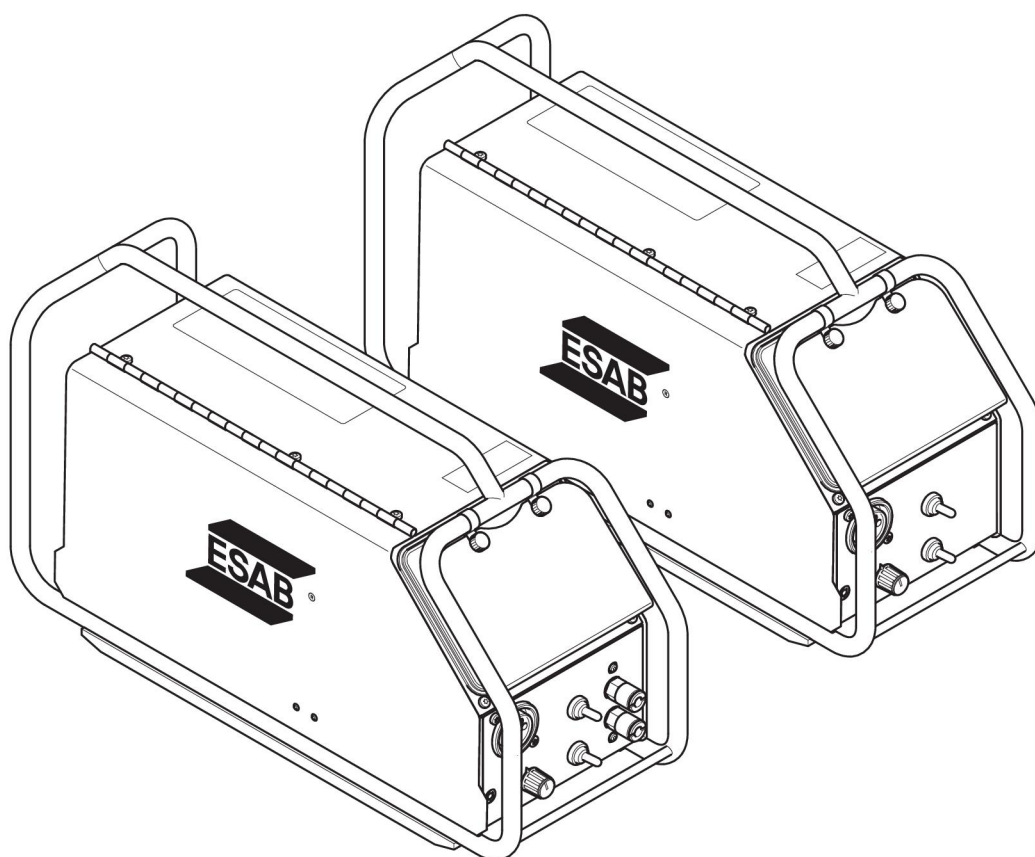




# **Warrior™ YardFeed 200**

# **Warrior™ YardFeed 200w**



## **Instruction manual**



## EU DECLARATION OF CONFORMITY

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

**Type of equipment**  
Wire Feeder

**Type designation**  
Warrior YardFeed 200, from serial number 528 xxx xxxx (2015 w/28)  
Warrior YardFeed 200w, from serial number 528 xxx xxxx (2015 w/28)

**Brand name or trade mark**  
ESAB

**Manufacturer or his authorised representative established within the EEA**

**Name, address, and telephone No:**  
ESAB AB  
Lindholmsallén 9, Box 8004, SE-402 77 Göteborg, Sweden  
Phone: +46 31 50 90 00, Fax: +46 584 411 924

**The following harmonised standard in force within the EEA has been used in the design:**  
EN 60974-5:2013, Arc Welding Equipment – Part 5: Wire Feeders  
EN 60974-10:2014, Arc Welding Equipment – Part 10: Electromagnetic Compatibility (EMC) requirements

**Additional Information:**  
Restrictive use, Class A equipment, intended for use in location other than residential

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

**Date**

**Signature**

**Position**

Gothenburg

A handwritten signature in black ink, appearing to read "Stephen Argo". The signature is written in a cursive, flowing style.

Global Director Equipment

2016-06-29

Stephen Argo

CE 2016

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# 1 SAFETY

## 1.1 Meaning of symbols

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

**DANGER!**

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

**WARNING!**

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

**CAUTION!**

Means hazards which could result in minor personal injury.

**WARNING!**

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



## 1.2 Safety precautions

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

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

1. Anyone who uses the equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
  - no unauthorised person is stationed within the working area of the equipment when it is started up
  - no-one is unprotected when the arc is struck or work is started with the equipment
3. The workplace must:
  - be suitable for the purpose
  - be free from drafts

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

**WARNING!**

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

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

**WARNING!**

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

**ELECTRIC SHOCK - Can kill**

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

**ELECTRIC AND MAGNETIC FIELDS - Can be dangerous to health**

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

**FUMES AND GASES - Can be dangerous to health**

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



**ARC RAYS - Can injure eyes and burn skin**

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



**NOISE - Excessive noise can damage hearing**

Protect your ears. Use earmuffs or other hearing protection.



**MOVING PARTS - Can cause injuries**

- Keep all doors, panels and covers closed and securely in place. Have only qualified people remove covers for maintenance and troubleshooting as necessary. Reinstall panels or covers and close doors when service is finished and before starting engine.
- Stop engine before installing or connecting unit.
- Keep hands, hair, loose clothing and tools away from moving parts.



**FIRE HAZARD**

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

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

**PROTECT YOURSELF AND OTHERS!**



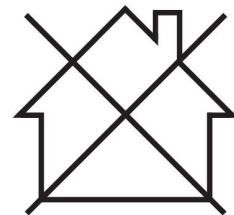
**CAUTION!**

This product is solely intended for arc welding.



**CAUTION!**

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



**NOTE!**

**Dispose of electronic equipment at the recycling facility!**

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

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

For further information contact the nearest ESAB dealer.



