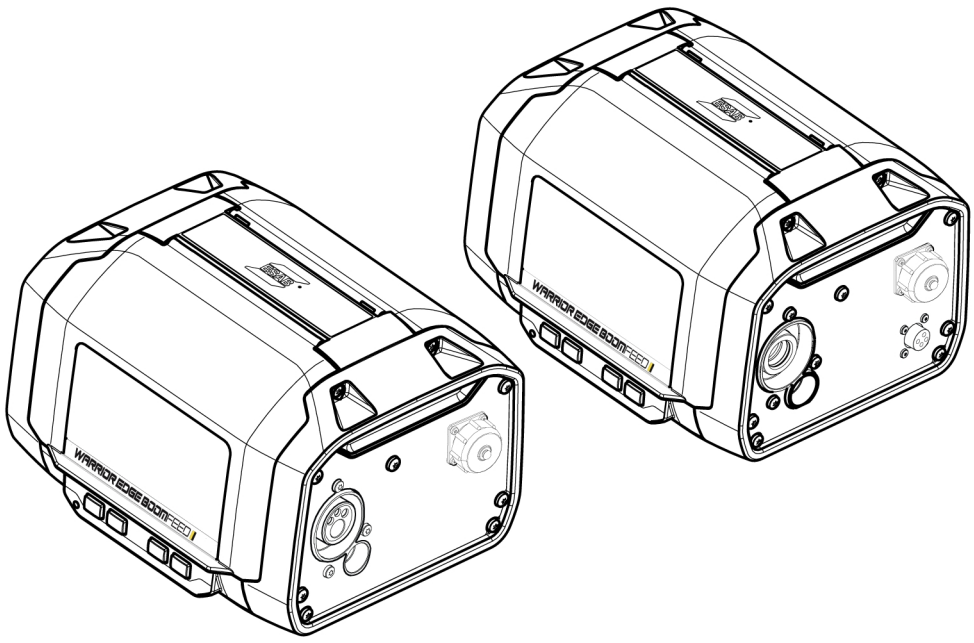
Warrior Edge BoomFeed



Instruction manual

A000 101 421 GB 20260326

Valid for: Serial number: OP543-, OP613YYXXXXXX

EU DECLARATION OF CONFORMITY

According to:

The Low Voltage Directive 2014/35/EU; The EMC Directive 2014/30/EU;
The RoHS Directive 2011/65/EU; The Ecodesign Directive 2009/125/EC

Type of equipment

Arc welding wire feeder

Type designation

Warrior Edge BoomFeed from serial number OP613 YY XX XXXX

X and Y represents digits, 0 to 9 in the serial number, where YY indicates year of production.

Brand name or trademark

ESAB

Manufacturer or his authorised representative established within the EEA

ESAB AB
Lindholmsallén 9, Box 8004, SE-402 77 Göteborg, Sweden
Phone: +46 31 50 90 00, www.esab.com

The following EN standards and regulations in force within the EEA has been used in the design:

EN 60974-5:2013	Arc Welding Equipment – Part 5: Wire Feeders
IEC/EN 60974-10: 2020	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 and environmental requirements stated above.

Place/Date **Signature**

Gothenburg
2026-03-26

Peter Burchfield
VP, Global Products

CE

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

If equipped with ESAB cooler
Use ESAB approved coolant only. Non-approved coolant might damage the equipment and jeopardize product safety. In case of such damage, all warranty undertakings from ESAB cease to apply.

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

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

ELECTRIC SHOCK - Can kill

- Install and ground the unit in accordance with instruction manual.
- 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.

HOT SURFACE - Parts can burn

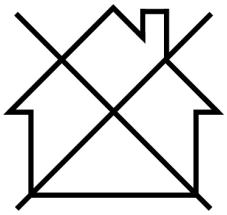
- Do not touch parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or insulated welding gloves to prevent burns.

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

PROTECT YOURSELF AND OTHERS!

CAUTION!
This product is solely intended for arc welding.

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.

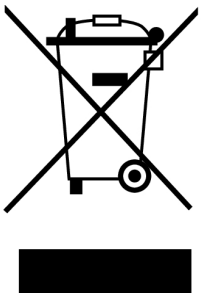


NOTE!
Dispose of electronic equipment at the recycling facility!

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

The **Warrior EDGE BoomFeed** wire feed unit is intended for MIG/MAG welding, used in conjunction with the Remote User Interface and Warrior EDGE 500 power source.

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

2.1 Equipment

The wire feed unit is supplied with:

- BoomFeed
- Marathon Pac™ Quick Connect Kit
- Interfacing Weld Cable
- Feed Roller V Groove 0.035/0.045 in (1.0/1.2 mm)
- Wire Guides for Fe(SS/C 0.8-1/16 in (0.6-1.6 mm)
- Safety Instructions
- Quick Start Guide

3 TECHNICAL DATA

Warrior Edge BoomFeed	
Power supply	60 V DC
Power requirement	48 W
Rated supply current	0.8 A
Wire feed speed	0.8–25 m/min (32–985 in./min)
Welding torch connection	ESAB Tweco / Euro Connector
Wire dimensions:	
Fe	0.6–2.0 mm (0.023–5/64 in.)
Ss	0.6–1.6 mm (0.023–1/16 in.)
Al	1.0–1.6 mm (0.040–1/16 in.)
Cored wire	0.9–2.4 mm (0.035–3/32 in.)
Weight	6 kg (13.2 lbs)
Dimensions (l × w × h)	322 × 235 × 182 mm (12.7 × 9.3 × 7.2 in.)
Operating temperature	-10° to +40 °C (14° to +104 °F)
Transport and storage temperature	-40° to +80 °C (-40° to +176 °F)
Shielding gas pressure	3–5 bar (43–73 psi)
Permissible load at +40 °C:	
60% duty cycle	500 A
100% duty cycle	400 A
Enclosure class	IP2X
Application class	S

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 specified load without overloading.

Enclosure class
The **IP** code indicates the enclosure class, i.e. the degree of protection against penetration by solids or liquids.

Equipment marked **IP2X** is intended for indoor use.

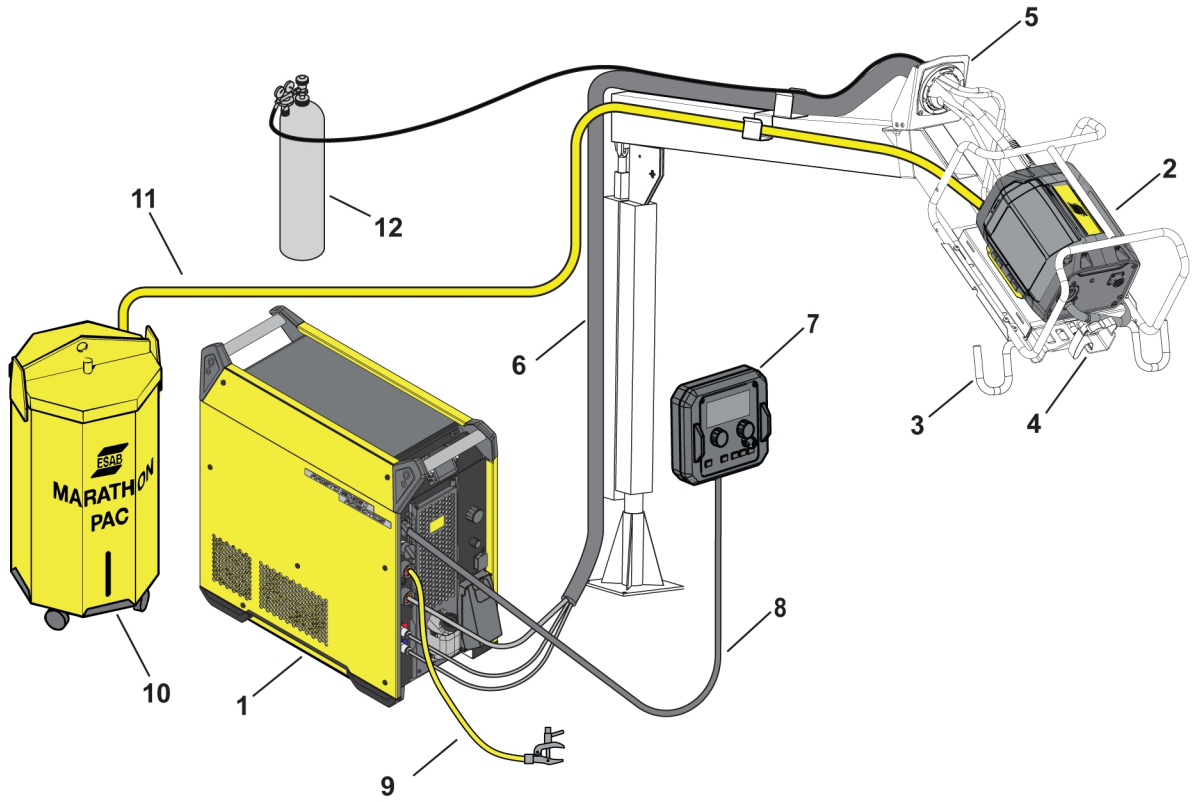
Application class
The symbol S indicates that the power source is designed for use in areas with increased electrical hazard.

