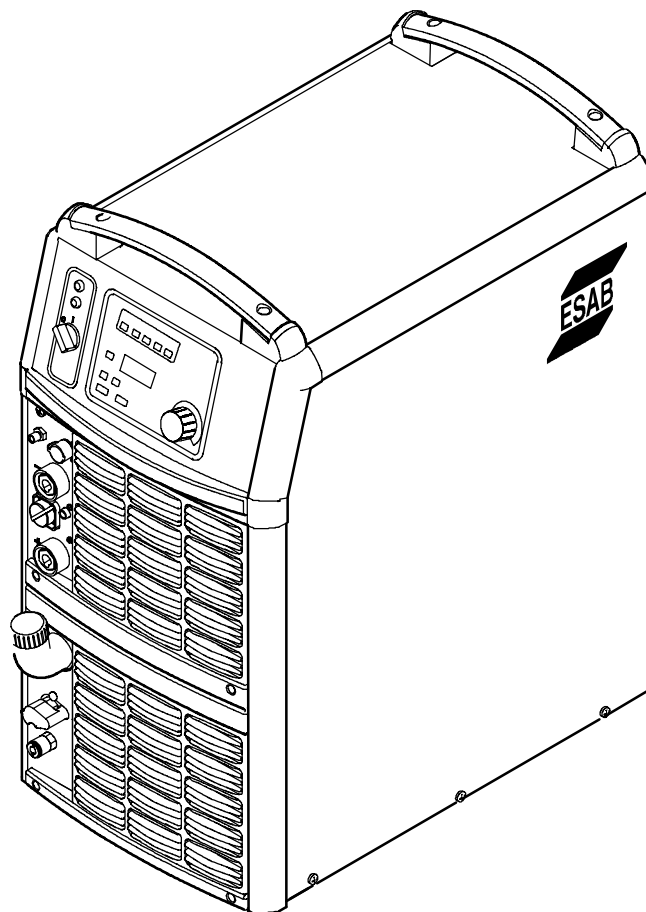


GB



Tig 4300i AC/DC

Origo™



Instruction manual

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1 DIRECTIVE

DECLARATION OF CONFORMITY

ESAB AB, Welding Equipment, SE-695 81 Laxå, Sweden, gives its unreserved guarantee that welding power source Tig 4300i AC/DC, Tig 4300iw AC/DC from serial number 710 (2007 w.10) are constructed and tested in compliance with the standard EN 60974-1 /-2 /-3 and EN 60974-10 in accordance with the requirements of directive (2006/95/EC) and (2004/108/EEC).

Laxå 2007-03-01



Kent Eimbrodt
Global Director
Equipment and Automation

2 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 unauthorized 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 drafts
4. Personal safety equipment
 - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
 - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. General precautions
 - Make sure the return cable is connected securely.
 - Work on high voltage equipment **may only be carried out by a qualified electrician.**
 - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
 - Lubrication and maintenance must **not** be carried out on the equipment during operation.



WARNING



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 MANUFACTURERS' 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 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.

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 earmuffs 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.

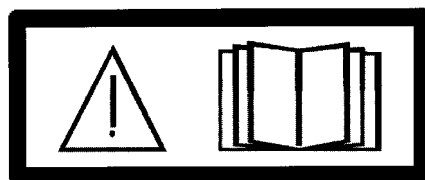
PROTECT YOURSELF AND OTHERS!

ESAB can provide you with all necessary welding protection and accessories.



WARNING!

Read and understand the instruction manual before installing or operating.

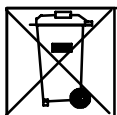


WARNING!

Do not use the power source for thawing frozen pipes.



This product is solely intended for arc welding.



Do not dispose of electrical equipment together with normal waste!

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative.

By applying this European Directive you will improve the environment and human health!

3 INTRODUCTION

The **Tig 4300i AC/DC** is a TIG welding power source, which can also be used for MMA welding. The power welding source can be used with alternating current (AC) or direct current (DC).

ESAB's accessories for the product can be found on page 17.

3.1 Equipment

The power source is delivered with 5 m mains cable incl the plug, 5 m return cable, instruction manuals for the power source and for the control panel.

3.2 The control panel

- **TA24 AC/DC**



See the separate instructions for detailed descriptions of the control panel.

