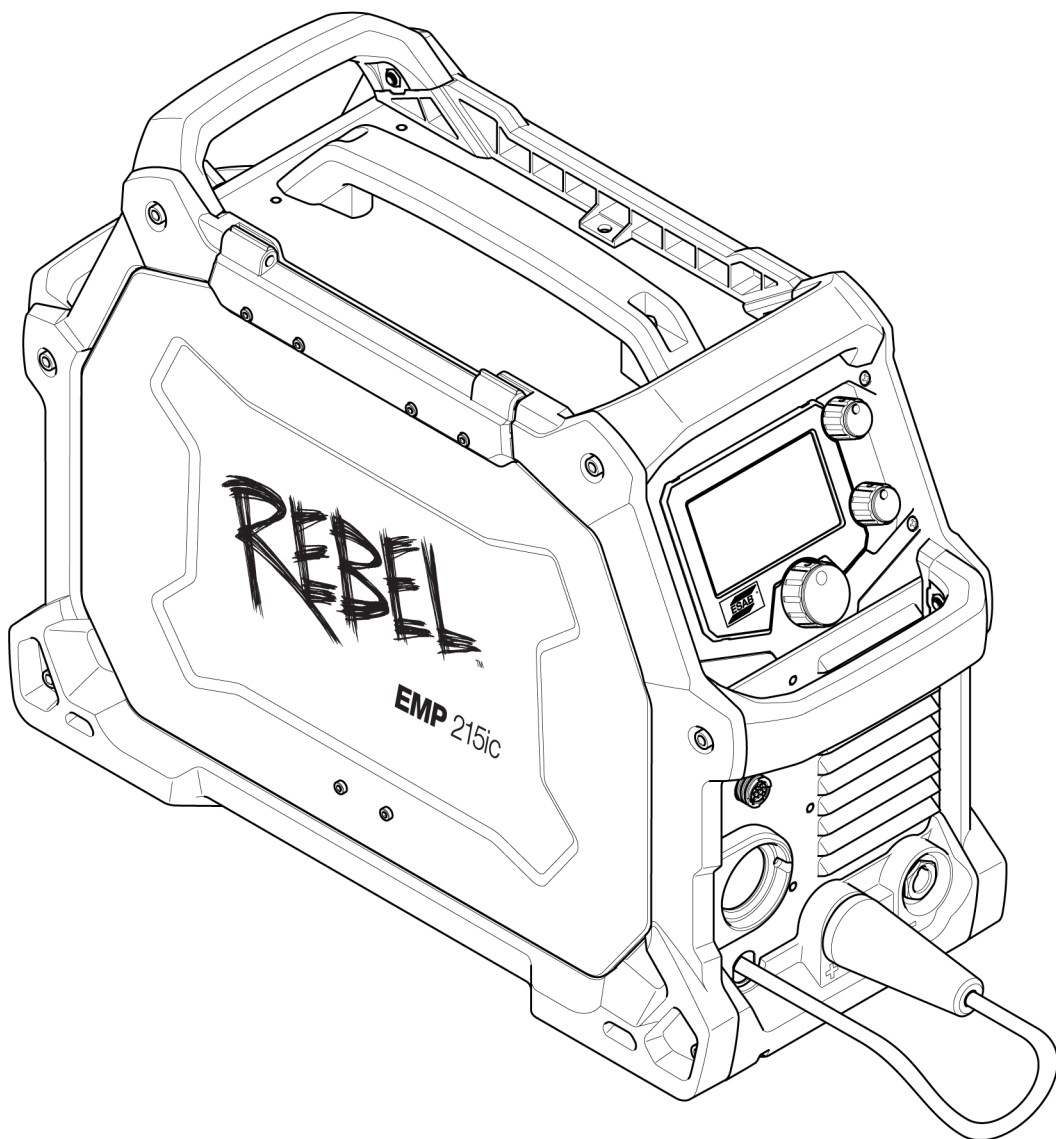


# **EMP 215ic**



## **Spare parts list**

<b>Ordering no.</b>	<b>Product</b>	<b>Notes</b>	<b>Serial no.</b>
0558 102 240	EMP 215ic Full Package, North America, CSA	Bobbin Ø4-8" (100-200 mm). CSA/Bayonet	CD315-xxx-xxxx
0558 102 239	EMP 215ic MIG/MMA Package, North America, CSA	Bobbin Ø4-8" (100-200 mm). CSA/Bayonet	CD315-xxx-xxxx