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 shall be used. These power sources are marked with the symbol S.

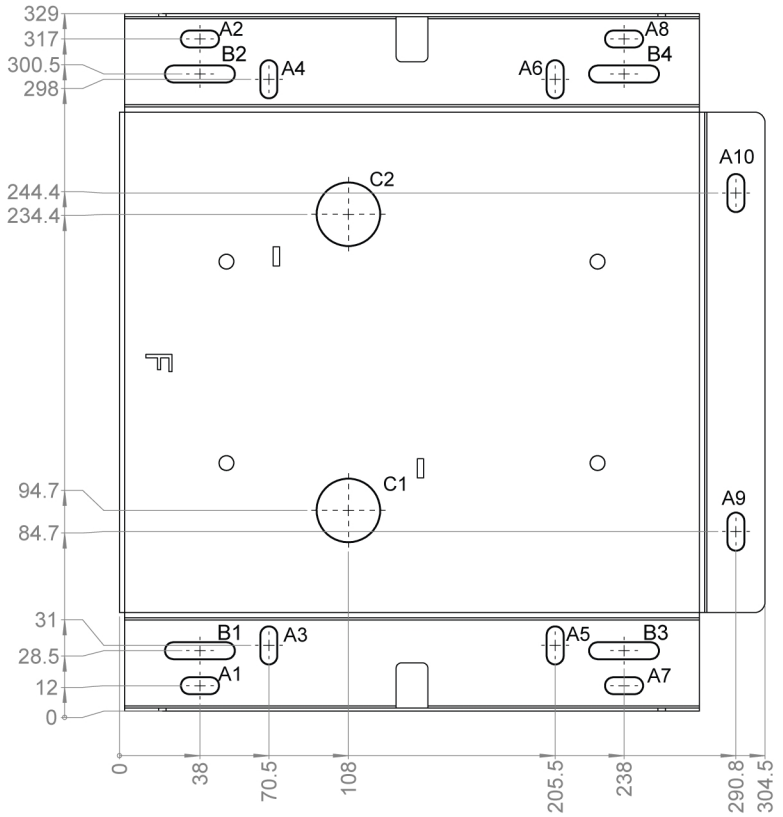
4.1 ESAB Balance Boom implementation



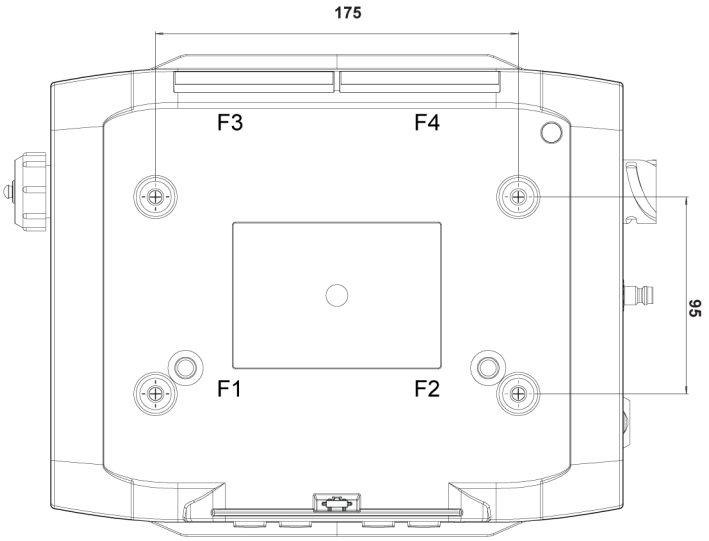
1. Power source
2. Warrior Edge BoomFeed with protective cage
3. Cable hanger
4. Torch strain relief
5. IC cable strain relief bracket
6. Interconnection cable
7. Remote user interface
8. Control cable
9. Return cable
10. Marathon pac™
11. Wire conduit
12. Gas cylinder

4.2 Dress kit and protective cage mounting pate

Warrior Edge BoomFeed is not exclusive to Warrior Balance Boom and can be mounted in various applications via the mounting plate (all dimensions are in mm).



TAG	SIZE
A1	8 X 18
A2	
A3	
A4	
A5	
A6	
A7	
A8	
A9	
A10	
B1	8 X 33
B2	
B3	
B4	
C1	M12
C2	
F1	M6
F2	
F3	
F4	

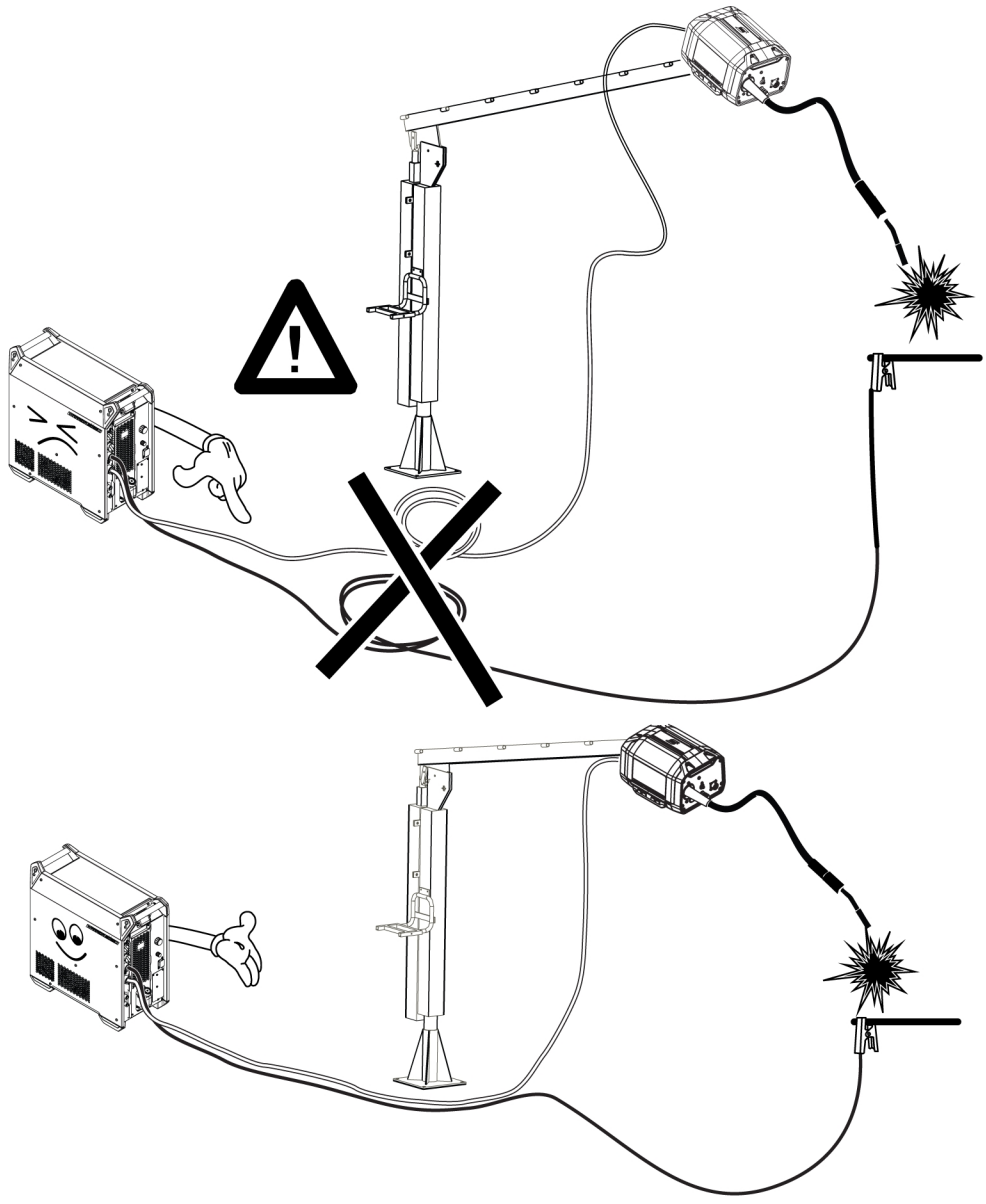


5 OPERATION

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!
Assure that the side panels are closed during operation.