4 TECHNICAL DATA

Tig 4300i AC/DC	
Mains voltage	400V, ± 10%, 3~ 50 Hz
Primary current	
I _{max} TIG	25 A
I _{max} MMA	32 A
No-load powering the energy-saving mode, 6,5 min. after welding	75 W
Voltage/current range	
TIG AC*/DC	4 – 430 A
MMA	16 – 430 A
Permissible load at TIG	
40 % duty cycle	430 A / 27.2 V
60 % duty cycle	400 A / 26.0 V
100 % duty cycle	315 A / 22.6 V
Permissible load at MMA	
40 % duty cycle	430 A / 37.2 V
60 % duty cycle	400 A / 36.0 V
100 % duty cycle	315 A / 32.6 V
Power factor at maximum current	
TIG	0.89
MMA	0.89

Tig 4300i AC/DC	
Efficiency at maximum current	
TIG	76 %
MMA	80 %
Open-circuit voltage	
MMA	83 V
Operating temperature range	-10 to + 40°C
Transportation temperature	-25 to +55°C
Continual sound pressure at no-load	<70 db (A)
Dimensions, lxbxh	625 x 394 x 776
Weight	95 kg
Insulation class transformer	H
Enclosure class	IP 23
Application class	S

Cooling unit	
Cooling power	2.0 kW at 40°C temperature difference and flow 1.0 l/min
Coolant	50 % water / 50% mono-ethylen glycol
Liquid quantity	5.5 l
Maximum water flow	2.0 l/min

*) *The minimum current during AC welding depends on the alloy used for the aluminium plates and their surface cleanliness.*

Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld at a certain load without overloading.

The duty cycle is valid for 40°C ambient temperature.

Enclosure class

The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP23** is designed for indoor and outdoor use.

Application class

The symbol **S** indicates that the power source is designed for use in areas with increased electrical hazard.

5 INSTALLATION

The installation must be executed by a professional.

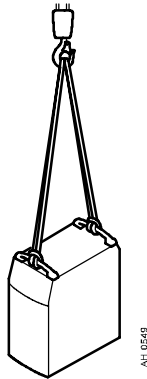


WARNING!

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.

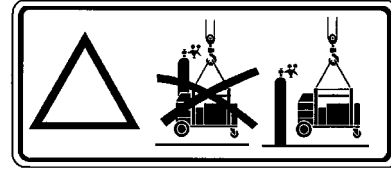
5.1 Lifting instructions

With power source



ANT 02549

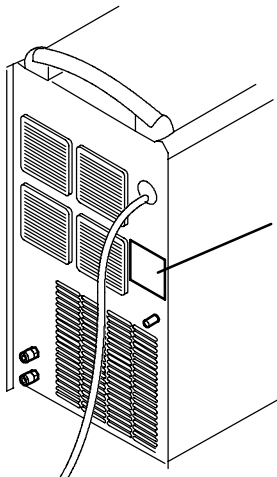
With power source and trolley



5.2 Placing

Position the welding power source such that its cooling air inlets and outlets are not obstructed.

5.3 Mains power supply



Check that the unit is connected to the correct mains power supply voltage, and that it is protected by the correct fuse sizes. A protective earth connection must be made, in accordance with regulations.

Rating plate with supply connection data.

Recommended fuse sizes and minimum cable areas

Tig 4300i AC/DC	TIG	MMA
Mains voltage	400 V 3~ 50 Hz	400 V 3~ 50 Hz
Mains cable area, mm²	4G4	4G4
Phase current, I effective	16.9 A	21.9 A
Fuse		
Anti-surge	16 A	20 A
Type C MCB	20 A	25 A

Note! The mains cable areas and fuse sizes as shown above are in accordance with Swedish regulations. Use the welding power source in accordance with the relevant national regulations.

