

Arc Welding solutions from **ESAB**



A full line of arc welding equipment for every application, industry and environment.

Arc Welding Equipment

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Arc Welding Processes

Shielded Metal Arc (Stick, Covered Electrode) Welding

In this first practical arc welding process, the arc is established between a wire rod and the work. The rod is coated with materials which generate a gas and form a slag to protect the weld puddle and the solidifying weld metal from the atmosphere. The coating may also supply alloying and refining ingredients, and the slag may help shape the weld bead, especially in vertical and overhead applications.

Electrodes are available for welding most carbon, low alloy and stainless steels, some non-ferrous metals, and a wide range of maintenance and repair applications.

Light-duty work is often done with AC power from low cost transformers; production work usually involves DC power from heavy-duty rectifiers.



Short Circuiting ("Short Arc," "Dip Transfer") Involves a small fast-freezing weld puddle. Metal is transferred from the electrode to the puddle by repeated short circuits. Small diameter wires are used and the process operates at low currents and voltages. "Short arc" is used for welding thin gauge metals in all positions and for vertical and overhead welding of heavier sections.

Spray Arc - Electrode metal is transferred to the weld puddle as discrete droplets. Deposition rate is high and there is little or no spatter. With solid wire, the technique is used for 1/8 in. (3.2 mm) and thicker work pieces and for downhand welding.

Pulsed Spray Arc - The welding current is varied rapidly between a high and a low value. Metal is transferred to the work only during the high current period. The high peak current provides excellent arc stability. The period of low current maintains the arc and reduces the average current, making it possible to weld thinner gauge materials and to weld in all positions using larger sized wire electrodes than otherwise possible.

Cored Wire - The electrode is fabricated from strip, enclosing a core of flux and metal which protects and refines the weld puddle and controls bead shape. Some cored wires can be used without external shielding gas. Smaller diameter wires can be used for all position welding. The addition of fluxing, alloy and slag-forming materials often allows high deposition rates, higher welding speeds and improved all-position capability compared with solid wires. This makes cored wire the material of choice in many high-production applications.

Gas Metal Arc (Mig) Welding

This most flexible metal joining process involves an arc established between the work piece and a wire electrode which is continuously fed by a wire feeder through a torch. The arc continuously melts the electrode to form the weld puddle. An appropriate gas or gas mixture shields the weld area from atmospheric contamination.

The Mig process has the advantages of high deposition rates, speed, excellent weld quality, minimal distortion of the work piece and no stub loss.

Mig welding includes several distinct process variations. Selection depends largely on the work piece thickness and welding position.



Gas Tungsten Arc (Heliarc, Tig) Welding

Introduced by ESAB, Tig welding produces welding heat from an arc between a non-consumable tungsten electrode and the work. An inert gas, usually argon, shields the arc and the work. Filler metal, if used, is added separately. Because the process uses totally inert shielding, welds of the highest quality are produced, and almost any metal can be welded.



Equipment and Materials Selection

Equipment for these processes is described in detail in this section and materials are shown in our All Products catalog.

Additional Technical Information

ESAB Technical Service Representatives are available to answer your questions at 1.800.ESAB.123. We also recommend that you take advantage of a series of handbooks published by ESAB which provide excellent guidance on the use of the arc welding processes. In addition, there are references from other sources which can be very helpful in achieving the best possible results.

Icon Key



Designates equipment capable of Gas Metal Arc (Mig) welding



Designates equipment capable of Heliarc (Gas Tungsten Arc or Tig) welding



Designates equipment capable of Shielded Metal Arc (Stick or Covered Electrode) welding

1Phase

Designates equipment requiring single-phase input power

3Phase

Designates equipment requiring three-phase input power

1Phase 3Phase

Designates equipment that can use single- or three-phase input power

AC

Designates equipment with alternating current output

DC

Designates equipment with direct current output

ACDC

Designates equipment with alternating current and direct current output

CC

Designates equipment with constant current output

CV

Designates equipment with constant voltage output

CVCC

Designates equipment with constant current and constant voltage output

Important Product Safety-

Sound common-sense procedures must be followed for personal protection and operating efficiency when using Arc welding equipment. Always comply with the manufacturer's recommendations for operating and maintaining the equipment, as set forth in the instructions provided with each unit. Also, be certain to use all applicable safety precautions, as described in Precaution and Safe Practices for Arc Welding, Cutting and Gouging, Form F-52-529, which is available from your local ESAB welding products distributor.

Arc Welding Equipment

Selection Guide

	Mig (GMAW)								Tig (GTAW)						Stick (SMAW)			Remote Control, Voltage	Remote Control, Current	Submerged Arc (SAW)	Arc Gauge (ACAG)
	Short arc	Quest™	Spray arc	Flux cored	Pulse arc	Super Pulse	Inductance	Slope	DC	AC	Live Tig	Touch Tig	Pulsed Tig	Hi freq.	DC	AC	Arc Force				
Compact Packages (built-in wire feeder)																					
Caddy Mig C200i	●	●	●	●																	
Migmaster 215 Pro	●		●	●			●														
Migmaster 280 Pro	●		●	●			●														
Migmaster 280 Pro MV	●		●	●			●														
Power Sources																					
Origo Mig 320	●		●	●			●														
Origo Mig 410	●		●	●			●														
Mig 4002c, 4002cw	●	○	●	●	○	◆	●		Opt		Opt				○			●	●		Opt
Mig 6502c, 6502cw	●	○	●	●	○	◆	●		Opt		Opt				○			●	●	Opt	Opt
Aristo Mig U5000i	●	○	●	●	○	◆	●		○			○	○	●	○		○	●	●		
Aristo Mig U5000iw	●	○	●	●	○	◆	●		○			○	○	●	○		○	●	●		
MiniArc 161LTS									●			●			●				●		
CaddyArc 201i A33									●			●			●		Auto		●		
CaddyTig 2200i TA33									●			●		●	●		●		●		
CaddyTig 2200i TA34									●			●	●(DC)	●	●		●		●		
Caddy Tig 2200i AC/DC TA34									●	●	●	●	●(DC)	●	●	●	●		●		
Origo Arc 410c									●			●			●		●		●		●
Origo Arc 650c									●			●			●		●		●		●
Wire Feeders																					
MobileFeed 300AVs	□		●	●	□																
Origo Feed 304 M12	●		●	●																	
Origo Feed 304 M13u	●		●	●																	
Origo Feed 3004 MA23	○		○	○			○								○		○	●	Opt		
Origo Feed 3004 MA24	○	○	○	○			○								○		○	●	Opt		
Origo Feed 4804 MA24	○	○	○	○			○								○		○	●	Opt		
AristoFeed 3004 U6	○	○	○	○	○		○		○		○	○	○	○	○		○	●	Opt		○
Aristo Feed 4804 U6	○	○	○	○	○		○		○		○	○	○	○	○		○	●	Opt		○
AristoFeed 3004 U8 ₂	○	○	○	○	○	○	○		○			○	○	○	○		○	●	Opt		○
AristoFeed 4804 U8 ₂	○	○	○	○	○	○	○		○			○	○	○	○		○	●	Opt		○

Legend: ● Standard feature best performance, □ Limited Applications, ◆ Use add-on pendant,
○ When used on corresponding Aristo or Mig 4002c/5002c/6502c power sources and feeder combination

Arc Welding Equipment

Selection Guide



	Rated Output			Primary Input ²		Physical			
	Rated current ¹ @ duty cycle	Welding current range amps	Max. wire feed speed ipm (m/min)	AC voltage	1 or 3 phase	Net wt. lbs. (kg)	Width in. (cm)	Length in. (cm)	Height in. (cm)
Compact Packages (built-in wire feeder)									
Caddy Mig C200i	180A @ 25%	30-200	472 (12)	230	1	26 (12)	7.8 (19.8)	17.7 (44.9)	13.7 (34.7)
Migmaster 215 Pro	250A @ 20%	40-250	748 (19)	208/230	1	220 (100)	16.5 (42)	33.8 (86)	28.7 (73)
Migmaster 280 Pro	250A @ 60%	40-300	750 (19)	208/230	1	341 (155)	21.7 (55)	32 (81)	34.3 (87)
Migmaster 280 Pro MV	250A @ 60%	40-300	750 (19)	230/460/575	1	341 (155)	21.7 (55)	32 (81)	34.3 (87)
Power Sources									
Origo Mig 320	320A @ 30%	40-320		230/460	3	245 (111)	16.7 (42.5)	33 (84)	32.7 (83)
Origo Mig 410	400A @ 50%	50-400		230/460	3	320 (145)	21.7 (55.2)	32 (81.2)	36.4 (92.5)
Mig 4002c, 4002cw	400A @ 60%	16-400		230/460	3	328 (149)	25.2 (64)	32.7 (83)	32.9 (83.5)
Mig 6502c, 6502cw	650A @ 60%	16-650		230/460	3	489 (222)	25.2 (64)	32.7 (83)	32.9 (83.5)
Aristo Mig U5000i	500A @ 60%	4-500		460	3	154 (70)	15.5 (39.4)	24.6 (62.5)	19.5 (49.6)
Aristo Mig U5000iw	500A @ 60%	4-500		460	3	198 (90)	15.5 (39.4)	24.6 (62.5)	30.6 (77.6)
MiniArc 161Lrs	150A @ 60%	5-150		115/230	1	18 (9)	5.8 (14.6)	15.8 (40.0)	10 (25.5)
CaddyArc 201i A33	220A @ 20%	3-220		230	1	18.3 (8.3)	7.4 (18.8)	16.5 (41.8)	8.2 (20.8)
CaddyTig 2200i TA33	220A @ 20%	3-220		230	1	20.7 (9.4)	7.4 (18.8)	16.5 (41.8)	8.2 (20.8)
CaddyTig 2200i TA34	220A @ 20%	3-220		230	1	20.7 (9.4)	7.4 (18.8)	16.5 (41.8)	8.2 (20.8)
CaddyTig 2200i AC/DC TA 34	220A @ 20%	3-220		230	1	34.6 (15.7)	7.4 (18.8)	16.5 (41.8)	13.6 (34.5)
Origo Arc 410c	400A @ 35%	20-400		230/460	3	346 (157)	31.5 (80)	51.5 (131)	30.7 (78)
Origo Arc 650c	650A @ 35%	20-650		230/460	3	491 (223)	31.5 (80)	51.5 (131)	30.7 (78)
Wire Feeders									
MobileFeed 300AVS	400A @ 100%		800 (20.3)	n/a		32 (14.5)	8.6 (21.7)	20.7 (52.6)	17.2 (43.7)
Origo Feed 304 M12	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Origo Feed 304 M13u	630A @ 60%		1000 (25)	42	1	33 (15)	10.8 (27.5)	27.2 (69)	16.1 (42)
Origo Feed 3004 MA23	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Origo Feed 3004 MA24	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Origo Feed 4804 MA24	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Aristo Feed 3004 U6	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Aristo Feed 4804 U6	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Aristo Feed 3004 U8 ₂	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)
Aristo Feed 4804 U8 ₂	630A @ 60%		1000 (25)	42	1	33.1 (15)	10.8 (27.5)	27.2 (69)	15.5 (42)

NOTES: ¹Rated Output is based on 60 Hz power. Ratings for 50 Hz may be lower. Refer to individual product pages for details.

²Refer to individual product pages for additional details.

Caddy® Mig C200i

Compact

1Phase DC CV 3 YEAR WARRANTY 100% GUARANTEE

Compacts

- Can weld mild steel, aluminum, stainless steel as well as MIG/MAG brazing
- QSet - automatically selects correct parameters for required wire/gas combination
- Its light weight and portability make it easy to get to the job site, indoors or outdoors
- Has PFC (power factor correction) ensures stable welding power, even when operated from a portable generator
- Polarity change - allows you to use gasless cored wire
- Ergonomic, high quality MXL180 torch 10 ft. (3 m) long
- Optimized for .030 in. wire. Will also accept .023 in. and 0.35 in. wires as needed

The Caddy Mig C200i is an easy-to-use, intelligent and powerful machine for MIG/MAG welding mild steels, aluminum and stainless steel as well as MIG brazing. The unit is also extremely portable, making the Caddy Mig C200i an excellent choice for repair, maintenance, and assembly work – both in the workshop and while on the go.

Made from advanced materials, the Caddy Mig C200i's housing is lightweight, durable, and impact-resistant. The machine also includes a built-in cable for easy transportation. Weighing a little over 26 lbs. (12 kg), the Caddy Mig C200i is the lightest welding unit in its output class. But what really sets the Caddy Mig C200i apart is its performance. The PFC (power factor correction) feature provides 30% more welding power from the same sized fuse.

To make sure operation is a breeze, the Caddy Mig C200i is equipped with QSet™. With QSet, you only need to set the plate thickness, not only will QSet automatically set all of the welding parameters, it also automatically adjusts during the process to maintain the optimum wire/ gas combination and prevent waste of resources. If you prefer, you can make adjustments with the wire feed speed and voltage.

A single-phase input connection makes it easy to find an electrical source. And the machine performs equally as well when powered by a portable generator. The Caddy Mig C200i is an efficient inverter power source.

Inside the Caddy Mig C200i's side panel is a wire feeder that fits a wire spool with an inner diameter of 2 in. (51 mm), an external diameter of 8 in. (200 mm), and a width of 2.125 in. (55 mm).

The Caddy Mig C200i is optimized to perform for welding with .023, .030 and .035 in. solid or cored wires. We recommend the following ESAB wires when welding with the Caddy Mig C200i. Spoolarc® 86, .023, .030 and .035 in. for welding of mild steels. Coreshield 15, .030 in. for gasless welding of mild steels. ERCuSi-A .030 and .035 in. for MIG /MAG brazing. ESAB ER308LSi MIG .023, .030 and .035 in. for 18Cr 8Ni stainless steel welding. Alcotec 5183 .035 in. for aluminum welding.



Ordering information

Caddy Mig C200i, 1 ph 230V0558101321
Ready to Weld package includes: 10 ft. (3 m) MXL 180 torch, R-33 FM580 regulator/flowmeter, 10 ft. (3 m) mains cable with 6-50P plug. 14.5 ft. (4.5 m) gas hose with 'B' male connector, 10 ft. (3 m) return cable with clamp, simple shoulder strap, fitted wear parts in torch/feeder (for .030 in. wire) and instruction manual. We also include 11 lbs. of 70S-6 mild steel .030" in. wire so you can begin welding immediately.

Accessories

Trolley 0459366887
Includes gas shelf.

Instruction Manual0440001031
Product Data Page ARC-23287

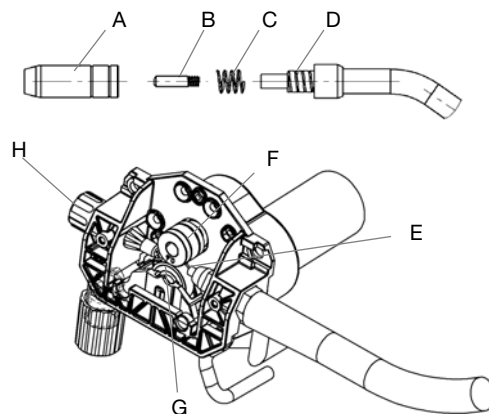
Caddy® Mig C200i

Compact



Specifications

	Caddy Mig C200i
Input voltage	230 V 1 phase 50/60 Hz
Fuse (slow)	16 A
Maximum welding output	200 A
Permitted load at 25% duty cycle	180 A / 23 V
Permitted load at 100% duty cycle	100 A/19 V
Setting range	30 - 200 A
Open circuit voltage	60 V
Wire feed speed	78 - 472 in./min (2 - 12 m/min)
Max. size of the wire reel	8 in 10 lbs (200 mm 5 kg)
Open circuit power	15 W
Power factor at maximum current	0.99
Efficiency at maximum current	82%
Dimensions L x W x H	17.68 x 7.8 x 13.66 in. (449 x 198 x 347 mm)
Weight with torch and cables	26 lbs (12 kg)
Enclosure class	IP 23
Operating temperature	14 to 104°F (-10 to +40°C)



Wear Parts

Item	Description	Part Number
A	Gas nozzle	0700200054*
B	Contact tip for .030 in. (0.8 mm) wire	0700200064*
B	Contact tip for .035 in. (0.9 mm) wire	0700200066
C	Nozzle spring	0700200078*
D	Tip adaptor	0700200072*
E	Steel liner .023 - .030 in. (0.6 - 0.8 mm) wire	0700200086*
E	Steel liner .035 - .045 in. (0.9 - 1.2 mm) wire	0700200088
F	Feed roller with groove	0349311890*
G	Pressure roller	0349312062*
H	Inlet nozzle	0455049002*

* As delivered. See MXL 200 torch for additional nozzles, tips, and liners.



Migmaster® 215 Pro/280 Pro

Compact strength and mobility.