WARNING!
Rotating parts can cause injury, take great care.



5.1 Welding cable size selection

The total cable length in the welding circuit is the sum of the lengths of both welding cables.

For example, if the power source is positioned 30 m (100 ft) from the workpiece, the total cable length is 60 m (200 ft), i.e. 2 × 30 m (100 ft). Refer to the 60 m (200 ft) column to select the appropriate cable size.

This table is intended as a general guideline and may not be suitable for all applications. If the weld cable overheats, select the next larger cable size.

Weld cable size mm² (AWG) is determined based on either a maximum voltage drop of 4 V or a minimum current density of 300 circular mils per ampere.

For cable lengths exceeding those shown, see AWS Fact Sheet No. 39, Welding Cables, available from the American Welding Society at **https://www.aws.org**.

Weld cable size and total cable length in the weld circuit								
	30 m (100 ft) or less		**45 m (150 ft)**	**60 m (200 ft)**	**70 m (250 ft)**	**90 m (300 ft)**	**105 m (350 ft)**	**120 m (400 ft)**
Welding amperes	**10 - 60% Duty cycle mm² (AWG)**	**60 - 100% Duty cycle mm² (AWG)**	**10 - 100% Duty cycle mm² (AWG)**					
100	4 (20)	4 (20)	4 (20)	3 (30)	2 (35)	1 (50)	1/0 (60)	1/0 (60)
150	3 (30)	3 (30)	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	3/0 (95)
200	3 (30)	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	4/0 (120)
250	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2×2/0 (2×70)	2×2/0 (2×70)
300	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2×2/0 (2×70)	2×3/0 (2×95)	2×3/0 (2×95)
350	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2×2/0 (2×70)	2×3/0 (2×95)	2×3/0 (2×95)	2×4/0 (2×120)
400	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2×2/0 (2×70)	2×3/0 (2×95)	2×4/0 (2×120)	2×4/0 (2×120)
500	2/0 (70)	3/0 (95)	4/0 (120)	2×2/0 (2×70)	2×3/0 (2×95)	2×4/0 (2×120)	3×3/0 (3×95)	3×3/0 (3×95)
600	3/0 (95)	4/0 (120)	2×2/0 (2×70)	2×3/0 (2×95)	2×4/0 (2×120)	3×3/0 (3×95)	3×4/0 (3×120)	3×4/0 (3×120)

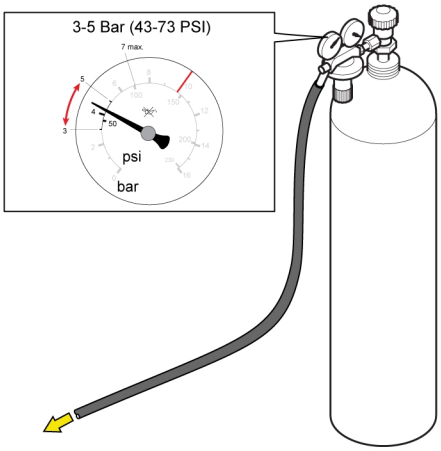
5.2 Recommended shielding gas regulators

The shielding gas outlet, cylinder, or bulk, should be equipped with a pressure regulator.

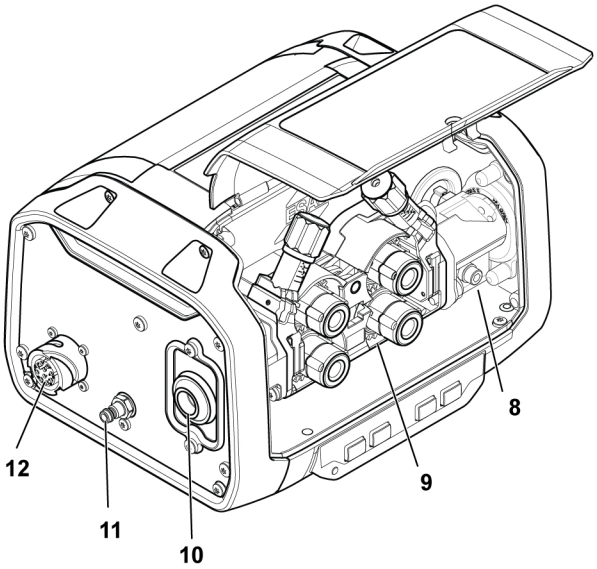
Set the pressure regulator in the range of 3-5 bar (43-73 psi).

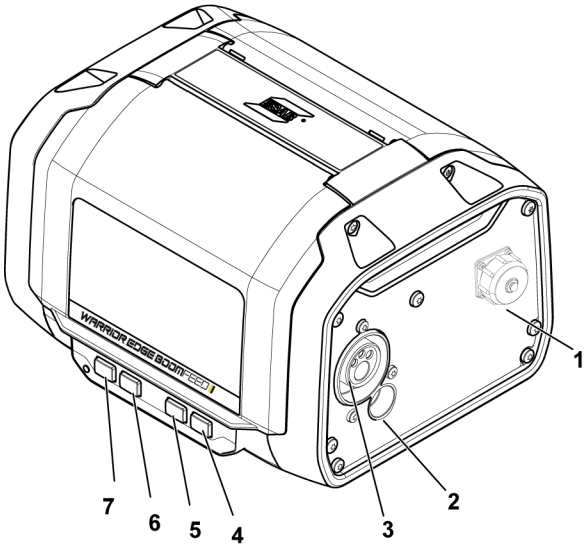
The shielding gas inlet pressure should not exceed 5 bar (73 psi).

The flow rate is to be set in the Remote User Interface.



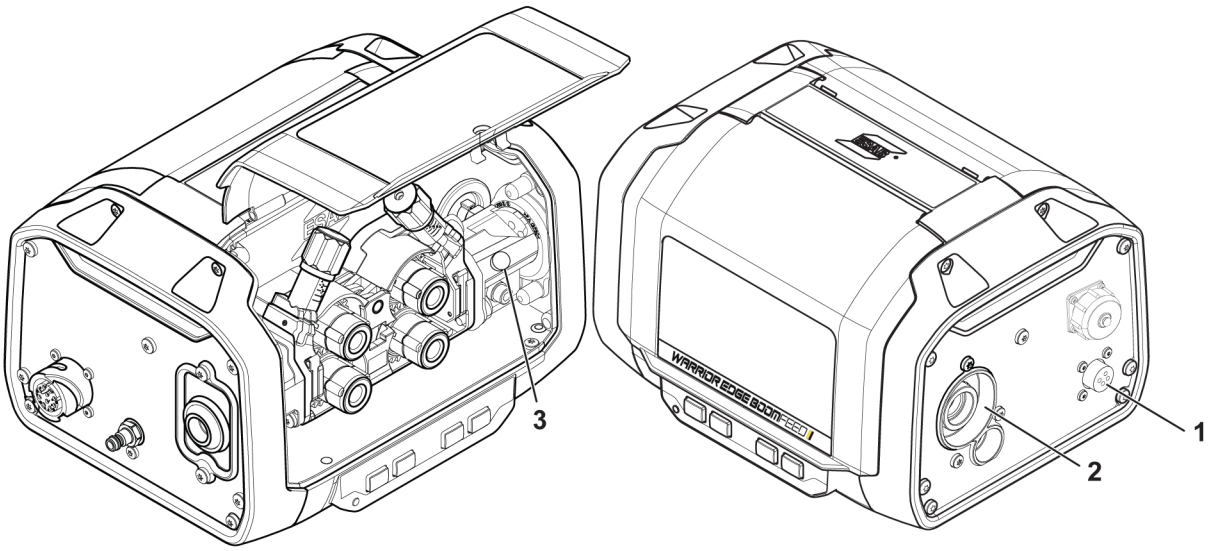
5.3 Connection (EURO)





1. Remote connector (19-pol)
2. Weld cable connection
3. Euro torch connector
4. Gas purge
5. Wire inching forward
6. Wire inching backwards
7. Maintenance mode
8. Weld cable connector screw
9. Feeder mechanism
10. Wire inlet/Wire conduit quick connector
11. Shielding gas inlet
12. Power and communication connector (10-pol)

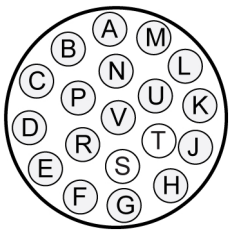
5.4 Connection (TWECO)



1. Trigger connector (4-pol)
2. Tweco torch connector
3. Thumb screw

NOTE!
Items 1,2 and 3 are unique to the TWECO variant. All other parts are the same as the EURO variant.