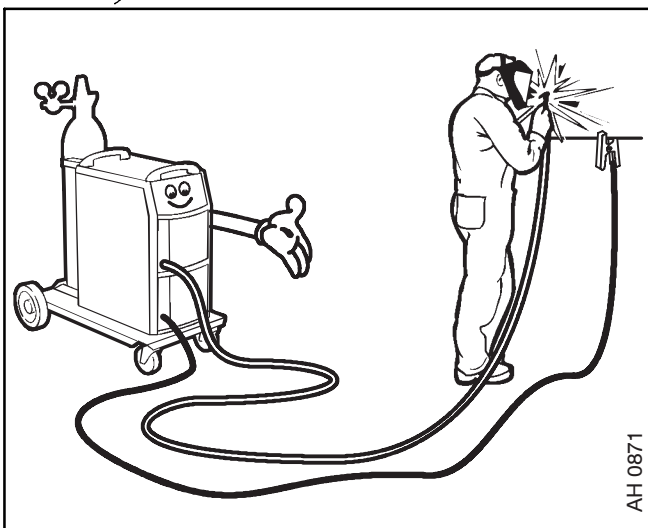
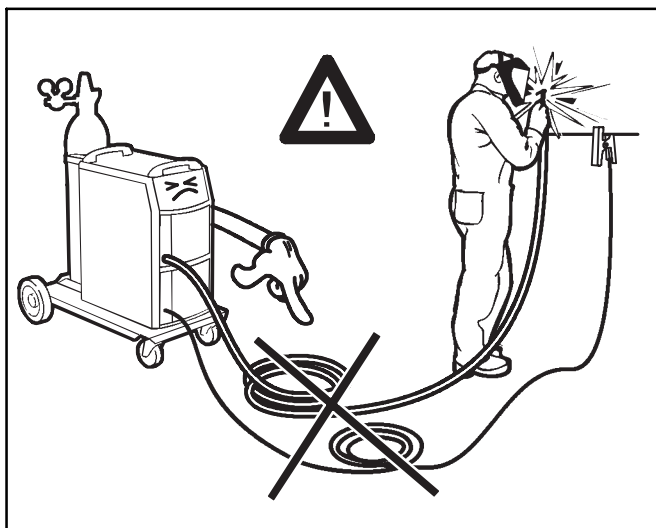
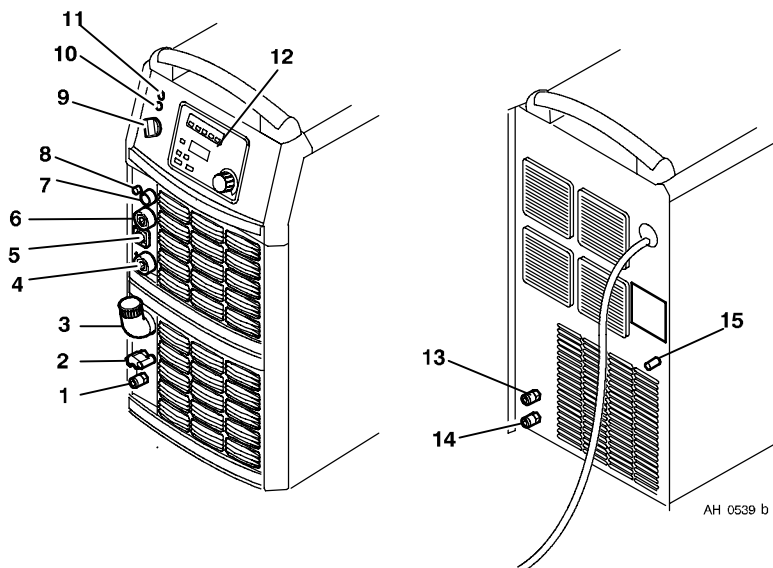
6 OPERATION

General safety regulations for the handling of the equipment can be found on page 3. Read through before you start using the equipment!

6.1 Connection and control devices

- | | | | |
|---|---|----|--|
| 1 | Connection for cooling water from the torch - RED | 9 | Main power supply switch, 0 / 1 / START |
| 2 | Connection with ELP*, for cooling water to the torch - BLUE | 10 | White indicating lamp - Power supply ON |
| 3 | Cooling water filler | 11 | Orange indicating lamp - Overheating |
| 4 | Connection for return cable (+) | 12 | Control panel (see the respective instructions) |
| 5 | Connection for remote control | 13 | Connection for cooling water. <i>Not used on this model.</i> |
| 6 | Connection for welding cable (-) or torch | 14 | Connection for cooling water. <i>Not used on this model.</i> |
| 7 | Connection for start signal from the welding torch | 15 | Connection for gas hose. |
| 8 | Connection for gas to the TIG torch | | |

*ELP = ESAB Logic Pump, see point 6.6.



AH 0871

6.2 Key to symbols



6.3 Turning on the power source

Turn on the mains power by turning switch (9) to the "START" position. Release the switch, and it will return to the "1" position.

If the mains power supply should be interrupted while welding is in progress, and then be restored, the power source will remain de-energised until the switch is again turned manually to the "START" position.

Turn the unit off by turning the switch to the "0" position.

Whether in the event of a loss of power supply or of turning the power source off in the normal manner, welding data will be stored so that it is available next time the unit is started.

6.4 Fan control

The power source fans continue to run for 6,5 minutes after welding has stopped, and the unit switches to *energy-saving mode*. They start again when welding restarts.

