Feed roller pressure not correct.

Action Change the feed roller pressure.

Cause 2.2 Feed rollers wrong size.

Action Replace feed rollers.

Cause 2.3 Grooves in feed rollers are worn.

Action Replace feed rollers.

3. Symptom **Welding cables overheating**

Cause 3.1 Poor electrical connection.

Action Clean and tighten all electrical connections.

Cause 3.2 Cross-section of welding cables too small.

Action Use cables with a larger cross-section or use parallel cables.

7 ACCESSORIES

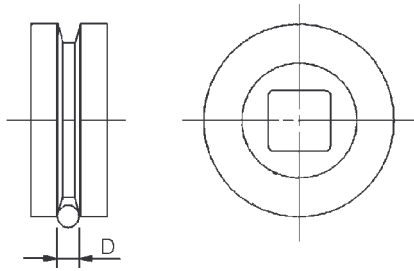
Manually operated slide	0154 465 xxx
Motor-driven slide	0334 333 xxx
Angular slide	0671 171 580
Contact equipment for twin wire 2x1.2 – 2x2.0 Light duty	0333 852 881
Contact equipment for twin wire 2x2.0 – 2x2.5–3.0 Heavy duty	0417 959 881
Fine-wire straightener for single wire	0332 565 880
Conversion kit A6 SFE1 to MIG/MAG welding	0461 246 880
Conversion kit A6 SFE1/A6 SFE2 to Twin with fine-wire straightener (LD) ...	0413 541 882
Conversion kit A6 SFE1/A6 SFE2 to Twin (HD)	0809 934 882
Pilot lamp (D20)	0153 143 885
Adapter M6/M10	0147 333 001

8 ORDERING OF SPARE PARTS

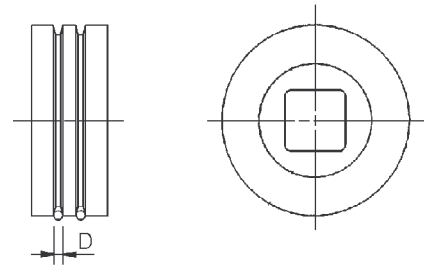
Spare parts are ordered through your nearest ESAB representative, see back cover. When ordering spare parts, please state machine type and number as well as designation and spare part number as shown in the spare parts list on page 25. This will simplify dispatch and ensure you get the right part.

WEAR COMPONENTS

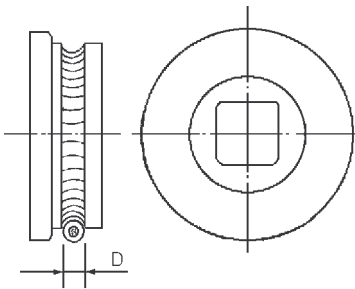
Feed rollers



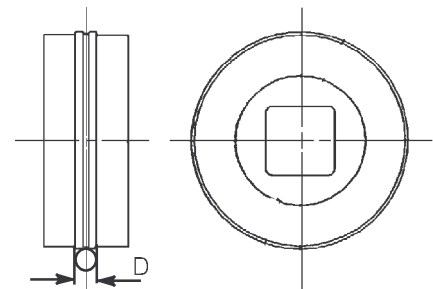
SAW and MIG/MAG	
Part no	D (mm)
0218 510 281	1,6
0218 510 282	2,0
0218 510 283	2,5
0218 510 286	4,0
0218 510 287	5,0
0218 510 288	6,0



SAW Twin (D35)	
Part no	D (mm)
0218 522 480	2,5
0218 522 481	3-3,2
0218 522 484	2,0
0218 522 486	1,2
0218 522 487	1,0
0218 522 488	1,6

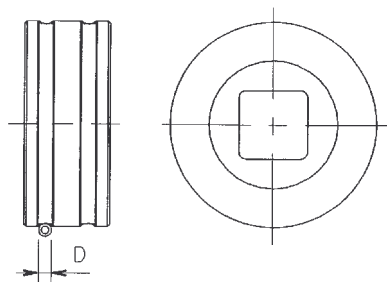


SAW and MIG/MAG tubular wire	
Part no	D (mm)
0146 024 880	0,8-1,6
0146 024 881	2,0-4,0



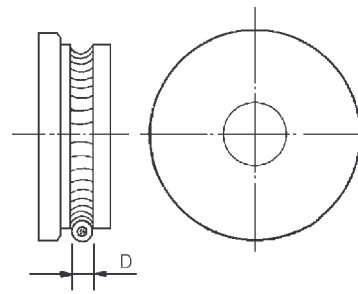
MIG/MAG	
Part no	D (mm)
0145 538 880	0,6
0145 538 881	0,8
0145 538 882	1,0
0145 538 883	1,2

	D (mm)
148 772-880	2,0-3,0

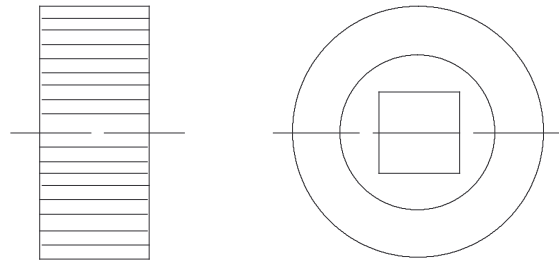


Pressure rollers

SAW and MIG/MAG tubular wire	
Part no	D (mm)
0146 025 880	0,8-1,6
0146 025 881	2,0-4,0
0146 025 882	5,0-7,0

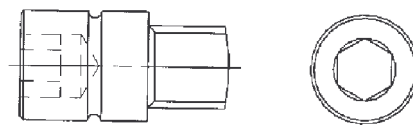


SAW Twin	
Part no	
0218 524 580	
0146 253 001	Stub shaft
0144 953 001	Spherical ball bearing
0190 452 178	Washer



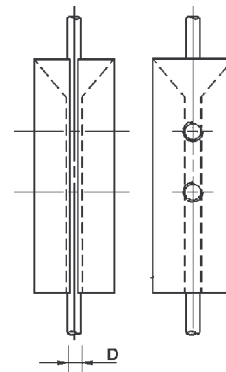
Stub shaft for pressure roller

SAW tubular wire	
Part no	
0212 901 101	

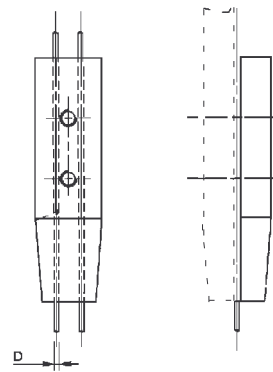


Contact jaws

SAW HD (D35)	
Part no	D (mm)
0265 900 880	3,0
0265 900 881	3,2
0265 900 882	4,0
0265 900 883	5,0
0265 900 884	6,0

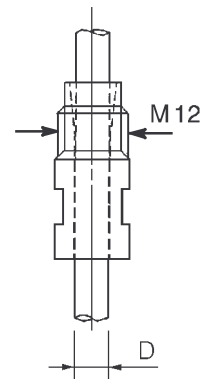


SAW Twin HD	
Part no	D (mm)
0265 902 880	2,5-3,0
0265 902 881	2,0
0265 902 882	1,6
0265 902 883	4,0

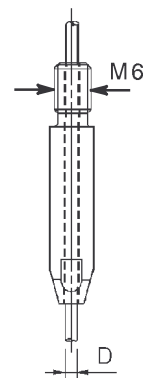


Contact tip

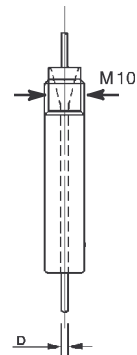
SAW LD (D20)	
Part no	D (mm)
0154 623 003	4,0
0154 623 004	3,2
0154 623 005	3,0
0154 623 006	2,5
0154 623 007	2,0
0154 623 008	1,6



MIG/MAG and SAW Twin LD (D35)	
Part no	D (mm)
0153 501 002	0,8
0153 501 004	1,0
0153 501 005	1,2
0153 501 007	1,6
0153 501 009	2,0
0153 501 010	2,4-2,5

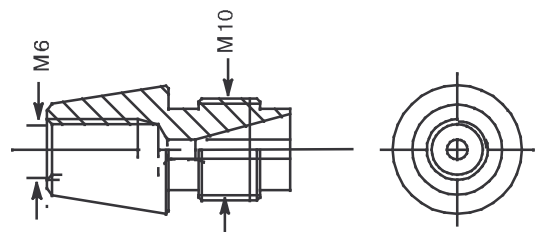


MIG/MAG (D35)	
Part no	D (mm)
0258 000 908	1,2
0258 000 909	1,6
0258 000 910	2,0
0258 000 911	2,4
0258 000 913	1,0
0258 000 914	0,8
0258 000 915	3,2



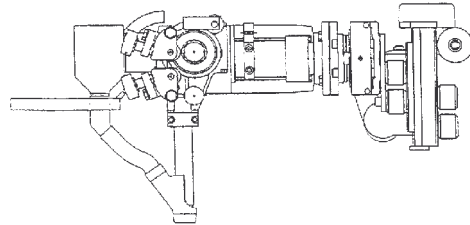
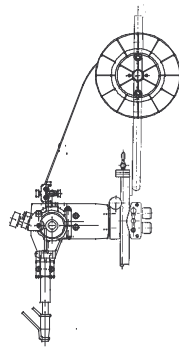
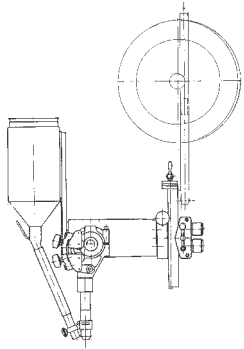
Adapter for contact tip

SAW and MIG/MAG (D35)	
Part no	D (mm)
0147 333 001	M6 / M 10



SPARE PARTS LIST

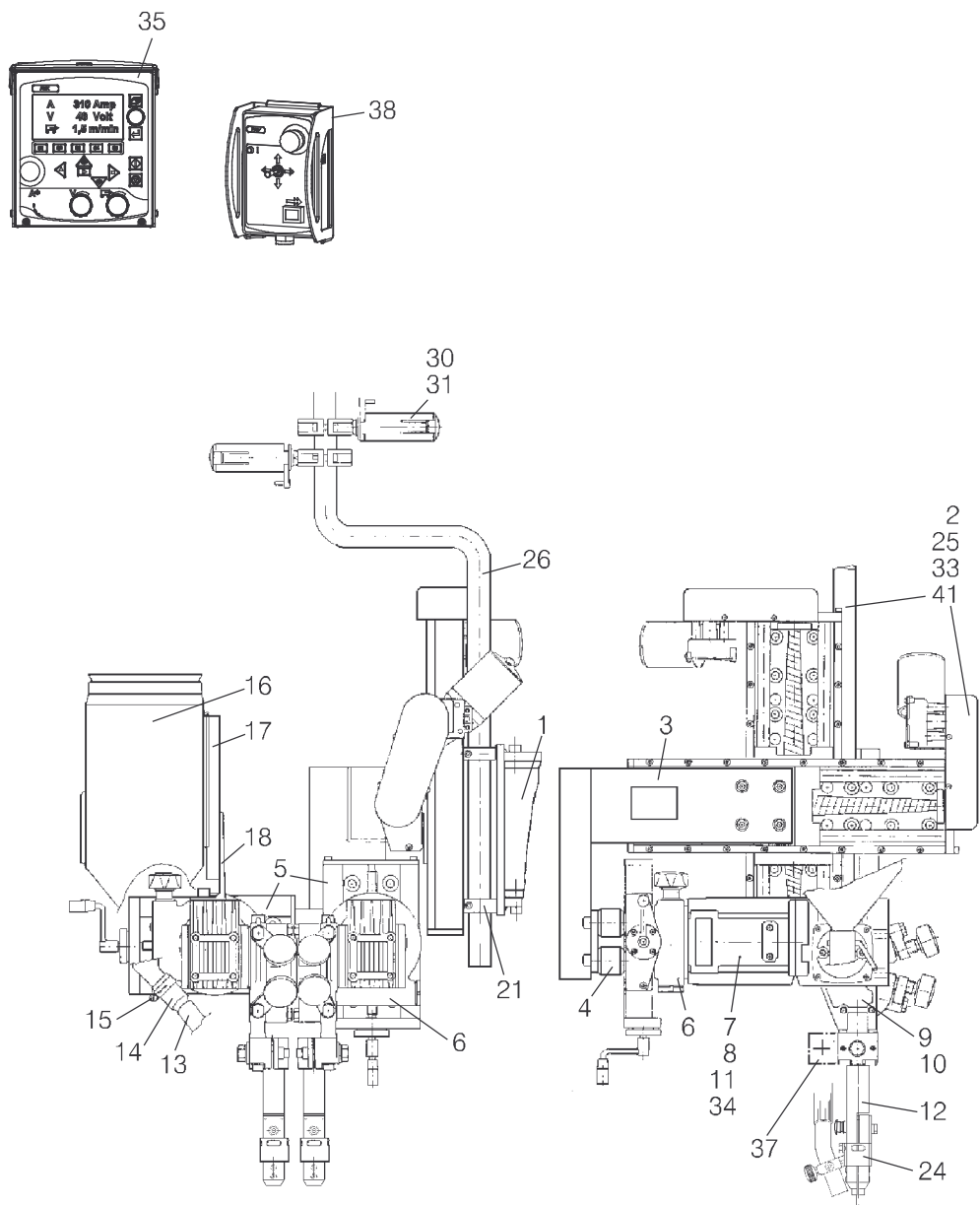
Edition 2009-11-09



Ordering no.	Denomination	Notes
0457720900	A6 SFE2	Welding head with PEK and A6 PAV
0457720903	A6 SFE2	Welding head without PEK
0457720904	A6 SFE2	Welding head without PEK
0457720905	A6 SFE2	Welding head with PEK
0457720907	A6 SFE2	Welding head with PEK
0457720909	A6 SFE2	Welding head with PEK and A6 PAV
0457720911	A6 SFE2	Welding head with PEK, A6 GMH
0457720913	A6 SFE2	Welding head with PEK, A6 GMH
0456563900	A6 SGE1	Welding head without PEK
0456563901	A6 SGE1	Welding head without PEK
0456563902	A6 SGE1	Welding head without PEK
0456563903	A6 SGE1	Welding head without PEK
0456563904	A6 SGE1	Welding head without PEK
0456563905	A6 SGE1	Welding head without PEK
0456563906	A6 SGE1	Welding head without PEK
0456563907	A6 SGE1	Welding head without PEK
0456563908	A6 SGE1	Welding head without PEK
0456564900	A6 SGE1	Welding head with PEK
0456564901	A6 SGE1	Welding head with PEK
0456564902	A6 SGE1	Welding head with PEK
0456564903	A6 SGE1	Welding head with PEK
0456564904	A6 SGE1	Welding head with PEK and A6 PAV
0456564905	A6 SGE1	Welding head with PEK and A6 PAV
0456564906	A6 SGE1	Welding head with PEK and A6 GMH
0456564907	A6 SGE1	Welding head with PEK and A6 GMH
0416967880	A6 Compact 500 (A6-SFE1C)	Welding head