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

## 2 INTRODUCTION

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The wire feed units Warrior™ YardFeed 200 and Warrior™ YardFeed 200w are intended for MIG/MAG (GMAW) welding together with welding power sources:

- Warrior 400i CC/CV
- Warrior 500i CC/CV

They come in different variants, see chapter "ORDERING NUMBERS".

The wire feed units are sealed and contains a four-wheel drive wire feed mechanism as well as control electronics.

They can be used together with wire from ESAB, standard S200 Ø 200 mm / Ø 8 in.

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



### 3 TECHNICAL DATA

<b>Warrior™ YardFeed 200</b>	
<b>Mains voltage</b>	42 V, 50-60 Hz
<b>Power requirement</b>	252 VA
<b>Rated supply current I<sub>1</sub></b>	6 A
<b>Settings data</b>	
Wire feed speed	1.9 - 25.0 m/min (75 - 985 in/min)
2/4 stroke	2 stroke or 4 stroke
Wire selection / Burnback	Solid or Cored
Creep start	Always on
Gas purging	Yes
Wire inching	Yes
<b>Torch connection</b>	EURO
<b>Wire bobbin: Type, Max. diameter</b>	S200, 200 mm (8 in.)
<b>Wire dimension</b>	
Fe	0.6 - 1.2 mm (0.023 - 0.045 in.)
Ss	0.6 - 1.2 mm (0.023 - 0.045 in.)
Al	1.0 - 1.2 mm (0.040 - 0.045 in.)
Cored wire	0.8 - 1.6 mm (0.030 - 1/16 in.)
<b>Weight</b>	
WYF 200	12 kg (26.5 lb)
WYF 200w	12.2 kg (26.9 lb)
<b>Dimensions (l × w × h)</b>	593 × 210 × 312 mm (23.3 × 8.3 × 12.28 in.)
<b>Operating temperature</b>	-10 to +40 °C (+14 to +104 °F)
<b>Transport and storage temperature</b>	-20 to +55 °C (-4 to +131 °F)
<b>Shielding gas</b>	All types intended for MIG/MAG welding
max pressure	0.5 MPA (5 bar / 72.5 psi)
<b>Maximum permissible load at</b>	
60% duty cycle	365 A
100% duty cycle	280 A
<b>Enclosure class</b>	IP23

#### Standard factory settings

Standard factory settings for Warrior™ YardFeed 200 are in/min and fully open gas valve.

#### Duty cycle

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

#### Enclosure class

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

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

## 4 INSTALLATION

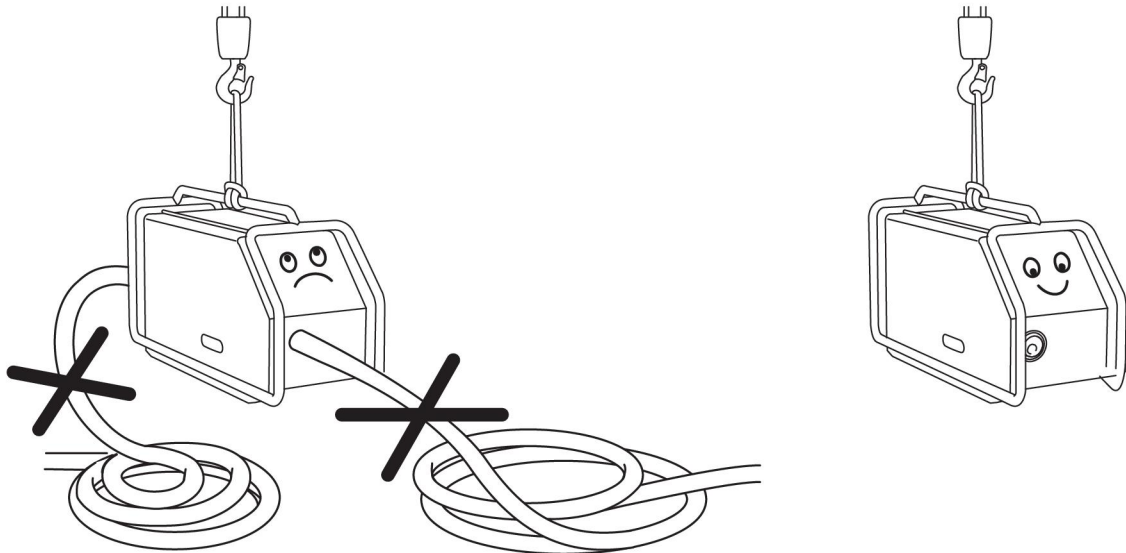
The installation must be carried out by a professional.



### WARNING!

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

### 4.1 Lifting instructions



## 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!



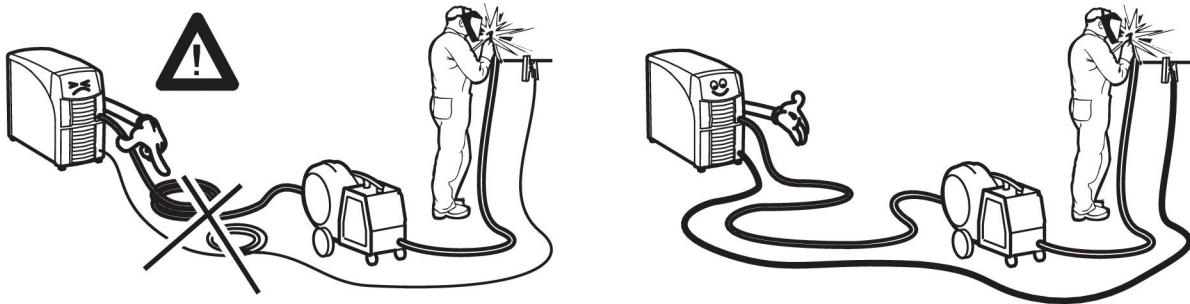
### WARNING!

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



### NOTE!

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



### WARNING!

Assure that the side panels are closed during operation.