The fans run at reduced speed for welding currents up to 144 A, and at full speed for higher currents.

6.5 Overheating protection

The power source has two thermal overload trips which operate if the internal temperature becomes too high, interrupting the welding current and lighting the orange indicating lamp on the front of the unit and a fault code is shown in the panel. They reset automatically when the temperature has fallen.

6.6 Cooling unit

Water lock

The cooling unit is equipped with a detection system **ELP (ESAB Logic Pump)** which checks that the water hoses are connected.

The power source On/Off switch must be in the "0" position (Off) when connecting a water-cooled TIG torch.

If a water-cooled TIG torch is connected, the water pump starts automatically when the main On/Off switch is turned to "START" and/or when welding starts. After welding, the pump continues to run for 6,5 minutes, and then switches to the *energy-saving mode*.

Function when welding

To start welding, the welder presses the torch trigger switch. The power source energises the torch and starts wire feed and the cooling water pump.

To stop welding, the welder releases the torch trigger switch. The welding current is interrupted, but the cooling water pump continues to run for 6,5 minutes, after which the unit switches to *energy-saving mode*.

Water flow guard

The water flow guard interrupts the welding current in the event of loss of coolant, and displays an error message on the control panel. The water flow guard is an accessory, see page 17.

7 MAINTENANCE

Regular maintenance is important for safe, reliable operation.

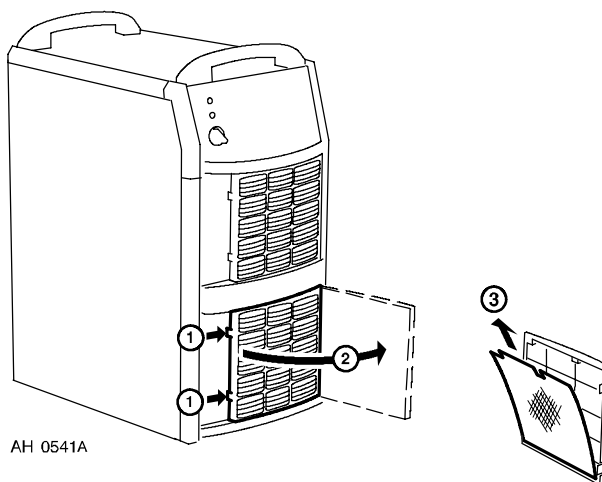
Only those persons who have appropriate electrical knowledge (authorized personnel) may remove the safety plates to connect or carry out service, maintenance or repair work on welding equipment.

Note!

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

7.1 Cleaning the air filter

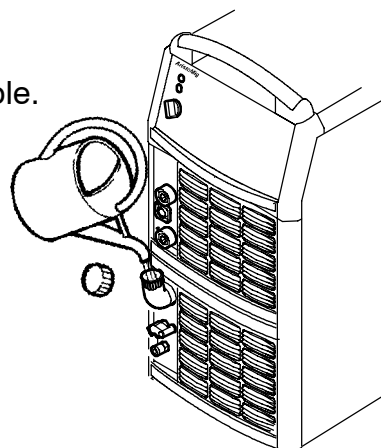
- Release the cover plate with the dust filter (1).
- Swing out the cover plate (2).
- Remove the dust filter (3).
- Blow it clean with compressed air at reduced pressure
- Replace the filter with the finer mesh on the side against the cover plate (2)
- Refit the cover plate with the filter.



7.2 Topping up the coolant

Top up with coolant until it is up to the level of the filling hole.

ESAB's refrigerant is recommended for use.
See accessories on page 17.



CAUTION!

The coolant must be handled as chemical waste.

8 FAULT TRACING

Try these recommended checks and inspections before sending for an authorised service technician.

Type of fault	Corrective action
No arc.	<ul style="list-style-type: none"> • Check that the mains power supply switch is turned on. • Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check start method (HF/Liftarc™) • Check the coolant flow. (if water flow guard is mounted) • Check the coolant level.
The welding current is interrupted during welding.	<ul style="list-style-type: none"> • Check whether the thermal cut-outs have tripped (indicated by the orange lamp on the front panel) and a fault code is shown in the panel. • Check the coolant flow. • Check the mains power supply fuses.
The thermal cut-out trips frequently.	<ul style="list-style-type: none"> • Check to see whether the dust filter is clogged. • Make sure that you are not exceeding the rated data for the power source (i.e. that the unit is not being overloaded).
Poor welding performance.	<ul style="list-style-type: none"> • Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check that the correct electrode / wire is being used. • Check that the correct welding gas is being used. • Check the gas flow. • Check the mains power supply fuses.