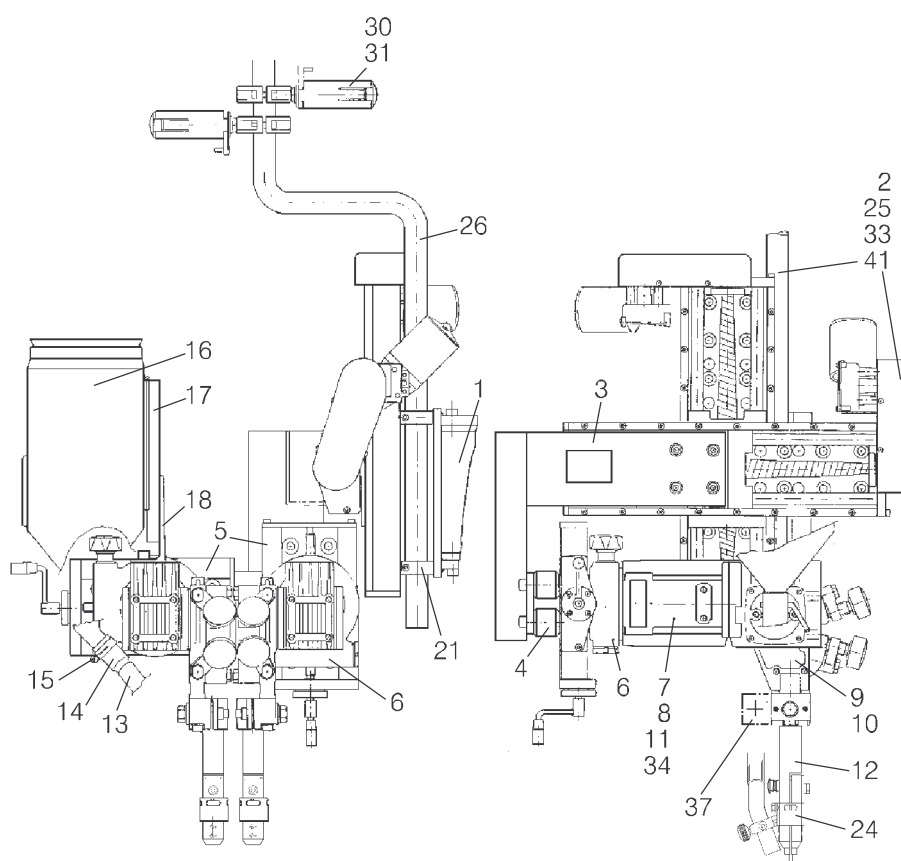
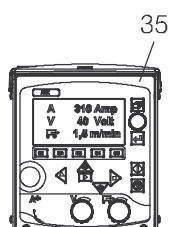
Item no.	Qty	Ordering no.	Denomination	Notes
		0457720900	Welding head with PEK and A6 PAV	A6 SFE2
1	1	0334549880	Swivel Bracket	A6 Slide (L=300), see separate manual
2	2	0334333884	Motorised Slide	
3	1	0334557880	Mounting bracket	200 V
4	8	0278300180	Insulator	
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Angular slide	A6 VEC (156:1), see separate manual
7	1	0145063906	Motor with gear	
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	D35 / L220
12	2	0334290880	Contact Equipment	
13		0333645880	Flux hose	L = 1,000
14	1	0153491001	Branching Tube	10 l
16	1	0147649881	Flux hopper	
17	1	0148487880	Holder	2 m
18	1	0334294001	Bracket	
27	4	0154734001	Brake hub lock	3 m
30	2	0146967880	Brake hub	PEK, see separate manual
33	2	0461241880	Motor cable	3 m
34	2	0460907892	Motor cable	A6 PAV, see separate manual
35	2	0460504880	Control box	3m
37	2	0461239883	Cable (arc voltage)	
38	1	0460697880	Control system for motorised slides	
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	
		0457720903	Welding head	A6 SFE2
1	1	0334549880	Swivel bracket	L = 90
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	A6 VEC (156:1), see separate manual
5	2	0154465880	Slide manually operated	
6	2	0671171580	Angular slide	A6 VEC (156:1), see separate manual
7	1	0145063906	Motor with gear	D35
8	1	0145063896	Motor with gear	D35
9	1	0147639880	Wire straightener (right mounted)	D35 / L220
10	1	0147639880	Wire straightener (right mounted)	
11	2	0218810183	Insulated hand wheel	L = 1,000
12	2	0334290880	Contact Equipment	3 m
13		0333645880	Flux hose	3 m
34	2	0460907892	Motor cable	
37	2	0461239883	Cable (arc voltage)	
80	2	0457713001	Bar	

Item no.	Qty	Ordering no.	Denomination	Notes
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m



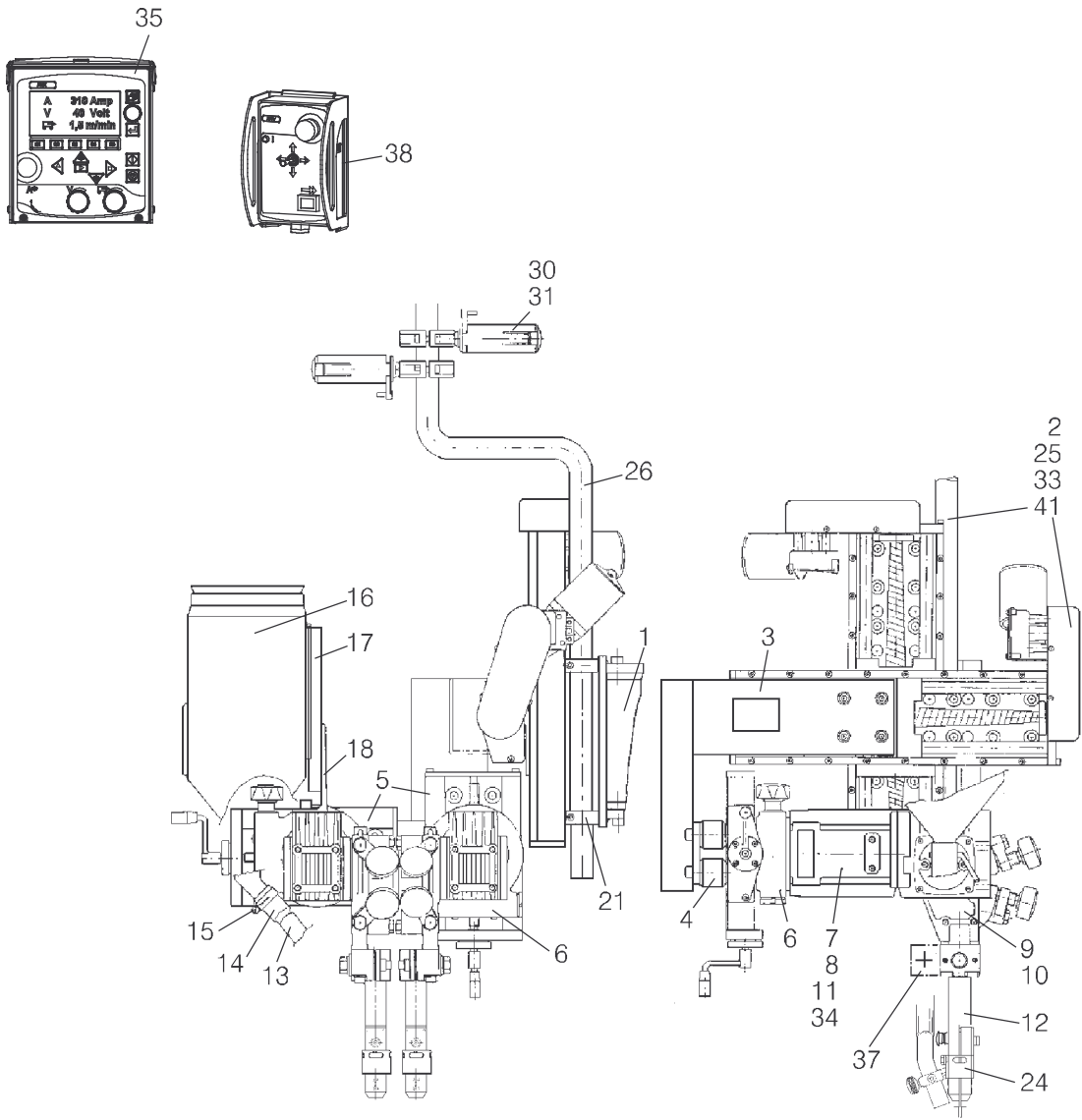
Item no.	Qty	Ordering no.	Denomination	Notes
		0457720904	Welding head	A6 SFE2
1	1	0334549880	Swivel bracket	
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Angular slide	
7	1	0145063906	Motor with gear	A6 VEC (156:1), see separate manual
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	
12	2	0334290880	Contact Equipment	D35 / L220
13		0333645880	Flux hose	L = 1,000
14	1	0153491001	Branching Tube	
16	1	0147649881	Flux hopper	10 l
17	1	0148487880	Holder	
18	1	0334294001	Bracket	
27	4	0154734001	Brake hub lock	
30	2	0146967880	Brake hub	
34	2	0460907892	Motor cable	3 m
37	2	0461239883	Cable (arc voltage)	3 m
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0457720905	Welding head with PEK	A6 SFE2
1	1	0334549880	Swivel bracket	
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Circular slide	
7	1	0145063906	Motor with gear	A6 VEC (156:1), see separate manual
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	
12	2	0334290880	Contact Equipment	D35 / L220
13		0333645880	Flux hose	L = 1,000
14	1	0153491001	Branching Tube	
16	1	0147649881	Flux hopper	10 l
17	1	0148487880	Holder	
18	1	0334294001	Bracket	
27	4	0154734001	Brake hub lock	
30	2	0146967880	Brake hub	
34	2	0460907892	Motor cable	3 m

Item no.	Qty	Ordering no.	Denomination	Notes
35	2	0460504880	Control box	PEK, see separate manual 3 m 3m
37	2	0461239883	Cable (arc voltage)	
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	