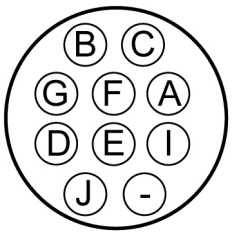
5.5 19-pol connection table



Pin	Description	Function
A	RxDP	Ethernet
B	RxDN	Ethernet
C	Ethernet shield pin	Ethernet shield
D	TxDP	Ethernet
E	TxDN	Ethernet
F	External output	External generic output
G	PP M-	Push/pull motor -
H	PP M+	Push/pull motor +
J	NC	Not connected
K	NC	Not connected
L	PP Enc A	Push/pull motor encoder channel A
M	Trigger+	Trigger

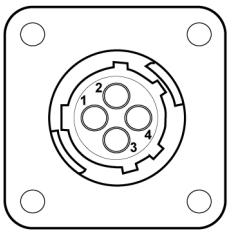
Pin	Description	Function
N	PP Enc B	Push/pull motor encoder channel B
P	NC	Not connected
R	NC	Not connected
S	24VDC_rtn	External power supply return for pull motor encoder (or) Digital remote
T	24VDC	External power supply 24VDC for pull motor encoder (or) Digital remote
U	Trigger-	Trigger
V	NC	Not connected

5.6 10-pol connection table



Pin	Description	Function
B	RxDN	Ethernet
C	RxDN	Ethernet
G	TxD	Ethernet
F	TxDN	Ethernet
A	Ethernet shield	Ethernet shield
D	+60 VDC	Power 60Vdc
E	+60 Vdc_return	Power 60Vdc
I	NC	Not connected
J	NC	Not connected
Housing	Cable shield	Outer cable shield

5.7 TWECO connector - 4-pin



Pin	Function	Pin name	Voltage specification
1	Trigger + communication	Trigger +	24 Vdc
2	Trigger return	Trigger -	24 Vdc

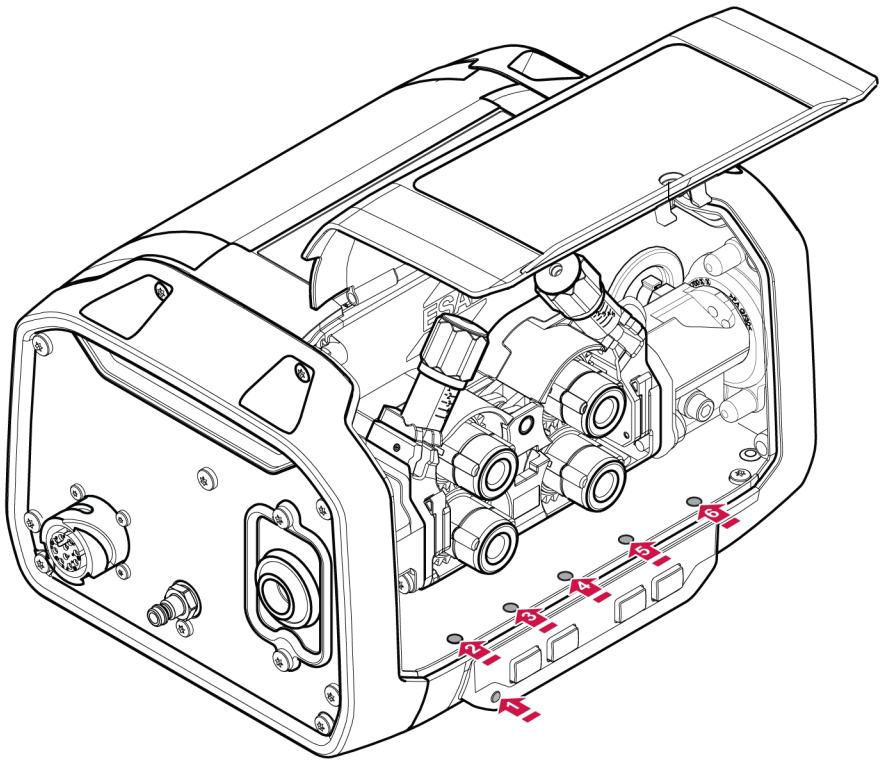
Pin	Function	Pin name	Voltage specification
3	Not used	-	-
4	Not used	-	-

5.8 Symbol and function explanations

	Shielding gas inlet
	Shielding gas purge
	Wire inch reverse
	Wire inch forward
	Remote connector
	Maintenance

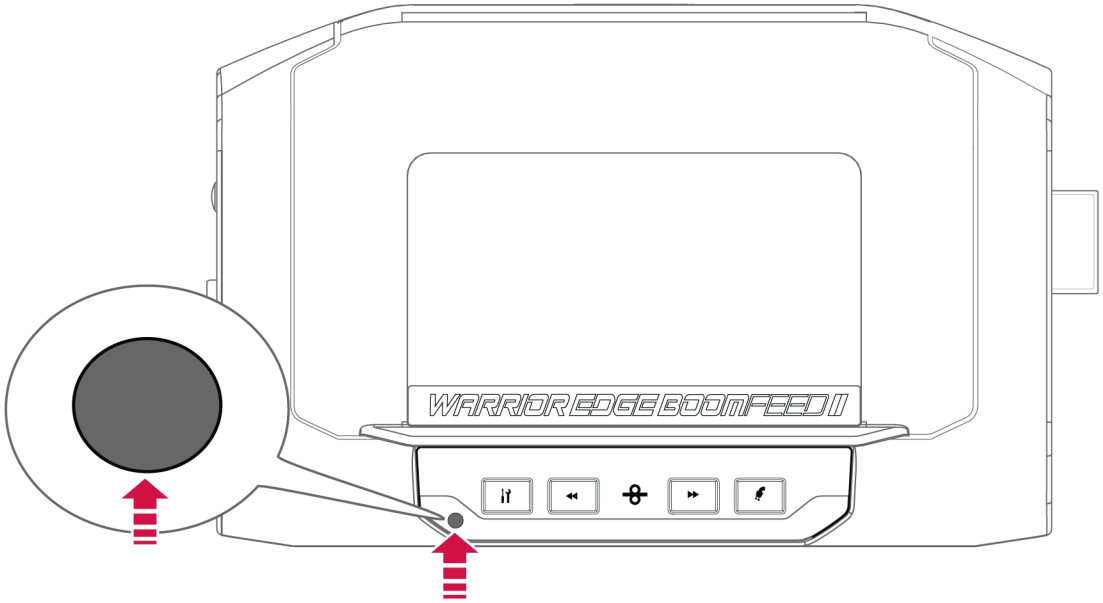
5.9 LED descriptions

LED-system status indication



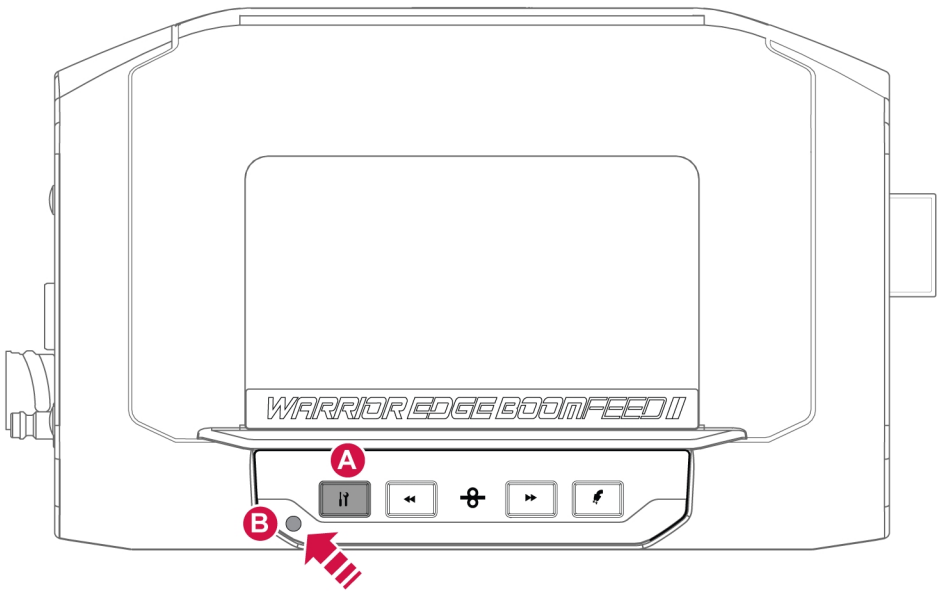
- **LED (1):** System status indication.
- **LEDs (2 to 6):** Indicate the direction of movement of the wire drive mechanism. The LEDs will light sequentially forward when the drive is moving forward/feeding wire forward. The LEDs will light sequentially backward when the drive is moving backward/reversing the wire feed.