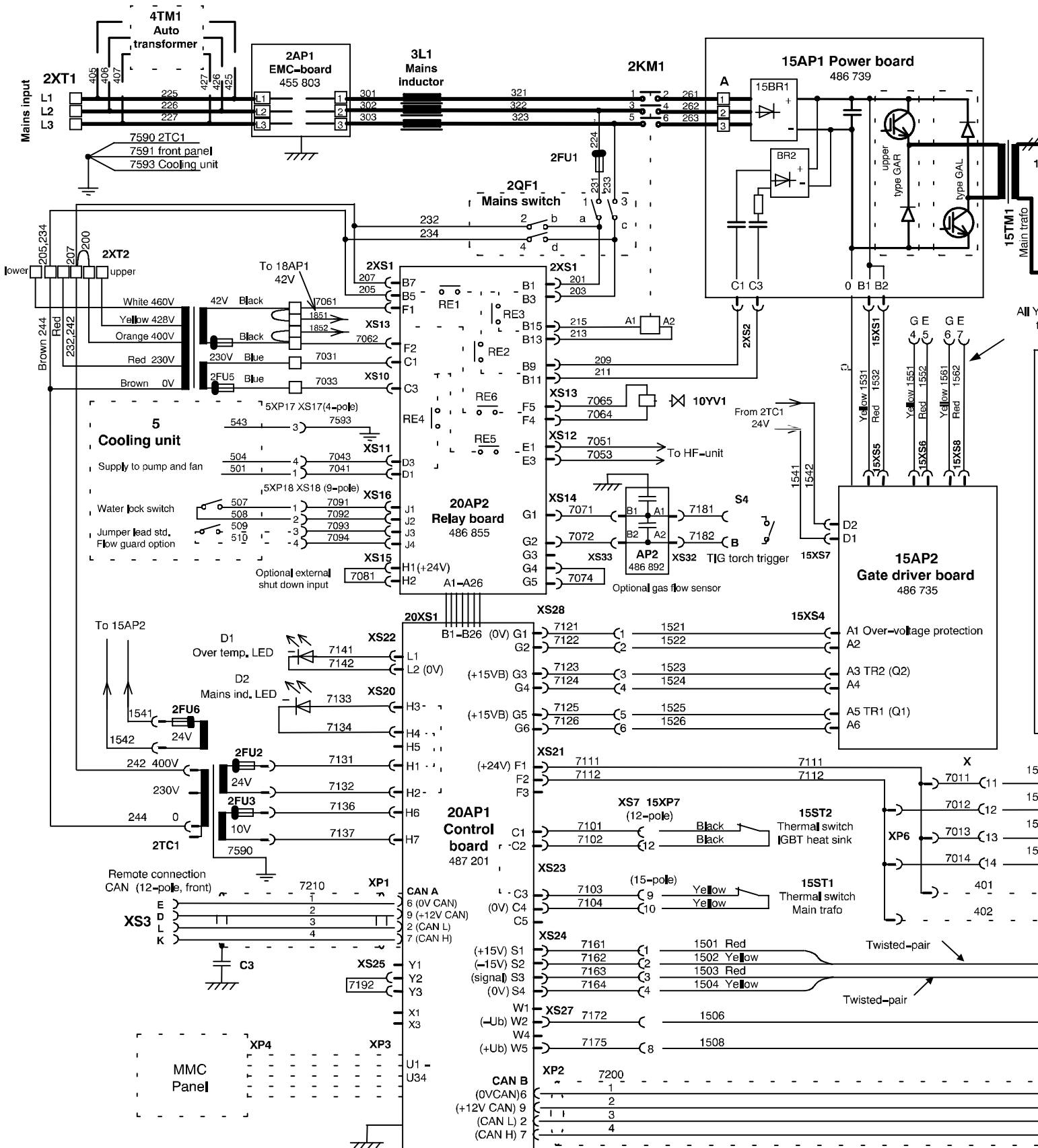
9 ORDERING OF SPARE PARTS

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

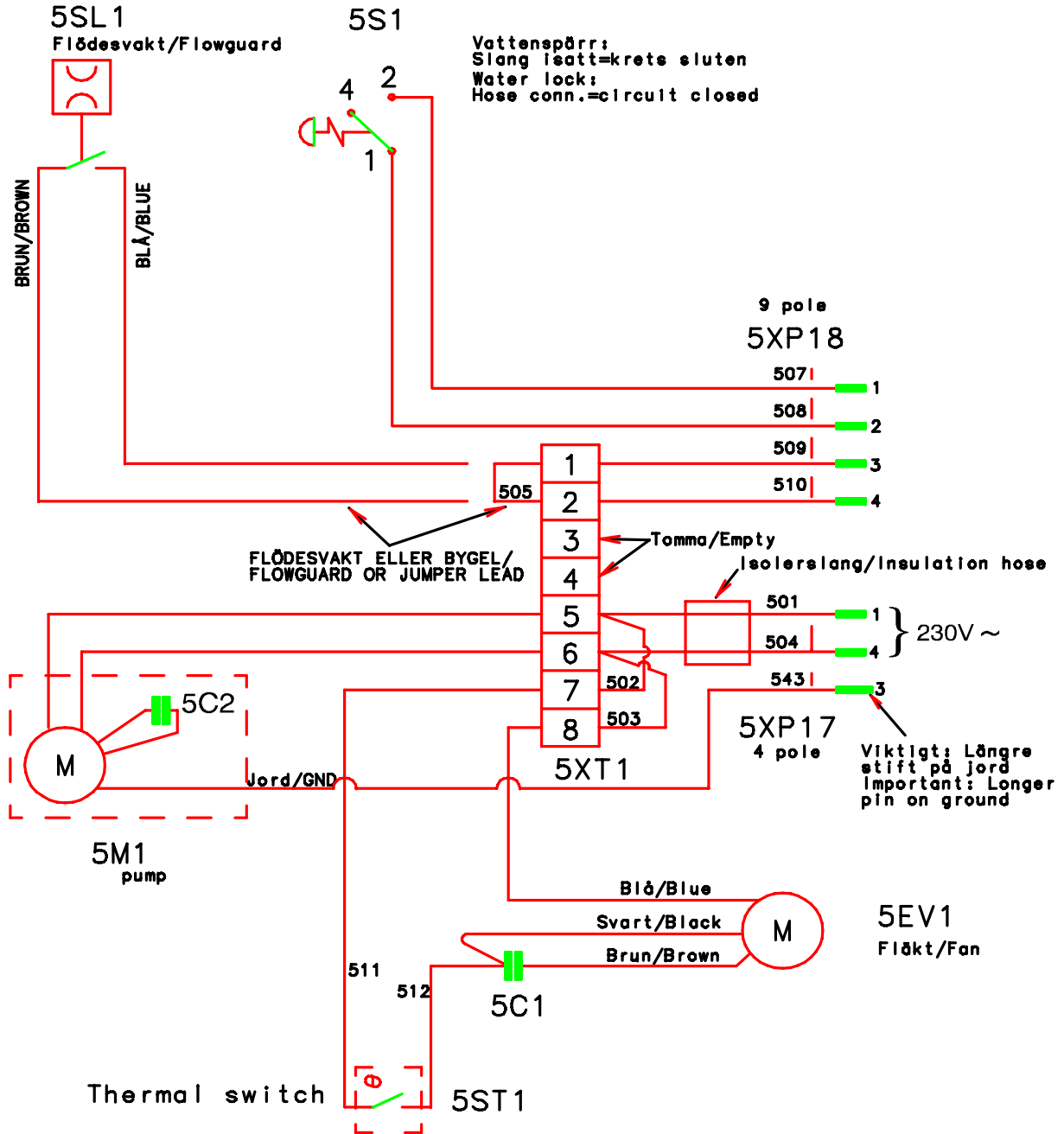
Tig 4300i AC/DC is designed and tested in accordance with the international and European standards IEC/EN 60974-1, 60974-2, 60974-3 and EN 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts may be ordered through your nearest ESAB dealer, see the last page of this publication.