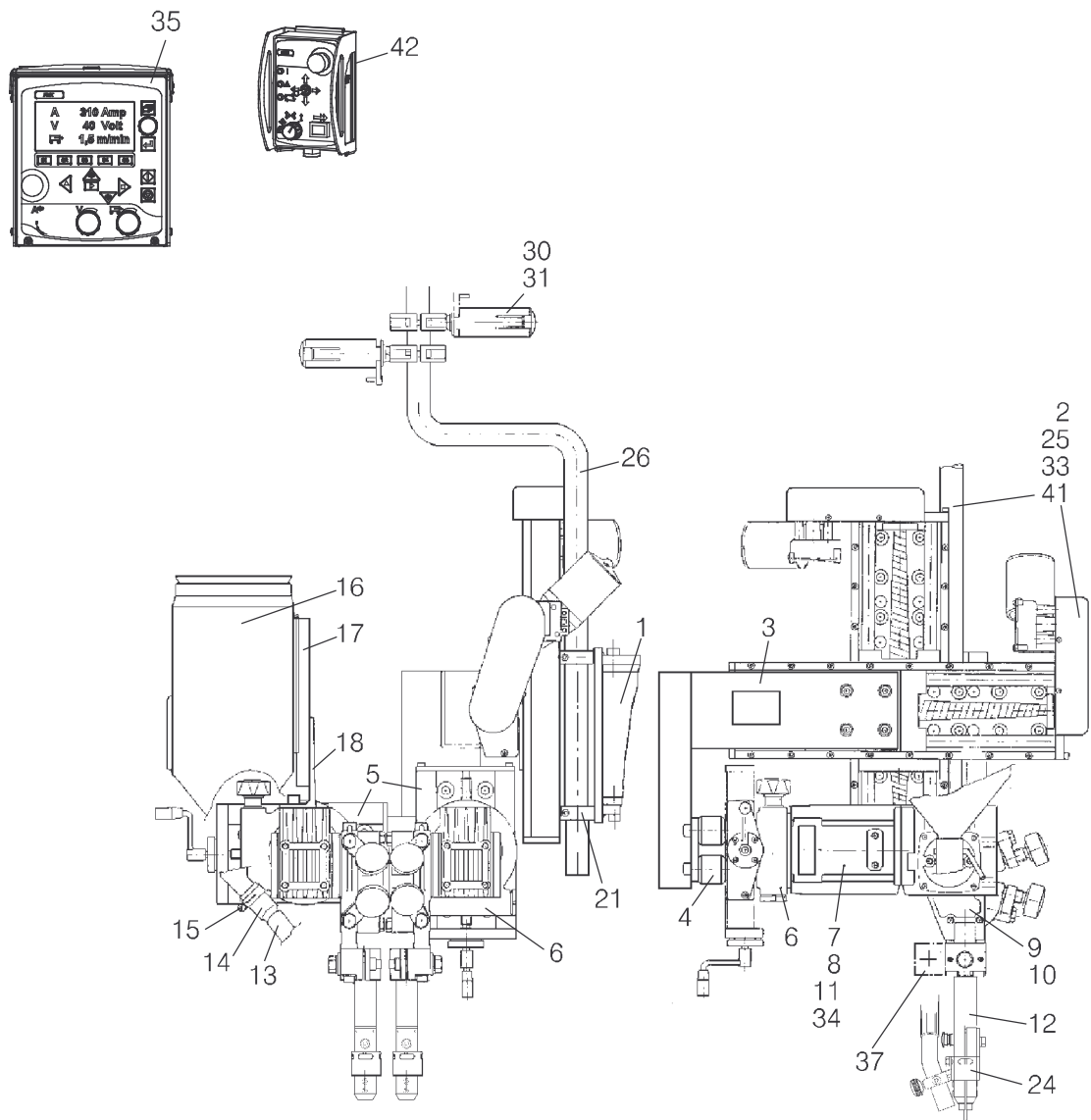
Item no.	Qty	Ordering no.	Denomination	Notes
		0457720907	Welding head with PEK	A6 SFE2
1	1	0334549880	Swivel bracket	
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Circular slide	
7	1	0145063906	Motor with gear	A6 VEC (156:1), see separate manual
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	
12	2	0334290880	Contact Equipment	D35 / L220
13		0333645880	Flux hose	L = 1,000
14	1	0153491001	Branching Tube	
16	1	0147649881	Flux hopper	10 l
17	1	0148487880	Holder	
18	1	0334294001	Bracket	
27	4	0154734001	Brake hub lock	
30	2	0146967880	Brake hub	
34	2	0460907892	Motor cable	3 m
35	2	0460504880	Control box	PEK, see separate manual
37	2	0461239883	Cable (arc voltage)	3 m
41	2	0154465881	Slide manually operated	L = 210
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0457720909	Welding head with PEK and A6 PAV	A6 SFE2
1	1	0334549880	Swivel Bracket	
2	2	0334333884	Motorised Slide	A6 Slide (L=300), see separate manual
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	200 V
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Angular slide	
7	1	0145063906	Motor with gear	A6 VEC (156:1), see separate manual
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	
12	2	0334290880	Contact Equipment	D35 / L220
33	2	0461241880	Motor cable	2 m
34	2	0460907892	Motor cable	3 m
35	2	0460504880	Control box	PEK, see separate manual
37	2	0461239883	Cable (arc voltage)	3 m
38	1	0460697880	Control system for motorised slides	A6 PAV, see separate manual

Item no.	Qty	Ordering no.	Denomination	Notes
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m

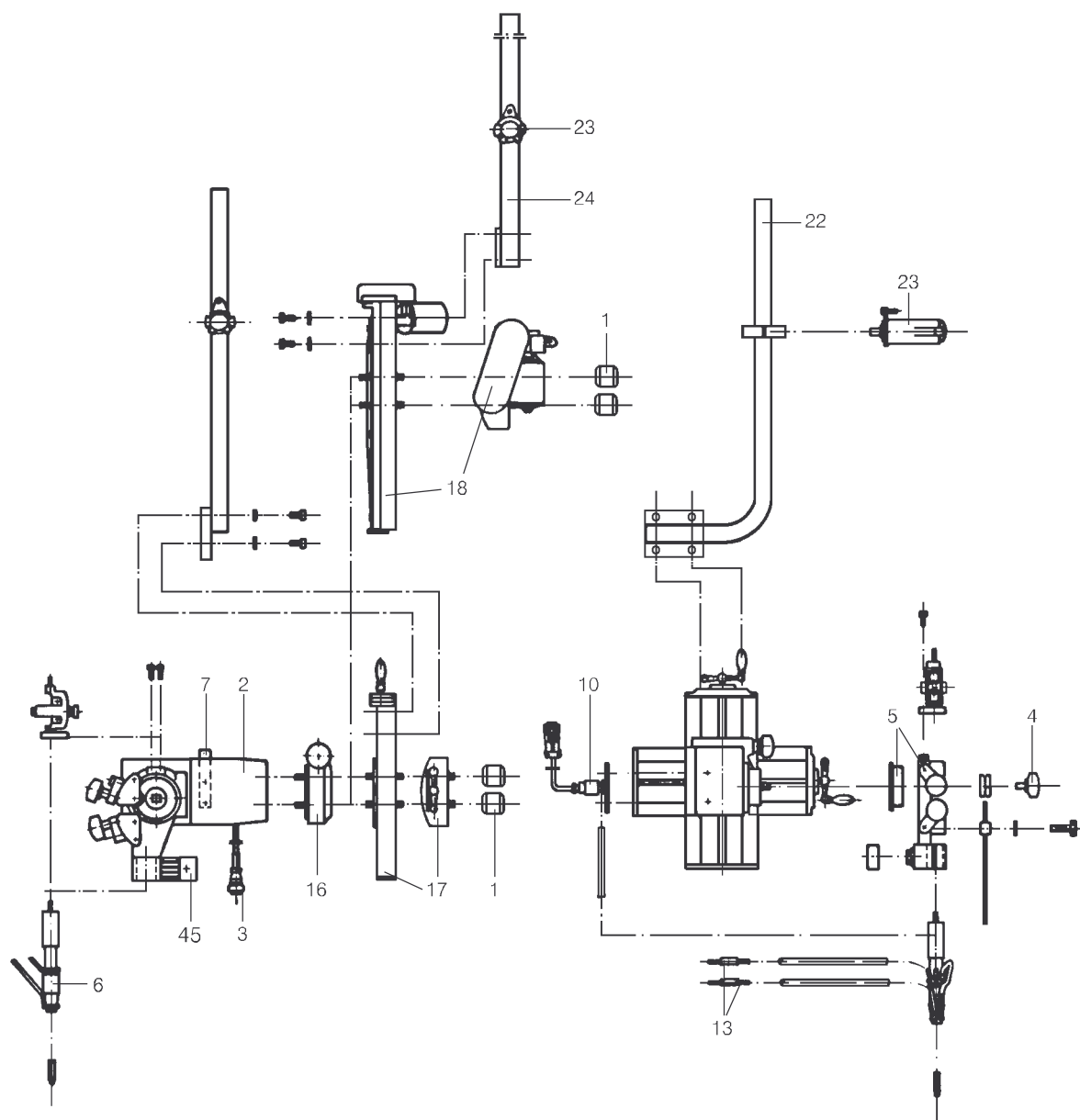


Item no.	Qty	Ordering no.	Denomination	Notes
		0457720911	Welding head with PEK, A6 GMH	A6 SFE2
1	1	0334549880	Swivel bracket	
2	2	0334333884	Motorised Slide	A6 Slide (L=300), see separate manual
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	200 V
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Angular slide	
7	1	0145063906	Motor with gear	A6 VEC (156:1), see separate manual
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	
12	2	0334290880	Contact Equipment	D35 / L220
33	2	0461241880	Motor cable	2 m
34	2	0460907892	Motor cable	3 m
35	2	0460504880	Control box	PEK, see separate manual
37	2	0461239883	Cable (arc voltage)	3 m
42	1	0460884880	Joint tracking equipment	A6 GMH, see separate manual
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0457720913	Welding head with PEK, A6 GMH	A6 SFE2
1	1	0334549880	Swivel bracket	
2	2	0334333884	Motorised Slide	A6 Slide (L=300), see separate manual
3	1	0334557880	Mounting bracket	
4	8	0278300180	Insulator	200 V
5	2	0154465880	Slide manually operated	L = 90
6	2	0671171580	Angular slide	
7	1	0145063906	Motor with gear	A6 VEC (156:1), see separate manual
8	1	0145063896	Motor with gear	A6 VEC (156:1), see separate manual
9	1	0147639880	Wire straightener (right mounted)	D35
10	1	0147639880	Wire straightener (right mounted)	D35
11	2	0218810183	Insulated hand wheel	
12	2	0334290880	Contact Equipment	D35 / L220
13		0333645880	Flux hose	L = 1,000
14	1	0153491001	Branching Tube	
16	1	0147649881	Flux hopper	10 l
17	1	0148487880	Holder	
18	1	0334294001	Bracket	
27	4	0154734001	Brake hub lock	
30	2	0146967880	Brake hub	
33	2	0461241880	Motor cable	2 m
34	2	0460907892	Motor cable	3 m
35	2	0460504880	Control box	PEK, see separate manual

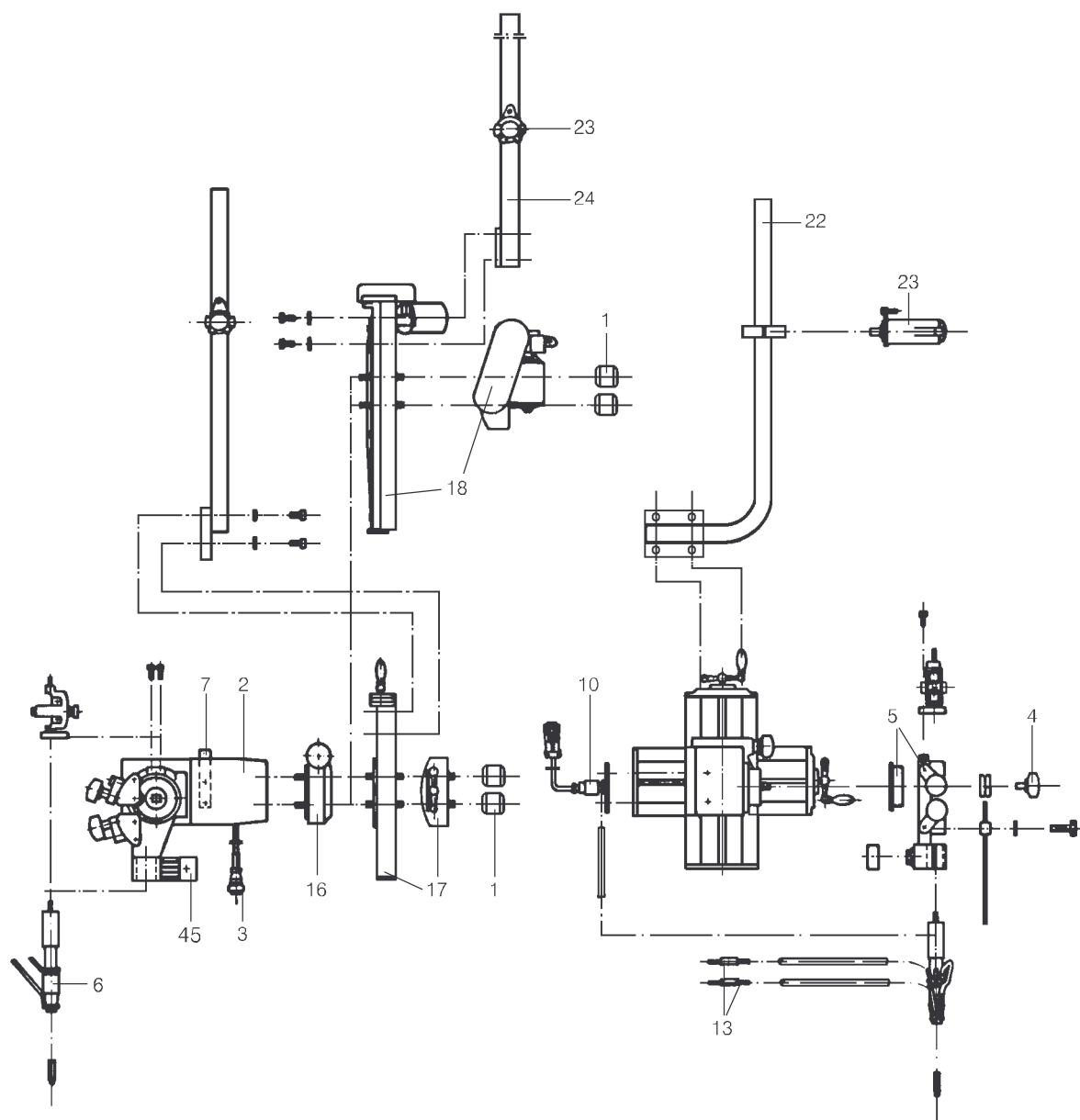
Item no.	Qty	Ordering no.	Denomination	Notes
37	2	0461239883	Cable (arc voltage)	3 m
42	1	0460884880	Joint tracking equipment	A6 GMH, see separate manual
80	2	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m