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see [esab.com](https://www.esab.com). 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.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

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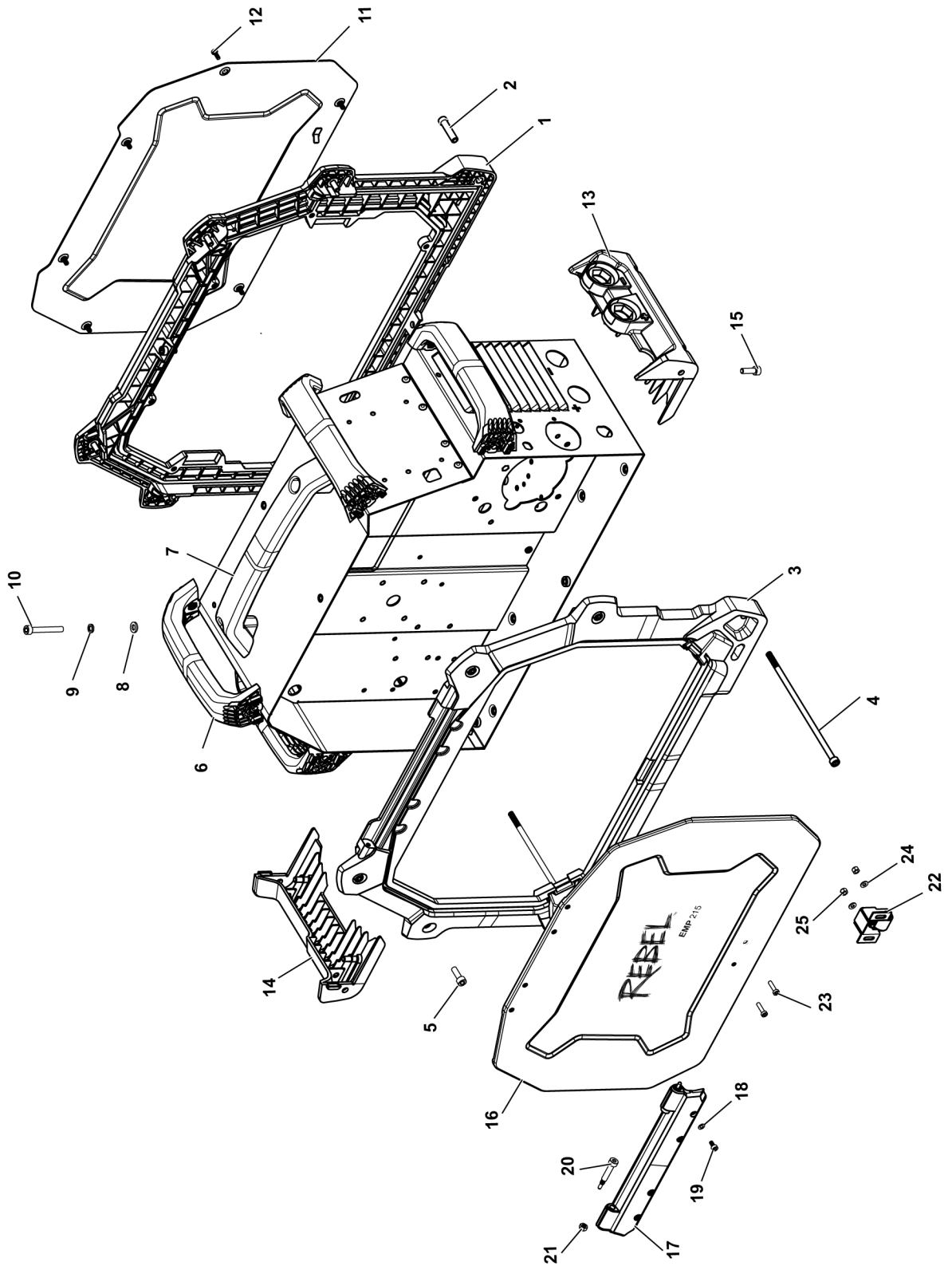
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# 1 SPARE PARTS