LED 1	
Orange	There is an active warning in the system, but no errors are present.
Red	There is an active error present in the system.
Solid green	The system is running normally with no warnings or errors.
Green (blinking)	The system is in a startup phase, such as Network Survey, System Survey, and Startup.
Solid white	The system is in Maintenance mode.
Solid yellow	The system is in Standby mode.



5.10 Enabling/disabling maintenance mode

All operations involving external physical control are disabled during maintenance mode. This is to ensure a safe working environment when performing routine maintenance.



1) Press the maintenance button (A) for three seconds to enable the maintenance mode. LED (B) will illuminate white.

2) Press the maintenance button (A) for three seconds to disable the maintenance mode. LED (B) illuminated white, will then illuminate green.

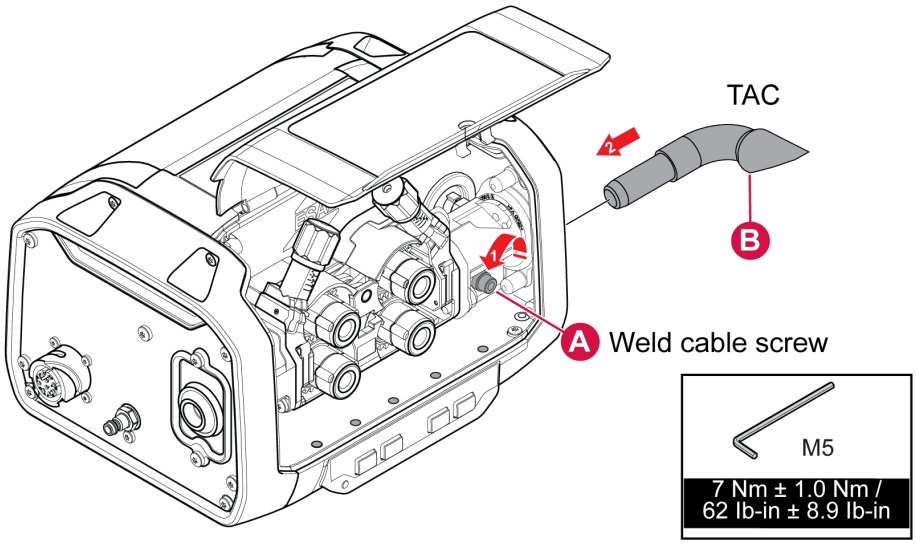
3) Green LED (B) indicate that the system in an normal operating condition.

5.11 Connecting True Arc Connector (TAC)

Connection

1) TAC securing screw - release screw (A) partially to allow insertion of TAC weld cable (B).

2) TAC Weld Cable - fully insert TAC weld cable connector in to weld cable connector and tighten the TAC securing screw (A).



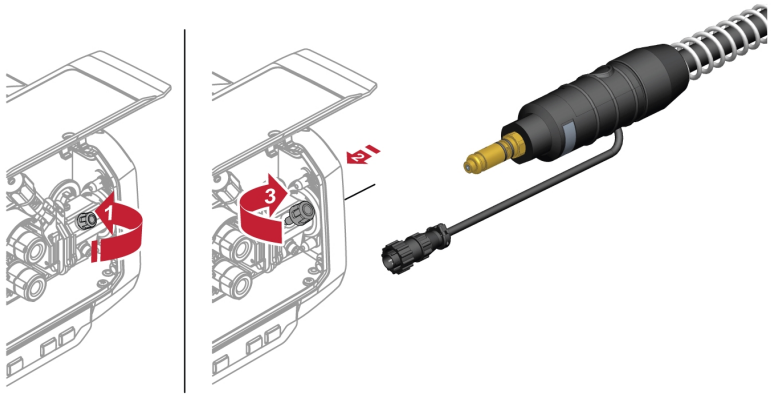
5.12 Connecting the TWECO torch

Connection

1) Loosen the thumb screw.

2) Insert the TWECO torch fully.

3) Tighten the thumb screw to secure the TWECO torch.

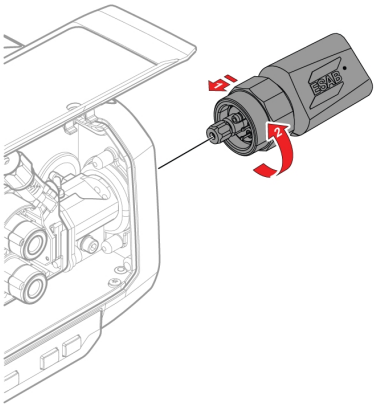


These steps should also be checked and carried out when the part is replaced.

5.13 Connecting the Euro torch

1) Insert the Euro torch into the Euro central connector.

2) Rotate the torch securing collar clockwise to secure the torch.



5.14 Shielding gas regulation

Warrior Edge BoomFeed is equipped with a digital gas measurement and control system that measures the mass flow of the shielding gas and controls it to the necessary mass flow value during welding.

The system has advantages over valve-only or valve-rotameter solutions in areas like on-the-fly gas delivery due to fast and dynamic control and responds to flow even when external disturbances occur and no overshot of flow at the weld start.

During the welding process, the gas flow is controlled and monitored. If the shielding gas system is unable to maintain gas flow due to loss of pressure, gas supply restriction, or other faults, the system will display an error to the power source HMI or RUI.

5.15 Installing wire

1) Open the transparent drive cover.

2) Install the new wire spool onto the spool hub or install a new marathon pack.

3) Release the tensioner arm by pulling the tensioner arm up out of its detent and rotating it outward. The feed roll pressure arm will spring up.

4) Install rollers for the selected wire size.

5) With a clean-cut wire, manually feed wire into and through the wire conduit, across the rear feed roll; through the center wire guide; across the front feed roll, and into the wire outlet guide. Thread enough wire that it will extend past the front of the wire feed unit.

6) Close the drive roll pressure arms and secure the rear and front tensioner arms to secure the wire in place.

7) Connect the torch assembly to the unit by inserting the end of the wire into the torch connector and securing the torch in the drive assembly connector.

8) Power up the power source.

9) With the torch cable laid out straight, feed the wire through the torch cable until the wire is visible at the end of the torch by pressing the jog/inch button or trigger switch on the torch.

10) Set and verify the wire feed tension for correct wire feed pressure, see *"Setting feed roll pressure"*, page 22.

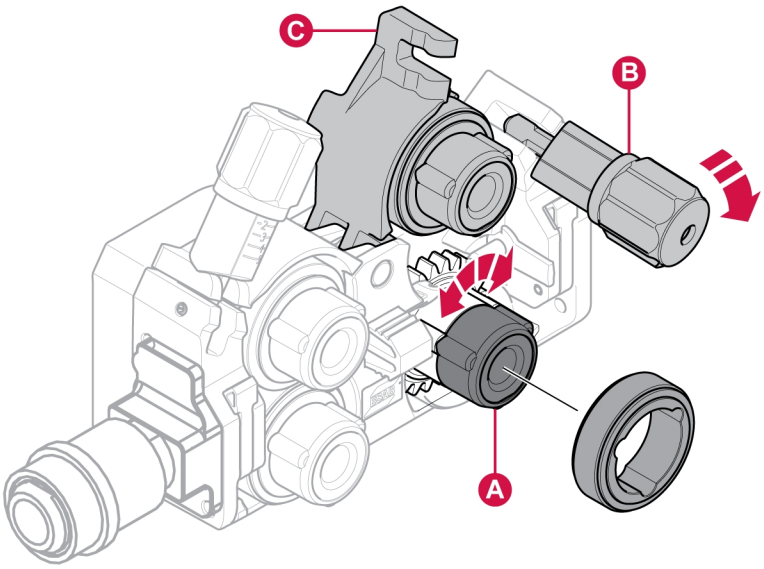
11) Close the transparent drive cover.