Item no.	Qty	Ordering no.	Denomination	Notes
		0456563900	Welding head	A6 SGE1
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0456563901	Welding head	A6 SGE1
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
22	1	0147328880	Reel holder (bent)	
23	1	0146967880	Brake hub	
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m

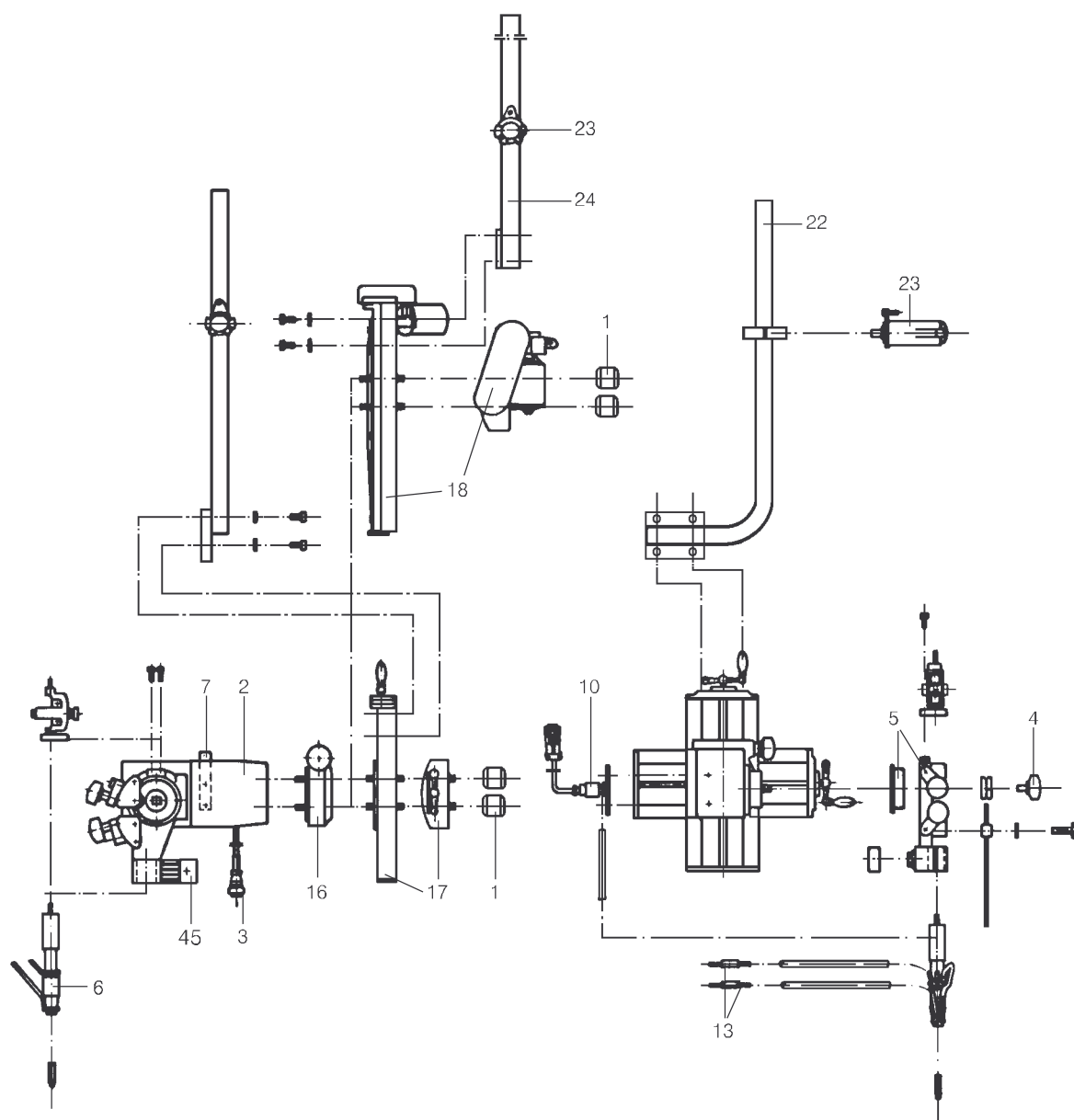


Item no.	Qty	Ordering no.	Denomination	Notes
		0456563902	Welding head	A6 SGE1
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
23	1	0146967880	Brake hub	
24	1	0334318880	Reel holder, straight	
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0456563903	Welding head	A6 SGE1
1	4	0278300180	Insulator	2000 V
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
16	1	0671171580	Angular slide	
17	2	0154465881	Slide, manually operated	L=210
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m

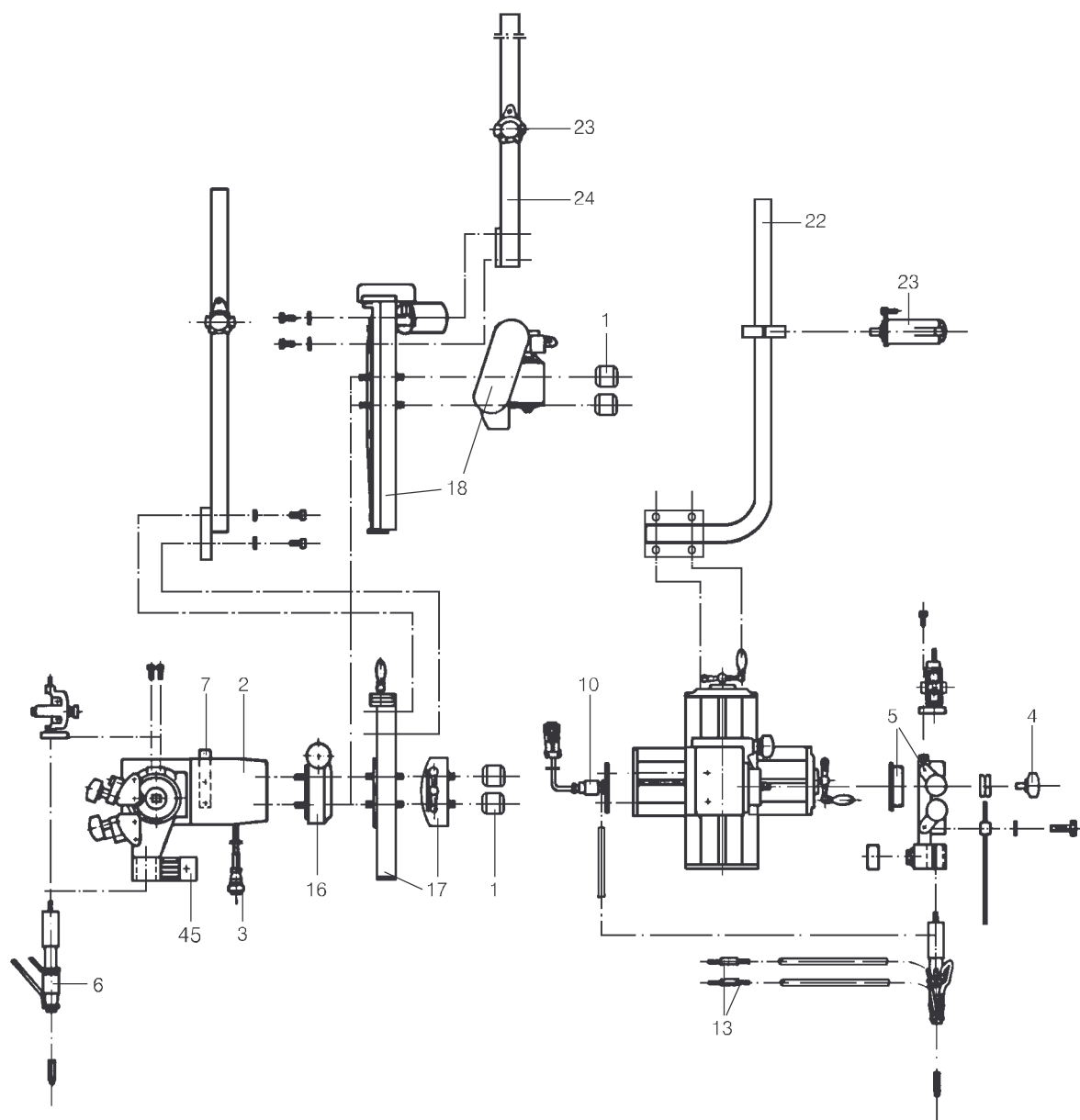


Item no.	Qty	Ordering no.	Denomination	Notes
		0456563904	Welding head	A6 SGE1
1	4	0278300180	Insulator	2000 V
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
16	1	0671171580	Angular slide	
17	2	0154465881	Slide, manually operated	L=210
22	1	0443510880	Reel holder (bent)	
23	1	0146967880	Brake hub	
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0456563905	Automatic welding	A6 SGE1
1	4	0278300180	Insulator	2000 V
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
16	1	0671171580	Angular slide	
18	2	0334333884	Motorised slides	A6 Slide (L=300), see separate manual
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0456563906	Automatic welding	A6 SGE1
1	4	0278300180	Insulator	2000 V
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	

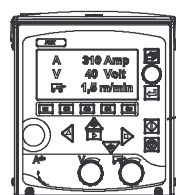
Item no.	Qty	Ordering no.	Denomination	Notes
16	1	0671171580	Angular slide	A6 Slide (L=300), see separate manual
18	2	0334333884	Motorised slides	
23	1	0146967880	Brake hub	
24	1	0334318880	Reel holder, straight	
45	1	0461239883	Cable (arc voltage)	
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m



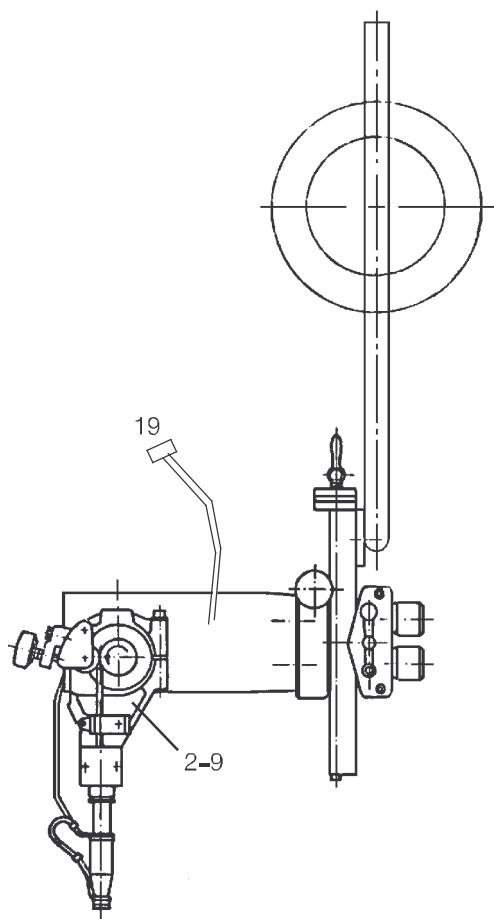
Item no.	Qty	Ordering no.	Denomination	Notes
		0456563907	Welding head	A6 SGE1
1	4	0278300180	Insulator	2000 V
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
16	1	0671171580	Angular slide	
18	2	0334333884	Motorised slides	A6 Slide (L=300), see separate manual
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m
		0456563908	Welding head	A6 SGE1
1	4	0278300180	Insulator	2000 V
2	1	0145063909	Motor with gear	A6 VEC (74:1), see separate manual
3	1	0460907892	Cable	L= 3 m
4	1	0218810183	Handwheel	
5	1	0147639880	Wire straightener (right mounted)	D35
6	1	0030465385	Connector	D35
7	1	0148493001	Cable holder	
10	1	0461238880	Solenoid valve with cable	
13	2	0147336880	Hose connection	
16	1	0671171580	Angular slide	
18	2	0334333884	Motorised slides	A6 Slide (L=300), see separate manual
23	1	0146967880	Brake hub	
24	1	0334318880	Reel holder, straight	
45	1	0461239883	Cable (arc voltage)	3.0 m
80	1	0457713001	Bar	
93	2	0449498880	Junction box complete	
94	2	0460908892	Encoder cable	3m



Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0456564900	Welding head with PEK	A6 SGE1
2	1	0460504880	Control box	PEK, see separate manual
3	1	0456563901	Welding head	
1	1	0456564901	Welding head with PEK	A6 SGE1
3	1	0460504880	Control box	PEK, see separate manual
4	1	0456563902	Welding head	
1	1	0456564902	Welding head with PEK	A6 SGE1
4	1	0460504880	Control box	PEK, see separate manual
5	1	0456563903	Welding head	
1	1	0456564903	Welding head with PEK	A6 SGE1
5	1	0460504880	Control box	PEK, see separate manual
5	1	0456563904	Welding head	