1Phase DC CV 3 YEAR WARRANTY 100% GUARANTEE

- Equipped with V/A digital meter with hold feature
- Creep start – gradual feed of wire for ultimate starts
- Adjustable wire feed speed
- Adjustable burnback timer – gives correct stick-out
- Spot welding timer
- Outstanding welding characteristics – efficient, high-quality welding
- Wide current and voltage range – multi-purpose applications
- Spool gun on-demand
- Sturdy, galvanized metal casing with air filter (optional)

The Migmaster 215 Pro/280 Pro are sturdy and robust step-controlled welding power units. They are intended for medium (215 Pro) to heavy-duty (280 Pro) MIG/MAG welding with solid wires of steel, stainless steel, or aluminum, as well as cored-wires with or without shielding gas. ESAB's proven technology and software provide reliability and outstanding welding performance.

The units are made with a strong galvanized metal casing to withstand harsh environments. Large wheels and built-in wire feeder ensure these machines are practical and mobile solutions. The units are fan-cooled and equipped with thermal overload protection.

A wide current and voltage range, plus two inductance outlets (280 Pro) make it easy to optimize settings for a variety of filler materials and gases. Migmaster 215 Pro/280 Pro units are equipped with the potentiometers to set the wire feed speed, spot welding time, and burnback time adjustment. Furthermore, Migmaster machines are equipped with such functions as creep start and inching.



Accessories

Air filter

215 Pro.....	0349302599
280 Pro.....	0349312810

Cable and torch holder

215 Pro.....	0349303362
280 Pro.....	0349312800

MT-250SG spool gun36779

ST-23A spool gun (requires 37301 adapter)19164

Dual Cylinder Tray Kit

215 Pro (208/230v)	0349309312
280 Pro	0349312760

Feed Rolls

.023 – .030 in. V-HARD	0367556001
.030 – .040 in. V-HARD	0367556002
.035 – .045 in. V-HARD*	0349312497
.040 – 3/64 in. U-SOFT	0367556004
.045 in./052 – .062 in. VK-G	0367556006

* Note: Included in ready to weld package

OrderingInformation

Migmaster 215 Pro Package

208/230 V, 15 ft. torch 0558101322

Migmaster 280 Pro Package

208/230 V, 15 ft. torch 0558101324

230/460/575 V, 15 ft. torch 0558101365

Ready to Weld package includes: console with wheel kit installed, 15 ft. (4.5 m) Gunmaster 250 A torch, 10 ft. (3 m) power cord, 10 ft. (3 m) work cable, R-33 FM580 regulator/flowmeter, (1) .035 and .045 contact tip, and 10# spool of 87HP .035

Migmaster® 215 Pro/280 Pro

Compact strength and mobility.



Specifications

	Migmaster 215 Pro	Migmaster 280 Pro
Input voltage	208/230 VAC, 1 ph, 60 Hz	208/230 VAC, 1 ph, 60 Hz 230/460/575 VAC, 1 ph, 60 Hz
Primary input current @ 250 A 25% DC	53 A/48 A	74 A/66 A 66 A/34 A/26 A
Permitted load at:		
20% duty cycle	250 A/23 V	X
40% duty cycle	X	300 A/29 V
60% duty cycle	160 A/22 V	250 A/26.5 V
100% duty cycle	110 A/19.5 V	194 A/23.7 V
Setting range (DC)	40 A/16 V–250 A/23 V	40 A/16 V–300 A/29 V
Power factor at maximum current	0.95	0.97
Efficiency at maximum current	76%	71%
Wire feed speed	75–700 in./min.	55–770 in./min.
Burnback time	0–0.25 sec.	0–0.25 sec.
Spot welding time	0.2–2.5 sec.	0.2–2.5 sec.
Creep start	Selectable	Selectable
Voltage steps	12	21
Dimensions L x W x H	33 x 16.7 x 32.7 in. (840 x 425 x 830 mm)	32 x 22 x 36.5 in. (840 x 552 x 925 mm)
Weight	216 lb (98 kg)	308 lb (140 kg)
Operating temperature	14 to 104°F (-10 to +40°C)	14 to 104°F (-10 to +40°C)
Enclosure class	IP 23 S	IP 23 S
Wire Dimensions		
Steel	.023–.045 in. (0.6–1.2 mm)	
Aluminum	.047 in. (1.2 mm)	
Stainless	.023–.045 in. (0.6–1.2 mm)	
Cored-wire	.035–.045/.052–.062 in. (0.9–1.6 mm)	



Aristo™ Mig U5000i/U5000iw

Power Source



- Multiprocess equipment; MIG/MAG, pulse MIG, MMA, TIG, Pulse TIG and Carbon Arc Gouging.
- Reliable and smooth starts and ends supported by efficient Hot Start and crater fill functions
- Efficient Man Machine Communication by the user-friendly control panel U6 or U8 Pendant
- Wide range of pre-programmed synergic lines. U8 Pendant provides the facility to define and store customized synergic lines for any material or gas combinations
- Memory for 10 (U6) or 256 (U8 Pendant) welding parameters
- TrueArcVoltage System, measures the correct arc voltage value independent of the length of the connection cable, return cable or welding gun.
- Dust filter to handle tough and dirty environment and avoid grinding-dust and metal particles inside the chassis
- Aristo SuperPulse, the welding process with the ability to control the heat input (U8 Pendant).



Robust and powerful

The Aristo Mig U5000i is the ideal choice when it comes to efficient production or prefabrication of high alloyed materials with a very high demand on the welding performance.

This power source is compact and a sturdy piece of equipment with a chassis made of extruded aluminum sections: Alutech™. This is a robust material that withstands rough treatment.

The power source is based on inverter IGBT technology that provides reliable equipment with outstanding welding characteristics. The control and communication CAN-bus system means less cables, which in turn increases operational reliability.

Flexibility

The power source is optimized to operate together with the wire feeders Aristo Feed 3004 and Feed 4804. Connection cables up to 115 ft. (35 m) provides a working radius of up to 115 ft. (35 m) to suit all your individual welding needs.

The TrueArcVoltage System guarantees that you weld with the correct arc voltage independent of any voltage drop in the welding cables. This means that you will get the same arc voltage and weld result whether you have a set-up with short connection cable and 3 m gun or a set-up with 35 meters working radius.

Ordering Information

Aristo Mig U5000i (3 x 460V 60Hz) 0459230885
Aristo Mig U5000iw (3 x 460V 60Hz) 0459230886
Delivery content: 16.4 ft. (5 m) mains cable and termination resistor plug.

Options / Accessories

Remote Controls - CAN (order cable separately)
 MTA1 CAN 0459491880
 Multi-function remote control for the following panels:
 A2, A4, TA4, TA6, MA4, MA6, U6, U8

Process	Knob 1	Knob 2
MMA	Current control	Arc force
TIG	Pulse current	Background current
MIG/MAG 1	Wire feed speed	Voltage control
MIG/MAG 2	Wire feed speed	Voltage trim %

M1 10 Program CAN 0459491882
 Synergic MIG for MA6, U6, U8

Process	Knob 1	Switch 1 Function
MIG/MAG 2	1-10 Memory Select	Voltage trim %



Instruction Manual 0459264001
 Product Data Page ARC-23143

Aristo™ Mig U5000i/U5000iw

Power Source



Options/Accessories

Handle includes mounting screws for separate installation. (Complete set = 2)	0459307881
Trolley 1 (Standard)	0458530880
Trolley 2 (with Mini Boom or Dual Feeder)	0458603880
Guide Pin (If no trolley)	0458731880
Quick Connector Kit for current, water and shielding gas supply for 2x AristoFeed	0459546880
MMC kit for MMC panel mounted in the	
power source	0459579880
MMC - U6	0458535890
Connection cables, water cooled torches	
5.6 ft. (1.7 m)	0459528970
16.4 ft. (5.0 m)	0459528971
32.8 ft. (10.0 m)	0459528972
49.2 ft. (15.0 m)	0459528973
82.0 ft. (25.0 m)	0459528974
115 ft. (35.0 m)	0459528975
ESAT service kit	0458847881

Remote Control Cables - CAN

Length	CAN 12 Pin	CAN 10 Pin
.25 m	0459554884	0459960883
5 m	0459554880	0459960880
10 m	0459554881	0459960881
15 m	0459554882	- NA -
25 m	0459554883	0459960882
5 m HD	0459554880	0459960880
10 m HD	- NA -	0459960881
25 m HD	- NA -	0459960882

Specifications

	Aristo Mig U5000i
Input Voltage	460 V, 3 phase, 60 Hz
Fuse slow, A	35
Setting range	
	MIG/MAG, A/V 16-500/8-60
	MMA DC, A 16-500
	TIG DC, A 4-500
Permitted load:	
	60% duty cycle, A/V 500/39
	100% duty cycle, A/V 400/34
Open circuit voltage, V	68-88
Energy save mode, W	50
Input power, kW	23
Power factor at maximum current	0.85
Efficiency at maximum current, %	86
Control voltage, V, Hz	42, 50/60
Dimensions L x W x H	25 in. x 16 in. x 20 in. (625 x 394 x 496 mm)
Dimensions with cooling unit	25 in. x 16 in. x 31 in. (625 x 394 x 776 mm)
Enclosure class	IP 23
Insulation class (main trafo.)	H
Operating temperature, °C	-10 till +40
Weight	152 lbs. (69 kg)
Application class	S
Standards	IEC/EN 60974-1, EN 50199
Water cooling unit	
Cooling capacity, W, l/min	2500 at 40°C, .4 (1.5)
Coolant volume, l/min	1.4 (5.5)
Max flow, l/min	.5 (2.0)
Max pressure, bar	50 (3.4)
Weight	44.1 lbs (20 kg)
Dimension L x W x H	25 in. x 16 in. x 11 in. (621 x 389 x 266 mm)

DC - CV / CVCC
Power Sources



Origo™ Mig 320/410 with Origo Feed 304 M12



- WFS range 31-1000 ipm
- 2/4 stroke – simplifies welding
- Adjustable burn-back timer – gives correct stick-out
- Creep start – gradual feed of wire for ultimate starts
- Quick connectors – shortest possible setup times
- Multiple mounting options – counterbalance and mast, wheel kit, or hanging bracket
- Inching/gas purge (optional)

Powerful and flexible.

The Origo MIG 320/410 are step-switched power sources for medium (320) to heavy-duty (410) MIG/MAG welding. The machines are made with a strong galvanized metal casing to withstand harsh environments. Its large wheels, sturdy lifting eyelets, and an undercarriage designed for forklift transport make the Origo MIG machine easy to move. The wide current and voltage make it easy to optimize settings for a wide variety of filler metals and gases.

The machines are optimized to operate together with the Origo Feed 304 M12 wire feeder. Electronically controlled feeding gives an accurate and stable arc. The feeders are available with 1.8 in. diameter (30 mm) feed rollers for wires up to .062 in. diameter (1.6 mm).

The wire feed unit sits on a swivel post mounted on the top of the Origo MIG 320/410, providing a 360-degree radius of operation. The feeder mechanism is easy to access, and all wear parts can easily be exchanged. A single pressure device makes it easy to adjust the appropriate feeding pressure. All electronic components are protected in a separate compartment.

Ordering Information

Ready to Weld Packages

MIG 320 Origo Feed 304 M12.....	0558101326
MIG 410 Origo Feed 304 M12.....	0558101328

Basic Packages

MIG 320 Origo Feed 304 M12.....	0558101327
MIG 410 Origo Feed 304 M12.....	0558101329

Ready to Weld package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch, 5.5 ft. (1.7 m) connection cable set, 16.4 ft. (5 m) work cable, reg. flowmeter Ar CO₂.

Basic package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch.



Feeder Accessories

Wheel kit	0458707880
Strain relief for welding torch	0457341881
Strain relief for connection cables	0459234880
Lifting eye	0458706880
Quick connector Marathon Pac™	F102440880
Adapter for 11 lb spool	0455410001
Steel spool cover	0459431880
Counter-balance Mini boom	
For 12" spools	0458705880
For 18" spools	0458705882
Extension bracket for 60 lb coil	0459233880
Coil adapter	34323
Inching and gas purge kit	0459465880

Connection Cable Sets

Air-Cooled Torch, 23 Pole

5.5 ft. (1.7 m)	0349312470
16.4 ft. (5.0 m)	0349312471
32.8 ft. (10.0 m)	0349312472
49.2 ft. (15.0 m)	0349312473
82.0 ft. (25.0 m)	0349312474
114.8 ft. (35.0 m)	0349312475

Includes: control cable, electrode cable, and gas hose.

Torches

Gun Master 400cc

25 ft. (7.6 m) Basic	0558001674
12 ft. (3.6 m) x .035-.045 in.	0558001667
15 ft. (4.5 m) x .035-.045 in.	0558001669
15 ft. (4.5 m) x .052-1/16 in.	0558001670

See ARC-23095 for additional information.

Instruction Manual

Origo Mig 320	0349301158
Origo Mig 410	0349301159
Feed 304 M12	0459161187
Product Data Page	ARC-23283

Origo™ Mig 320/410

with Origo Feed 304 M12



Specifications

Power Supply	Wire Spool Capacity	Max. Spool Diameter	Wire Feed Speed	Dimensions (L X W X H)	Weight Enclosed	Wire Dimensions
42 VAC, 50/60 Hz	44 lb (19 kg) or 60 lb (27 kg)*	12 in. (300 mm) (enclosed)	31-1000 in./min. (0.8-25.0 m/min.)	27.1 x 10.8 x 16.1 in. (690 x 275 x 420 mm)	33 lb (15 kg)	Steel .023-.062 in. (0.6-1.6 mm) Stainless steel .023-.062 in. (0.6-1.6 mm) Aluminum .040-.062 in. (1.0-1.6 mm) Cored wire .030-.062 in. (0.8-1.6 mm)

* Requires optional accessories

DC - CV / CVCC
Power Sources



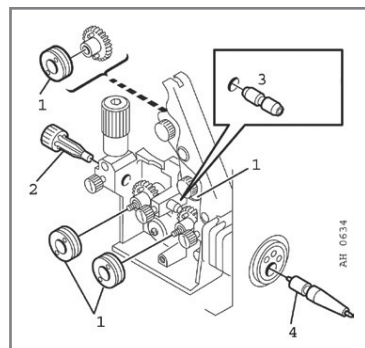
Wear Parts

Wire Diameter (in.)	Wire Type	1 Feeder Roller (4 required)	2 Inlet Nozzle	3 Intermediate Nozzle	4 Outlet Nozzle	Groove Type	Marking
.023 / .030	Fe, Ss, C	0459052001	0455049001	0455072002	0469837880	V	0.6 S2 / 0.8 S2
.030 / .035 - .040	Fe, Ss, C	0459052002	0455049001	0455072002	0469837880	V	0.8 S2 / 1.0 S2
.035 - .040 / .045*	Fe, Ss, C	0459 052003	0455049001	0455072002	0469837880	V	1.0 S2 / 1.2 S2
.052 / .063	Fe, Ss, C	0459052013	0455049001	0455072002	0469837880	V	1.4 S2 / 1.6 S2
.035 - .040 / .045	C	0558002352	0455049001	0455072002	0469837880	V-K	1.0 R2 / 1.2 R2
.045 / .045	C	0458825010	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.2 R2
.045 / .052	C	37319	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.4 R2
1/16 - 5/64	C	37320	0455049001	0455072002	0469837880	V-K	1.6 R2
.035 - 3/64	Al	36860	0455049001	0456615001	0469837881	U	0.8 A2 / 1.0 A2
3/64 - 1/16	Al	36861	0455049001	0456615001	0469837881	U	1.2 A2 / 1.6 A2

C = cored wire

* as delivered

K = knurled groove



Origo™ Mig 320/410

with Origo Feed 304 M12

- Outstanding welding characteristics – high-efficient and quality welds
- Sturdy galvanized metal casing with air filter (optional)
- Wide current and voltage range – for multiple applications
- Selectable inductance taps – both have 2 taps
- Easy change of polarity – all types of cored wire
- Digital meter – provides an accurate reading of the set welding parameters and will hold its display even after welding has finished
- Idle mode – power and noise efficient; cooling fan works only when needed
- Undercarriage standard



Accessories

Air filter

MIG 3200349302599

MIG 4100349302423

Cable and torch holder0349303362

Dual manual switch box Origo Feed M12*0558001872

Stabilizer

MIG 320 0349303475

MIG 410 0349303474

Reinforcer kit for counterbalance (410).....0349309748

* No machine top mounting

Specifications

	Origo Mig 320	Origo Mig 410
Input Voltage	230/460 V 3 ph 60 Hz	230/460 V 3 ph 60 Hz
Permitted load:		
30% duty cycle	320 A/30 V	X
50% duty cycle	X	400 A/34 V
60% duty cycle	250 A/27 V	365 A/32 V
100% duty cycle	195 A/24 V	280 A/28 V
Primary current:		
30% duty cycle	34/18 A	X
50% duty cycle	X	45/22 A
60% duty cycle	23/12 A	41/21 A
100% duty cycle	16/8 A	28/14 A
Setting range (DC)	40 A/16 V–320 A/30 V	50 A/16.5 V–400 A/34 V
Open circuit voltage	16–40 V	17–45 V
Open circuit power	200 W	360 W
Open circuit power with cooling unit	X	600 W
Power factor at maximum current	0.94	0.98
Efficiency at maximum current	75%	71%
Control voltage	42 V, 50/60 Hz	X
Voltage steps	40	40
Inductance outlets	2	2
Dimensions L x W x H	33 x 16 x 32 in. (840 x 425 x 830 mm)	32 x 21 x 36 in. (812 x 552 x 925 mm)
Weight	244 lb (111 kg)	317 lb (144 kg)
Weight with cooling unit	X	348 lb (158 kg)
Operating temperature	14 to 104°F (-10 to +40 °C)	14 to 104°F (-10 to +40 °C)
Enclosure class	IP 23	IP 23

MobileFeed 300AVS

Wire Feeder



- Arc voltage feeder for use with DC, CC or CV power supplies with straight (DC-) or reverse (DC+) polarity operation - no switches to set
- Ideal for harsh environments such as pipe lines, shipyards, offshore, general fabrication and more
- For use with 8 or 12 in. wire spools for enhanced portability, smaller size and reduced weight
- Enclosed, super impact-resistant case protects against dirt, metal grit, and moisture as well as extreme abuse, from grinding sparks, corrosive chemicals, drops and more
- 'CC' Euro torch connection for fast setup - no external gas hose or trigger wire
- Heavy duty 4 roll feed unit with PWM drive provides powerful, dependable wire feeding with Automatic slow wire run-in and Electronic Dynamic Braking for overall improved operation
- Safety features include insulated case, secondary contactor, low voltage torch trigger circuit and overload protection
- Designed to meet the most rigid standards. Meets IEC-974-1 specifications.