5.16 Removing wire

1) Open the transparent drive cover.
2) Release the tensioner arms by pulling it up out of detent and rotating it outward.
3) Cut the wire at the end of the torch near the contact tip.
4) Use the reverse button on the feeder and manually rewind the wire spool, securing the wire by hand between the conduit and spool or conduit and marathon pack. Pay attention to not releasing the end of the wire and unwinding the spool or falling into the marathon pack.
5) Secure the end of the wire to the wire spool or marathon pack.
6) Remove the spool retention key or spool hub nut or drum cap.
7) Remove wire spool or empty marathon pack.
8) Close the transparent drive cover.

5.17 Changing feed rollers

When changing to a different wire, the feed rolls should also be changed to match the new wire type or diameter. For more information about correct feed rolls, see *"WEAR PARTS"*, page 33.



1) Enable maintenance mode.
2) Open the transparent cover.
3) Unlock the feed rollers to be exchanged by rotating the roller quick lock (A) for each roller.
4) Relieve the pressure on the feed rollers by folding the pressure arm (B) down and thereby releasing the swing arms (C).

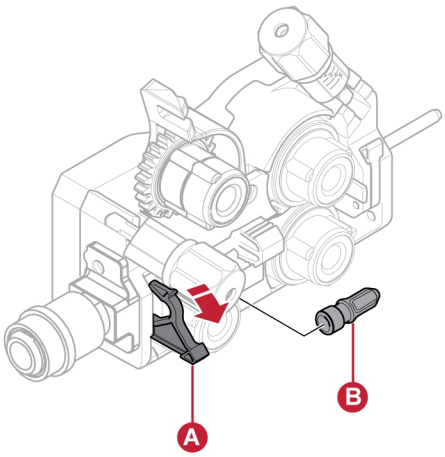
5) Remove the feed rollers and install the correct ones (see *"WEAR PARTS"*, page 33).

6) Reapply the pressure on the feed rollers by pushing the swing arms (C) down and securing them using the pressure arm (B).

7) Lock the rollers by rotating the roller quick locks (A).

8) Close the transparent cover.

5.18 Removing/installing/adjusting wire feed guides



1) Enable the maintenance mode.

2) Open the transparent cover.

3) Remove the lower left feed roller (see *"Changing feed rollers"*, page 20).

4) Remove the middle wire guide (see *"Changing the middle wire guide"*, page 21).

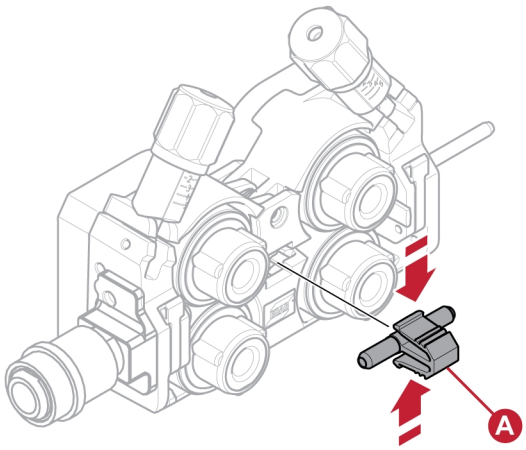
5) Unlock the inlet wire guide quick lock (A) by folding it out.

6) Remove the inlet wire guide (B), pulling it forward.

7) Install the correct inlet wire guide (see *"WEAR PARTS"*, page 33).

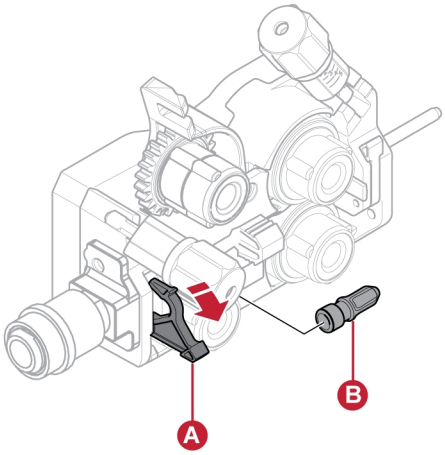
8) Lock the new inlet wire guide using the wire guide quick lock (A).

5.19 Changing the middle wire guide



1) Enable the maintenance mode.
2) Open the transparent cover.
3) To remove the center wire guide, pinch the center of the wire guide and pull out the guide (A).
4) To install the center wire guide, pinch the guide and push it into place. The clips will lock the guide into place.

5.20 Changing the outlet wire guide



1) Enable the maintenance mode.
2) Open the transparent cover.
3) To remove the wire outlet guide, release the pressure on the front feed roll pressure arm by rotating the front tensioner arm outward.
4) Remove the lower front feed roll.
5) Remove the center wire guide.
6) Unlock the wire outlet guide quick lock (A) by folding it out.
7) Remove the wire outlet guide (B), pulling it backward.
8) Install the new wire outlet guide.
9) Lock the new wire outlet guide into place using the wire guide quick lock (A).
10) Reinstall the center wire guide.
11) Reinstall the lower front feed roll.
12) Close the transparent cover.

5.21 Setting feed roll pressure

NOTE!
Over tension of the brake will cause rapid wear of mechanical feeder parts, overheating of electrical components and possibly more incidences of contact tips burnback.

The roller pressure should be adjusted separately with as little pressure as possible to ensure good wire feed ability.

1) The feed roll pressures should be adjusted independently, determined by the wire type and diameter. The front feed roll pressure should be slightly higher than the rear feed roll pressure

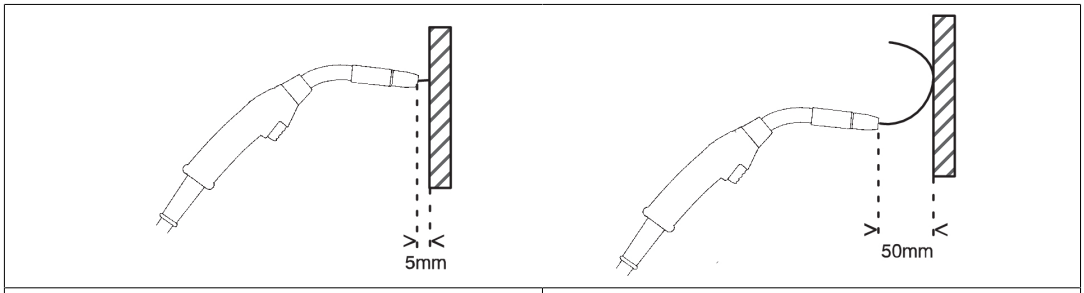


Figure A | *Figure B*

2) To check that the feed pressure is set correctly, feed the wire against a non-conductive surface. e.g. a piece of wood.

3) While holding the welding torch approximately 5 mm (3/16 in.) from the piece of wood (figure A), the feed rolls should slip.

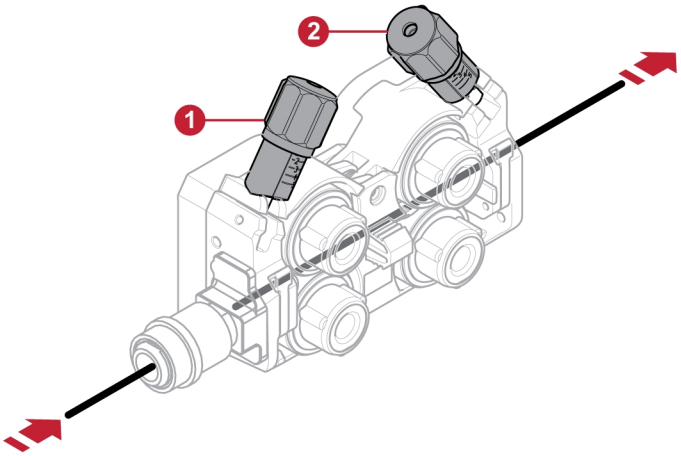
4) While holding the welding torch approximately 50 mm (2.0 in.) from the piece of wood, the wire should feed out and bend (figure B).