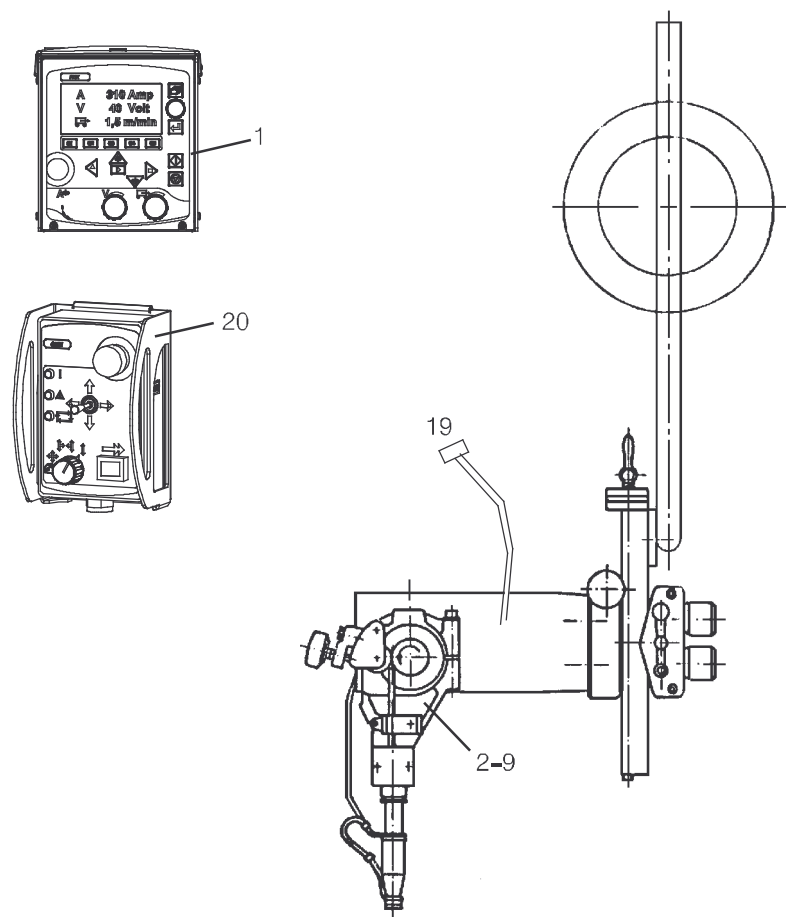
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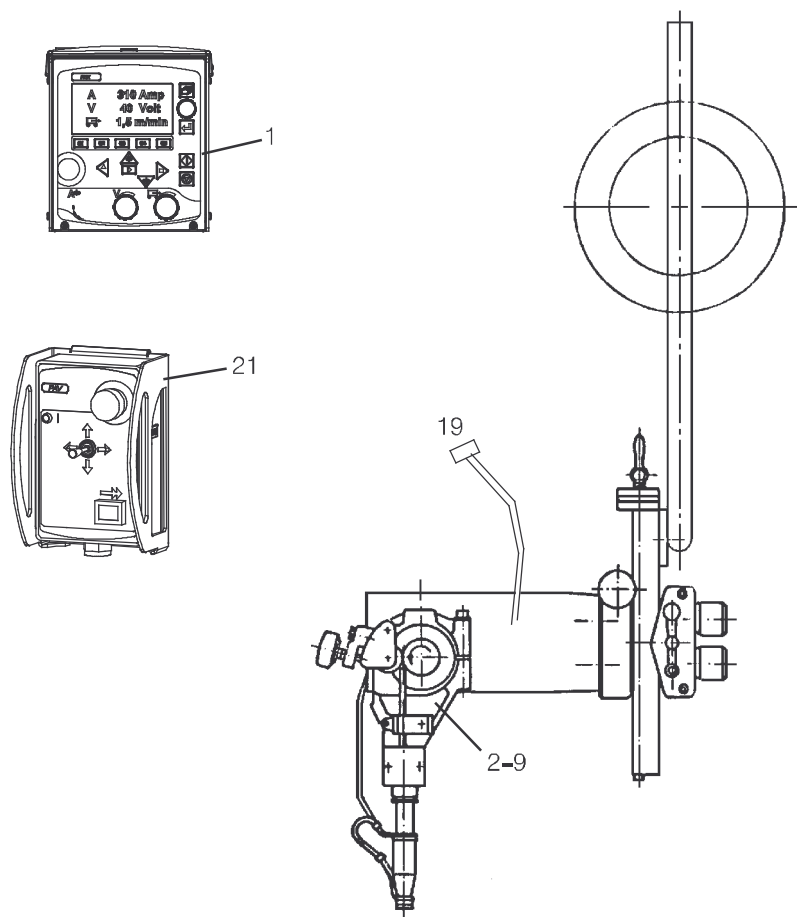
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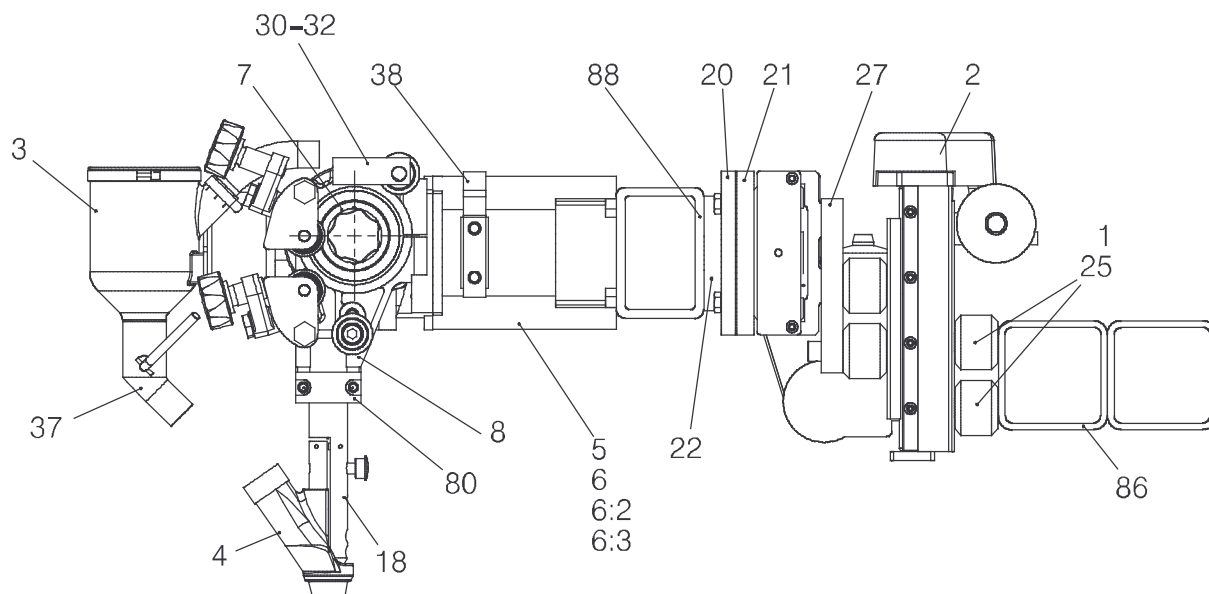
Item no.	Qty	Ordering no.	Denomination	Notes
		0456564904	Welding head with PEK and A6 PAV	A6 SGE1
1	1	0460504880	Control box	PEK, see separate manual
6	1	0456563905	Welding head	
19	2	0461241880	Motor cable	2.0 m
20	1	0460697880	Control system for motorised slides	A6 PAV, see separate manual
30	1	0190313105	Spiral	d 19/15
31	1	0190313111	Spiral	d 56/50
		0456564905	Welding head with PEK and A6 PAV	A6 SGE1
1	1	0460504880	Control box	PEK, see separate manual
7	1	0456563906	Welding head	
19	2	0461241880	Motor cable	2.0 m
20	1	0460697880	Control system for motorised slides	A6 PAV, see separate manual
30	1	0190313105	Spiral	d 19/15
31	1	0190313111	Spiral	d 56/50



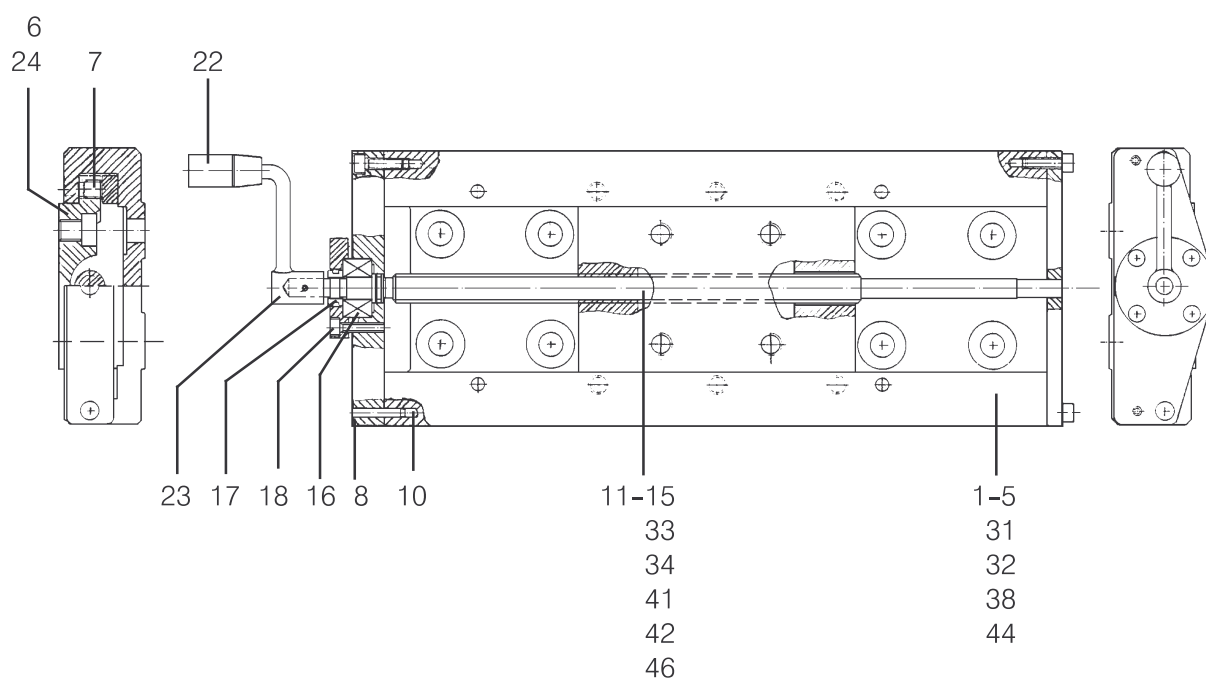
Item no.	Qty	Ordering no.	Denomination	Notes
		0456564906	Welding head with PEK and A6 GMH	A6 SGE1
1	1	0460504880	Control box	PEK, see separate manual
8	1	0456563907	Welding head	
19	2	0461241880	Motor cable	2.0 m
21	1	0460884880	Joint-tracking equipment	A6 GMH, see separate manual
30	1	0190313105	Spiral	d 19/15
31	1	0190313111	Spiral	d 56/50
		0456564907	Welding head with PEK and A6 GMH	A6 SGE1
1	1	0460504880	Control box	PEK, see separate manual
9	1	0456563908	Welding head	
19	2	0461241880	Motor cable	2.0 m
21	1	0460884880	Joint-tracking equipment	A6 GMH, see separate manual
30	1	0190313105	Spiral	d 19/15
31	1	0190313111	Spiral	d 56/50