Ordering Information

Each MobileFeed wire feeder includes gas solenoid, contactor, and dual groove feed rolls.

MobileFeed 300AVS LC40 0558005729

Note: Uses LC40 type cable connector

Accessories

50mm OKC Cable Connectors

OKC Female Cable Connector, 1/0-4/0 cable 13735631

OKC Male Cable Connector, 1/0-4/0 cable 13732513

LC40 Cable Connectors

LC40 Cable Connector Set (male / female), 1/0-3/0 81F25

LC40 Male Cable Connector, 1/0-3/0 81F26

LC40 Female Cable Connector, 1/0-3/0 81F27

Specifications

	MobileFeed 300AVS
Wire Speed Range (actual speed range depends on the arc voltage)	50 - 800 ipm (1.8 - 20.3 m/min)
Rating	400 A @ 100% duty cycle
Wire Diameter Capacity	.023 - 5/64 in. (0.6 - 2.0 mm)
Wire Spool Capacity	12 in. x 44 lb.
Primary Input** (open circuit voltage or arc voltage)	
Minimum	16.5 VDC
Maximum	100 VDC (113v peak)
Weight	32 lbs (14.5 kg)
Dimensions W" x H" x L" (mm)	8.6 in. x 17.2 in. x 20.7 in. (217 mm x 437mm x 526 mm)

Note: MobileFeed 300AVS will fit through 18 in. (457 mm) dia. hole.
Not for use with AC power sources



Spool Adaptor

Use for adapting to 8 in. (20.3 cm) diameter spools 17511

Use for adapting to 10 in. (25.4 cm) diameter spools 34330

Gas Meter (measures gas flow at the gun) 19043



MobileFeed 300AVS

Wire Feeder

Drive Rolls and Guide Tubes

Wire Diameter	Description	Roll	Qty	Guide Tube	Qty	Center Guide	Qty	Inlet Guide	Qty
.023 in. (0.6 mm)	V-Solid	21155	2	0558001077	1	0558001757	1	0558001758	1
.030 in. (0.8 mm)	V-Solid	21155	2	0558001077	1	0558001757	1	0558001758	1
.035 in. (0.9 mm) +	V-Solid	21156+	2	0558001078+	1	0558001757+	1	0558001758+	1
.045 in. (1.2 mm) +	V-Solid	21156+	2	0558001078+	1	0558001757+	1	0558001758+	1
.052 in. (1.4 mm)	V-Solid	21157	2	0558001079	1	0558001757	1	0558001758	1
.062 in. (1.6 mm)	V-Solid	21157	2	0558001079	1	0558001757	1	0558001758	1
.030 in. (0.8 mm)	K-Cored	21160	2	0558001077	1	0558001757	1	0558001758	1
.035 in. (0.9 mm)	K-Cored	21160	2	0558001078	1	0558001757	1	0558001758	1
.045 in. (1.2 mm) *	K-Cored	21161*	2	0558001079*	1	0558001757*	1	0558001758*	1
.052 in. (1.4 mm) *	K-Cored	21161*	2	0558001079*	1	0558001757*	1	0558001758*	1
1/16 in. (1.6 mm) *	K-Cored	21161*	2	0558001079*	1	0558001757*	1	0558001758*	1
5/64 in. (2.0 mm)	K-Cored	21162	2	0558001079	1	0558001757	1	0558001758	1
3/64 in. (1.2 mm)	U-Soft	21159	2	0558001898	1	0558001895	1	0558001758	1
1/16 in. (1.6 mm)	U-Soft	21159	2	0558001898	1	0558001895	1	0558001758	1

* As delivered on 0558005729

+ As delivered on 0558005728 and 0558005832

Note: Two lower drive rolls are required for four roll drive systems.

Use flat, smooth pressure roll(s) (P/N 2361 2397) supplied with wire feeder.



Origo™ Feed 304 M13u Wire Feeder



- Remote voltage control, allows local setting of power source voltage output
- Wire feed speed, accurate graduated dial shows settings in 50 ipm (1 m/min.) increments
- Adjustable burn-back time to correct stick-out and reduce wear of contact tips
- 2/4 stroke, helps minimize operator fatigue by optionally selecting trigger lock in the 4 stroke mode
- Inching/Gas Purge - Inching eliminates unsafe trigger pulls to load wire. Gas Purge ensures a clean start with pure shield gas
- Creep start - simplifies start/stop and gradual feed of wire to optimize the starts.
- Quick connectors - shortest possible set-up times. No tools required to change feed rolls, connect gas hose, weld cable or control cable.

With its galvanized metal casing, the ESAB Origo Feed is ideal for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The four wheel roll feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire - to avoid operational disturbance.

The feeders are available with either 1.18 in. (30 mm) rolls for wires from .023 in. (0.6 mm) up to 5/64 in. (2.0 mm). All operating adjustments are made on the front panel of the feeder, giving a good overview of the settings.

The front panel of the M13u is equipped with switches for inching/gas purge, 2/4 stroke and creep start. A wire feed speed knob with accurate graduated dial and adjustable burn-back are included. A remote voltage control is provided with 10 graduations from min. to max. settings. The panel is easy to operate with accurate setting that suits different needs and demands.

Extra versatility can be provided by utilizing one of the following mounting options for the Origo™ Feed. Counterbalance & Mast, Wheel Kit or Hanging Bracket.

Ordering Information

Basic Packages

Origo Feed 304 M13u with QC 0558101668

Origo Feed 304 M13u with lugs..... 0558101669

Feeder Only

Origo Feed 304 M13u 0459115860

Basic package includes: feeder, 400 A torch, cables, R-33 flowmeter.



Shown with optional plastic spool cover

Feeder Accessories

Wheel kit	0458707880
Strain relief for welding torch	0457341881
Feeder strain relief for connection cables	0459234880
Lifting eye.....	0458706880
Quick connector MarathonPac	0558002354
Adapter for 11 lb spool.....	0455410001
Steel spool cover	0459431880
Counter-balance Mini boom	
For 12" spools	0458705880
For 18" spools	0458705882
Extension bracket for 60 lb coil.....	0459233880
Coil adapter (requires 0459233880).....	34323
Spool cover	
Plastic 12"	0458674880
Steel 12"	0459431880

Connection Cable Sets

Air-Cooled Torch

5.5 ft. (1.7 m)	0349312460
16.4 ft. (5.0 m)	0349312461
32.8 ft. (10.0 m)	0349312462
49.2 ft. (15.0 m)	0349312463
82.0 ft. (25.0 m)	0349312464
114.8 ft. (35.0 m)	0349312465

Includes: control cable, electrode cable, and gas hose.

Torches

GunMaster 400cc

25 ft. (7.6 m) Basic	0558001674
12 ft. (3.6 m) x .035-.045 in.....	0558001667
15 ft. (4.5 m) x .035-.045 in.	0558001669
15 ft. (4.5 m) x .052-1/16 in.	0558001670

See ARC-23095 for additional information.



Origo™ Feed 304 M13u

Wire Feeder

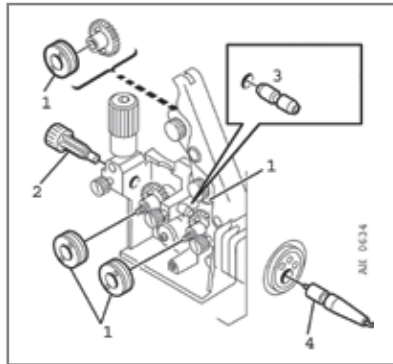
Feeder Data

Power Supply	Wire Spool Capacity	Max. Spool Diameter	Wire Feed Speed	Dimension (L x W x H)	Weight	Wire Dimensions
42 VAC, 50/60 Hz	44 lb (18 kg) or 66 lb (30 kg)*	12 in. (300 mm) (enclosed)	32-1000 in./min. (0.8-25.0 m/min.)	27.1 x 10.8 x 16.1 in. (690 x 275 x 420 mm)	33 lb (15 kg)	Steel .023-.062 in. (0.6-1.6 mm) Stainless steel .023-.062 in. (0.6-1.6 mm) Aluminum .030-.062 in. (0.8-1.6 mm) Cored wire . 035-.078 in. (0.9-2 mm)

* Requires optional accessories

Panel (MMC) functions

- Remote voltage control
- Wire feed speed
- 2/4 stroke – simplifies handling of the welding torch
- Adjustable burn-back time
- Gas purge/wire inching (standard)
- Creep start



Wear Parts

Wire Diameter (in.)	Wire Type	1 Feeder Roller (4 required)	2 Inlet Nozzle	3 Intermediate Nozzle	4 Outlet Nozzle	Groove Type	Marking
.023 / .030	Fe, Ss, C	0459052001	0455049001	0455072002	0469837880	V	0.6 S2 / 0.8 S2
.030 / .035 -.040	Fe, Ss, C	0459052002	0455049001	0455072002	0469837880	V	0.8 S2 / 1.0 S2
.035 - .040 / .045*	Fe, Ss, C	0459 052003	0455049001	0455072002	0469837880	V	1.0 S2 / 1.2 S2
.052 / .063	Fe, Ss, C	0459052013	0455049001	0455072002	0469837880	V	1.4 S2 / 1.6 S2
.035 -.040 / .045	C	0558002352	0455049001	0455072002	0469837880	V-K	1.0 R2 / 1.2 R2
.045 / .045	C	0458825010	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.2 R2
.045 / .052	C	37319	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.4 R2
1/16 - 5/64	C	37320	0455049001	0455072002	0469837880	V-K	1.6 R2
.035 - 3/64	Al	36860	0455049001	0456615001	0469837881	U	0.8 A2 / 1.0 A2
3/64 - 1/16	Al	36861	0455049001	0456615001	0469837881	U	1.2 A2 / 1.6 A2

C = cored wire

* as delivered

K = knurled groove

Origo™ Feed 3004 MA23

with Mig 4002c/6502c Power Supply



- Quick connectors – reduces setup times
- Meets IEC 60974-5 safety standard with low voltage (42 VAC) operations and overload protection circuit to help eliminate breakdowns
- TrueArcVoltage™ System – measures the correct arc voltage value independent of the length of the connection cable or welding torch
- Can be equipped with a counterbalance device, lifting eye, or wheel kit for increased mobility
- Burnback
- Continuous adjustable inductor

Optimum welding solutions for easy setup and operation in GMAW/FCAW/ SMAW.

With its galvanized metal casing, the ESAB Origo Feed 3004 is ideal for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The four-wheel roller feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire – to avoid operational disturbances.

The feeder has rolls with a diameter of 1.18 in. (30 mm) for wires up to .062 in. (1.6 mm) diameter. All adjustments are made on the man-machine communication panels (MMC) of the feeder, giving a good overview of the settings.

With the Origo Feed 3004, you have your choice of power sources. The MIG 4002c and 6502c switching converter (chopper) power sources are all intended for heavy-duty applications. The units are easily transported, and the digital (CANbus) communications and control system reduces the need for cables.

Ordering Information

Ready to Weld Packages

MIG 4002c Origo Feed 3004 MA23.....0558101332

MIG 6502c Origo Feed 3004 MA23.....0558101336

Basic Packages

MIG 4002c Origo Feed 3004 MA230558101333

MIG 6502c Origo Feed 3004 MA230558101337

Ready to Weld package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch, 5.5 ft. (1.7 m) connection cable set, 16.4 ft. (5 m) work cable, reg. flowmeter Ar CO₂.

Basic package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch.



Feeder Accessories

Wheel kit	0458707880
Strain relief for welding torch	0457341881
Feeder strain relief for connection cables	0459234880
Lifting eye.....	0458706880
Quick connector MarathonPac.....	0558002354
Adapter for 11 lb spool.....	0455410001
Steel spool cover	0459431880
Counter-balance Mini boom	
For 12" spools	0458705880
For 18" spools	0458705882
Extension bracket for 60 lb coil.....	0459233880
Coil adapter	34323
Remote control MTA1 CAN.....	0459491880
Remote connection cable for CAN 10p.....	0459960880
Miggy Track remote adapter	0459681880
Push Pull adapter kit.....	0459681881

Connection Cable Sets

Air-Cooled Torch, 10 pole

5.5 ft. (1.7 m)	0349312450
16.4 ft. (5.0 m)	0349312451
32.8 ft. (10.0 m)	0349312452
49.2 ft. (15.0 m)	0349312453
82.0 ft. (25.0 m)	0349312454
114.8 ft. (35.0 m)	0349312455

Includes: control cable, electrode cable, and gas hose.

Torches

GunMaster 400cc

25 ft. (7.6 m) Basic	0558001674
12 ft. (3.6 m) x .035-.045 in.....	0558001667
15 ft. (4.5 m) x .035-.045 in.	0558001669
15 ft. (4.5 m) x .052-1/16 in.	0558001670

See ARC-23095 for additional information.

Instruction Manual

Origo Feed 3004	0444 408 187
MA23/MA24	0460 454 187
MIG 4002/6502	0349 301 162

Product Data Page ARC-23275

Wire
Feeders



Origo™ Feed 3004 MA23

with Mig 4002c/6502c Power Supply

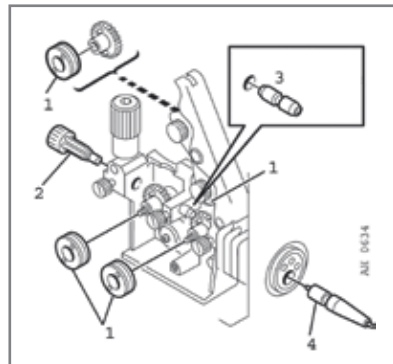
Feeder Data

Power Supply	Wire Spool Capacity	Max. Spool Diameter	Wire Feed Speed	Dimension (L x W x H)	Weight Enclosed	Wire Dimensions
42 VAC, 50/60 Hz	44 lb (19 kg) or 60 lb (27 kg)*	12 in. (300 mm) (enclosed)	32-1000 in./min. (0.8-25.0 m/min.)	27.1 x 10.8 x 16.1 in. (690 x 275 x 420 mm)	33 lb (15 kg)	Steel .023-.062 in. (0.6-1.6 mm) Stainless steel .023-.062 in. (0.6-1.6 mm) Aluminum .040-.062 in. (1.0-1.6 mm) Cored wire . 030-.062 in. (0.8-1.6 mm)

* Requires optional accessories

Panel (MMC) functions

- Process select
- 2/4 stroke – simplifies handling of the welding torch
- Gas pre/post flow
- Digital V/A meters
- Gas purge/wire inching
- Memory for 3-parameter set



Wear Parts

Wire Diameter (in.)	Wire Type	1 Feeder Roller (4 required)	2 Inlet Nozzle	3 Intermediate Nozzle	4 Outlet Nozzle	Groove Type	Marking
.023 / .030	Fe, Ss, C	0459052001	0455049001	0455072002	0469837880	V	0.6 S2 / 0.8 S2
.030 / .035 -.040	Fe, Ss, C	0459052002	0455049001	0455072002	0469837880	V	0.8 S2 / 1.0 S2
.035 - .040 / .045*	Fe, Ss, C	0459 052003	0455049001	0455072002	0469837880	V	1.0 S2 / 1.2 S2
.052 / .063	Fe, Ss, C	0459052013	0455049001	0455072002	0469837880	V	1.4 S2 / 1.6 S2
.035 -.040 / .045	C	0558002352	0455049001	0455072002	0469837880	V-K	1.0 R2 / 1.2 R2
.045 / .045	C	0458825010	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.2 R2
.045 / .052	C	37319	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.4 R2
1/16 - 5/64	C	37320	0455049001	0455072002	0469837880	V-K	1.6 R2
.035 - 3/64	Al	36860	0455049001	0456615001	0469837881	U	0.8 A2 / 1.0 A2
3/64 - 1/16	Al	36861	0455049001	0456615001	0469837881	U	1.2 A2 / 1.6 A2