### WARNING!

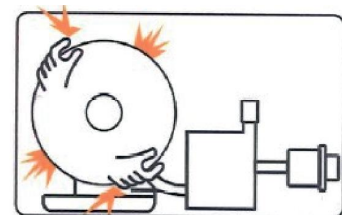
Rotating parts can cause injury, take great care.



### WARNING!

Risk of crushing when replacing the wire bobbin!

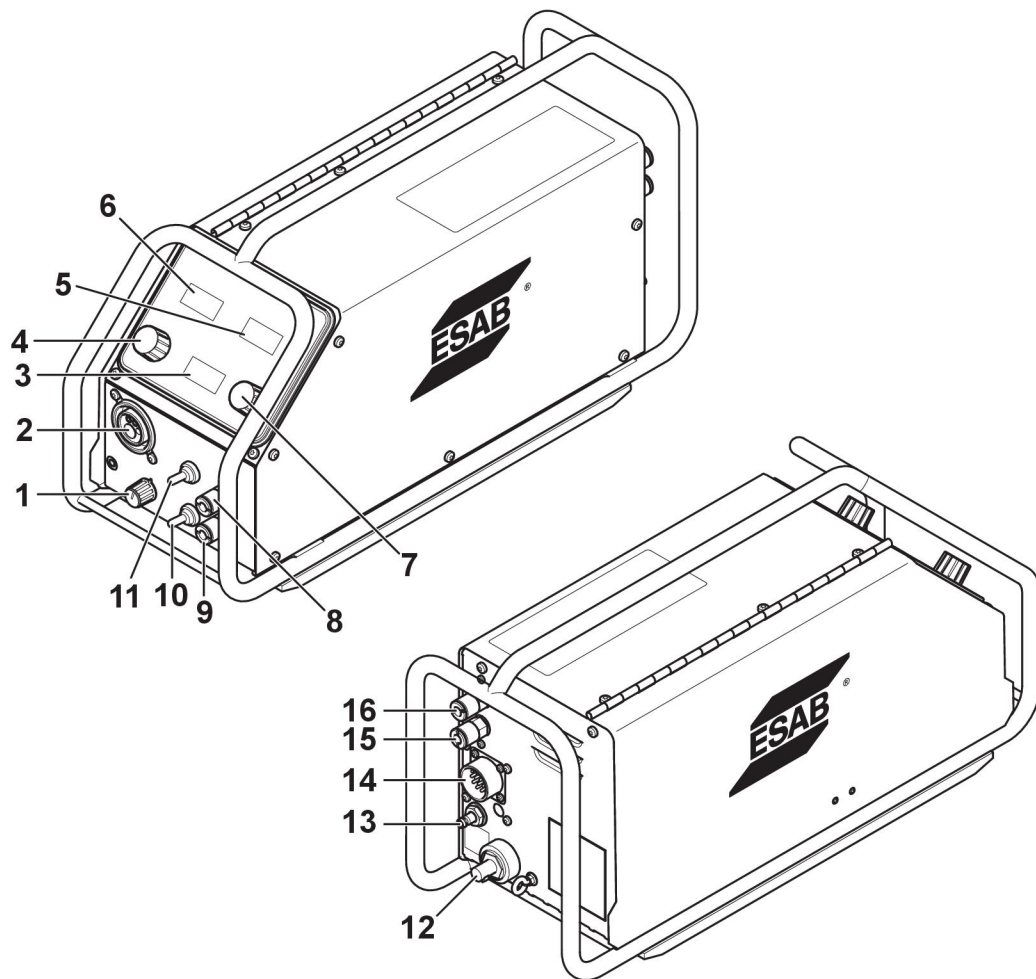
Do **not** use safety gloves when inserting the welding wire between the feed rollers.



### 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.

## 5.1 Connections and control devices



1	Safety contact switch	9	Connection RED for cooling water to power source (cooling unit) **
2	Connection for welding torch (Euro connector)	10	Toggle switch for gas purging / wire inching
3	Display wire feed speed (in/min or m/min)*	11	Switch for 2 stroke/ 4 stroke
4	Knob for setting the voltage	12	Connection for welding current from power source (OKC)
5	Display current (A)	13	Connection for shielding gas
6	Display voltage (V)	14	Connection for control cable from power source
7	Knob for setting the wire feed speed (m/min or in/min)	15	Connection RED, for coolant to power source (cooling unit)
8	Connection BLUE for cooling water from power source (cooling unit) **	16	Connection BLUE, for coolant from power source (cooling unit)

\*For setting of display wire feed speed unit, see the "Function" section.

\*\* Cooling water connections are only available on certain models.

**NOTE!**

The display for wire feed speed is activated a few seconds after the safety contact switch is set to "Welding ON" mode (1).

**NOTE!**

Coolant connections are only available on certain models.

## 5.2 Function

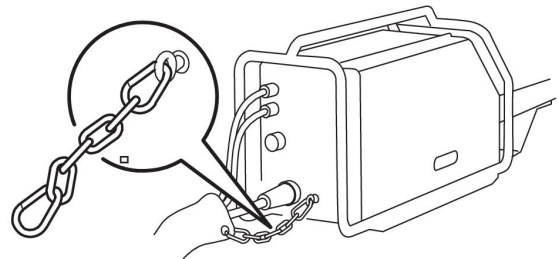
### Water connection

When connecting a water-cooled welding torch, the main power supply switch of the power source must be in the OFF position and the cooling unit switch must be in position 0.

A water connection kit can be ordered as an accessory, see chapter "Accessories".

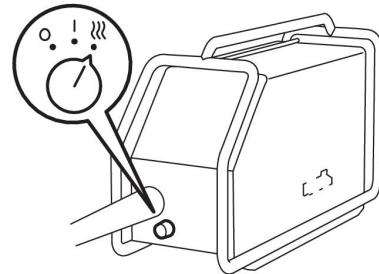
### Strain relief

Hook the strain relief onto the hook on the rear side of the feeder unit and the connection cable.