Diagram

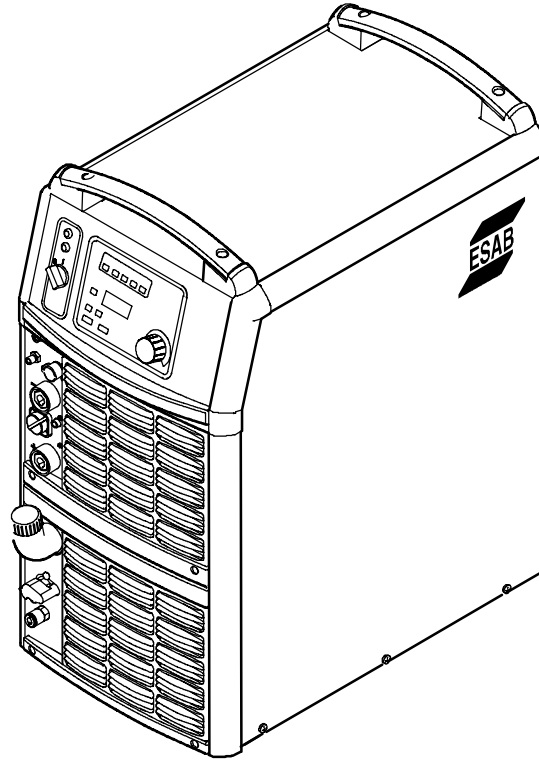


Cooling unit



Tig 4300i AC/DC

Ordering number



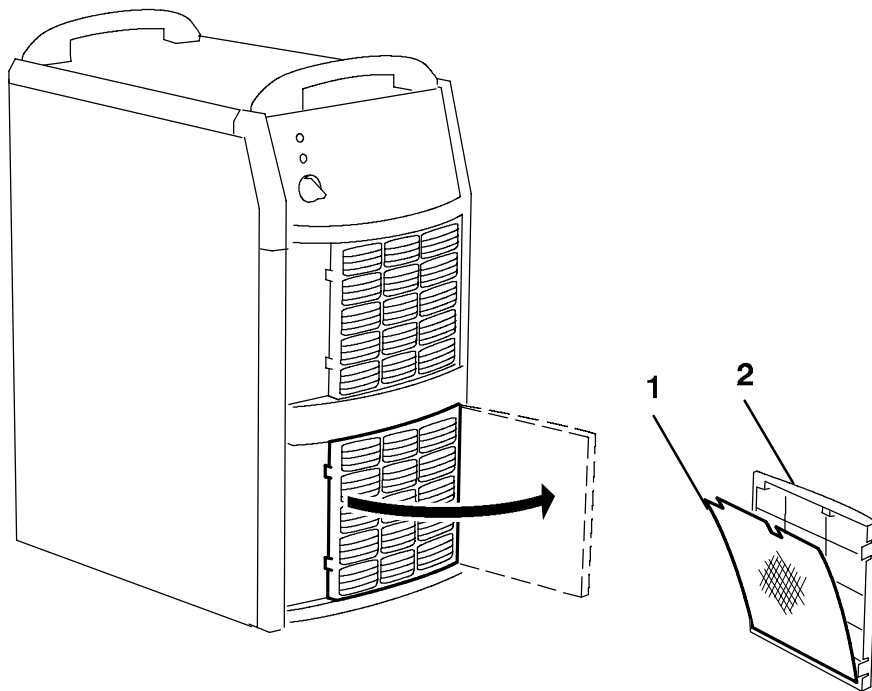
Ordering no.	Denomination	Type
0460 100 880	Welding power source	Origo™ Tig 4300iw, AC/DC, TA24 AC/DC
0459 839 008	Spare parts list	Tig 4300i AC/DC
0459 839 003	Spare parts list	Control panel, Origo™ TA24 AC/DC
0459 944 xxx	Instruction manual	Control panel, Origo™ TA24 AC/DC

Instruction manuals and the spare parts list are available on the Internet at www.esab.com

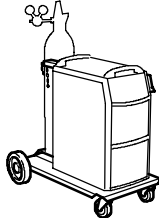



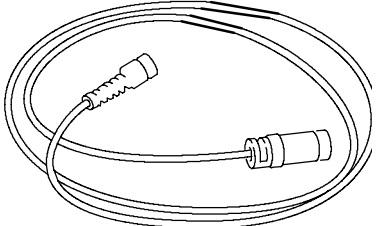

Tig 4300i AC/DC

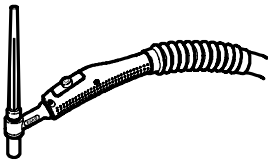
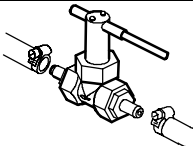
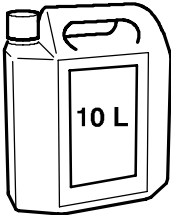
Spare parts list