## 1.1 Housing

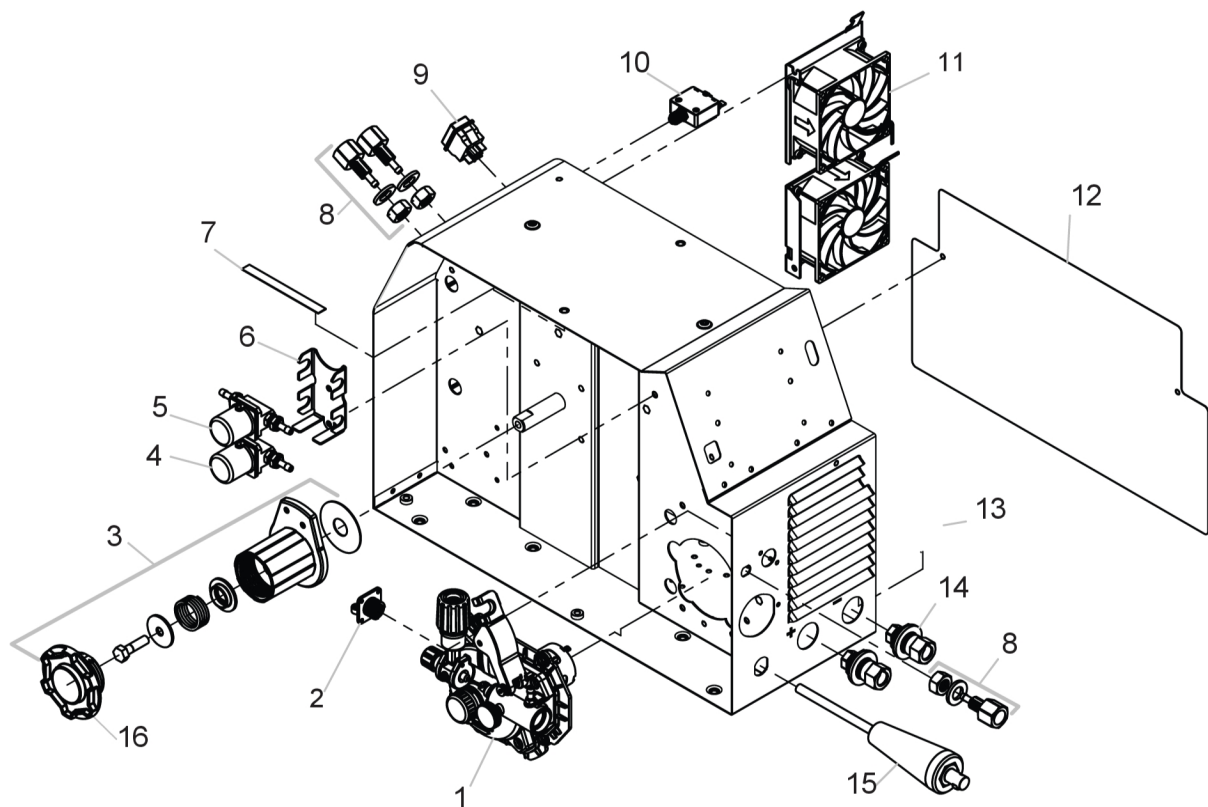
Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 397	Side frame, power side	
2	2		Barrel nut	M6×35
3	1	0558 102 398	Side frame, spool side	
4	2	0558 102 664	Barrel bolt	M6×175
5	8		Socket head screw	M6×1×18
6	4	0558 102 399	Handle	
7	1	0558 102 400	Top handle	
8	2		Flat washer	M6
9	2		Washer split lock	M6
10	2		Socket head screw	M6×1×45
11	1	0558 102 401	Side door, power side with ESAB logo	
12	6		Socket head low profile screw	M4×10
13	1	0558 102 402	Front foot	
14	1	0558 102 403	Rear foot	
15	4		Socket head screw	M6×1×18
16	1	0558 102 404	Side door, spool side with Rebel logo	
17	1	0558 102 406	Hinge	
18	4		Washer	M4×8
19	4		Cap screw	M4×8
20	2	0558 102 407	Hinge pin	
21	2		Lock nut	M5
22	1	0558 102 405	Roller latch assembly	
23	2		Screw	M4×16
24	2		Flat washer	M4×9
25	2		Lock nut	M4×0.7