### Safety contact switch

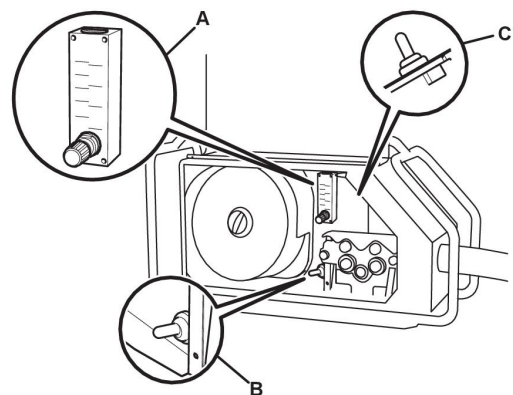
- 0 Welding OFF
- 1 Welding ON
- ☹ Heat ON (accessory) and welding OFF  
The bobbin area is heated so that the welding wire is kept dry when welding.



### Gasflow control and solid/cored wire

Open the lid for access to the gasflow control and selection of the solid/cored wire.

- A** = Gas flow meter
- B** = Setting solid or cored wire
- C** = Display setting, in/min or m/min



### Wire selection – Solid wire

Short Circuit Termination (SCT) behavior is selected when the trigger is released to adapt to welding with solid wire.

SCT is a way to stop the welding with some small short circuits to reduce the end crater and oxidation. It also gives the advantage of a good start performance with solid wire.



### Wire selection – Cored wire

A constant burnback time is selected when the trigger is released to adapt to welding with cored wire.



### 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 occurs for as long as the button is held depressed and occurs without voltage or wire feed starting.



### Wire inching

Wire inching is used when one needs to feed wire without welding voltage being applied. 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.



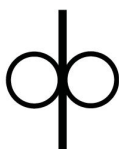
### 4-stroke

With 4 stroke, the 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, the wire feed then stops and when the switch is released the gas post-flow starts.



### Voltage

Higher voltage increases the arc length and produces a hotter, wider arc.



### Wire feed speed

This sets the required feed speed of the filler wire in inches per minute (in/min) or meters per minute (m/min).

## 5.3 Wire feed pressure

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

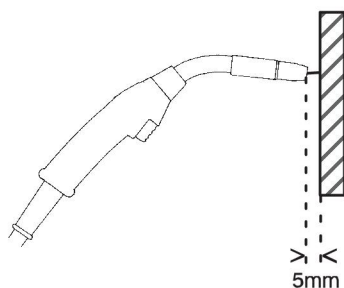


Figure A

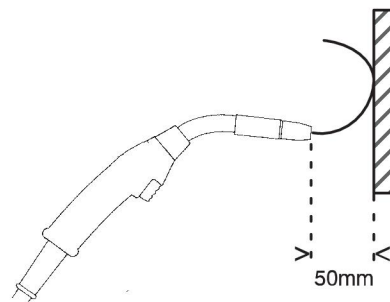


Figure B

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 approx. 5 mm from the piece of wood (figure A) the feed rollers should slip.

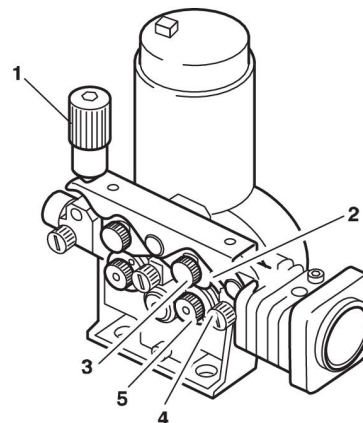
If you hold the welding torch approx. 50 mm from the piece of wood, the wire should be fed out and bend (figure B).

## 5.4 Replacing and inserting wire

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

## 5.5 Changing feed rollers

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



During installation, repeat the above in reverse order.

### Choice of track in the feed rollers

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

## 6 MAINTENANCE



### NOTE!

Regular maintenance is important for safe and reliable operation.



### CAUTION!

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

### 6.1 Inspection and cleaning

#### Wire feed unit

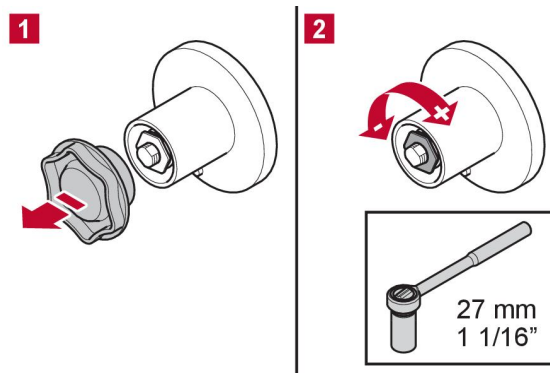
Check regularly that the wire feed unit is not clogged with dirt.

Cleaning and replacement of the wire feed unit mechanism's worn parts should take place at regular intervals in order to achieve trouble-free wire feed. Note that if pre-tensioning is set too hard, this can result in abnormal wear on the pressure roller, feed roller and wire guide.

#### The brake hub

The hub is adjusted when delivered.

Adjust the brake hub so that the wire is slightly slack when wire feed stops.