Item	Ordering no.	Denomination
1	0458 398 001	Filter
2	0458 383 001	Front grill



Accessories

	<p>Trolley 0458 530 881</p>										
	<p>Remote control unit AT1 CAN 0459 491 883 MMA and TIG: current</p>										
	<p>Remote control unit AT1 CF CAN 0459 491 884 MMA and TIG: rough and fine setting of current.</p>										
	<p>T1 Foot CAN - Foot Control unit 0460 315 890 Including 5 m cable</p>										
	<p>Remote cable CAN 4 pole - 12 pole</p> <table data-bbox="651 1355 1385 1527"> <tr> <td>5 m</td> <td>0459 544 880</td> </tr> <tr> <td>10 m</td> <td>0459 554 881</td> </tr> <tr> <td>15 m</td> <td>0459 554 882</td> </tr> <tr> <td>25 m</td> <td>0459 554 883</td> </tr> <tr> <td>0.25 m</td> <td>0459 554 884</td> </tr> </table>	5 m	0459 544 880	10 m	0459 554 881	15 m	0459 554 882	25 m	0459 554 883	0.25 m	0459 554 884
5 m	0459 544 880										
10 m	0459 554 881										
15 m	0459 554 882										
25 m	0459 554 883										
0.25 m	0459 554 884										
	<p>Return cable 5 m 70 mm² 0700 006 895</p>										

	<p>TIG torch TXH 400w incl. 4 m cable assembly 0460 014 840 incl. 8 m cable assembly 0460 014 880 TIG torch TXH 400w HD incl. 4 m cable assembly 0460 014 841 incl. 8 m cable assembly 0460 014 881 TIG torch TXH 400wr HD incl. 4 m cable assembly 0461 014 841 incl. 8 m cable assembly 0461 014 881 Remote adapter kit for TXH 400wr HD, incl. holder 0459 491 912* *Recommended remote interconnection cable 0459 554 884</p>
	<p>Water flow guard 0.7 l/min 0456 855 880</p>
	<p>Coolant (Ready mixed) 50% water and 50% mono-ethylene glycol (10 l) 0194 230 002</p>

ESAB subsidiaries and representative offices

Europe

AUSTRIA

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

BELGIUM

S.A. ESAB N.V.
Brussels
Tel: +32 2 745 11 00
Fax: +32 2 745 11 28

THE CZECH REPUBLIC

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

DENMARK

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

FINLAND

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

FRANCE

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

GERMANY

ESAB GmbH
Solingen
Tel: +49 212 298 0
Fax: +49 212 298 218

GREAT BRITAIN

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

ESAB Automation Ltd

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

HUNGARY

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

ITALY

ESAB Saldatura S.p.A.
Mesero (Mi)
Tel: +39 02 97 96 81
Fax: +39 02 97 28 91 81

THE NETHERLANDS

ESAB Nederland B.V.
Utrecht
Tel: +31 30 2485 377
Fax: +31 30 2485 260

NORWAY

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

POLAND

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

PORTUGAL

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

SLOVAKIA

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

SPAIN

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

SWEDEN

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

ESAB international AB

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

SWITZERLAND

ESAB AG
Dietikon
Tel: +41 1 741 25 25
Fax: +41 1 740 30 55

North and South America

ARGENTINA

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

BRAZIL

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

CANADA

ESAB Group Canada Inc.
Mississauga, Ontario
Tel: +1 905 670 02 20
Fax: +1 905 670 48 79

MEXICO

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

USA

ESAB Welding & Cutting Products
Florence, SC
Tel: +1 843 669 44 11
Fax: +1 843 664 57 48

Asia/Pacific

CHINA

Shanghai ESAB A/P
Shanghai
Tel: +86 21 5308 9922
Fax: +86 21 6566 6622

INDIA

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

INDONESIA

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

JAPAN

ESAB Japan
Tokyo
Tel: +81 3 5296 7371
Fax: +81 3 5296 8080

MALAYSIA

ESAB (Malaysia) Snd Bhd
Selangor
Tel: +60 3 8027 9869
Fax: +60 3 8027 4754

SINGAPORE

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

SOUTH KOREA

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

UNITED ARAB EMIRATES

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

Representative offices

BULGARIA

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

EGYPT

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

ROMANIA

ESAB Representative Office
Bucharest
Tel/Fax: +40 1 322 36 74

RUSSIA

LLC ESAB
Moscow
Tel: +7 095 543 9281
Fax: +7 095 543 9280

LLC ESAB

St Petersburg
Tel: +7 812 336 7080
Fax: +7 812 336 7060

Distributors

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

www.esab.com



ESAB AB
SE-695 81 LAXÅ
SWEDEN
Phone +46 584 81 000



www.esab.com