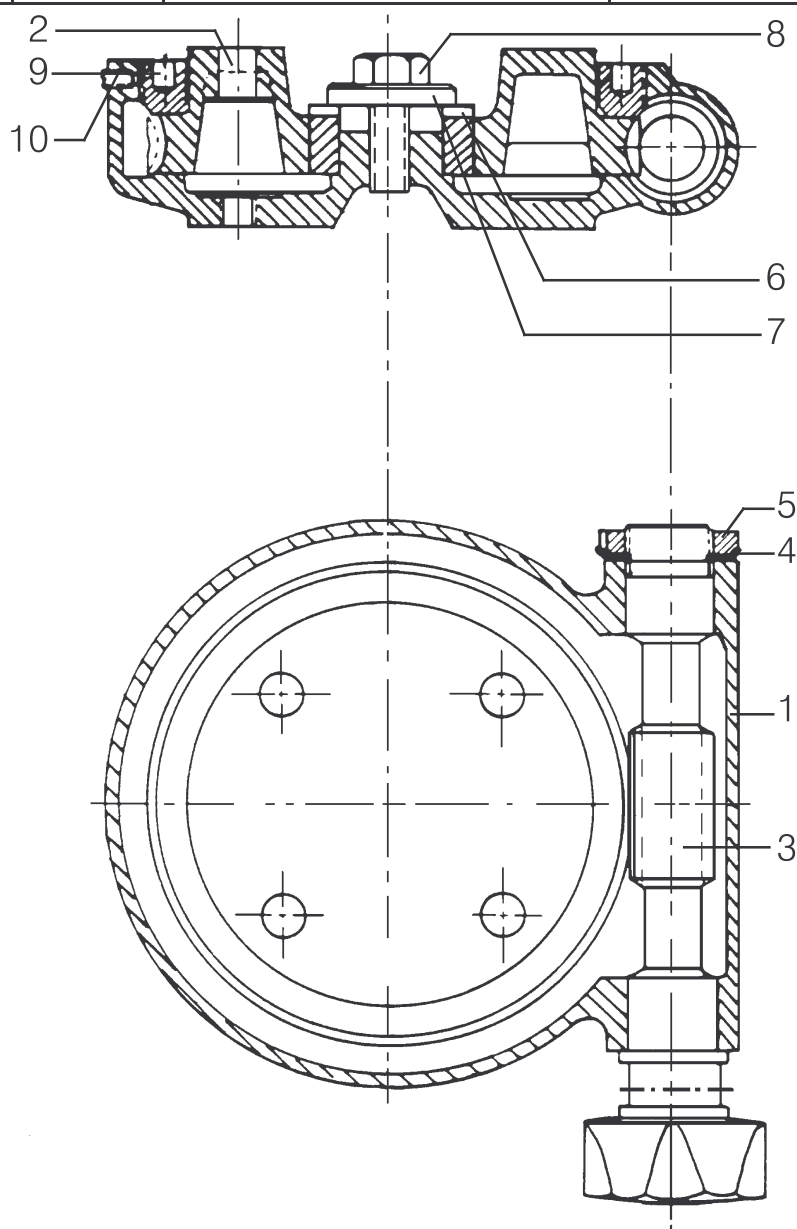
Item no.	Qty	Ordering no.	Denomination	Notes
		0416967880	Welding head	A6 Compact 500 (A6-SFE1C)
1	8	0278300180	Insulator	2000 V.
2	2	0334333880	Motorised slide	A6 Slide (l=60), see separate manual
3	1	0153856884	Flux hopper with flux valve	1 l
4	1	0254900880	Flux funnel	
5	1	0145063896	Motor with gear	A6 VEC (4000rpm, 156:1), see separate manual
6	1	0449253882	Cable unit	L =5
6:2	1	0456490883	Motor cable	5.0m
63	1	0456504884	Cable (arc-voltage)	5m
7	1	0218810183	Insulated hand wheel	
8	1	0147639889	Wire straightener (right mounted)	D35
18	1	0417959886	Contact device	hd l=180
20	1	0334170001	Clamping ring	
21	1	0334171001	Plate	
22	1	0334172001	Gear bracket	
25	4	0212204527	Stop screw	SK6SS
27	1	0411408001	Mounting plate	
30	1	0416955001	Attachment for roller	
31	1	0153148880	Pressure roller	
32	1	0332411880	Stub shaft with washer	
37		0443383001	Flux hose	d32/25
38	1	0416957001	Wire conduit mount	
80	1	0457713001	Bar	
86	1	0806265880	Bracket	
88	1	0811053001	Bracket	



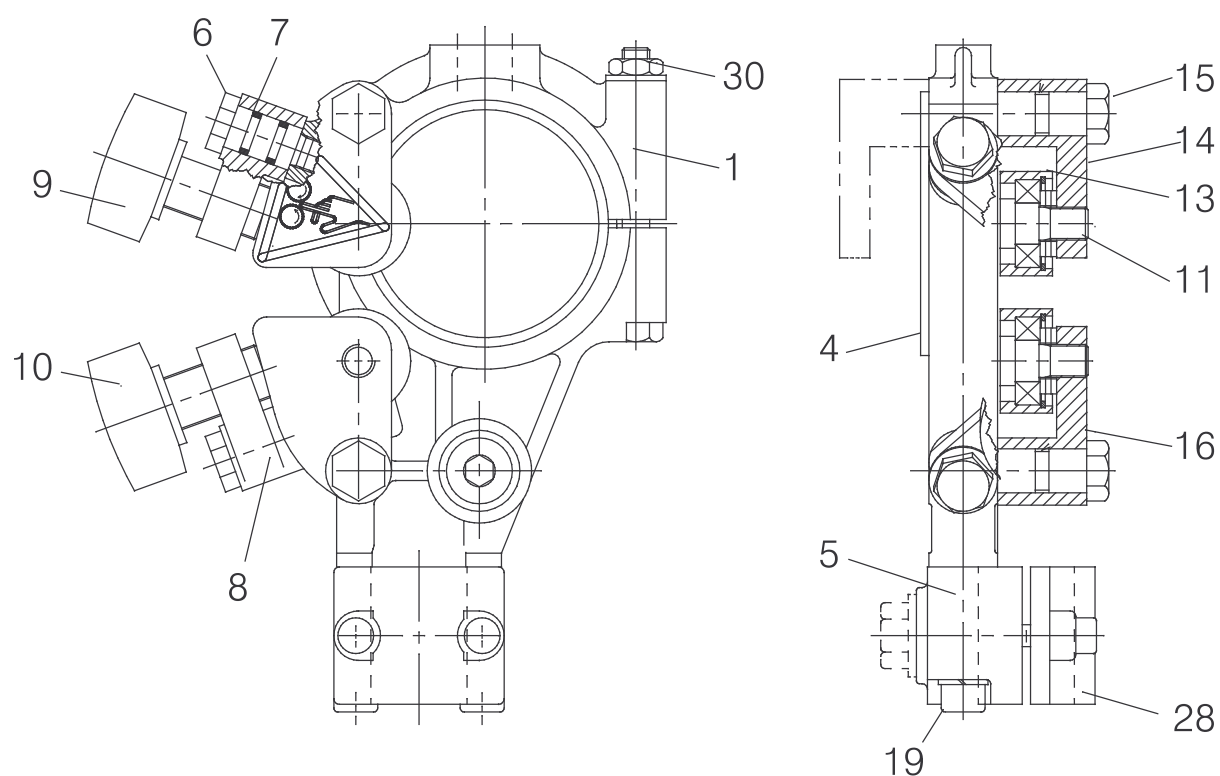
Item	Qty	Orderingno.	Denomination	Remarks
		0154465880	Slide, manually operated	L=90
1	1	0154464001	Slide frame	
6	1	0154463880	Carriage with slide rails	
7	6	0190509485	Stop screw	M10x10
8	1	0154458001	End piece	
10	2	0211102957	Roll pin	D5x20
11	1	0154461001	Lead screw	
16	1	0190531201	Ball bearing	SKF 3201
17	1	0154456001	Lock nut	
18	1	0154457001	Ball bearing cap	
22	1	0334537001	Handle crank	
23	1	0211102938	Roll pin	D3x20
		0154465881	Slide, manually operated	
2	1	0154464002	Slide frame	
6	1	0154463880	Carriage with slide rails	
7	6	0190509485	Stop screw	M10x10
8	1	0154458001	End piece	
10	2	0211102957	Roll pin	D5x20
12	1	0154461002	Lead screw	
16	1	0190531201	Ball bearing	SKF 3201
17	1	0154456001	Lock nut	
18	1	0154457001	Ball bearing cap	
22	1	0334537001	Handle crank	
23	1	0211102938	Roll pin	D3x20



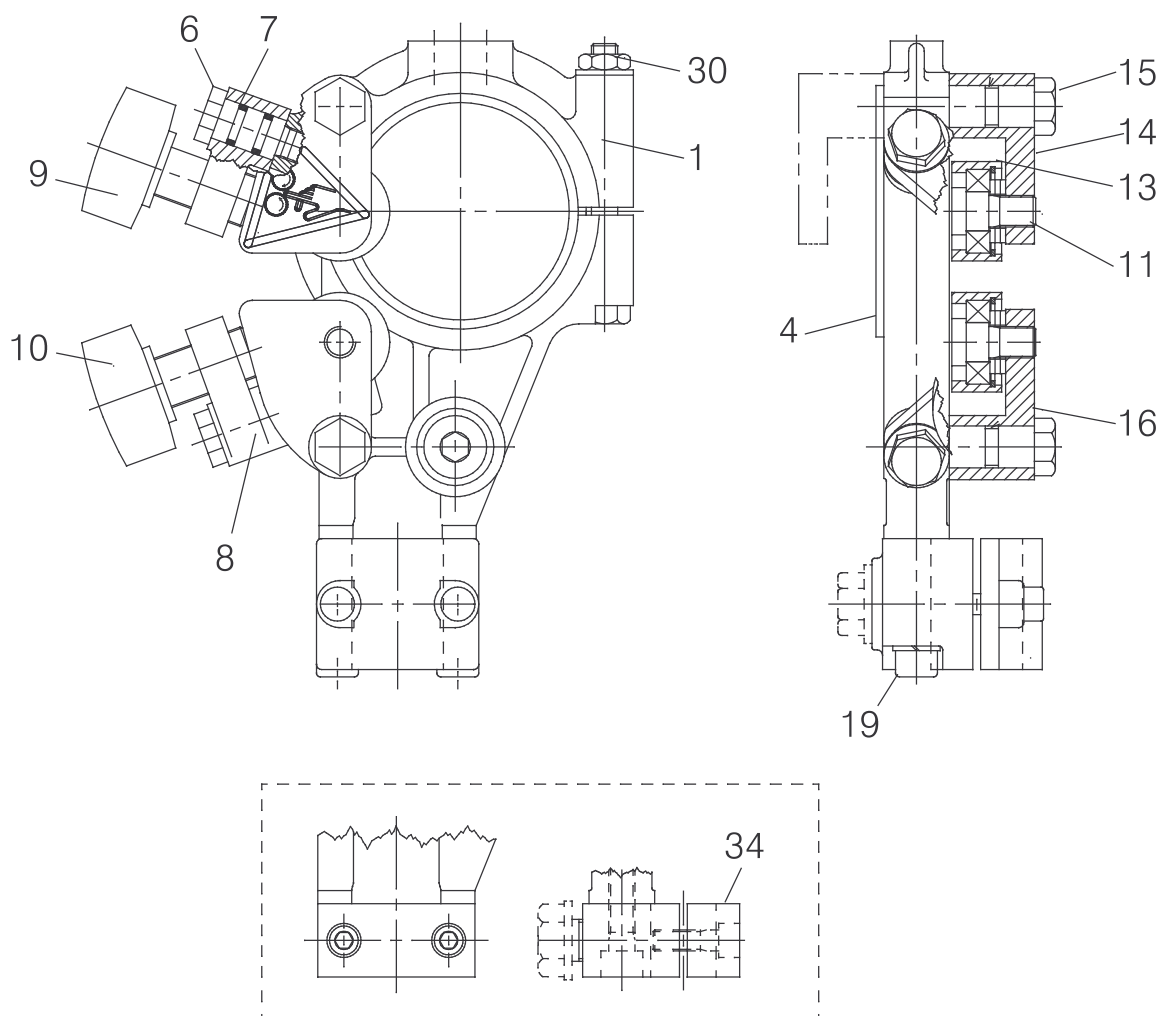
Item	Qty	Orderingno.	Denomination	Remarks
		0671171580	Angular slide	
1	1	0232601901	Housing (casing)	
2	1	0232303101	Worm wheel	
3	1	0040644080	Worm screw	
4	1	0215401206	Locking washer	D25
5	1	0215401306	Nut	
6	1	0218522301	Eccentric bushing	
7	1	0215100204	Washer	D36/13x6
8	1	0212101628	Screw	M12x30
9	1	0212911101	Screw	
10	1	0212204346	Stop screw	M5x12