#### Welding torch

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



## 7 ORDERING SPARE PARTS

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### **CAUTION!**

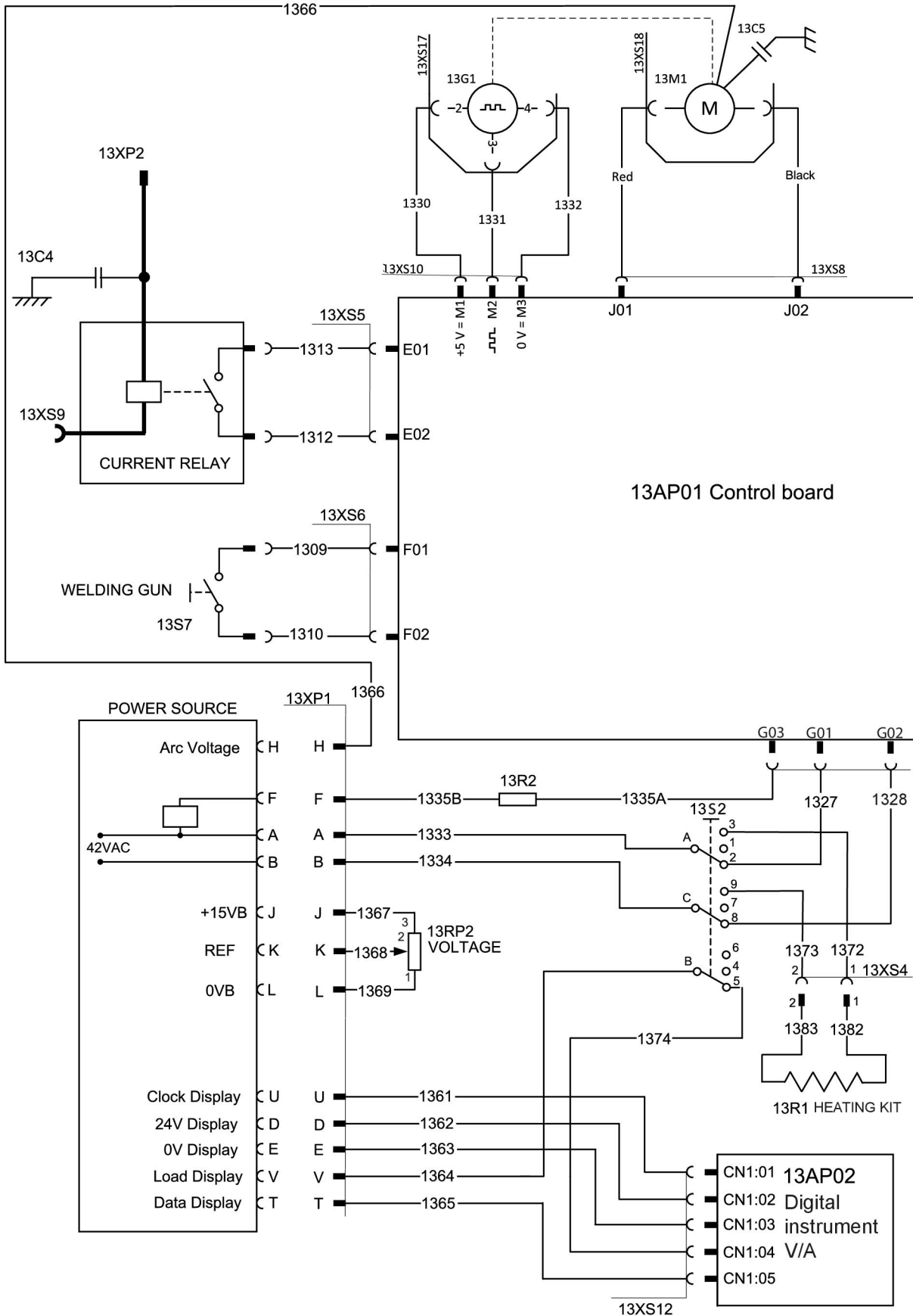
Repair and electrical work should be performed by an authorised ESAB service technician. Use only ESAB original spare and wear parts.

**The Warrior™ YardFeed 200 and Warrior™ YardFeed 200w are designed and tested in accordance with international and European standards IEC/EN 60974-5 and IEC/EN 60974-10, Canadian standard CAN/CSA-E60974-5 and US standard ANSI/IEC 60974-5. On completion of service or repair work, it is the responsibility of the person(s) performing the work to ensure that the product still complies with the requirements of the above standards.**

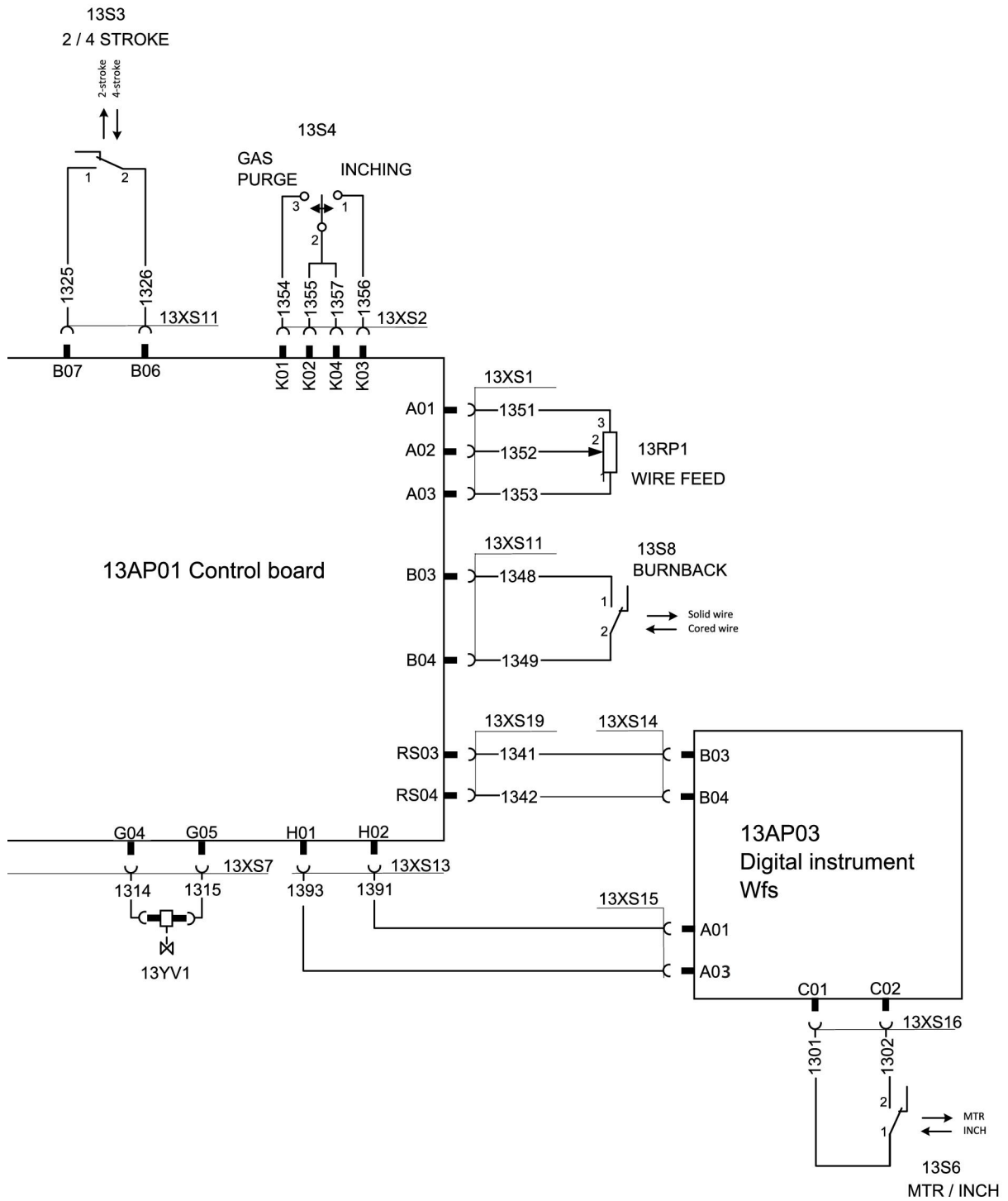
Spare parts and wear parts can be ordered through your nearest ESAB dealer, see the back cover of this document. When ordering, please state product type, serial number, designation and spare part number in accordance with the spare parts list. This facilitates dispatch and ensures correct delivery.