C = cored wire

* as delivered

K = knurled groove

Origo™ Feed 3004 MA23

with Mig 4002c/6502c Power Supply



Power Source Features

- Multi-voltage – ready to work anywhere
- Energy saving mode saves power
- Outstanding arc across total power range
- Robust power technology
- Dust filter to prevent grinding-dust and metal particles from entering the chassis (optional)
- Undercarriage standard



Power Source Accessories

Air filter.....	0349302252
Electrode holder assembly QC – 15 ft.	21226
Power source strain relief for connection cables..	0349311700
Cable and torch holder.....	0349303362
Dual cylinder tray kit.....	0349312780

Dual feeder manual switch over control for Origo feed MA23	0588001819
Work cable assembly	
15 ft. w/clamp 50 mm OKC.....	36253
32 ft. w/clamp 50 mm OKC.....	0558008683
MMC cable to power supply.....	0458357885

Specifications

	4002c	6502c
Input voltage	230/460 V 3 ph 60 Hz	230/460 V 3 ph 60 Hz
Permitted load		
60% duty cycle	400 A / 34 V	650 A / 44 V
100% duty cycle	310 A / 30 V	500 A / 39 V
Primary current		
60% duty cycle	56/26 A	103/47 A
100% duty cycle	43/20 A	80/37A
Setting range (DC) GMAW/FCAW (MIG/MAG)	16–400 A / 8–60 V	16–650 A / 8–60 V
Setting range (STICK)	16–400A	16–650A
Open circuit voltage GMAW/FCAW (MIG/MAG)	62 V	62 V
Open circuit voltage SMAW (STICK)	68 V	68 V
Open circuit power	500 W	670 W
In energy saving mode, 15 min. after welding	60 W	60 W
Power factor at maximum current	0.88	0.90
Efficiency at maximum current	70%	76%
Control voltage	42 V, 50/60 Hz	42 V, 50/60 Hz
Dimensions L x W x H	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)
Weight	328 lb (149 kg)	489 lb (222 kg)
Weight with cooling unit	359 lb (163 kg)	520 lb (236 kg)
Operating temperature	14 to 104°F (-10 to 40°C)	14 to 104°F (-10 to 40°C)
Enclosure class	IP 23	IP 23

Wire
Feeders



Origo™ Feed 3004 MA24

with Mig 4002c/6502c Power Supply



- Quick connectors – reduces setup times
- Meets IEC 60974-5 safety standard with low voltage (42 VAC) operations and overload protection circuit to help eliminate breakdowns
- TrueArcVoltage™ system – measures the correct arc voltage value independent of the length of the connection cable or welding torch
- Can be equipped with a counterbalance device, lifting eye, or wheel kit for increased mobility
- Burnback
- Continuous adjustable inductor

Optimum welding solutions for easy setup and operation in GMAW/FCAW/SMAW.

With its galvanized metal casing, the ESAB Origo Feed 3004 is ideal for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The four-wheel roller feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire – to avoid operational disturbances.

The feeder has rolls with a diameter of 1.18 in. (30 mm) for wires up to .062 in. (1.6 mm) diameter. All adjustments are made on the man-machine communication panels (MMC) of the feeder, giving a good overview of the settings. The M24 MMC also features QSet,™ which automatically selects the correct parameters for your required wire/gas combination.

With the Origo Feed 3004, you have your choice of power sources. The MIG 4002c and 6502c switching converter (chopper) power sources are all intended for heavy-duty applications. The units are easily transported, and the digital (CANbus) communications and control system reduces the need for cables.

Ordering Information

Ready to Weld Packages

MIG 4002c Origo Feed 3004 MA240558101338

MIG 6502c Origo Feed 3004 MA240558101342

Basic Packages

MIG 4002c Origo Feed 3004 MA240558101339

MIG 6502c Origo Feed 3004 MA240558101343

Ready to Weld package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch, 5.5 ft. (1.7 m) connection cable set, 16.4 ft. (5 m) work cable, reg. flowmeter Ar CO₂.

Basic package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch.



Feeder Accessories

Wheel kit	0458707880
Strain relief for welding torch	0457341881
Feeder strain relief for connection cables	0459234880
Lifting eye.....	0458706880
Quick connector MarathonPac	0558002354
Adapter for 11 lb spool	0455410001
Steel spool cover	0459431880
Counter-balance Mini boom	
For 12" spools	0458705880
For 18" spools	0458705882
Extension bracket for 60 lb coil.....	0459233880
Coil adapter	34323
Remote control MTA1 CAN.....	0459491880
Remote connection cable for CAN 10p.....	0459960880
Miggy Track remote adapter	0459681880
Push Pull adapter kit.....	0459681881

Connection Cable Sets

Air-Cooled Torch, 10 Pole

5.5 ft. (1.7 m)	0349312450
16.4 ft. (5.0 m)	0349312451
32.8 ft. (10.0 m)	0349312452
49.2 ft. (15.0 m)	0349312453
82.0 ft. (25.0 m)	0349312454
114.8 ft. (35.0 m)	0349312455

Includes: control cable, electrode cable, and gas hose.

Torches

Gun Master 400cc

25 ft. (7.6 m) Basic	0558001674
12 ft. (3.6 m) x .035-.045 in.	0558001667
15 ft. (4.5 m) x .035-.045 in.	0558001669
15 ft. (4.5 m) x .052-1/16 in.	0558001670

See ARC-23095 for additional information.

Instruction Manual

Origo Feed 3004	0444408187
MA23/MA24.....	0460454187
MIG 4002/6502.....	0349301162
Product Data Page	ARC-23276

Origo™ Feed 3004 MA24

with Mig 4002c/6502c Power Supply

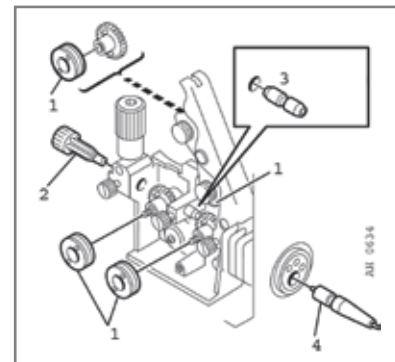


Feeder Data

Power Supply	Wire Spool Capacity	Max. Spool Diameter	Wire Feed Speed	Dimensions (L x W x H)	Weight Enclosed	Wire Dimensions
42 VAC, 50/60 Hz	44 lb (19 kg) or 60 lb (27 kg)*	12 in. (300 mm) (enclosed)	32-1000 in./min. (0.8-25.0 m/min.)	27.1 x 10.8 x 16.1 in. (690 x 275 x 420 mm)	33 lb (15 kg)	Steel .023-.062 in. (0.6-1.6 mm) Stainless steel .023-.062 in. (0.6-1.6 mm) Aluminum .040-.062 in. (1.0-1.6 mm) Cored wire .030-.062 in. (0.8-1.6 mm)

* Requires optional accessories

- **Process select**
- **QSet** – automatically selects correct parameters for required wire/gas combination
- **2/4 stroke** – simplifies handling of the welding torch
- **Gas pre/post flow**
- **Digital V/A meters**
- **Gas purge/wire inching**
- **Memory for 3 parameter set**
- **Creep start** – provides a soft, direct start with less spatter
- **Pre-programmed synergic lines** – ensure optimum settings with a wide choice of materials, wire dimensions, and gas combinations
- **Crater filling** – provides a smooth finish, extends the lifetime of the contact tip, and eliminates cracking at the end of the weld run



Wear Parts

Wire Diameter (in.)	Wire Type	1 Feeder Roller (4 required)	2 Inlet Nozzle	3 Intermediate Nozzle	4 Outlet Nozzle	Groove Type	Marking
.023 / .030	Fe, Ss, C	0459052001	0455049001	0455072002	0469837880	V	0.6 S2 / 0.8 S2
.030 / .035 -.040	Fe, Ss, C	0459052002	0455049001	0455072002	0469837880	V	0.8 S2 / 1.0 S2
.035 - .040 / .045*	Fe, Ss, C	0459 052003	0455049001	0455072002	0469837880	V	1.0 S2 / 1.2 S2
.052 / .063	Fe, Ss, C	0459052013	0455049001	0455072002	0469837880	V	1.4 S2 / 1.6 S2
.035 -.040 / .045	C	0558002352	0455049001	0455072002	0469837880	V-K	1.0 R2 / 1.2 R2
.045 / .045	C	0458825010	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.2 R2
.045 / .052	C	37319	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.4 R2
1/16 - 5/64	C	37320	0455049001	0455072002	0469837880	V-K	1.6 R2
.035 - 3/64	Al	36860	0455049001	0456615001	0469837881	U	0.8 A2 / 1.0 A2
3/64 - 1/16	Al	36861	0455049001	0456615001	0469837881	U	1.2 A2 / 1.6 A2

C = cored wire

* as delivered

K = knurled groove

Wire Feeders



Origo™ Feed 3004 MA24

with Mig 4002c/6502c Power Supply

Power Source Features

- Multi-voltage – ready to work anywhere
- Energy saving mode saves power
- Outstanding arc across total power range
- Robust power technology
- Dust filter to prevent grinding-dust and metal particles from entering the chassis (optional)
- Undercarriage standard



Power Source Accessories

Air filter 0349302252
 Electrode holder assembly QC – 15 ft. 21226
 Power source strain relief for connection cables .. 0349311700
 Cable and torch holder..... 0349303362
 Dual cylinder tray kit..... 0349312780

Dual feeder manual switch over control for
 Origo feed MA 24 0588001819
 Work cable Assembly
 15 ft. w/clamp 50 mm OKC..... 36253
 32 ft. w/clamp 50 mm OKC..... 0558008683
 MMC cable to power supply..... 0458357885

Specifications

	4002c	6502c
Input voltage	230/460 V 3 ph 60 Hz	230/460 V 3 ph 60 Hz
Permitted load		
60% duty cycle	400 A / 34 V	650 A / 44 V
100% duty cycle	310 A / 30 V	500 A / 39 V
Primary current		
60% duty cycle	56/26 A	103/47 A
100% duty cycle	43/20 A	80/37A
Setting range (DC) GMAW/FCAW (MIG/MAG)	16–400 A / 8–60 V	16–650 A / 8–60 V
Setting range (STICK)	16–400A	16–650A
Open circuit voltage GMAW/FCAW (MIG/MAG)	62 V	62 V
Open circuit voltage SMAW (STICK)	68 V	68 V
Open circuit power	500 W	670 W
In energy saving mode, 15 min. after welding	60 W	60 W
Power factor at maximum current	0.88	0.90
Efficiency at maximum current	70%	76%
Control voltage	42 V, 50/60 Hz	42 V, 50/60 Hz
Dimensions L x W x H	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)
Weight	328 lb (149 kg)	489 lb (222 kg)
Weight with cooling unit	359 lb (163 kg)	520 lb (236 kg)
Operating temperature	14 to 104°F (-10 to 40°C)	14 to 104°F (-10 to 40°C)
Enclosure class	IP 23	IP 23

Aristo™ Feed 3004 U6

with Mig 4002c/6502c Power Supply



- Quick connectors – reduces setup times
- Meets IEC 60974-5 safety standard with low voltage (42 VAC) operations and overload protection circuit to help eliminate breakdowns
- TrueArcVoltage™ System – measures the correct arc voltage value independent of the length of the connection cable or welding torch
- Can be equipped with a counterbalance device, lifting eye, or wheel kit for increased mobility
- Burnback
- Continuous adjustable inductor

Optimum welding solutions for easy setup and operation in GMAW/FCAW/ SMAW/GTAW.

With its galvanized metal casing, the ESAB Aristo Feed 3004 is ideal for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The four-wheel roller feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire – to avoid operational disturbances.

The feeder has rolls with a diameter of 1.18 in. (30 mm) for wires up to .062 in. (1.6 mm) diameter. All adjustments are made on the man-machine communication panels (MMC) of the feeder, giving a good overview of the settings. The U6 MMC also features QSet,™ which automatically selects the correct parameters for your required wire/gas combination.

With the Aristo Feed 3004, you have your choice of power sources. The MIG 4002c and 6502c switching converter (chopper) power sources are all intended for heavy-duty applications. The units are easily transported, and the digital (CANbus) communications and control system reduces the need for cables.

Ordering Information

Ready to Weld Packages

MIG 4002c Aristo Feed 3004 U6	0558101344
MIG 6502c Aristo Feed 3004 U6	0558101348

Basic Packages

MIG 4002c Aristo Feed 3004 U6	0558101345
MIG 6502c Aristo Feed 3004 U6	0558101349

Ready to Weld package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch, 5.5 ft. (1.7 m) connection cable set, 16.4 ft. (5 m) work cable, reg. flowmeter Ar CO₂.

Basic package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch.



Feeder Accessories

Wheel kit	0458 707 880
Strain relief for welding torch	0457 341 881
Feeder strain relief for connection cables	0459 234 880
Lifting eye.....	0458 706 880
Quick connector MarathonPac	0558 002 354
Adapter for 11 lb spool.....	0455 410 001
Steel spool cover	0459 431 880
Counter-balance Mini boom	
For 12" spools	0458705880
For 18" spools	0458705882
Extension bracket for 60 lb coil.....	0459 233 880
Coil adapter	34323
Remote control	
MTA1 CAN	0459 491 880
M1 CAN 10p.....	0459 491 882
Remote connection cable for CAN 10p.....	0459 960 880
Miggy Track remote adapter	0459 681 880
Push Pull adapter kit.....	0459 681 881
T1 foot control 10p.....	0460 315 881

Connection Cable Sets

Air-Cooled Torch, 10 Pole	
5.5 ft. (1.7 m)	0349312450
16.4 ft. (5.0 m)	0349312451
32.8 ft. (10.0 m)	0349312452
49.2 ft. (15.0 m)	0349312453
82.0 ft. (25.0 m)	0349312454
114.8 ft. (35.0 m)	0349312455

Includes: control cable, electrode cable, and gas hose.

Torches

Gun Master 400cc

25 ft. (7.6 m) Basic.....	0558001674
12 ft. (3.6 m) x .035-.045 in.	0558001667
15 ft. (4.5 m) x .035-.045 in.	0558001669
15 ft. (4.5 m) x .052-1/16 in.	0558001670

See ARC-23095 for additional information.

Instruction Manual

Aristo Feed 3004.....	0444408187
Aristo U6	0459287287
MIG 4002/6502	0349301162
Product Data Page	ARC-23277

Wire
Feeders



Aristo™ Feed 3004 U6

with Mig 4002c/6502c Power Supply

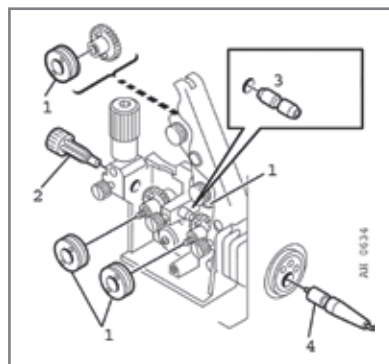
Feeder Data

Power Supply	Wire Spool Capacity	Max. Spool Diameter	Wire Feed Speed	Dimensions (L x W x H)	Weight Enclosed	Wire Dimensions
42 VAC, 50/60 Hz	44 lb (19 kg) or 60 lb (27 kg)*	12 in. (300 mm) (enclosed)	32-1000 in./min. (0.8-25.0 m/min.)	27.1 x 10.8 x 16.1 in. (690 x 275 x 420 mm)	33 lb (15 kg)	Steel .023-.062 in. (0.6-1.6 mm) Stainless steel .023-.062 in. (0.6-1.6 mm) Aluminum .040-.062 in. (1.0-1.6 mm) Cored wire .030-.062 in. (0.8-1.6 mm)

* Requires optional accessories

Panel (MMC) functions

- Process select
- QSet – automatically selects correct parameters for required wire/gas combination
- 2/4 stroke – simplifies handling of the welding torch
- Gas pre/post flow
- Digital V/A meters
- Gas purge/wire inching
- Memory for 10 parameter set
- Pulse/synergic pulse
- 60 pre-programmed synergic lines – ensure optimum settings with a wide choice of materials, wire dimensions, and gas combinations
- Crater filling, adjustable burnback time, and post-gas – provide a smooth finish, extend the lifetime of the contact tip, and eliminate cracking at the end of the weld run