1 SPARE PARTS



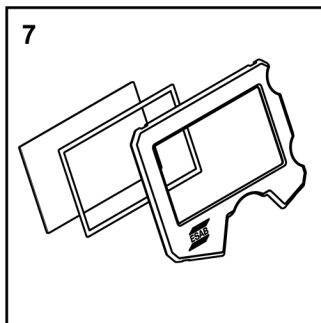
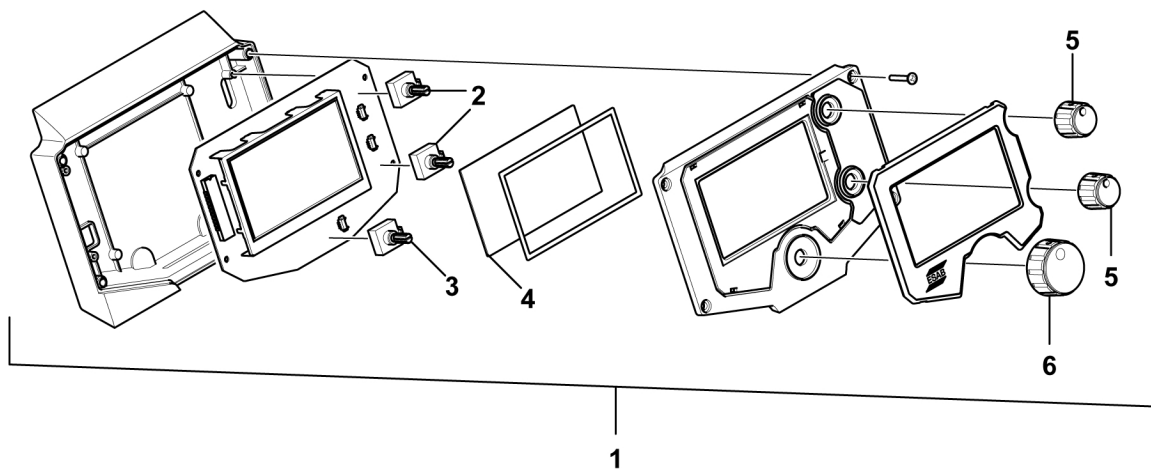
## 1.2 Connection parts

Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 408	Wire feeder mechanism	
2	1	0558 102 409	8-pin Remote cable assembly	
3	1	0558 102 411	Brake hub kit	
4	1	0558 102 648	MIG Solenoid gas assembly	
5		0558 102 649	TIG Solenoid gas assembly	
6	1	0558 102 925	Dual Solenoid bracket	
7	1	0558 102 650	LED Wire harness assembly	
8	3	0558 102 414	Gas connector	CSA
9	1	0558 102 415	Main supply switch	
10	1	0558 102 521	Circuit breaker	
11	1	0558 102 753	Fan bracket assembly	
12	1	0558 102 651	Protective mylar sheet	
13	1	0558 102 832	Current sensor	
14	1	0558 102 410	Brake hub nut	
15	2	0558 102 418	OKC contact, female	
16	1	0558 102 419	Polarity change cable assembly	