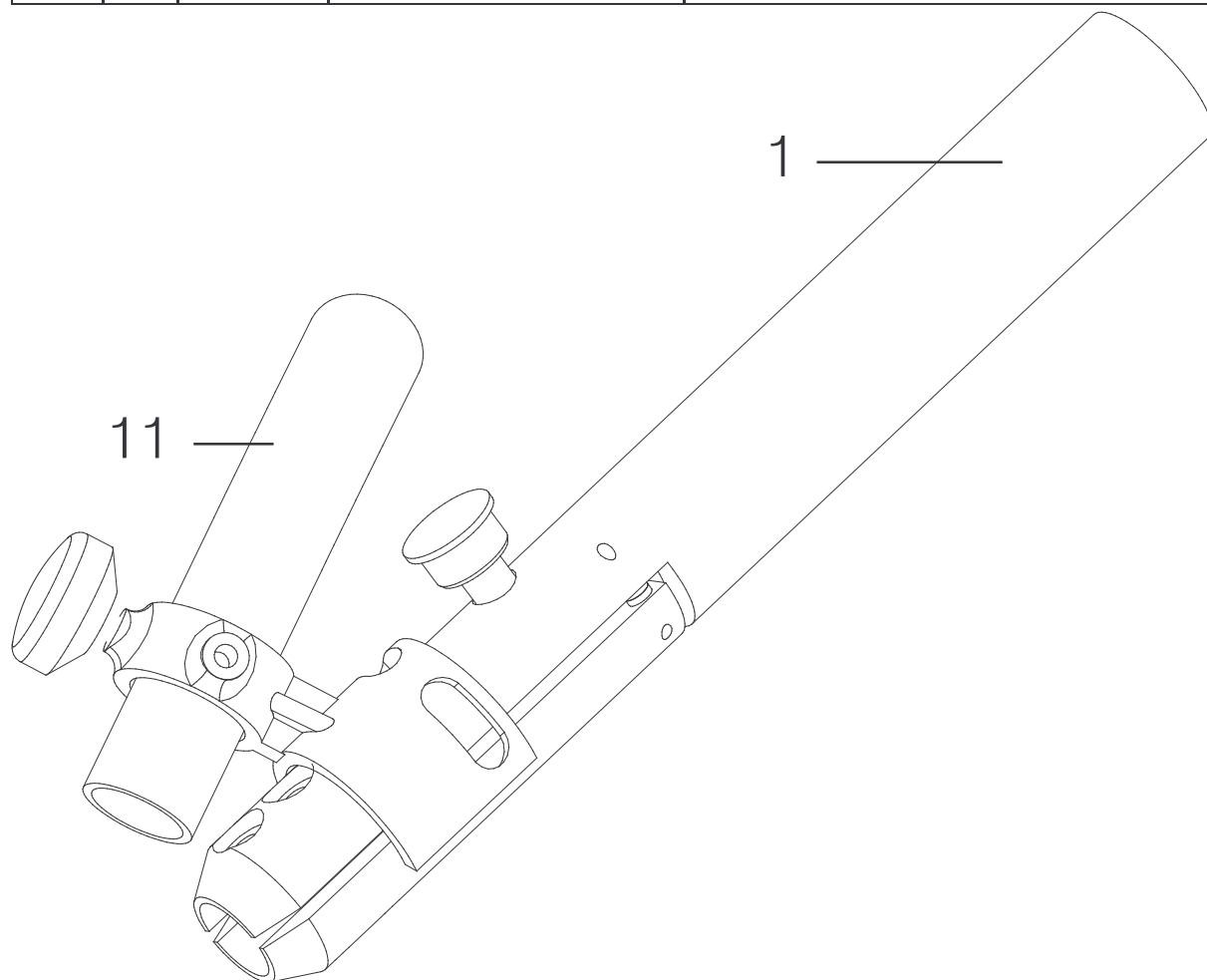
Item no.	Qty	Ordering no.	Denomination	Notes
		0147639880	Wire straightener(right mounted)	
1	1	0156449001	Clamp	D35
4	1	0215503601	Insulating sleeve	
5	1	0156530001	Clamp half	
6	2	0212900001	Spacer screw	
7	4	0215201209	Sealing, O-ring	D11.3x2.4
8	2	0218400801	Pressure roller arm	
9	1	0218810181	Handwheel, insulated	
10	1	0218810182	Handwheel, insulated	
11	3	0332408001	Stub shaft	D18.1/10.2
13	3	0153148880	Pressure roller	
14	1	0415498001	Pressure roller, upper	
15	2	0212902601	Spacer screw	
16	1	0415499001	Pressure roller, lower	D35
19	2	0219501013	Spring washer	
28	1	0156531001	Clamp half	
30	1	0212 601110	Nut	



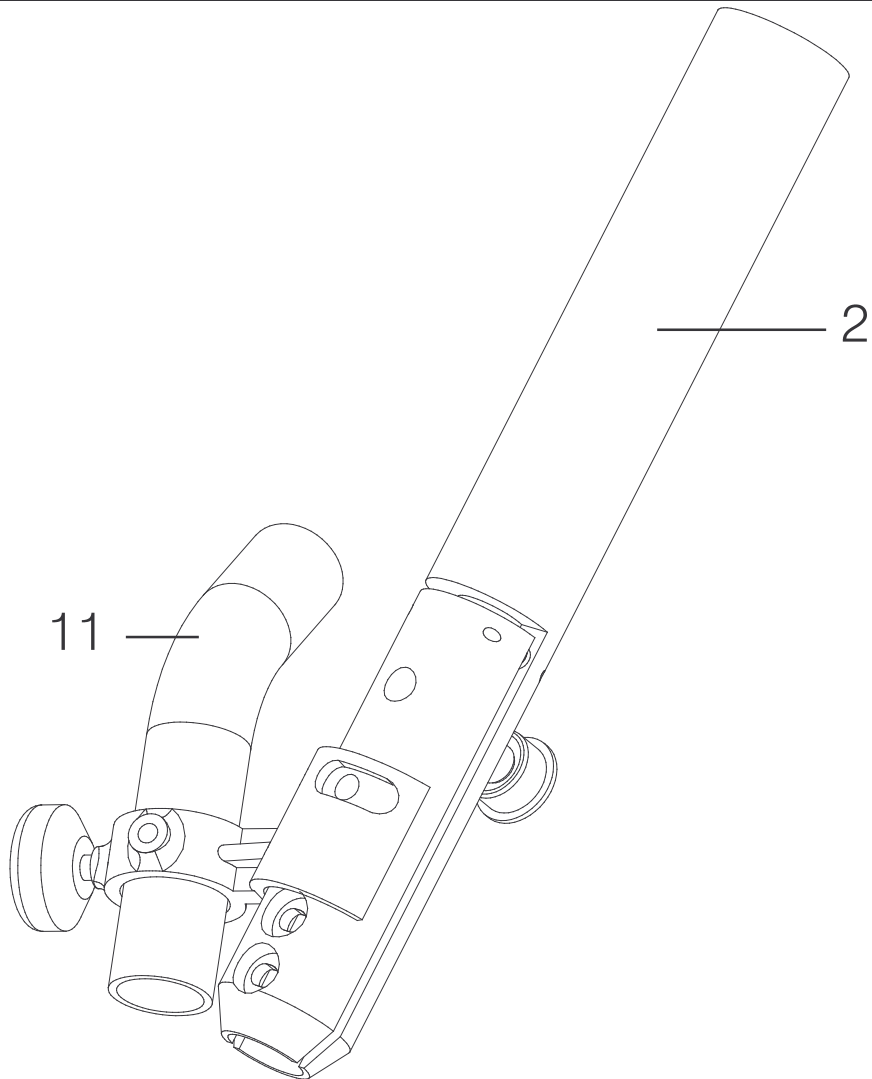
Item no.	Qty	Ordering no.	Denomination	Notes
		0147639889	Wire straightener(right mounted)	A6 S COMPACT 500 (A6 SFE1C)
1	1	0156449001	Clamp	11,3x2,4
4	1	0215503601	Insulating sleeve	
6	2	0212900001	Spacer screw	
7	4	0215201209	OSealing, O-ring	
8	2	0218400801	Pressure roller arm	
9	1	0218810181	Insulated hand wheel	
10	1	0218810182	Insulated hand wheel	
11	3	0332408001	Stub shaft	
13	3	0153148880	Pressure roller	
14	1	0415498001	Pressure roller, upper	
15	2	0212902601	Spacer screw	a2/a6 d18,1/10,2 M10 D 35
16	1	0415499001	Pressure roller, lower	
19	2	0219501013	Spring washer	
30	1	0212601110	Nut	
34	1	0416956001	Contact clip	



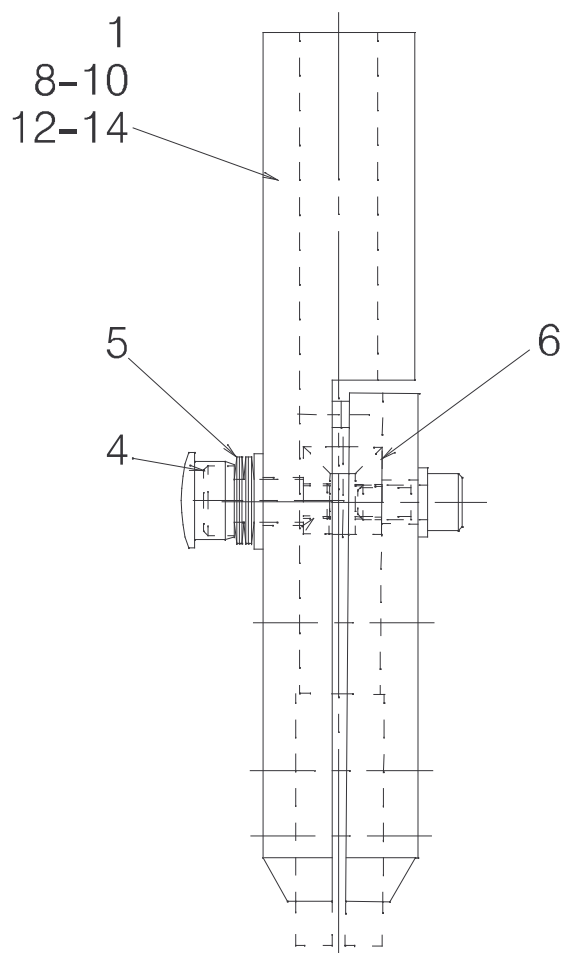
Item	Qty	Orderingno.	Denomination	Remarks
1	1	0334290880	Contact equipment single wire	D35
11	1	0417959880	Contact jaw tube	L=220
11	1	0153299880	Flux nozzle complete	



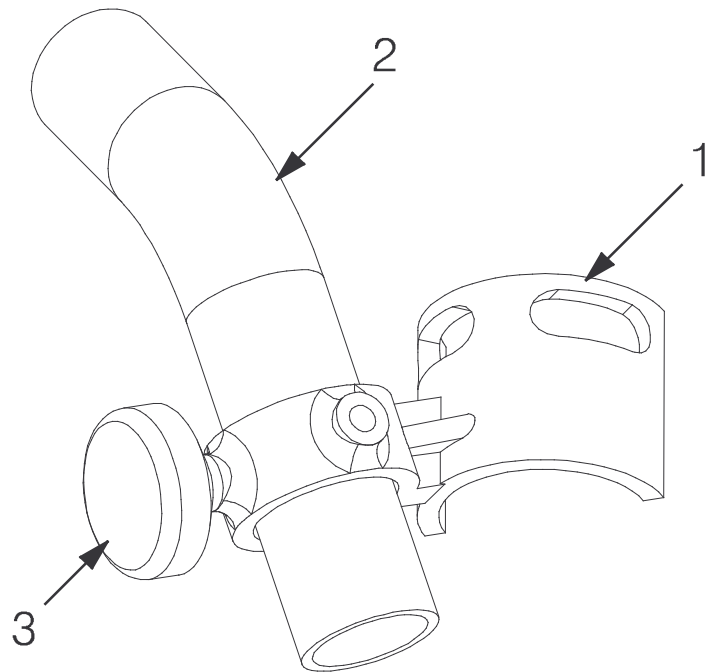
Item	Qty	Orderingno.	Denomination	Remarks
2	1	0334290882	Contact equipment single wire	D35
11	1	0417959881	Contact jaw tube	L=275
		0153299880	Flux nozzle complete	



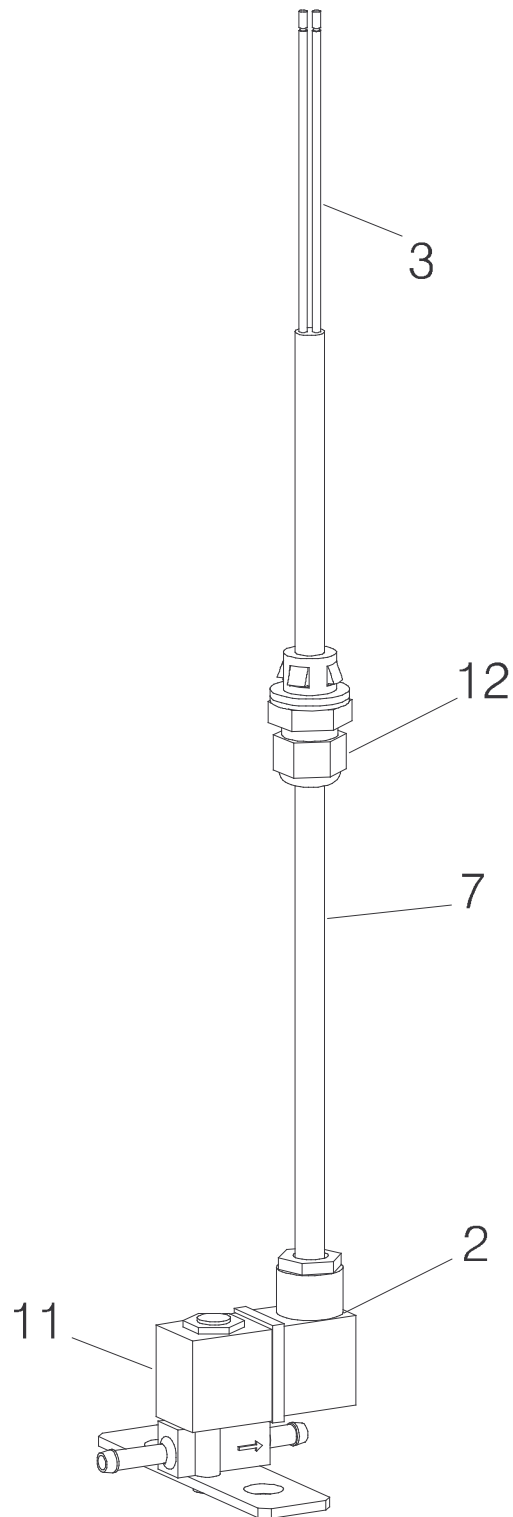
Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0417959880	Contact jaw tube	L = 220mm
4	1	0443344880	Contact tube	L = 220 mm
5	4	0219504307	Cup spring	d20/10.2, T=1.1
6	1	0417979001	Ring	
4	1	0417959881	Contact jaw tube	L = 275 mm
5	4	0219504307	Cup spring	d20/10.2, T=1.1
6	1	0417979001	Ring	
8	1	0443344881	Contact tube	L = 275 mm
1	1	0417959886	Contact jaw tube	L = 180
4	1	0443344885	Contact tube	L = 180 mm
5	4	0219504307	Cup spring	d20/10.2, T=1.1
6	1	0417979001	Ring	