5) The image below serves as a guideline showing approximate roller pressure settings for standard conditions with correct spool hub brake force. If the torch cables are long, dirty or worn, the pressure setting may need to be increased. Always check the roller pressure setting on a case-by-case basis by feeding out the wire against an insulated object as described above.

6) A table showing approximate settings can be found on the inside of the left door of the wire drive covers

Wire feeder mechanism (side A):

Wire diameter (mm)(in.)			**0.8** .030	**0.9** .035	**1.2** .045	**1.4** .052	**1.6** 1/16
			Pressure setting				
Wire material	Fe, Ss	Pressure arm 1	1.5 - 2.0				
		Pressure arm 2	2.0 - 2.5				
	Cored	Pressure arm 1	1.0 - 1.5				
		Pressure arm 2	1.5 - 2.0				
	Al	Pressure arm 1	1.0 - 1.5				
		Pressure arm 2	1.5 - 2.0				



1. Tensioner unit 1
2. Tensioner unit 2

5.22 Activating Water cooling system

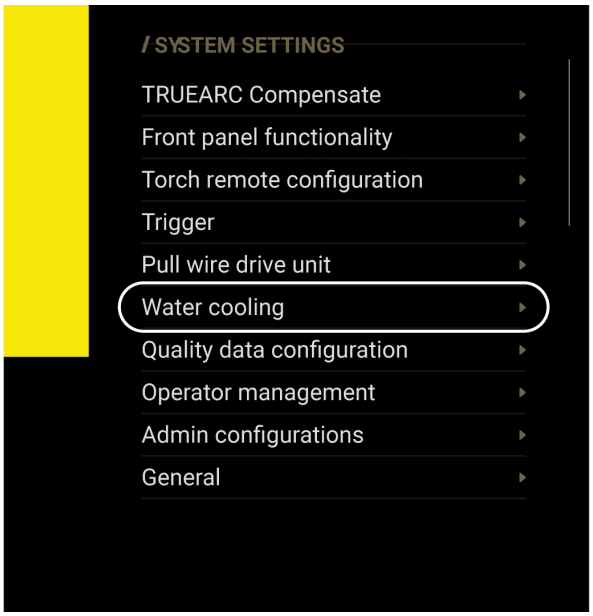
The Warrior BoomFeed can be used with both air-cooled and water-cooled systems in conjunction with the Remote User Interface.

With an air-cooled system, the user needs to do nothing.

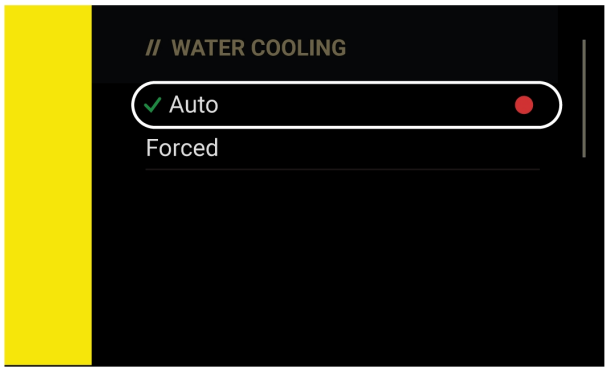
With a water-cooled system, the user must manually activate the water cooling. Warrior BoomFeed does not have an ELP switch to enable the cooler when the water hoses are connected and the user must manually activate the water cooler via the Remote User Interface. Follow the steps below to activate the cooler manually during initial setup:

1) Go to *Menu* and select *System Settings*.

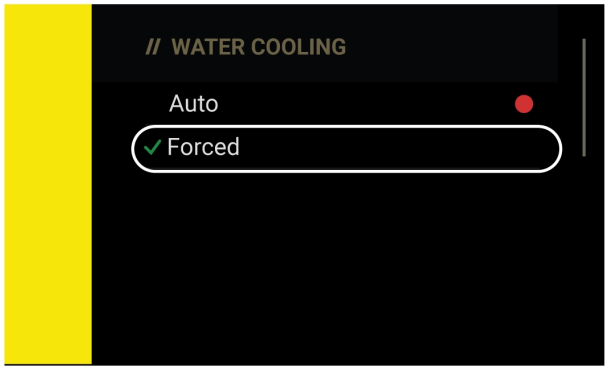
2) Select *Water Cooling*.



3) The *Auto* option shows a red light, indicating the cooling unit is not connected or activated.



4) Scroll down to *Forced* and select, activating the cooling unit.



5) Close the *Menu*.

6 MAINTENANCE

6.1 Inspection, cleaning and replacement

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

- Cleaning and replacement of the worn parts in the wire feed mechanism should take place at regular intervals in order to achieve trouble-free wire feed. Note that if pre-tensioning is set too high, this can result in abnormal wear on the pressure roller, feed roller and wire guide.
- Clean the liners and other mechanical parts of the wire feed mechanism, using compressed air, at regular intervals or if the wire feed seems irregular.
- Changing nozzles.
- Checking driving-wheel.
- Changing the cog-wheel package.

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

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

6.2 Calibration and validation of measured values

The wire feeder displays the measured values, arc voltage and welding current, as rectified arithmetic mean values (measure value formation).

- The wire feed speed is set on the feeder control panel, and the set speed is presented on the display, in units of m/min or in./min.
- The welding power source used together with the feeder (see the "INTRODUCTION" chapter) measures and calculates the mean value of arc voltage and welding current. The measured values are transferred from the welding power source to the feeder via a digital bus.

The accuracy of the set and measured values is recommended to be calibrated and validated periodically, to check if the values are within the accepted deviation. Calibration and validation should be performed by a trained service technician possessing sufficient training in welding and measurement technology. Guiding principles for calibration/validation and accepted deviation for each displayed parameter can be found in the service manual.

7 ORDERING SPARE PARTS

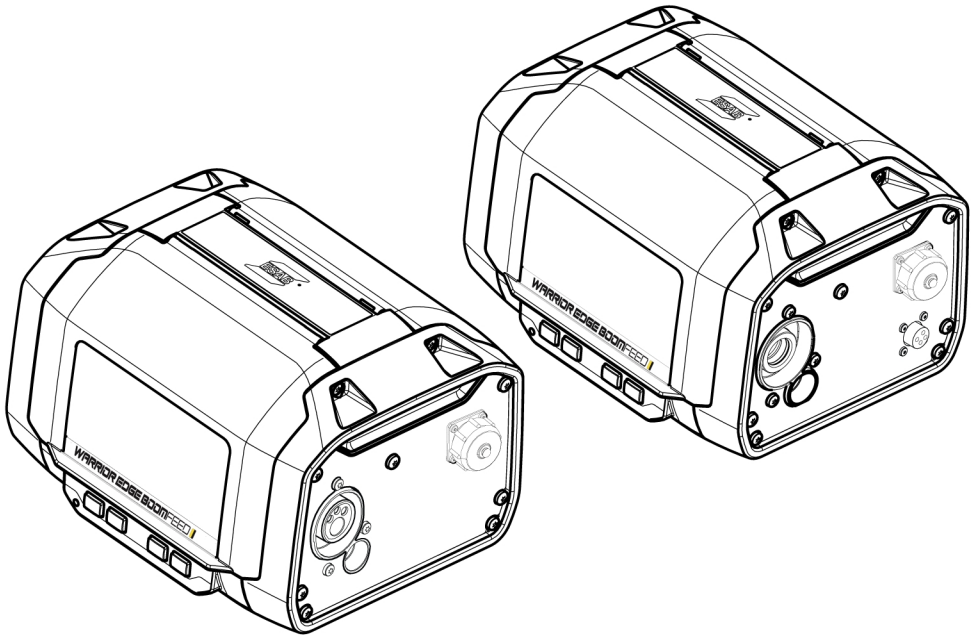
CAUTION!
Repair and electrical work should be performed by an authorised ESAB service technician. Use only ESAB original spare and wear parts.

The **Warrior Edge BoomFeed** is designed and tested in accordance with the international and European standards **EN IEC 60974-5**, **EN IEC 60974-10, Class A** and international and 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 **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.