# DIAGRAM

## Warrior™ Yard Feed 200



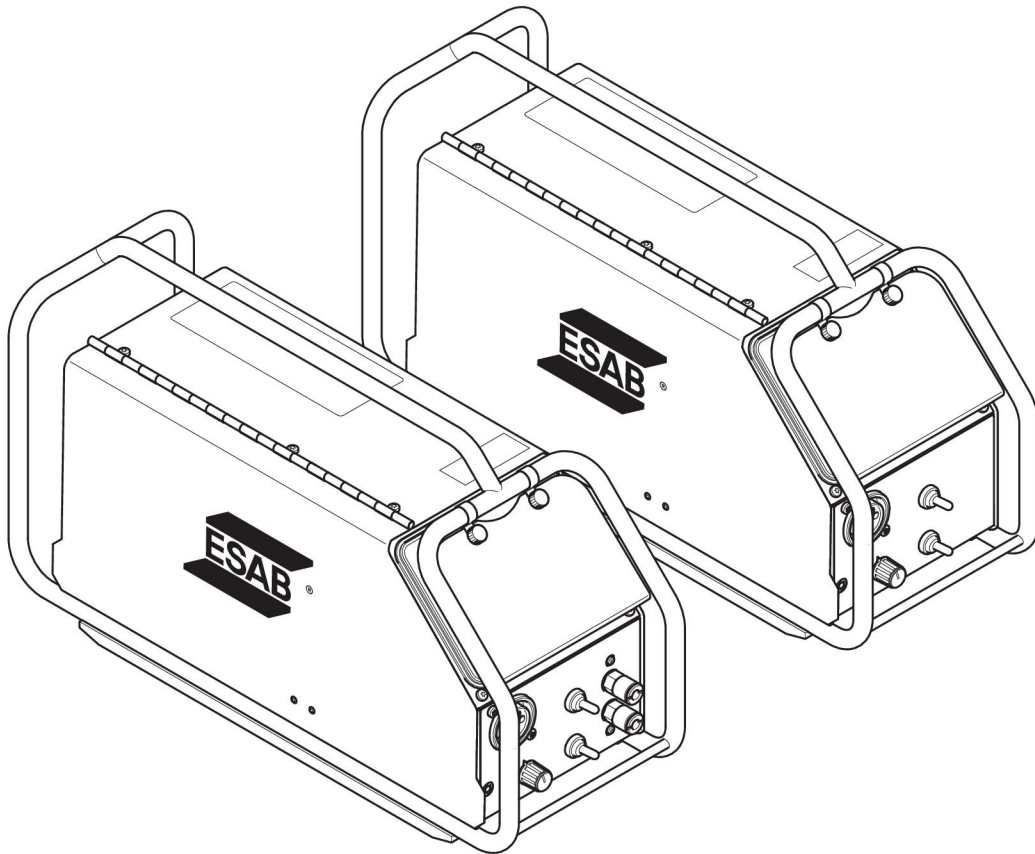
DIAGRAM



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**ORDERING NUMBERS**

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Ordering no.	Denomination	Type
0459 906 900	Warrior™ YardFeed 200	
0459 906 901	Warrior™ YardFeed 200w	with water cooling
0463 390 001	Spare parts list	

Instruction manuals and the spare parts list are available on the Internet at: [www.esab.com](http://www.esab.com)