### 1.3 User interface

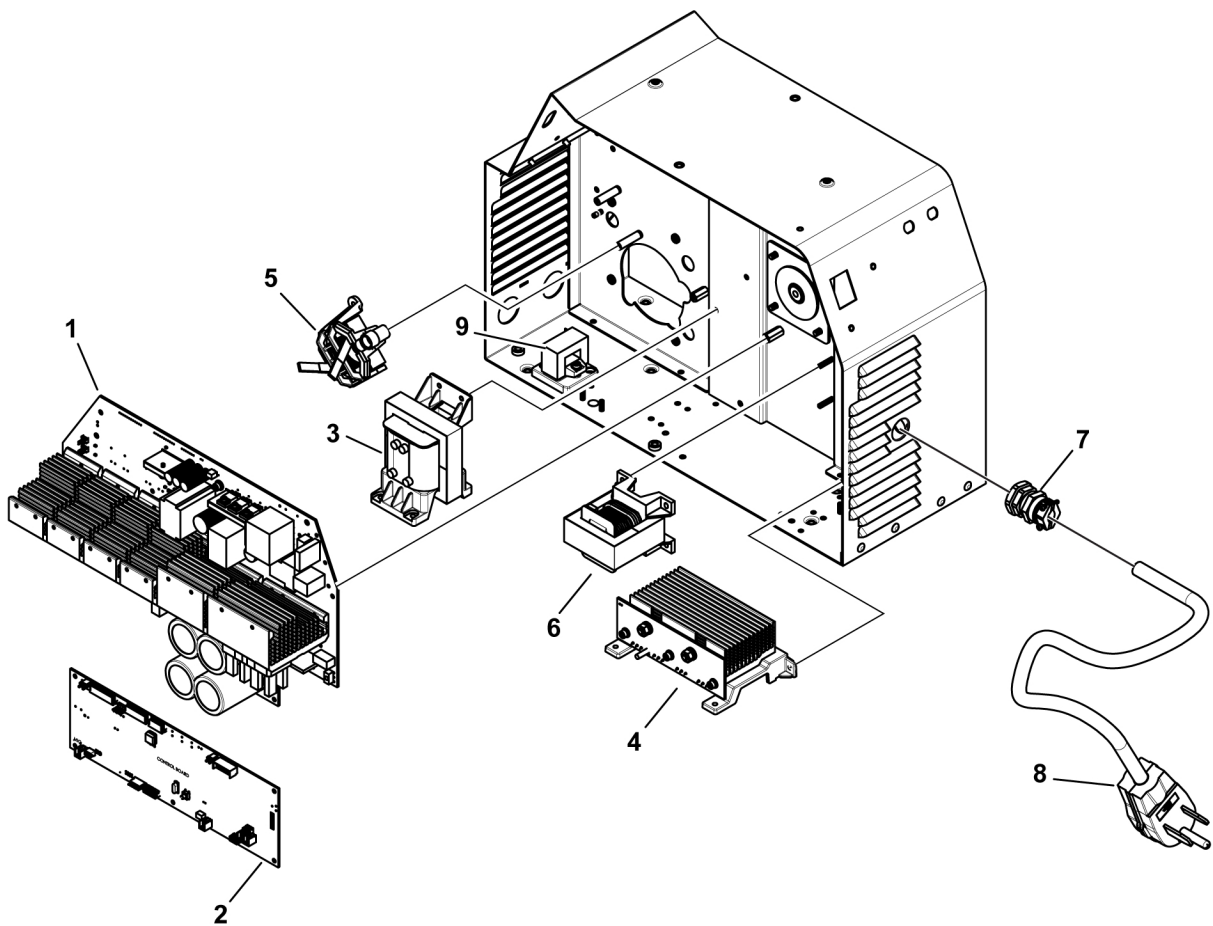
Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 833	EMP 215ic panel assembly	CSA
2	2	0558 102 423	Encoder for small knob	
3	1	0558 102 424	Encoder for large knob	
4	1	0558 102 438	Replaceable display lens	
5	2	0558 102 440	Knob, small	
6	1	0558 102 441	Knob, large	
7	1	0558 102 437	EMP 215ic lens assembly kit	