Wear Parts

Wire Diameter (in.)	Wire Type	1 Feeder Roller (4 required)	2 Inlet Nozzle	3 Intermediate Nozzle	4 Outlet Nozzle	Groove Type	Marking
.023 / .030	Fe, Ss, C	0459052001	0455049001	0455072002	0469837880	V	0.6 S2 / 0.8 S2
.030 / .035 - .040	Fe, Ss, C	0459052002	0455049001	0455072002	0469837880	V	0.8 S2 / 1.0 S2
.035 - .040 / .045*	Fe, Ss, C	0459 052003	0455049001	0455072002	0469837880	V	1.0 S2 / 1.2 S2
.052 / .063	Fe, Ss, C	0459052013	0455049001	0455072002	0469837880	V	1.4 S2 / 1.6 S2
.035 - .040 / .045	C	0558002352	0455049001	0455072002	0469837880	V-K	1.0 R2 / 1.2 R2
.045 / .045	C	0458825010	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.2 R2
.045 / .052	C	37319	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.4 R2
1/16 - 5/64	C	37320	0455049001	0455072002	0469837880	V-K	1.6 R2
.035 - 3/64	Al	36860	0455049001	0456615001	0469837881	U	0.8 A2 / 1.0 A2
3/64 - 1/16	Al	36861	0455049001	0456615001	0469837881	U	1.2 A2 / 1.6 A2

C = cored wire

* as delivered

K = knurled groove

Aristo™ Feed 3004 U6

with Mig 4002c/6502c Power Supply



Power Source Features

- Multi-voltage – ready to work anywhere
- Energy saving mode saves power
- Outstanding arc across total power range
- Robust power technology
- Dust filter to prevent grinding-dust and metal particles from entering the chassis (optional)
- Undercarriage standard



Power Source Accessories

Air filter	0349302252
Electrode holder assembly QC – 15 ft.	21226
Power source strain relief for connection cables ..	0349311700
Cable and torch holder	0349303362
Dual cylinder tray kit	0349312780

Dual feeder manual switch over control for Origo feed U6	0588001819
Work cable Assembly	
15 ft. w/clamp 50 mm OKC	36253
32 ft. w/clamp 50 mm OKC	0558008683
MMC cable to power supply	0458357885

Specifications

	4002c	6502c
Input voltage	230/460 V 3 ph 60 Hz	230/460 V 3 ph 60 Hz
Permitted load		
60% duty cycle	400 A / 34 V	650 A / 44 V
100% duty cycle	310 A / 30 V	500 A / 39 V
Primary current		
60% duty cycle	56/26 A	103/47 A
100% duty cycle	43/20 A	80/37A
Setting range (DC) GMAW/FCAW (MIG/MAG)	16–400 A / 8–60 V	16–650 A / 8–60 V
Setting range (STICK)	16-400A	16-650A
Open circuit voltage GMAW/FCAW (MIG/MAG)	62 V	62 V
Open circuit voltage SMAW (STICK)	68 V	68 V
Open circuit power	500 W	670 W
In energy saving mode, 15 min. after welding	60 W	60 W
Power factor at maximum current	0.88	0.90
Efficiency at maximum current	70%	76%
Control voltage	42 V, 50/60 Hz	42 V, 50/60 Hz
Dimensions L x W x H	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)
Weight	328 lb (149 kg)	489 lb (222 kg)
Weight with cooling unit	359 lb (163 kg)	520 lb (236 kg)
Operating temperature	14 to 104°F (-10 to 40°C)	14 to 104°F (-10 to 40°C)
Enclosure class	IP 23	IP 23

Wire
Feeders



Aristo™ Feed 3004 U82 Plus

with Mig 4002c/6502c Power Supply



- Quick connectors – reduces setup times
- Meets IEC 60974-5 safety standard with low voltage (42 VAC) operations and overload protection circuit to help eliminate breakdowns
- TrueArcVoltage™ System – measures the correct arc voltage value independent of the length of the connection cable or welding torch
- Can be equipped with a counterbalance device, lifting eye, or wheel kit for increased mobility
- Burnback
- Continuous adjustable inductor

Optimum welding solutions for easy setup and operation in GMAW/FCAW/ SMAW/GTAW.

With its galvanized metal casing, the ESAB Aristo Feed 3004 is ideal for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The four-wheel roller feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire – to avoid operational disturbances.

The feeder has rolls with a diameter of 1.18 in. (30 mm) for wires up to .062 in. (1.6 mm) diameter. All adjustments are made on the man-machine communication panels (MMC) of the feeder, giving a good overview of the settings. The U82 Plus MMC also features QSet, which automatically selects the correct parameters for your required wire/gas combination.

With the Aristo Feed 3004, you have your choice of power sources. The MIG 4002c and 6502c switching converter (chopper) power sources are all intended for heavy-duty applications. The units are easily transported, and the digital (CANbus) communications and control system reduces the need for cables.

Ordering Information

Ready to Weld Packages

MIG 4002c Aristo Feed 3004 U82 Plus	0558101354
MIG 6502c Aristo Feed 3004 U82 Plus	0558101358
MIG 4002c Dual Aristo Feed 3004	0558101366
MIG 6502c Dual Aristo Feed 3004	0558101368

Basic Packages

MIG 4002c Aristo Feed 3004 U82 Plus	0558101355
MIG 6502c Aristo Feed 3004 U82 Plus	0558101359

Ready to Weld package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch, 5.5 ft. (1.7 m) connection cable set, 16.4 ft. (5 m) work cable, reg. flowmeter Ar CO₂.

Basic package includes: power source, feeder, 15 ft. (4.5 m) 400 A torch.



Feeder Accessories

Wheel kit	0458707880
Strain relief for welding torch	0457341881
Feeder strain relief for connection cables	0459234880
Lifting eye.....	0458706880
Quick connector MarathonPac	0558002354
Adapter for 11 lb spool	0455410001
Steel spool cover	0459431880
Counter-balance Mini boom	
For 12" spools	0458705880
For 18" spools	0458705882
Extension bracket for 60 lb coil.....	0459233880
Coil adapter	34323
Remote control	
MTA1 CAN*	0459491880
M1 CAN 10p*	0459491882
Remote connection cable for CAN 12p*	0459554880
Miggy Track remote adapter	0459681880
Push Pull adapter kit.....	0459681881
Extension cable U8 ² 24.5 ft. 12 p	0460877891
T1 foot control 12p.....	0460315880

*Uses 12p remote cables

Connection Cable Sets

Air-Cooled Torch, 10 Pole

5.5 ft. (1.7 m)	0349312450
16.4 ft. (5.0 m)	0349312451
32.8 ft. (10.0 m)	0349312452
49.2 ft. (15.0 m)	0349312453
82.0 ft. (25.0 m)	0349312454
114.8 ft. (35.0 m)	0349312455

Includes: control cable, electrode cable, and gas hose.

Torches

Gun Master 400cc

25 ft. (7.6 m) Basic	0558001674
12 ft. (3.6 m) x .035-.045 in.	0558001667
15 ft. (4.5 m) x .035-.045 in.	0558001669
15 ft. (4.5 m) x .052-1/16 in.	0558001670

See ARC-23095 for additional information.

Instruction Manual

Aristo Feed 3004.....	0444408187
Aristo U82 Plus	0460896187
MIG 4002/6502	0349301162
Product Data Page	ARC-23278

Aristo™ Feed 3004 U82 Plus

with Mig 4002c/6502c Power Supply



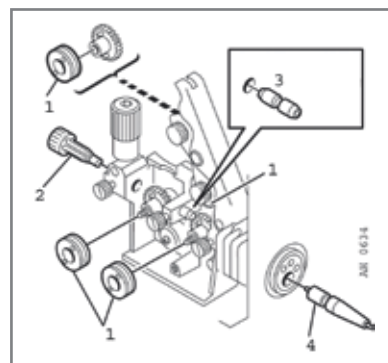
Feeder Data

Power Supply	Wire Spool Capacity	Max. Spool Diameter	Wire Feed Speed	Dimensions (L x W x H)	Weight Enclosed	Wire Dimensions
42 VAC, 50/60 Hz	44 lb (19 kg) or 60 lb (27 kg)*	12 in. (300 mm) (enclosed)	32-1000 in./min. (0.8-25.0 m/min.)	27.1 x 10.8 x 16.1 in. (690 x 275 x 420 mm)	33 lb (15 kg)	Steel .023-.062 in. (0.6-1.6 mm) Stainless steel .023-.062 in. (0.6-1.6 mm) Aluminum .040-.062 in. (1.0-1.6 mm) Cored wire .030-.062 in. (0.8-1.6 mm)

* Requires optional accessories

Panel (MMC) functions

- Process select
- QSet – optimizes parameters for the best quality weld
- 2/4 stroke – simplifies handling of the welding torch
- Gas pre/post flow
- Digital V/A meters
- Gas purge/wire inching
- Memory for 255 parameter set
- Pulse/synergic pulse and SuperPulse
- 230 pre-programmed synergic lines – ensure optimum settings with a wide choice of materials, wire dimensions, and gas combinations
- Crater filling, adjustable burnback time, post-gas – provide a smooth finish, extends lifetime of the contact tip, and eliminates cracking at end of the weld run
- Create your own synergic lines – unlimited
- Limit editor – set and measured values
- Remote operator pendant



Wear Parts

Wire Diameter (in.)	Wire Type	1 Feeder Roller (4 required)	2 Inlet Nozzle	3 Intermediate Nozzle	4 Outlet Nozzle	Groove Type	Marking
.023 / .030	Fe, Ss, C	0459052001	0455049001	0455072002	0469837880	V	0.6 S2 / 0.8 S2
.030 / .035 - .040	Fe, Ss, C	0459052002	0455049001	0455072002	0469837880	V	0.8 S2 / 1.0 S2
.035 - .040 / .045*	Fe, Ss, C	0459 052003	0455049001	0455072002	0469837880	V	1.0 S2 / 1.2 S2
.052 / .063	Fe, Ss, C	0459052013	0455049001	0455072002	0469837880	V	1.4 S2 / 1.6 S2
.035 - .040 / .045	C	0558002352	0455049001	0455072002	0469837880	V-K	1.0 R2 / 1.2 R2
.045 / .045	C	0458825010	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.2 R2
.045 / .052	C	37319	0455049001	0455072002	0469837880	V-K	1.2 R2 / 1.4 R2
1/16 - 5/64	C	37320	0455049001	0455072002	0469837880	V-K	1.6 R2
.035 - 3/64	Al	36860	0455049001	0456615001	0469837881	U	0.8 A2 / 1.0 A2
3/64 - 1/16	Al	36861	0455049001	0456615001	0469837881	U	1.2 A2 / 1.6 A2
C = cored wire		* as delivered				K = knurled groove	

Wire Feeders



Aristo™ Feed 3004 U82 Plus

with Mig 4002c/6502c Power Supply

Power Source Features

- Multi-voltage – ready to work anywhere
- Energy saving mode saves power
- Outstanding arc across total power range
- Robust power technology
- Dust filter to prevent grinding-dust and metal particles from entering the chassis (optional)
- Undercarriage standard



Power Source Accessories

Air filter..... 0349302252
 Electrode holder assembly QC – 15 ft. 21226
 Power source strain relief for connection cables .. 0349311700
 Cable and torch holder..... 0349303362
 Dual cylinder tray kit..... 0349312780

Dual feeder switch over control for

Origo feed U8₂..... 0349311825

Work cable Assembly

15 ft. w/clamp 50 mm OKC..... 36253

32 ft. w/clamp 50 mm OKC..... 0558008683

Specifications

	4002c	6502c
Input voltage	230/460 V 3 ph 60 Hz	230/460 V 3 ph 60 Hz
Permitted load		
60% duty cycle	400 A / 34 V	650 A / 44 V
100% duty cycle	310 A / 30 V	500 A / 39 V
Primary current		
60% duty cycle	56/26 A	103/47 A
100% duty cycle	43/20 A	80/37A
Setting range (DC) GMAW/FCAW (MIG/MAG)	16–400 A / 8–60 V	16–650 A / 8–60 V
Setting range (STICK)	16–400A	16–650A
Open circuit voltage GMAW/FCAW (MIG/MAG)	62 V	62 V
Open circuit voltage SMAW (STICK)	68 V	68 V
Open circuit power	500 W	670 W
In energy saving mode, 15 min. after welding	60 W	60 W
Power factor at maximum current	0.88	0.90
Efficiency at maximum current	70%	76%
Control voltage	42 V, 50/60 Hz	42 V, 50/60 Hz
Dimensions L x W x H	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)	32.6 x 25.1 x 32.8 in. (830 x 640 x 835 mm)
Weight	328 lb (149 kg)	489 lb (222 kg)
Weight with cooling unit	359 lb (163 kg)	520 lb (236 kg)
Operating temperature	14 to 104°F (-10 to 40°C)	14 to 104°F (-10 to 40°C)
Enclosure class	IP 23	IP 23

Aristo™ SuperPulse™

3Phase DC CV 3 YEAR WARRANTY 100% SATISFACTION GUARANTEE

- Makes positional welding easier
- Allows welding with low heat input
- Provides uniform penetration
- Allows operator more control over welding speed
- TIG-looking weld appearance with MIG
- Very adaptable to all kind of mechanization, for example, Railtrac and Miggytrac
- Extends working range with larger wire size
- Less sensitive to joint gap variations
- Less sensitive to unequal heat transfer

If your application demands efficient root runs or positional welding on thin, or thick aluminum or stainless materials, then SuperPulse will provide the optimum solution. With productivity as the objective, today's TIG process is tomorrow's Aristo SuperPulse.

The prime advantage of the pulse/pulse process is the ability to control the heat input. Pulse/pulse is a well established process and has mainly been focused on aluminum welding.

Now SuperPulse is a further development of the pulse/pulse concept with the following additional combinations:

Pulse/short arc—Replace the TIG process by welding the root pass with the pulse/short-arc process. This process enables full control of the heat input for any thin sheet welding.

Spray arc/pulse—A very efficient process in positional welding of thicker materials. Aluminum can be welded straight upwards without the usual torch manipulation. (Less tiring for the operator)

MIG brazing of very thin sheets is another application where we recommend Aristo SuperPulse.

New welding processes will always require expert advice and training. To find out more about the process or applications surrounding Aristo SuperPulse please contact your local ESAB sales office for further information.

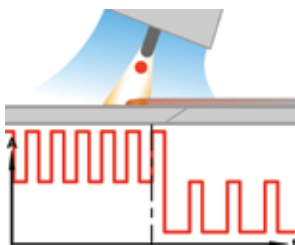
ESAB has welding process centers located in Hanover (US), Florence (US), Gothenburg (SE), Solingen (DE), Utrecht (NL), Waltham Cross (GB), Milan (IT) and Vamberk (CZ). All are prepared to undertake application trials for you, or offer a complete application/training package.

A complete package consists of:

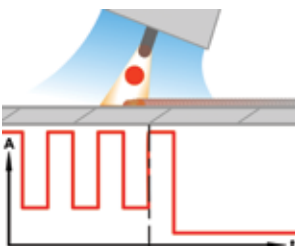
Aristo Mig or Origo Mig power source
Aristo Feed 3004 wire feeder with U8₂ pendant
MIG welding torch



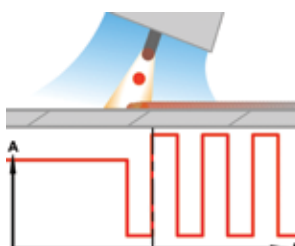
Wire Feeders



pulse / pulse



pulse / short arc



spray / pulse



Balanced Boom Assembly

- Extended a 12 or 15 ft. torch's reach from a 20 ft. radius up to a 31 ft. radius
- 350 degree envelope of operation in most uses
- Boom adjusts from 50 degrees up to 6 degrees down from horizontal position, can be used for tall weldments
- Fully balances feeder weight for fingertip control of feeder height, no lever jacking
- Mast has 6 ft. 10 in. clearance from floor to boom support pin
- Standard mounting directly to concrete floor
- Pallet and cart mounting options available
- Extremely rugged steel construction for years of continuous use
- Weld parameters easily adjustable on the standard feeder at the end of boom
- Wire spools mountable to mast or feed wire from Marathon Pac

Ordering Information

Balance Boom		
8 ft. B-8/FHD	0558004002	
10 ft. B-10/FHD	0558004006	
12 ft. B-12/FHD	0558003734	
16 ft. B-16/FHD	0558003737	

Accessories

Plastic Trough		
8 ft.	0558004004	
10 ft.	0558004008	
12 ft.	0558003447	
16 ft.	0558003732	

(Troughs neatly contain cables and hoses to feeder)

Boom Mounting Bracket Kit		
DuraDrive Feeder	0558003735M	
Aristo, Origo Feed	0558005581	

Feeder Strain Relief for Torch	0457341881	
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(Aristo or Origo only, not for DuraDrive)

ERS Conduit Bushing Support Bracket	37770	
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(Used with 948259. Holds conduit inlet inline with spool)

Spindle Assembly	948259	
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(For mast mounted spools. Requires 1/4" hardware)

Coil Adapter for 60 lb. coils	34323	
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Pallet Base	37776	
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(Requires anchoring to floor in use)

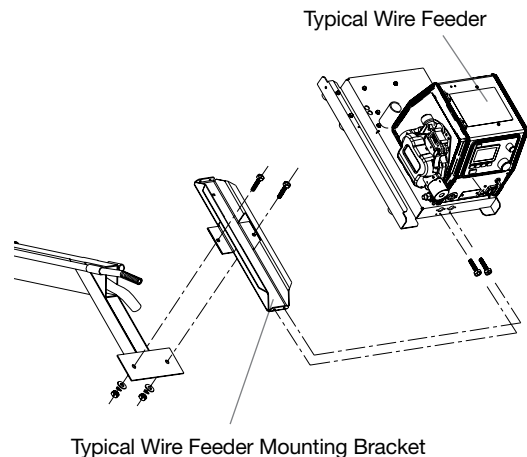
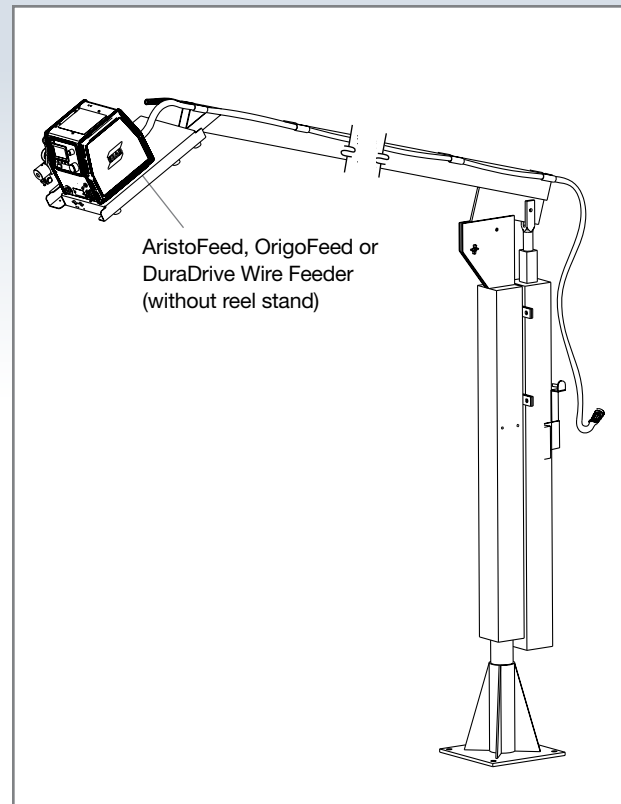
Welding Cart with Wheels	37777	
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(Use with 12 ft. maximum boom and 300 lb. and heavier power source)

Inlet Guide 4-30 mm Marathon	0558002354	
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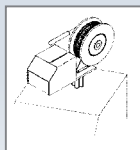
(Accepts QCA Adapter 899F50)

See Marathon Pac Conduits to guide wire from Marathon Pacs or mast mounted spindles. Add 4 ft. to boom length to get conduit length for mast mounted spindle. Add at least 7 ft. plus boom length for Marathon Pac payed wire.