APPENDIX

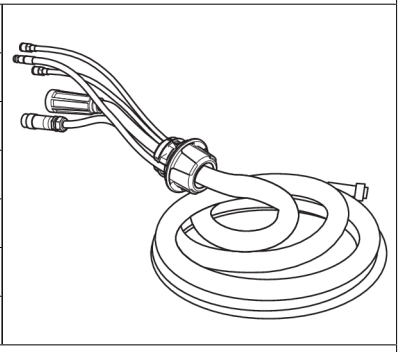
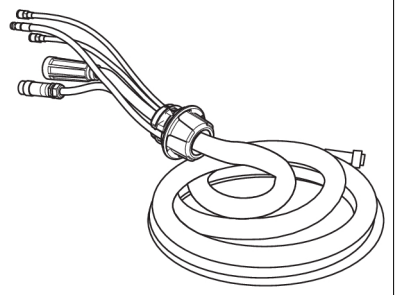
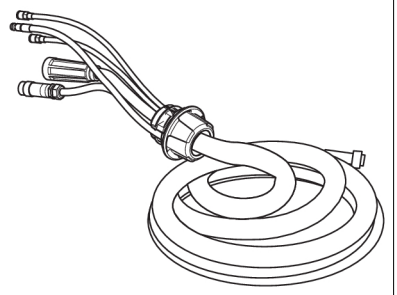
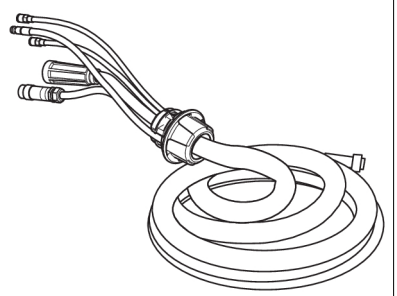
ORDERING NUMBERS

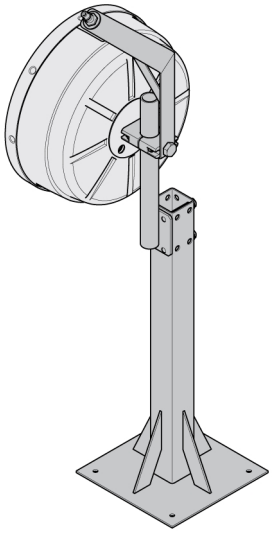
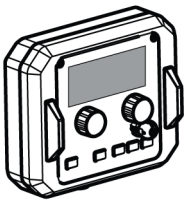
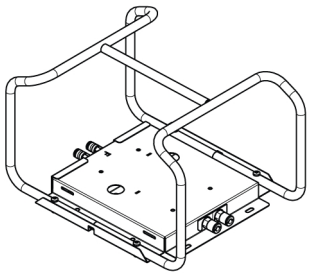
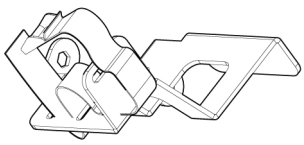
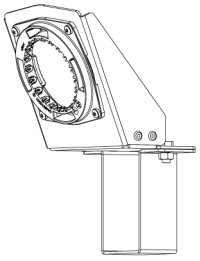


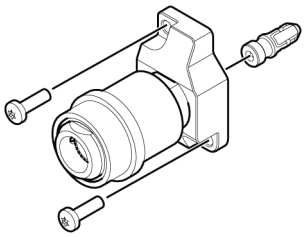
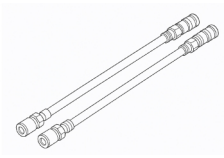
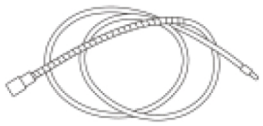
Ordering number	Denomination	Notes
0463 808 001	Warrior Edge BoomFeed	Safety instruction
0448 777 880	Warrior Edge BoomFeed	Euro
0448 777 881	Warrior Edge BoomFeed	Tweco
A000 101 416	Warrior Edge BoomFeed	Quick start guide
0448 137 001	Warrior Edge BoomFeed	Spare parts list

Technical documentation is available on the Internet at: **www.esab.com**

ACCESSORIES

Interconnection cable with pre-assembled strain relief, liquid cooled, 70 mm²		
0446 310 890	2.3 m (7 ft.)	
0446 310 891	5 m (16 ft.)	
0446 310 892	10 m (33 ft.)	
0446 310 893	15 m (49 ft.)	
0446 310 894	20 m (66 ft.)	
0446 310 895	25 m (82 ft.)	
0446 310 896	35 m (115 ft.)	
Interconnection cable with pre-assembled strain relief, air cooled, 70 mm²		
0446 310 880	2.3 m (7 ft.)	
0446 310 881	5 m (16 ft.)	
0446 310 882	10 m (33 ft.)	
0446 310 883	15 m (49 ft.)	
0446 310 884	20 m (66 ft.)	
0446 310 885	25 m (82 ft.)	
0446 310 886	35 m (115 ft.)	
0446 310 887	50 m (164 ft.)	
Interconnection cable with pre-assembled strain relief, liquid cooled, 95 mm²		
0446 310 990	2.3 m (7 ft.)	
0446 310 991	5 m (16 ft.)	
0446 310 992	10 m (33 ft.)	
0446 310 993	15 m (49 ft.)	
0446 310 994	20 m (66 ft.)	
0446 310 995	25 m (82 ft.)	
0446 310 996	35 m (115 ft.)	
Interconnection cable with pre-assembled strain relief, air cooled, 95 mm²		
0446 310 980	2.3 m (7 ft.)	
0446 310 981	5 m (16 ft.)	
0446 310 982	10 m (33 ft.)	
0446 310 983	15 m (49 ft.)	
0446 310 984	20 m (66 ft.)	
0446 310 985	25 m (82 ft.)	
0446 310 986	35 m (115 ft.)	
0446 310 987	50 m (164 ft.)	

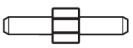
0461 184 880	Bobbin holder complete	
0448 850 880	Remote user interface	
0349 314 650	Control cable EDGE 10 m	
0349 314 652	Control cable EDGE 5 m	
0349 314 654	Control cable EDGE 2 m	
0448 748 880	Dress kit, Warrior Edge BoomFeed	
A000 101 417	Torch strain relief	
A000 101 299	Strain reief bracket	

A000 101 314	Cable hanger	
A000 102 073	Marathon™ Pac Quick connector, LH, EURO	
A000 102 071	Marathon™ Pac Quick connector, LH, TWECO	
A000 101 749	Water connection kit, BoomFeed	
Wire conduits (CE)		
F102437884	8 m (26 ft.)	
F102437885	12 m (39.4 ft.)	

WEAR PARTS

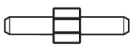
Fe, Ss and cored wire

Wire diameter (in.) (mm)	**.023** 0.6	**.030** 0.8	**.040** 0.9/1.0	**.045** 1.2	**.052** 1.4	**1/16** 1.6	**Feed roller**
V-groove 	**X**	**X**					0445 850 001
		X	**X**				0445 850 002
			X				0445 850 003
			X	**X**			0445 850 004
				X			0445 850 005
					X	**X**	0445 850 006

Inlet wire guide 	**Middle wire guide** 	**Outlet wire guide** 
0446 541 001	0446 080 882	0445 830 883 (Tweco)
		0445 830 881 (Euro)

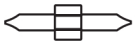
Cored wire – Different wire guides dependent on wire diameter!

Wire diameter (in.) (mm)	**.040** 0.9/1.0	**.045** 1.2	**.052** 1.4	**1/16** 1.6	**Feed roller**
V-K-knurled 	**X**	**X**			0445 850 030
		X			0445 850 031
		X	**X**		0445 850 032
				X	0445 850 033

	Inlet wire guide 	**Middle wire guide** 	**Outlet wire guide** 
Wire diameter 0.040–1/16 in. 0.9–1.6 mm	0446 541 001	0446 080 882	0445 830 883 (Tweco)
			0445 830 881 (Euro)

Al wire

Wire diameter (in.) (mm)	**.023** 0.6	**.030** 0.8	**.040** 0.9/1.0	**.045** 1.2	**.052** 1.4	**1/16** 1.6	**Feed roller**
U-groove 		**X**	**X**				0445 850 050
			X	**X**			0445 850 051
				X		**X**	0445 850 052

Inlet wire guide	Middle wire guide	Outlet wire guide
		
0446 541 001	0446 080 881	0445 830 886 (Tweco)
		0445 830 885 (Euro)

NOTE!
Each kit will be delivered with assembly instructions for proper installation.

A **WORLD** OF **PRODUCTS** AND **SOLUTIONS.**

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