## 1.4 Control modules

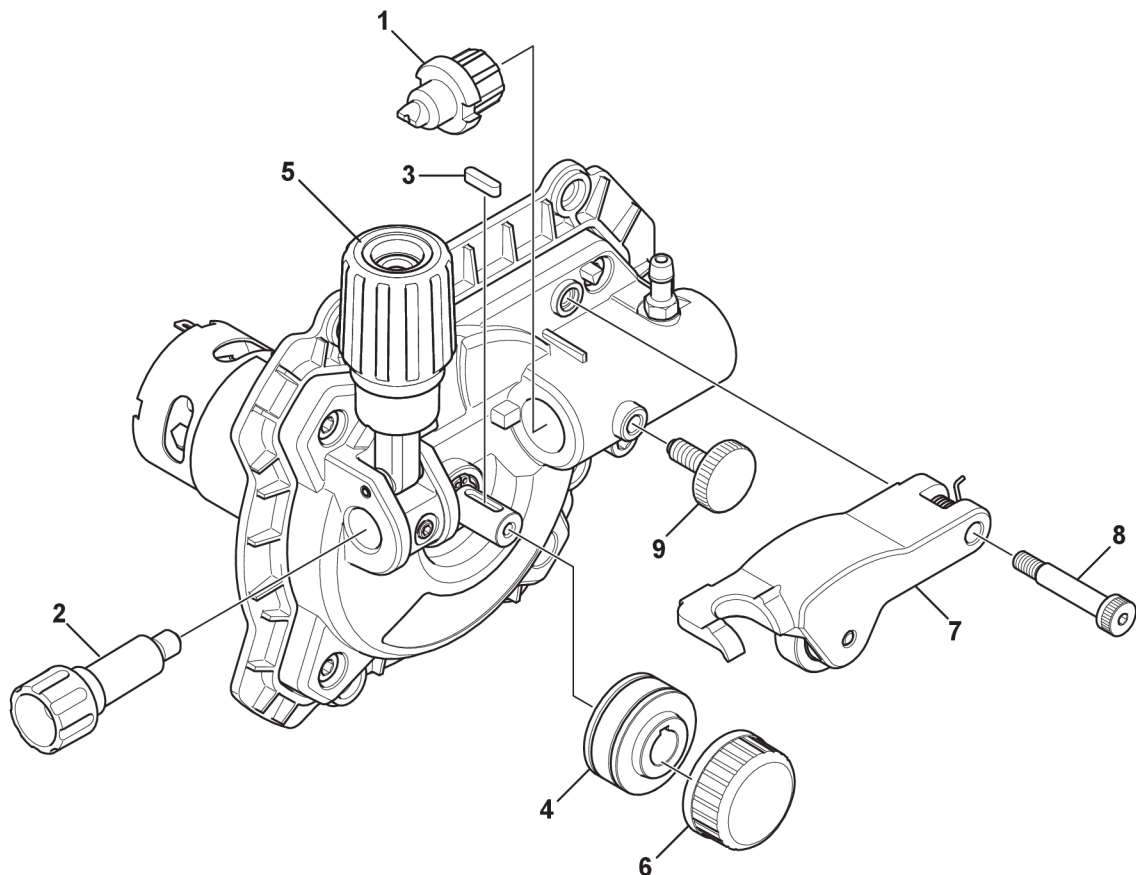
Item	Qty	Ordering no.	Denomination	Notes
1	1	0558 102 426	PCB Power board assembly	CSA
2	1	0558 102 835	PCB Control board complete	CSA
3	1	0558 102 428	Main transformer with NTC (3x)	
4	1	0558 102 836	Output diode assembly	
5	1	0558 102 837	Output inductor assembly	
6	1	0558 102 838	PFC inductor assembly	
7	1	0558 102 432	Strain relief assembly	
8	1	0558 102 433	Mains cable complete	CSA
9	1	0558 102 434	Warning label	Not included in illustration





## 2 WEAR PARTS

Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 326	Wire outlet guide	Fe/SS/Flux Cored	0.030 in. / 0.035 in. / 0.045 in. (0.8 mm / 0.9 mm / 1.2 mm)
	0558 102 327	Wire outlet guide	Fe/SS/Flux Cored	0.024 in. (0.6 mm)
2	0558 102 328	Wire inlet guide	Fe/SS/Flux Cored	0.024 in. / 0.030 in. / 0.035 in. / 0.045 in. (0.6 mm / 0.8 mm / 0.9 mm / 1.2 mm)
3	0558 102 334	Key-drive shaft	N/A	N/A
4	7977036	Feed roll "V" groove	Fe/SS	0.024 in. / 0.030 in. (0.6 mm / 0.8 mm)
	W4014800	Feed roll "V" groove	Fe/SS	0.024 in. / 0.035 in. (0.6 mm / 0.9 mm)
	7977732	Feed roll "V" knurled	Flux Cored	0.030 in. / 0.035 in. (0.8 mm / 0.9 mm)
	7044277	Feed roll "V" knurled	Flux Cored	0.045 in. (1.1 mm)
5	0558 102 329	Locking knob (Wire tension)	N/A	N/A
6	0558 102 518	Feed roller retaining knob		
7	0558 102 331	Pressure arm complete assembly	N/A	N/A
8	0558 102 330	Screw	N/A	N/A
9	0558 102 333	MIG gun locking knob	N/A	N/A







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