Typical Wire Feeder Mounting Bracket

Wire Feeder Accessories



Swivel Post

- Allows wire feeder to swivel freely on the post

Swivel Post

For power sources such as ESAB 353cv, 453cv, or 653cvcc36172

Swivel Post with Mounting Bracket - Bracket attaches to Inverter Cart (P/N 31700) or other flat mounting surfaces.....34075

Accessories for DuraDrive 4-30, 4-48

Digital Dual Schedule Option..... 0558001912

Digital Pulse/Dual Schedule Option..... 0558002496

Pre/Postflow/Spot/Trig Lock Option 0558001914

Control Cable

8 ft. 0558002358

30 ft.30780

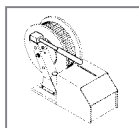
60 ft.30781

Marathon Pac Inlet Guide

4-30 (Req's. 899F50)..... 0558002354

4-48 (Req's. 899F50)..... 0558002519

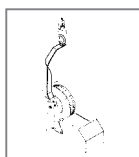
Marathon Pac Inlet Guide, 4-48..... 0558002519



Carrying Handle Kit

- Includes handle with rubber grip/mounting hardware

DuraDrive 0558002356



Boom Hanging Bracket Kit

- Includes hanging bracket and mounting hardware

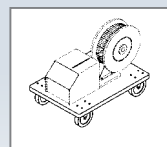
4HD34321

Hanging Bail, DuraDrive0558003047

Spool Cover Kit

- Includes cover and mounting hardware (not for use with coils)

DuraDrive0558002357



Wire Feeder Wheel Cart

- Cart makes it easy to roll wire feeder around job site. Cart is 5 7/8 in. (15 cm) high and includes base, front swivel caster wheels, rear caster wheels and mounting hardware

Wire Feeder Wheel Cart34324

Water Kit

- Convenient way of using water cooled torches. Kit consists of inlet/outlet fittings, mounting hardware, quick action connectors for the torch and 10 ft. (3 m) water hoses with "B" size water fittings

DuraDrive 37801

Coil Adaptor

Standard - Use with 60 or 65 lb. (27 or 30 kg) coils.....34323

Spool Spacer

8 in. (20.3 cm) diameter spools.....17511

10 in. (25.4 cm) diameter spools..... 34330

R-33 Regulator/Flowmeter

- Regulator with Lexan flow tube, 3000 psi cylinder gauge

R-33-FM-580* - Argon 10-50 cfh21557

R-33-FM-320* - CO₂ 10-65 cfh..... 21558

*Refer to Gas-1000 catalog for details

Hoses / Fittings

Gas Hose Assemblies

3 ft. (0.8 m)..... 31504

6 ft. (3.8 m)..... 31503

12 1/2 ft. (3.8 m)40V77

25 ft. (7.5 m).....34V38

12 1/2 ft. (3.8 m) heavy duty (CO₂)..... 19416

25 ft. (7.5 m) heavy duty (CO₂) 19415

Gas Hose Coupler11N17

Gas Hose Coupler, "Y" 950356

Water Hose Assemblies

3 ft. (0.8 m)..... 20634

6 ft. (1.8 m)..... 20633

12 1/2 ft. (3.8 m).....40V76

25 ft. (7.5 m) 406196

Water Hose Coupler11N18

Gas Spud (Surge Reducer) 19X76

Install Gas Spud between gas solenoid inlet and gas hose coming from flowmeter. Flowrate will be limited to approx. 35 to 45 cfh on a 50 psig regulator/flowmeter and 30-35 cfh on a 25 psig regulator/flowmeter.

Note: This Gas Spud cannot be used on wire feeders having a direct crimped or clamped hose connection to the solenoid. Only hose connections having a standard 5/8 in. 'B' hose nut fitting can be used.

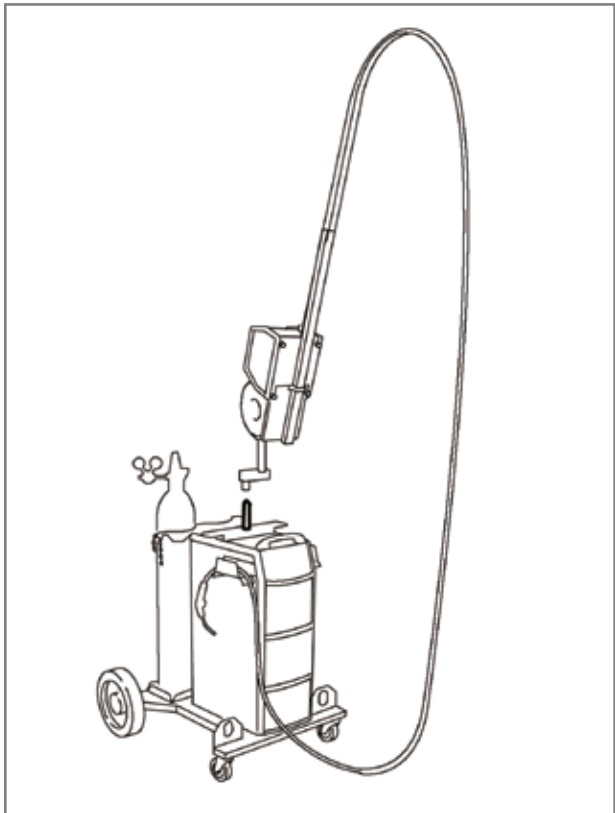
Counterbalance Mini-Boom

- Up to 25 ft. working radius—effective area of over 1900 sq. ft.
- 350 degree working envelope
- Mounts easily to power source, inverter cart or stationary pedestal
- Lowest cost boom on the market
- Adjustable boom length
- Adjustable counter-balance spring



Ordering Information

Swivel Post for 353/453/460/653 power sources	36172
Inverter Cart Fits SVI 450i and 350 mpi	31700
Swivel Post with bracket (Required with 31700 cart).....	34075
Mini-Boom Aristo/Origo Feed Models	
up to 12" 44 lb. coils.....	0458705880
up to 18" 65 lb. coils.....	0458705882
Required to add mini-boom to power sources shown below:	
Stabilizer (MIG 320)	0349303475
Reinforcer kit for counterbalance (MIG 410/510)....	0349309748
Stabilizer (MIG 410/510)	0349303474
Aristo Swivel Post (Required with no cart)	0458731880
Aristo Trolley Cart - used when 0458705880 or 0458705882	
Mini-Boom is desired has dual feed support also	0458603880



AristoMig power source, AristoMig wire feeder, 25ft. MIG torch, 0458 750 880 Mini-Boom and 0458 603 880 Trolley Cart with 2 gas cylinder capacity shown.

MXL™ - MIG/MAG Gun Consumables



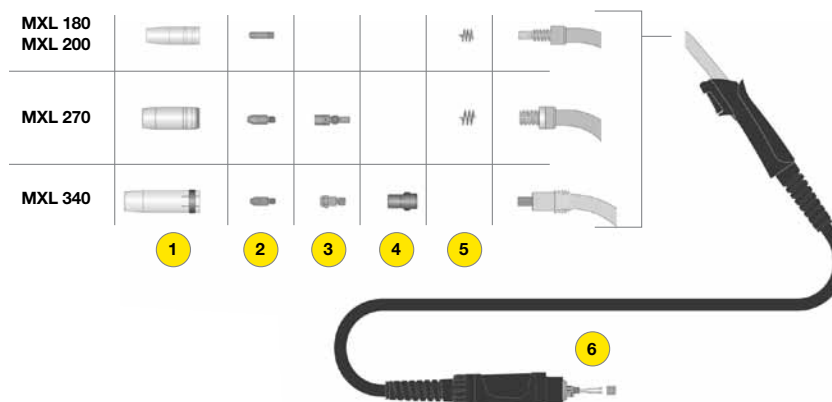
Consumables and Wear Parts

			MXL 180 / 200	MXL 270	MXL 340
1	Gas Nozzle				
	Standard	7/16" (12 mm)	0700200054		
	Standard	9/16" (15 mm)		0700200055	
	Standard	5/8" (16 mm)			0700200056
	Straight	5/8" (16 mm)	0700200057		
	Straight	11/16" (18 mm)		0700200058	
	Straight	3/4" (19 mm)			0700200059
	Conical	3/8" (9.5 mm)	0700200060		
	Conical	7/16" (12 mm)		0700200061	
	Conical	7/16" (12 mm)			0700200062
2	Contact Tip				
		.023" (0.6mm)	0700200063		
		.030" (0.8mm)	0700200064		
		.035" (0.9mm)	0700200065		
		.040" (1.0mm)	0700200066		
		.030" (0.8mm)		0700200068	0700200068
		.035" (0.9mm)		0700200069	0700200069
		.040" (1.0mm)		0700200070	0700200070
		.045" (1.2mm)		0700200071	0700200071
3	Tip Adaptor				
		Standard	0700200072		
		Standard		0700200073	
		Short			0700200074
4					
		Use With Teflon Liners		0700200067*	0700200075
5	Gas Diffusor				
					0700200080
5	Nozzle Spring				
			0700200078		
6					
				0700200079	
6	Liner				
	Steel	.023"-.030" (0.6-0.8) 13 ft. (4.0m)	0700200086†	0700200086	0700200086
	Steel	.035"-.045" (0.9-1.2) 13 ft. (4.0m)	0700200088†	0700200088	0700200088
	Teflon	.023"-.030" (0.6-0.8) 13 ft. (4.0m)	0700200090†	0700200090*	0700200090
	Teflon	.035"-.045" (0.9-1.2) 13 ft. (4.0m)	0700200092†	0700200092*	0700200092

* Use tip adaptor 0700200067 when using teflon liners

Bold = Standard Deliveries

† MXL 180 use requires removal of wear inlet / collet



Gun Master 250/400

- “Slide-on” standard and heavy duty copper wall nozzles deliver performance and dependability
- Lightweight handle is impact resistant for long life
- Cable resists cuts, spatter, oil and abrasion

Ordering Information

Complete Assemblies (NAS Style)

Gun Master 250 NAS

10 ft. x .023	0558001630
10 ft. x .035-.045.....	0558001631
12 ft. x .035-.045.....	0558001635
15 ft. x .035-.045.....	0558001639

Gun Master 400 NAS

10 ft. x .035-.045.....	0558001653
12 ft. x .035-.045.....	0558001656
12 ft. x .052-1/16	0558001657
15 ft. x .035-.045.....	0558001659
15 ft. x .052-1/16	0558001660

Complete Assemblies (CC Style)

Gun Master 250cc

10 ft. x .035-.045.....	0558001644
12 ft. x .035-.045.....	0558001645
15 ft. x .035-.045.....	0558001649

Gun Master 400cc

12 ft. x .035-.045.....	0558001667
15 ft. x .035-.045.....	0558001669
15 ft. x .052-1/16	0558001670

Basic (NAS Style)

Gun Master 400 NAS 25 ft. Basic..... 0558001664

Basic (CC Style)

Gun Master 400cc 25 ft. Basic..... 0558001674

Options

ESAB Power Pin for MIG 35..... 0558002313

Lincoln Power Pin..... 0558001862

45 Degree 250 A Gooseneck..... 0558001616

(for Gun Master 250)

Gas Meter (measures gas flow at the gun)..... 19043

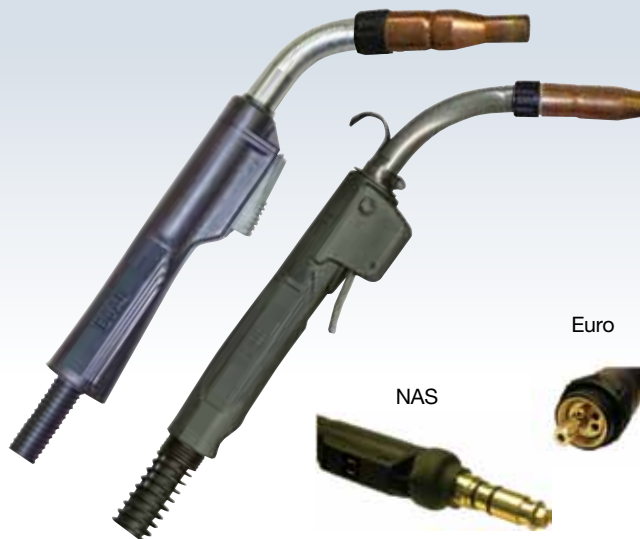
Specifications

Gun Amperage Ratings

Gun Master	100% Duty Cycle		60% Duty Cycle	
	CO ₂	Mixed	CO ₂	Mixed
250 A	250	180	300	250
400 A	400	275	525	400

Note: Ratings are based on tests that comply with NEMA ARC Welding Section Standard 11-6-1975 for Duty Cycle. “The time period of one complete cycle shall be 10 minutes” (60% = 6 minutes).

National Electrical Manufacturers Association
2101 L Street N.W., Washington, D.C., 20037.



Consumables / Accessories

Liner Selection

Steel / Flux Core

.023 x 10,12,15 ft.....	0558001675
.030 x 10,12,15 ft.....	37031
.035/.045 x 10,12,15 ft.....	37032
.052-1/16 x 10,12,15 ft.....	37033
5/64 x 10,12,15 ft.....	0558001676
3/32 x 10,12,15 ft.....	37034
7/64 1/8 x 10,12,15 ft.....	952948
.035 - .045 x 25 ft.....	0558002137
.052 - 1/16 x 25 ft.....	0558002138
5/64 x 25 ft.....	0558002139
3/32 x 25 ft.....	0558002140

Aluminum

.035-3/64 x 15 ft. Poly.....	37039*
3/64-1/16 x 15 ft. Poly.....	37040*

*Requires Jumper Sleeve P/N 0558006682 when H.D. parts used.

Note: All 15 ft. Liners can be trimmed to fit 10 ft. or 12 ft.

Aluminum Optimization Kits

For use with MA23 / 24, Aristo U6, U82, Origo Feed 3004, 304

.035 and 3/64 Al.....	0558007841
3/64 and 1/16 Al.....	0558007842

Note: Includes 15 ft. liners (CITFE), drive roll guides (4), tips (2 ea. size for kit), nozzle H.D. 5/8" and jumpers sleeve.