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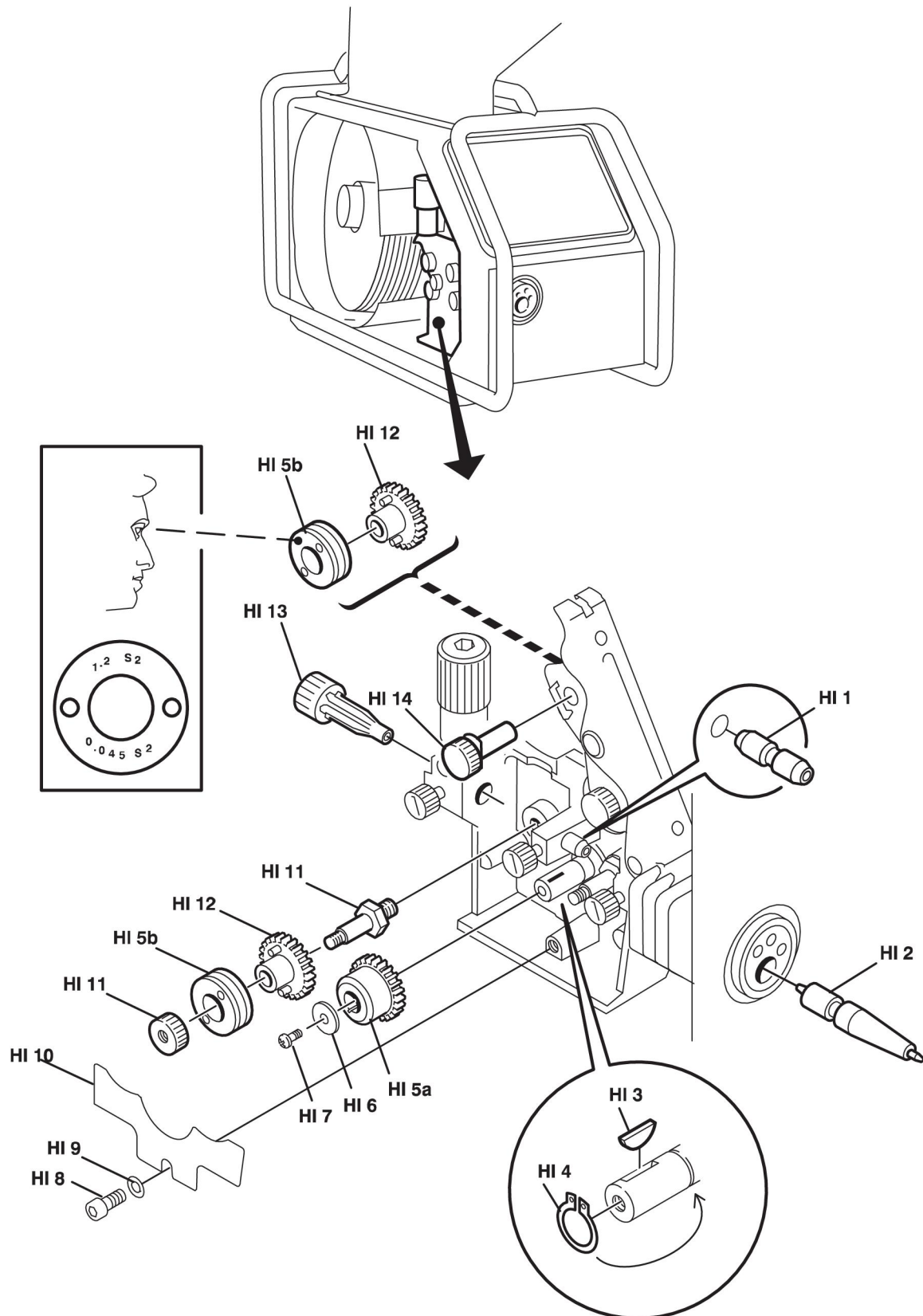
**WEAR PARTS**


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Item	Ordering number	Denomination	Wire type	Wire dimensions
HI 1	0455 072 002	Intermediate nozzle	Fe, Ss & cored	Ø 2.0 mm steel for 0.6-1.6 mm (0.079 in. steel for .023-1/16 in.)
	0456 615 001	Intermediate nozzle	Al	Ø 2.0 mm plastic for 0.8-1.6 mm (0.079 in. plastic for .030-1/16 in.)
HI 2	0469 837 880	Outlet nozzle	Fe, Ss & cored	Ø 2.0 mm steel for 0.6-1.6 mm (0.079 in. steel for .023-1/16 in.)
	0469 837 881	Outlet nozzle	Al	Ø 2.0 mm plastic for 0.8-1.6 mm (0079 in. plastic for .030-1/16 in.)
HI 3	0191 496 114	Key		
HI 4	0215 701 007	Locking washer		
HI 5a	0459 440 001	Motor gear euro, drive gear		

## WEAR PARTS

Item	Ordering number	Denomination	Wire type	Wire dimensions mm (in.)	Groove type	Roller markings
HI 5b	0459 052 001	Feed/pressure rollers	Fe, Ss & cored	Ø 0.6 & 0.8 (.023 & .030)	V	0.6 <b>S2</b> & 0.8 <b>S2</b>
	0459 052 002	Feed/pressure rollers	Fe, Ss & cored	Ø 0.8 & 1.0 (.030 & .040)	V	0.8 <b>S2</b> & 1.0 <b>S2</b>
	0459 052 003	Feed/pressure rollers	Fe, Ss & cored	Ø 0.9/1.0 & 1.2 (.035-.040 & 0.045)	V	1.0 <b>S2</b> & 1.2 <b>S2</b>
	0459 052 013	Feed/pressure rollers	Fe, Ss & cored	Ø 1.4 & 1.6 (.055 & 1/16)	V	1.4 <b>S2</b> & 1.6 <b>S2</b>
	0458 825 001	Feed/pressure rollers	Cored	Ø 0.9/1.0 & 1.2 (.035-.040 & 0.045)	V- knurled	1.0 <b>R2</b> & 1.2 <b>R2</b>
	0458 825 010	Feed/pressure rollers	Cored	Ø 1.2 & 1.2 (0.045 & 0.045)	V- knurled	1.2 <b>R2</b> & 1.2 <b>R2</b>
	0458 825 002	Feed/pressure rollers	Cored	Ø 1.2 & 1.4 (0.045 & .055)	V- knurled	1.2 <b>R2</b> & 1.4 <b>R2</b>
	0458 825 003	Feed/pressure rollers	Cored	Ø 1.6 (1/16)	V- knurled	1.6 <b>R2</b> & 2.0 <b>R2</b>
	0458 824 001	Feed/pressure rollers	Al	Ø 0.8 & 0.9/1.0 (.030 & .035-.040)	U	0.8 <b>A2</b> & 1.0 <b>A2</b>
	0458 824 002	Feed/pressure rollers	Al	Ø 1.0 & 1.2 (.040 & 0.045)	U	1.0 <b>A2</b> & 1.2 <b>A2</b>
	0458 824 003	Feed/pressure rollers	Al	Ø 1.2 & 1.6 (0.045 & 1/16)	U	1.2 <b>A2</b> & 1.6 <b>A2</b>
<p>Only use pressure and feed rollers marked <b>A2</b> , <b>R2</b> or <b>S2</b> . The rollers are marked with wire dimension in mm, some are also marked with inches.</p>						