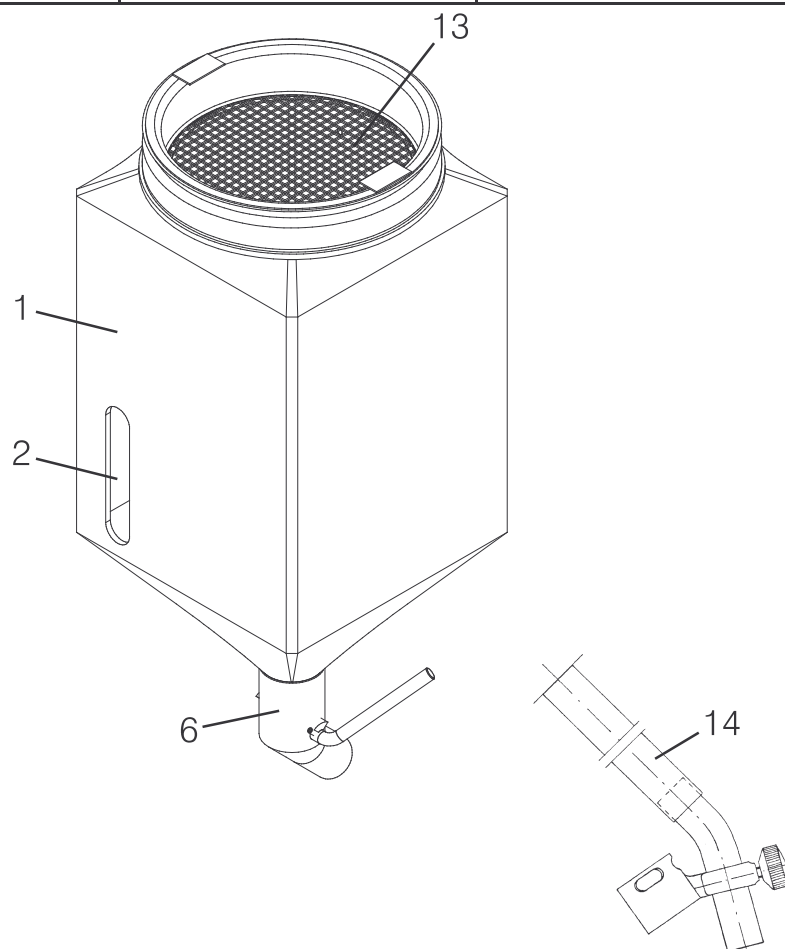
Item no.	Qty	Ordering no.	Denomination	Notes
		0153299880	Flux nozzle complete	
1	1	0153290002	Holder for flux pipe	
2	1	0153296001	Flux pipe, bent	
3	1	0153425001	Wheel	



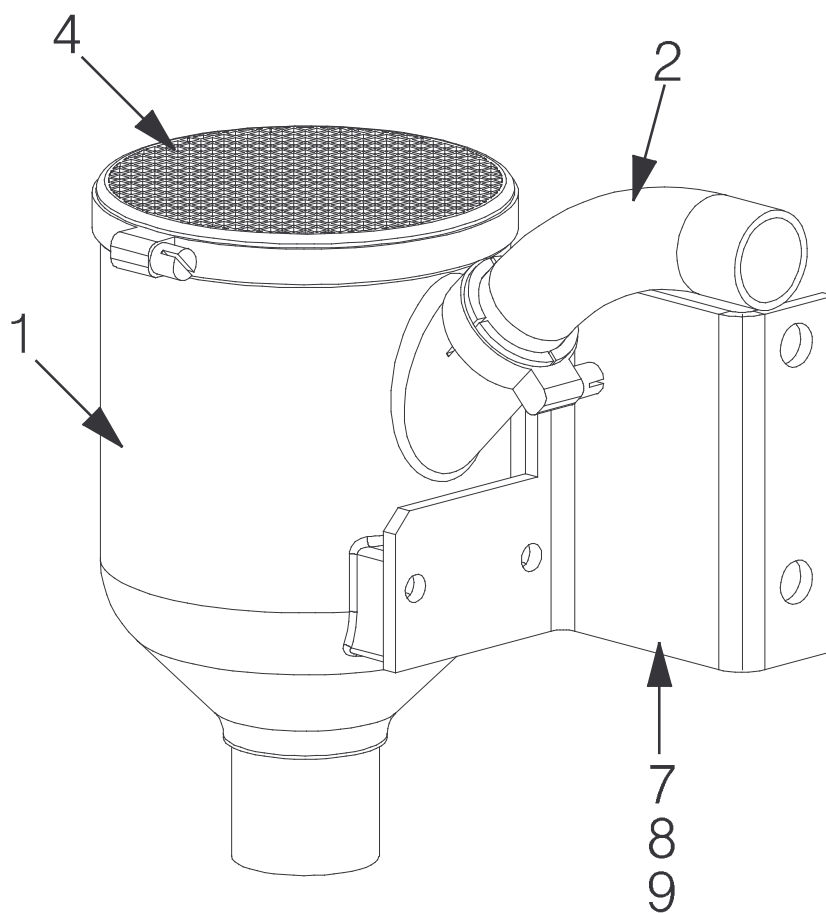
Item	Qty	Orderingno.	Denomination	Notes
		0461238880	Solenoid valve with cable	L=2.0m, 42V
2	1	0157259001	Contact	mha
3	0	0262612802	Cable	1x0,75 mm2 rx black
7	2	0262613329	Cable	rev 2*0,75
11	1	0193054002	Solenoid valve	42v
12	1	0194269002	Bushing	



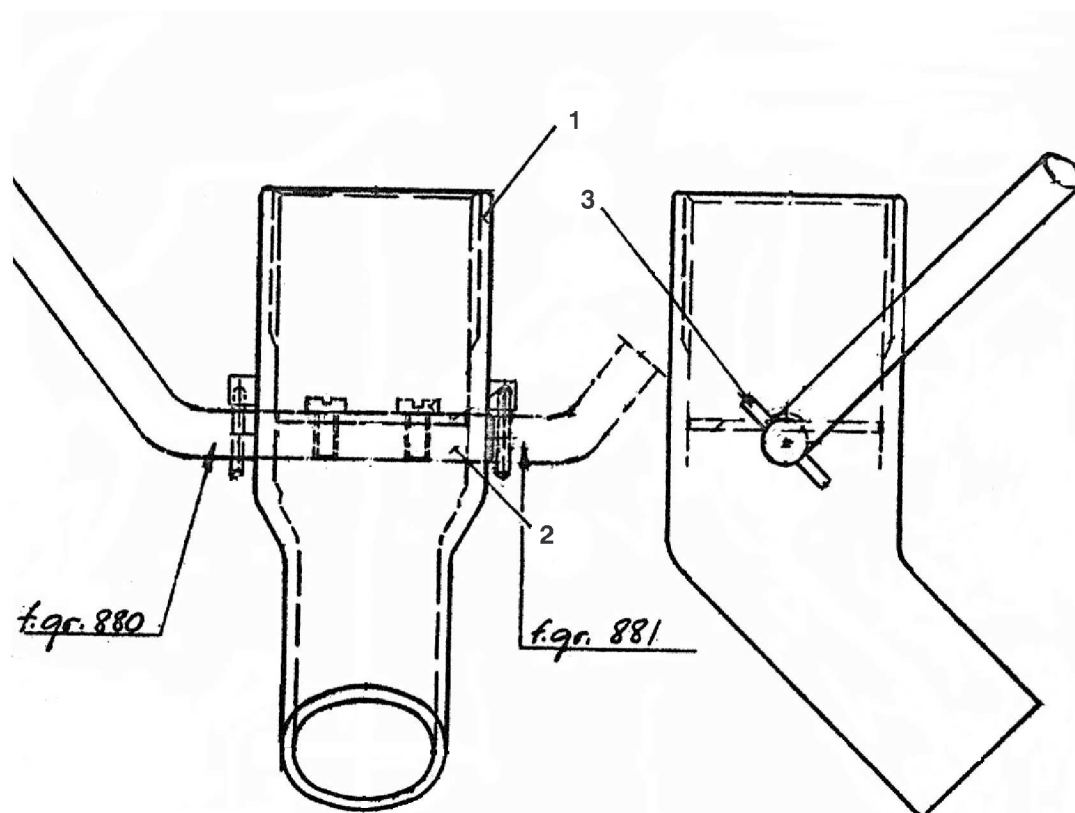
Item	Qty	Orderingno.	Denomination	Remarks
		0147649881	Flux hopper (complete)	10 l
1	1	0154007001	Hopper for flux	
2	1	0148837001	Window	
6	1	0153347880	Flux valve	
13	1	0020301780	Flux strainer	
14	1	0443383002	Flux hose	L=500



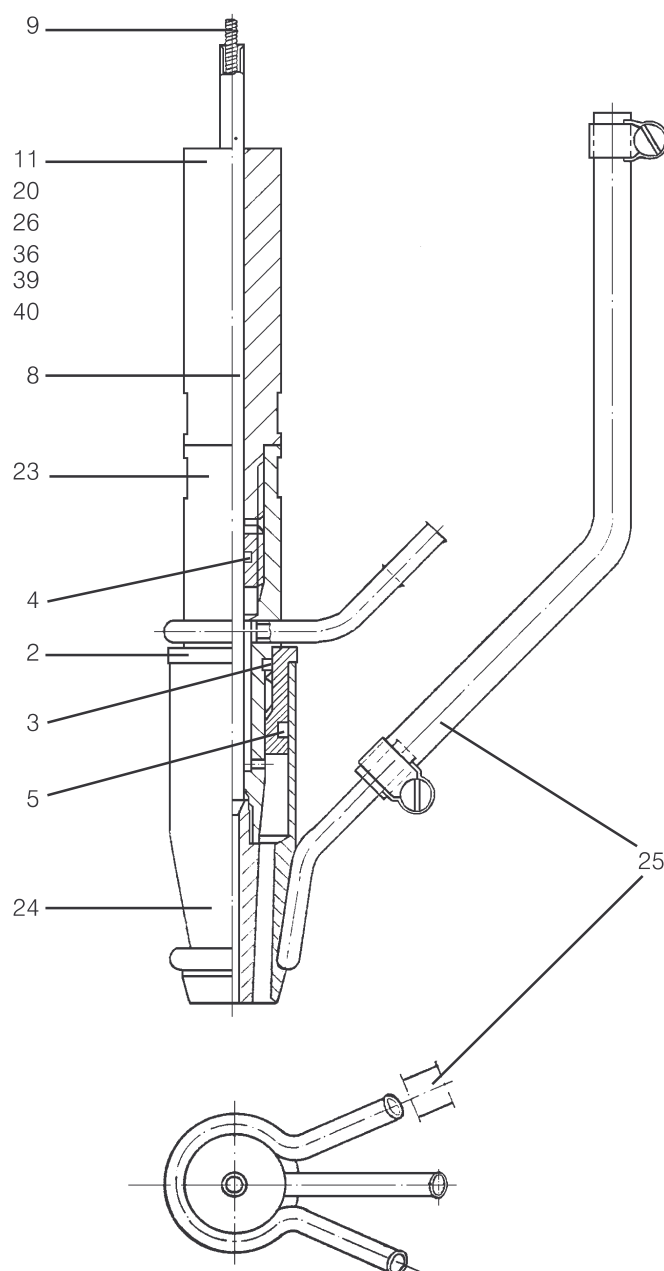
Item no.	Qty	Ordering no.	Denomination	Notes
9	1	0153856884	Flux hopper without flux valve	
10	1	0810153001	Holder	
11	1	0153856780	Flux hopper, joint details	
	1	0153347880	Flux valve	
1	1	0153853001	Flux hopper, joint details	1 l
2	1	0153854001	Flux hopper	
4	1	0153855001	Pipe	
			Filter	



Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0153347880	Flux valve	
2	1	0153348001	Outlet	
3	1	0153349001	Shaft	
		0211102938	Roll pin	d 3x20



Item no.	Qty	Ordering no.	Denomination	Notes
		0030465385	Connector	
2	1	0145226001	Insulating sleeve	
3	1	0190 680313	O-ring	OR 15.3x2.4
4	1	0190680303	O-ring	OR 5.3x2.4
5	1	0190680405	O-ring	OR 22.2x3
8	1	0334278880	Insert tube	
9	1	0334279001	Spiral	
20	1	0146094001	Extension	
23	1	0145534882	Contact tube	
24	1	0145227882	Gas nozzle	
25	1	0144998882	Water hose	L = 180



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