Trigger Leads, ESAB Style for NAS style guns

6 in., Gun Master 250.....	0558001815
24 in., Gun Master 250.....	0558002583
Gun Master 400.....	2075216

Control Plugs (Options)

Lincoln (LN 7, 8, 9, NAS)..... 0558001864



MIG/MAG gun holder..... 0760022300

Instruction Manual

Gun Master 250..... F-15-612

Gun Master 400..... F-15-613

Product Data Page..... ARC-23095

Gun Master 250/400



Liners for Gun Master 250 / 400

Wire Type and Size	Liner
Hard Wires	
.030 in. (0.8mm)	37031
.035 in. - .045 in. (0.9mm - 1.2mm)	37032
.045 in. - 1/16 in. (1.2 - 1.6mm)	37033
5/64 in. - 3/32 in. (2 - 2.4mm)	37034
Soft Wires	
.035 in. (0.9mm)	37039*
3/64 in. - 1/16 in. (1.2 - 1.6mm)	37040*

*Requires jumper sleeve P/N 0558006682 for aluminum/soft wire liners

Contact Tips

Standard Duty Tips		Heavy Duty Tips	
Wire Size	Part Number	Wire Size	Part Number
.023	20543	.030	0558002367
.030	20544	.035	0558002368
.035	996995	.040	0558002369
.045	37290	.045	37286
.045 - 3/64	996999	3/64 Aluminum	17765
.052	2075349	.052	17778
1/16	996997	1/16 Hard or Cored Wire	37291
5/64	2075230	1/16 Aluminum	948835
		5/64	948832
		3/32	948833

Nozzles

Standard Duty		Tip Relationship Using All Sizes Standard Duty Tips		Tip Relationship Using All Sizes Heavy Duty Tips Except 5/64 in. and 3/32 in.
Inside Diameter	Part Number			
3/8 in.	0558001609	1/8 in. Stick Out	Copper	1/8 in. Stick Out
1/2 in.	0558001612	Flush	Copper	Flush
1/2 in.	0558001611	1/8 in. Stick Out	Copper	1/8 in. Stick Out
1/2 in.	0558001613	1/4 in. Stick Out	Copper	1/4 in. Stick Out
5/8 in.	0558001614	1/8 in. Stick Out	Copper	1/8 in. Stick Out
5/8 in.	0558001615	1/4 in. Stick Out	Copper	1/4 in. Stick Out
Standard Duty Tip/Nozzle Adaptor				
Tip/Adaptor	0558001608			
Heavy Duty		Tip Relationship Using 5/64 in. and 3/32 in. Heavy Duty Tips Only		Tip Relationship Using All Sizes Heavy Duty Tips Except 5/64 in. and 3/32 in.
Inside Diameter	Part Number			
5/8 in.	0558001599	1/8 in. Recess	Copper	Flush
5/8 in.	0558001600	1/4 in. Recess	Copper	Flush
5/8 in.	0558001598	Flush	Copper	1/8 in. Stick Out
5/8 in.	0558001601	1/8 in. Stick Out	Copper	1/4 in. Stick Out
Heavy Duty Tip/Nozzle Adaptor				
Tip/Adaptor	0558001888			

All tips are the medium length to give these relationships.



Mig Guns

Water-Cooled ST-16/ST-21/ST-21M

- Rated at 600 Amps with any shielding gas
- Handles flux cored wires to 7/64 in.
- ST-21M has an in-line body style designed for mechanized applications



ST-21



ST-16

ST-21M

Specifications

	ST-16	ST-21	ST-21M
Gun Capacity	600 A, 100% duty cycle	600 A, 100% duty cycle	600 A, 100% duty cycle
Dimensions			
Length	13 3/4 in. (350 mm)	12 1/2 in. (315 mm)	10 1/4 in. (260 mm)
Height	4 1/4 in. (110 mm)	7 1/16 in. (180 mm)	
Handle Diameter	1 3/8 in. (35 mm)	1 3/8 in. (35 mm)	1 3/8 in. (35 mm)
Gun Angle	55°	180°	180°
Weight (less service lines)	28 oz. (794 g)	38 oz. (1077 g)	28 oz. (794 g)
Cooling Requirements (minimum)	1.6 qt./min. (1.5 l/min.)	1.6 qt./min. (1.5 l/min.)	1.6 qt./min. (1.5 l/min.)
Wires Accommodated			
Hard	.030-3/32 in. (0.8-2.4 mm)	.030-3/32 in. (0.8-2.4 mm)	.030-3/32 in. (0.8-2.4 mm)
Soft	.035-3/32 in. (0.9-2.4 mm)	.035-3/32 in. (0.9-2.4 mm)	.035-3/32 in. (0.9-2.4 mm)
Cored	.030-7/64 in. (0.8-2.8 mm)	.030-7/64 in. (0.8-2.8 mm)	.030-7/64 in. (0.8-2.8 mm)

Ordering Information

These guns do not include liner/conduits, contact tips/tubes or nozzles. Select the accessories listed in Tables under Mig Gun Accessories to customize a gun that is just right for your job.

ST-16, 10 ft. (3.0 m) 997498
 ST-21, 12 ft. (3.6 m) 995950
 ST-21M, 2 ft. (0.6 m) 690509

Options / Accessories

Spatter Liner 633603
 Centering Bushing 17782
 EH-10A Mech. Gun Mounting Bracket (ST-21M) 633885
 EH-10A Connection Block Assy (ST-21M) 58V74
 ST-16/21 Outlet Adapter for DuraDrives 0588000995
 Power Cable Adaptor 45V11
 Gas Meter (measures gas flow at the gun) 19043

Instruction Manuals

ST-16 F-11-744
 ST-21 F-12-218
 ST-21M F-11-964
 Product Data Page ARC-23218

Mig Guns Accessories

Water-Cooled ST-16/ST-21/ST-21M



MIG Gun Consumables and Wear Parts

ST-16 / 21/ 21M Contact Tips and Tubes for Water-Cooled Mig Guns

Wire Size	Inside Diameter	Contact Tips		Contact Tubes
		Short	Long	
.030 in. (0.8 mm)	0.037	632791	20123	–
.035 in. (0.9 mm)	0.043	632793	632794	996104
.045 in. (1.2 mm)	0.054	37278	37279	37280
3/64 in. (1.2 mm)	0.058	–	–	996105
3/64 in. (1.2 mm)	0.061	632795	632796	–
.052 in. (1.4 mm)	0.062	–	–	996816
1/16 in. (1.6 mm)	0.073	–	37282	37283
1/16 in. (1.6 mm)	0.078	632797	632798	996106
5/64 in. (2.0 mm)	0.094	–	–	996107
3/32 in. (2.4 mm)	0.107	632800	–	996108
7/64 in. (2.8 mm)	0.123	633611	–	–

Gas Nozzles for Water-Cooled Mig Guns

Nozzle Size	Inside Diameter	ST-16 / 21/21M
8	1/2 in.	598739*
10	5/8 in.	598721*
10 Long	5/8 in.	598891*
12	3/4 in.	633985
12 Medium	3/4 in.	997310
12 Long	3/4 in.	639756
12 Spot	3/4 in.	993757

*Requires Spatter Liner 633603

Conduits and Liners for ST-16/21 Water-Cooled Mig Guns

Wire Size	Hard and Flux-Cored Wire			Aluminum		
	10ft. Conduit	ST-16 Jumper Liner	ST-21 Jumper Liner	10 ft. Conduit	ST-16 Jumper Liner	ST-21 Jumper Liner
.030 in. (0.8 mm)	633455	993822	–	–	–	–
.035 in. (0.9 mm)	633455	993822	–	633578	636877*	–
.045 in. (1.2 mm)	633456	993823	995951	–	–	–
3/64 in. (1.2 mm)	–	–	–	633578	636877*	995953
.052 in. (1.4 mm)	633456	993823	995951	–	–	–
1/16 in. (1.6 mm)	633456	993823	995951	634777	636879	995953
5/64 in. (2.0 mm)	598806	993823	995952	–	–	–
3/32 in. (2.4 mm)	598922	598927	995952	46V68	994552	995954

*Requires Support Liner 598927

Conduits and Liners for ST-21M Water-Cooled Mig Guns*

Wire Size	Hard and Flux-Cored Wire			Aluminum			Conduit Liner
	4 ft.	6 ft.	10 ft.	4 ft.	6 ft.	10 ft.	
.045 in. (1.2 mm)	38V86	39V99	40V18	–	–	–	–
3/64 in. (1.2 mm)	–	–	–	38V89	40V01	–	42V74
.052 in. (1.4 mm)	38V86	39V99	40V18	–	–	–	–
1/16 in. (1.6 mm)	38V86	39V99	40V18	39V80	39V83	40V20	42V75
5/64 in. (2.0 mm)	38V89	40V01	–	–	–	–	–
3/32 in. (2.4 mm)	39V80	39V83	40V20	39V80	39V83	40V20	42V73
7/64 in. (2.8 mm)	39V80	39V83	40V20	–	–	–	–

* ST-21M requires bracket (P/N 633885) and adaptor (P/N 61N59) for use with the above conduits when mounting away from feeder. Refer to torch manuals for specific accessories required to install on wire feeder (available online at www.esabna.com)



Mig Spool Gun Packages

ST-23A Spool Gun

- Rugged 250 Amp, 100% duty cycle performance
- Service lines enter the rear of gun instead of handle for improved balance and accessibility
- Inching pushbutton mounted on bottom of handle
- 30 ft. service lines

ST-23A

- Designed for use with Migmaster Compacts
- Weighs less than 3 lbs.
- Uses durable contact tips and nozzles
- Powerful gear motor in handle pulls welding wire from 4 in. diameter spool in the molded gun case
- Partial depression of the torch trigger controls gas pre- and post-flow operations - full depression provides wire feeding as well as gas flow
- Wire feed control mounted on gun provides precise adjustment of wire feed rate at torch



Ordering Information

ST-23A Spool Gun - Includes one 3/64 in. contact tip, drive roll, liner, control cable, gas hose and #10 nozzle and 30 ft. service lines19164

Options / Accessories

- Zippered Hose Sheath**
25 ft. for gun service line protection35454
- ST-23A Control Cable Extension** Extends spool gun control cable by 30 ft. (9.1 m)636968
- ST-23A Power Cable / Gas Hose Extension** - Includes coupling 11N19 for extending 30 ft. (9.1 m)15626
- ST-23A to MultiMaster Adaptor** - This would also fit MigMaster 203, 253's, 215, 280 PRO37301
- ST-23 Feed Roll**
.030-.035 in. (.8-.9 mm)636343
.045-.062 in. (1.2-1.6 mm) 996112*
- Torch Liner**
.045-.062 in. (1.2-1.6 mm) 19167*
.030-.035 in. (.8-.9 mm)19166
- Contact Tips see Accessories page
Nozzles see Accessories page
*As delivered.

Mig Spool Gun Packages



MT-250 SG

- Designed for use with the Migmaster Compacts
- Weighs less than 3 lbs.
- Uses durable MT contact tips and nozzles
- Powerful gear motor in handle pulls welding wire from 4 in. diameter spool in the molded gun case
- Partial depression of the torch trigger controls gas pre- and post-flow operations - full depression provides wire feeding as well as gas flow
- Wire feed control mounted on gun provides precise adjustment of wire feed rate at torch



MT-250 SG Spool Gun

- Medium-duty 200 Amp, 100% duty performance
- Spool holder adjusts to balance in the operator's hand
- 25 ft. service lines

Ordering Information

MT-250 SG Spool Gun - Includes three 3/64 in. contact tips, drive roll, liner, control cable, gas hose and #10 nozzle and 25 ft. service lines36779

Options / Accessories

MT-250 SG

Zippered Hose Sheath

25 ft. for gun service line protection35454

Gun Extension Lines

Gas Hose Assembly, 25 ft. 34V38

Coupling, Gas Hose (5/8 in. - 18 in.) 11N17

Replacement power hose/gas hose, 25 ft.0558002476

Quick Connector

Male #2 - 1/013733936

Female #2 - 1/013735632

Gas Meter (measures gas flow at the gun)19043

Feed Roll .030-3/64 in. Soft wire(.8-1.2 mm) *36866

Feed Roll Knurled .030-.045 in. Hard wire(.8-1.2 mm)36867

Inlet Guide Liner .030-3/64 in. (.8-1.2 mm) Gray36869

Barrel Liner .030-3/64 in. (.8-1.2 mm) White36871

Contact Tips see Accessories page

Nozzles see Accessories page



Mig Spool Gun

Accessories

ST-23A, MT-250SG Spool Guns

Contact Tips

Wire Size	Inside Diameter	Short	Contact Tips		
			**Standard Duty Medium	Long	**Heavy Duty Medium
.023 in. (0.6mm)	0.031	–	20543	999742	–
.030 in. (0.8mm)	0.037	–	20544	996994	0558002367
.030 in. (Notched)	0.043	–	36884	–	–
.035 in. (0.9mm)	0.043	–	996995	996996	0558002368
.035 in. (Notched)	0.048	–	36885	–	–
.040 in. (1.0mm)	0.048	–	37287	37288	0558002369
.045 in. (1.2mm)	0.054	999578	37290	996998	37286
3/64 in. (Notched)	0.060	–	36886†	–	–
3/64 in. (1.2mm)	0.058	–	996999‡	–	17765

*Requires Tip Adapter 17983

**Requires Tip Adapter 17984

‡Included with ST-23A

†Included with MT-250SG

Nozzles

Size	Inside Diameter	Standard Duty	Heavy Duty
6	3/8 in. (10mm)	998895	–
8	1/2 in. (13mm)	998893	–
8 HD	1/2 in. (13mm)	–	999471
10	5/8 in. (16mm)	998894	–
10 HD	5/8 in. (16mm)	–	999472**
12 HD	3/4 in. (20mm)	–	999473
12 Spot	3/4 in. (20mm)	–	999625

** Included with ST-23A and MT-250SG

Mig Gun PP36 Plus

MIG/MAG Torch with wire feed speed control



- Improved 42 VDC motor for more torque and constant, trouble-free feeding
- Improved drive-roll system for soft or difficult wires
- Improved gas seal for long distance arc shielding
- Air cooled 300A CO₂, 280A mixed gases, 60% duty cycle
- Optimum torch cooling – high endurance
- Time-saving torch neck replacement utilizes central plug system
- Robust construction for durability and extended torch life
- 3-piece combined cable assembly for better flexibility – especially for long distances
- Options available to use with most ESAB 42 VDC wire feeding systems with wire feed speed control at torch
- Optional 9" extended 180° and 45° swiveling necks for hard to reach joints

Ordering Information

PP36 Plus Gas-Cooled

Gun assemblies include standard neck, 3/64 in. drive roll, liners, HD 8mm contact tip, short tip holder and 5/8 in. nozzle
23 pin control plug (for MA23/24, U6, U8₂ feeders) stocked

180° neck

15 ft.	0558101453
25 ft.	0558101455

45° neck

15 ft.	0558101454
25 ft.	0558101456

10 pin control plug (for MA6, U6, U8 feeders that use 0558004301 Push-Pull module installed for Python only, sold before 3/11/2011)

180° neck

15 ft.	0558101457
25 ft.	0558101459

45° neck

15 ft.	0558101458
25 ft.	0558101460

2 pin control plug (for Mig-4HD sold with Mig-41A before 3/8/2011)

180° neck

15 ft.	0558101461
25 ft.	0558101463

45° neck

15 ft.	0558101462
25 ft.	0558101464



Shown with extended 45° 9 in. neck option

Specifications

PP 36	
Gun Capacity*	
Air-Cooled	300 A, CO ₂
Mixed Gases	280 A, 60% duty cycle
Dimensions	
Length	6 3/8 in. (16.9 cm)
Length (Standard Neck)	6 in. (15.24 cm)
Length (Extended Neck)	9 in. (22.86 cm)
Length (Body and Cable Support)	7 in. (17.8 cm)
Height	7 3/8 in. (187 mm)
Handle Diameter	1 3/8 in. (3.49 cm)
Weight (less service lines)	2.2 lbs. (1 kg)
Water Cooling Requirements	.4 gal./min. (1.5 l/min.)
Wires Accommodated	
.030 in. (0.8 mm)	.035 in. (0.9 mm)
.040 in. (1.0 mm)	.045 in. (1.2 mm)
3/64 in. (1.6 mm)	.062 in.
1/16	

*Rated using power source with VDE standard volt/amp characteristic ($V=14V+0.05xA$). When pulse MIG welding, reduce rating by 35%. This applies to any MIG torch.