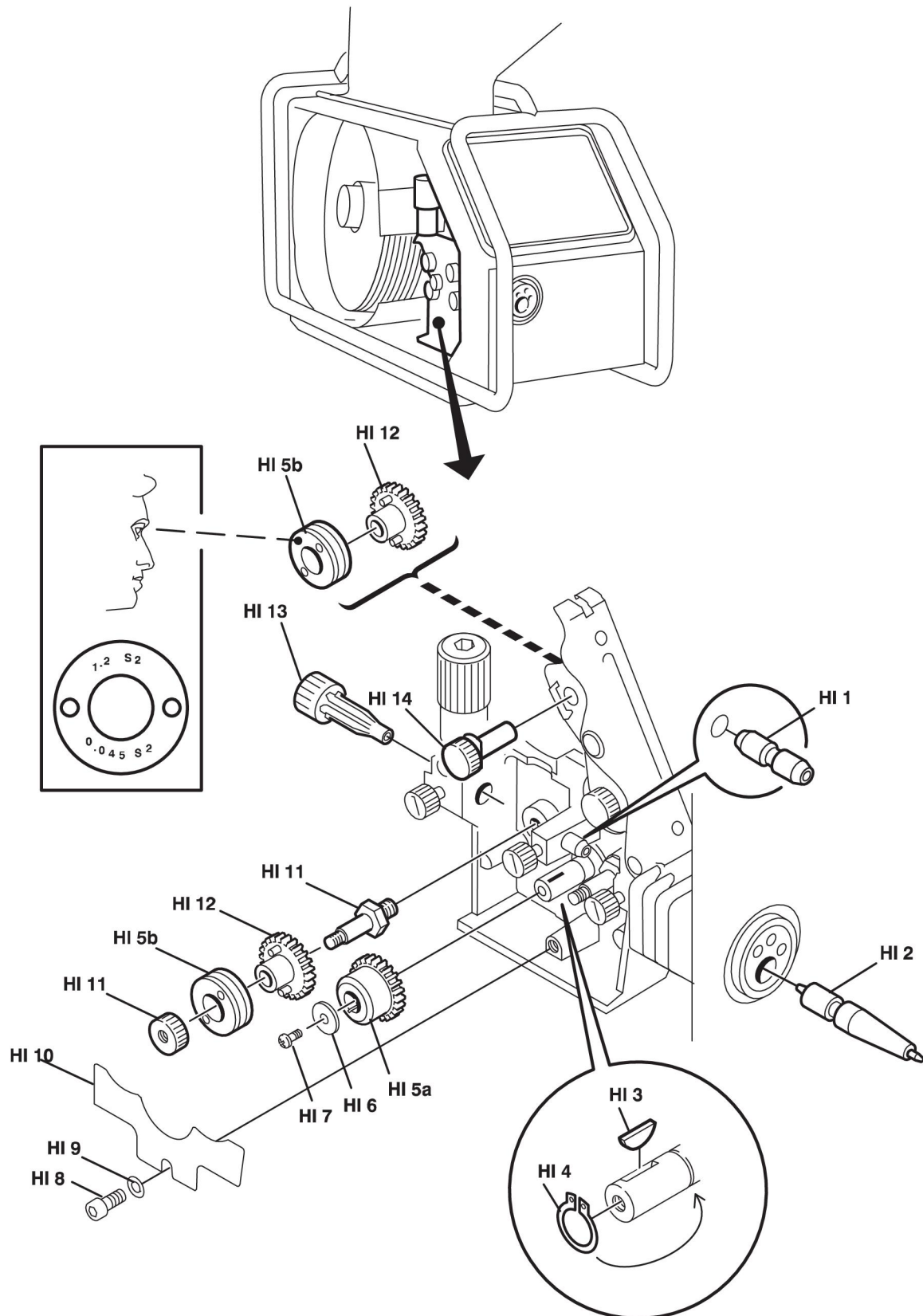
## WEAR PARTS

Item	Ordering number	Denomination	Notes
HI 6		Washer	Ø 16/5×1
HI 7		Screw	M4×12
HI 8		Screw	M6×12
HI 9		Washer	Ø 16/8.4×1.5
HI 10	0469 838 001	Cover	
HI 11	0458 722 880	Axle and Nut	
HI 12	0459 441 880	Gear adapter	
HI 13	0455 049 001	Inlet nozzle	Ø 3 mm for 0.6-1.6 mm (.118 in for .023-1/16 in.) Fe, Ss, Al and cored wire)
	0460 007 001	Inlet nozzle	<b>Long-life</b> for Fe, Ss and cored wire
HI 14	0458 999 001	Shaft	

**Welding with aluminium wire**

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

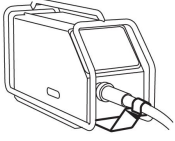
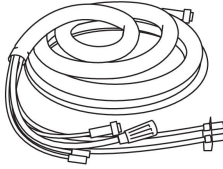
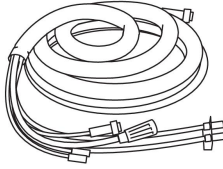




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**ACCESSORIES**


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0457 341 881	<b>Strain relief for welding gun</b>	
<b>Connection set air, 50 mm<sup>2</sup>, 19/19 pole</b>		
0459 836 562	10 m	
0459 836 563	15 m	
0459 836 564	25 m	
0459 836 565	35 m	
0459 836 566	50 m	
<b>Connection set water, 50 mm<sup>2</sup>, 19/19 pole</b>		
0459 836 572	10 m	
0459 836 573	15 m	
0459 836 574	25 m	
0459 836 575	35 m	
0459 836 576	50 m	



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