Instruction Manual 0558011520
Product Data Page ARC-23291



Mig Gun PP36 Plus

MIG/MAG Torch with wire feed speed control

Consumables and Accessories

Gun assemblies include standard neck, 3/64 in. drive roll, liners, HD 8 mm contact tip, short tip holder and 5/8 in. nozzle

Necks (require liner, tip holder, tip and nozzle)

Extended

45° 9 in. neck	0558101465
180° 9 in. neck	0558101466

Standard

180° 6 in. neck	0558101467
45° 6 in. neck	0558101468

Replacement neck inlet guide.....0558101469

Neck liners (length of neck and wire size used)

Extended 45° 9 in. neck, 10.71 in. lg. (272 mm)

Orange .030 in. - .045 in.	0558101505
Blue .052 in. - .062 in.	0558101507

Extended 180° 9 in. neck, 8.62 in. lg. (219 mm)

Orange .030 in. - .045 in.	0558101504
Blue .052 in. - .062 in.	0558101506

Standard 180° 6 in. neck, 5.63 in. lg. (143 mm)

Orange .030 in. - .045 in.	0558101500
Blue .052 in. - .062 in.	0558101502

Standard 45° 6 in. neck, 7.80 in. lg. (198 mm)

Orange .030 in. - .045 in.	0558101501
Blue .052 in. - .062 in.	0558101503

Tip Holders and Diffusor (spray arc, short arc and tip size)

Gas Diffusor.....0558101470

Holder Tip

M8 Spray Arc, standard, short	0558101471
M8 Short Arc, long	0558101472
M6 Spray Arc, short	0558101473
M6 Short Arc, long	0558101474

Contact Tips (wire size, type and tip size)

M8

.030 in. Aluminum	0558101475
.035 in. Aluminum	0558101476
.040 in. Aluminum	0558101477
3/64 in. Aluminum, standard	0558101478
1/16 in. Aluminum	0558101479
.030 in. Hard Wire	0558101480
.035 in. Hard Wire	0558101481
.040 in. Hard Wire	0558101482
3/64 in. Hard Wire	0558101483
1/16 in. Hard Wire	0558101484

M6

.030 in. Aluminum	0558101485
.035 in. Aluminum	0558101486
.040 in. Aluminum	0558101487
3/64 in. Aluminum	0558101488
1/16 in. Aluminum	0558101489
.030 in. Hard Wire	0558101490
.035 in. Hard Wire	0558101491
.040 in. Hard Wire	0558101492
3/64 in. Hard Wire	0558101493
1/16 in. Hard Wire	0558101494

Nozzles

Cylindrical 3/4 in.	0558101495
Conical 5/8 in. Standard	0558101496
Conical Small 1/2 in.	0558101497
Conical Heavy Duty 5/8 in.	0558101498
Spot Weld 3/4 in.	0558101499

Conduit Liners (wire size and type)

Aluminum

Hi-Life .030 - 3/64 in. 17 ft. Standard.	0558101515
Hi-Life .030 - 3/64 in. 28 ft. Standard.	0558101516
Hi-Life .052 - 1/16 in. 17 ft.	0558101517
Hi-Life .052 - 1/16 in. 28 ft.	0558101518

Hard Wire

.024 in. - .030 in. 17 ft.	0558101510
.035 in. - .045 in. 17 ft.	0558101511
.035 in. - .045 in. 28 ft.	0558101512
.052 in. - .062 in. 17 ft.	0558101513
.052 in. - .062 in. 28 ft.	0558101514

Stainless Steel

C-TFE .024 in. - .030 in. 17 ft.	0558101519
C-TFE .024 in. - .030 in. 28 ft.	0558101520
C-TFE .035 in. - .045 in. 17 ft.	0558101521
C-TFE .035 in. - .045 in. 28 ft.	0558101522
C-TFE .052 in. - .062 in. 17 ft.	0558101523
C-TFE .052 in. - .062 in. 28 ft.	0558101524

Liner Support Tube 44mm (required for above)....0558001542

Drive Rolls (wire size)

.030 in. (0.8 mm)	0558101530
.035 in. (0.9 mm)	0558101531
.040 in. (1.0 mm)	0558101532
3/64 in. (1.2 mm), Standard	0558101533
1/16 in. (1.6 mm)	0558101534

Replacement Pressure Roll Assembly.....0558101557

Wire Feeder Accessories

Required to Connect PP36 Plus

CAN Controlled Wire Feeders (MA23, MA24, U6, U82)

Adapter Kit with Wire Feed Speed Control

(requires 1 and 2).....0459681881

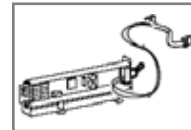
CAN / Analog Wire Feeders (MA23, MA24, U6, U82)

Adapter Kit without Wire Feed Speed Control

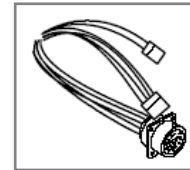
(requires only 2).....0459020883

CAN/Analog Wire Feeders (M12, MA23, MA24, U6, U82)

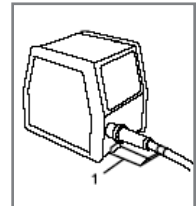
Torch Strain Relief, use is recommended¹.....0457341881



1



2



1

Feed Rolls and Guides for Aristo and Origo Feed 3004 for Aluminum Wire

Center Guides (1 required)	
0.030 in. / 0.035 in.	0558007171
3/64 in.	0558007172
1/16 in.	0558007173
Outlet Guides (1 required)	
0.030 in. / 0.035 in.	0558006891
3/64 in.	0558006892
1/16 in.	0558006893
Feed Rolls (4 required)	
0.035 in. / 3/64 in., Polished	0558007835
3/64 in. / 1/16 in., Polished	0558007836

Origo™ Arc 410c/650c

Heavy Duty MMA/TIG/CAC-A

3 Phase DC CC **3 YEAR WARRANTY** 100% GUARANTEE



- Best for cellulosic electrodes
- Outstanding welding characteristics – efficient and high-quality welding
- Wide current and voltage range – multi-purpose applications
- Mains voltage compensation – stable welding controls
- Stepless current control – exact settings with optional remote control
- Hot start, arc force, and anti-stick
- Digital V / A meter
- Optional wheel kit is available



Units shown with optional wheel kit.

The Origo Arc 410c and 650c are sturdy and robust switching converter (chopper) power sources intended for manual heavy-duty MMA welding with coated electrodes, TIG welding, and air carbon arc gouging. The machines are built with proven technology, so you can count on the highest level of reliability and outstanding welding performance. In addition, Origo Arc's strong metal housing makes for ideal use in harsh industrial environments.

Easy to use

The wide current range of the Origo Arc makes it easy to optimize settings – allowing the machine to be used with an extensive range of filler materials. These units are equipped with functions such as hot start, arc force, and anti-stick. It is also possible to adjust parameters during welding process.

Flexibility

The units have vertical static characteristics, which means that regardless of cable length and arc voltage, the current remains constant. The dynamic characteristics of the Origo Arc range ensure a stable, spatter-free arc, and an easily controlled molten pool.

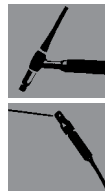
High performance

Due to the high power factor, energy consumption is low, and installation costs can be kept to a minimum. The welding properties of the Origo Arc units are configured to meet the requirements of welding with cellulosic electrodes. The arc is very flexible when starting from the lowest currents. When the arc is shortened, arc force makes weld penetration easier – especially when the electrode is pressed against the welded material.

In control

The Origo Arc 410c and 650c are equipped with the A12 control panel. The A12 is a full-featured control panel with a V/A instrument and a receiver for wireless current setting. As an option, the Origo Arc range can be equipped with remote control. The units are switched off automatically in case of overheating.

Tig / Stick
Power Sources



Origo™ Arc 410c/650c

Heavy Duty MMA/TIG/CAC-A

Specifications

	Origo Arc 410c	Origo Arc 650c
Input voltage	230/460 V 3 ph 60 Hz	230/460 V 3 ph 60 Hz
Permitted load at 35% duty cycle	400 A/36 V	650 A/44 V
Permitted load at 60% duty cycle	310 A/33 V	490 A/40 V
Permitted load at 100% duty cycle	240 A/30 V	400 A/36 V
Primary current at 35% duty cycle	54 A/28 A	109 A/57 A
Primary current at 60% duty cycle	38 A/20 A	69 A/36 A
Primary current at 100% duty cycle	27 A/14 A	57 A/30 A
Setting range (DC)	20 A/20 V–400 A/36 V	20 A/20 V–650 A/44 V
Open circuit voltage	53–70 V	53–70 V
Open circuit power	390 W	510 W
Power factor at maximum current	0.90	0.90
Efficiency at maximum current	74%	77%
Dimensions L x W x H	51.5 x 31.5 x 30.7 in. (1310 x 800 x 780 mm)	51.5 x 31.5 x 30.7 in. (1310 x 800 x 780 mm)
Weight	346 lb (157 kg)	491 lb (223 kg)
Operating temperature	14 to 104°F (-10 to +40°C)	14 to 104°F (-10 to +40°C)
Enclosure class	IP 23	IP 23

Ordering Information

Origo Arc

410c, A12 0349312420
 650c, A12 0349312430

Accessories

Remote Controls

N02 wireless 0349304617
 MMA 1 32.8 ft. (10 m) 0349501024
 AT1 0459491896
 AT1 CoarseFine 0459491897

Wheel kit 0349312090

Remote connection cables

16.4 ft. (5 m) analog 12 pole 0459552880
 32.8 ft. (10 m) analog 12 pole 0459552881
 49.2 ft. (15 m) analog 12 pole 0459552882
 82.0 ft. (25 m) analog 12 pole 0459552883

Welding and work cables

Welding cable 5m OKC95 500A 0700006894
 Return cable 5m OKC95 500A 0700006895



MiniArc® 161LTS

Power Source



- The MiniArc 161 Automatic Primary Select operates on either 115 or 230 VAC and will automatically configure to the primary input supplied
- Fixed hot start - allows the operator to easily strike an arc without the electrode sticking to the plate
- Fixed arc force - allows the operator to get deeper penetration into the plate without the electrode sticking to the plate
- Lift arc tig gives you the luxury of lifting the tungsten as opposed to traditional scratch starting which can deposit tungsten into the plate resulting in contamination
- Able to use cellulosic 6010 electrodes with ease
- 18 Pound weight - Makes this unit portable and easy to carry directly to the job
- Comes with a shoulder strap
- Includes 10 ft. work cable with clamp, 10 ft. welding cable with electrode holder
- Thermal indicator prevents the machine from becoming damaged if airflow is blocked or from exceeding the duty cycle
- Simple interface - amperage knob, stick/TIG switch and on/off switch on front panel of unit
- Small and portable, inverter based
- 5 to 160 Amps current range for DC Welding



Specifications

	MiniArc 161LTS
Input Voltage	115/230 VAC, 1 ph., 60 Hz
Voltage Tolerance	+/- 15%
115V Operating Data	
Output Range (Stick)	5 A/110 A
Stick Duty Cycle / Rated Output	110 A/24.4 V@35% 60 A/22.4 V@100%
Output Range (Lift Tig)	5 A/110 A
Lift TIG Duty Cycle / Rated Output	110 A/14.4 V@35% 60 A/12.4 V@100%
Primary Current	
100% Duty Cycle	19 A Stick/10.5 A Tig
35% Duty Cycle	32.5 A Stick/22.5 A Tig
Open Circuit Voltage (max)	80 V Stick/15 V Tig
230V Operating Data	
Output Range (Stick)	5 A/110 A
Stick Duty Cycle / Rated Output	160 A/26.4 V@35% 88 A/23.5 V@100%
Output Range (Lift Tig)	5 A/160 A
Lift TIG Duty Cycle /Rated Output	160 A/16.4 V@35% 88 A/16.4 V@100%
Primary Current	
100% Duty Cycle	14.5 A Stick/8.4 A Tig
35% Duty Cycle	28.5 A Stick/18.5 A Tig
Open Circuit Voltage (max)	80 V Stick/ 15 V Tig
Efficiency	80%
Power Factor	.73
Net Weight	18 lbs. (8 kg)
Dimensions W x L x H	5.75 x 15.75 x 10 in. (146 x 400 x 255 mm)

Ordering Information

MiniArc 161LTS, Stick Package0558101694
Includes power source with 10 ft. power cord, 115V/230 input power adapter cable, 10 ft. heavy duty ground cable and clamp, 10 ft, heavy duty electrode holder and cable and sample pack of ESAB electrodes.

MiniArc 161LTS, Tig Package0558101699
Includes power source with 10 ft. power cord, 115V/230 input power adapter cable, 10 ft. heavy duty ground cable and clamp, 10 ft, heavy duty electrode holder and cable and sample pack of ESAB electrodes, HW-17FV torch, R33 reg/flowmeter and TIG accessory kit.

Options / Accessories

Welding cable 200A, 16 ft. OKC 25.....0700006882
Return cable 200A, 16 ft. OKC 25.....0700006883
Tig Torch, 17FV, 20 ft. w/accessory kit0558101723
R33-FM580 Regulator/Flowmeter.....21557
TIG torch accessory kit999126

Tig / Stick
Power Sources



Caddy™ Arc 201i

Power Source

1Phase DC CC 3 YEAR WARRANTY 100% SATISFACTION GUARANTEE

- Fifth generation Caddy™ features advanced inverter technology built in – deliver unparalleled performance in a rugged, portable package
- Adjustable hot start makes it easy to strike the electrode – avoids starting problems
- Adjustable arc force sets the intensity of the arc – improves weld quality
- ArcPlus™ II improves welding characteristics and simplifies work – produces better weld quality with less clean up
- Equipped with large OKC 50 cable connectors – for greater durability
- Features compact design with impact resistant polymer and aluminum casing – makes the unit lightweight and easy to carry
- Small size does not compromise vital cooling of internal components
- Large heat sinks and innovative design make this Caddy™ machine run cooler – promotes longer machine life even when used in harsh environments
- Designed to keep sensitive interior parts clean and dust free
- Built in accordance with IP23 for outdoor use, even in wet-weather conditions – makes this machine ideal for on-site work
- Equipped with a PFC (Power Factor Correction) circuit – allows the machine to perform a full range of functions on a 16 A fuse, protects against fluctuating mains voltage, and makes it safer to use with a generator
- Operates with extra long mains cables – expands working radius



Control Panel

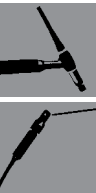
The advanced Caddy™ A33 features a digital display panel with hot-start and arc force control for fine tuning, MMA or TIG selection, LiveTig™ start, two memory settings and remote control.

MMA and ArcPlus™ II

Caddy™ Arc supplies direct current and allows you to weld most metals including alloy and non alloy steel, stainless steel and cast iron. The Caddy™ Arc 201i welds electrodes up to 5/32" diameter.

TIG Welding

To TIG weld with the Caddy™ Arc, all you need is a TIG torch with a gas valve, gas regulator and cylinder of gas. The Caddy™ A33 control panel provides Live Tig™ start for electronic control of the start current. You can weld mild steel or stainless steel with or without filler material.



Caddy™ Arc 201i

Power Source



Ordering Information

Caddy™ Arc 201i, A 33 package 0460445884
 Packages include 10 ft. (3m) MMA welding and return cable kit
 with “screw” type electrode holder

Options

Shoulder Strap 0460265003
2 Wheel Trolley
 Small gas bottle 0459366885
 Gas bottle on side 0460330880
Remote Controls
 MMA 1, 33 ft. (10 m) cable 0349501024
 AT 1 0459491896
 AT1 CoarseFine 0459491897

Connection cables for AT1 and AT1 CoarseFine

16.5 ft. (5 m) cable 0459552880
 33 ft. (10 m) cable 0459552881
 49 ft. (15 m) cable 0459552882
 82 ft. (25 m) cable 0459552883

Remote Foot Control*

25 ft. cable 0558008905

TIG torch TXH™ OKC50

150V, 13 ft. (4 m) 0460011843
 150V, 26 ft. (8 m) 0460011883
 200V, 13 ft. (4 m) 0460012841
 200V, 26 ft. (8 m) 0460012881

TIG torch Remote 25 ft.* 0558008904

* Remotes for use with A33 models only.

Specifications

	Caddy™ Arc 201i
Input Voltage	230/1ph 50/60 Hz
Fuse (slow), A	16
Recommended generator size, kVA	12
Permitted load at 104°F (40°C), MMA	
25% duty cycle, A/V	170/26.8
60% duty cycle, A/V	130/25.2
100% duty cycle A/V	110/24.4
Permitted load at 104°F (40°C), TIG	
25% duty cycle, A/V	220/18.8
60% duty cycle, A/V	150/16.0
100% duty cycle A/V	140/15.6
Setting range MMA (A33), A	4-170
Setting range TIG (A33), A	3-220
Open circuit voltage (A33), V	72
Power factor at max. current	0.99
Efficiency at max. current	81
Dimensions L x W x H	16.46 x 7.40 x 8.19 in. (418 x 188 x 208 mm)
Weight	18.30 lbs (8.3 kg)
Enclosure class	IP 23

Tig / Stick
Power Sources



Caddy™ Tig 2200i

Power Source

1Phase DC CC  100% 

- Fifth generation Caddy machines feature advanced inverter technology built in – deliver unparalleled performance in a rugged, portable package
- Designed for quality TIG welding with a variety of metals
- Extremely easy to use – all welding parameters displayed in an easy-to-understand format
- ESAB 2-Program function (TA34) – allows pre-programming and program changes during welding
- Pulsed TIG feature (TA34) – for greater control of heat input and weld pool
- Micro Pulse (TA34) – minimizes area affected by heat, particularly when working with thin metals
- ArcPlus™ II (TA34) improves welding characteristics and simplifies work – produces better weld quality with less clean up
- Hot start and Arc force settings (with TA34) – create true MMA welding characteristics
- Equipped with large OKC 50 cable connectors – for greater durability
- Compact design with impact resistant polymer and aluminum casing – makes unit lightweight and easy to carry
- Small size does not compromise vital cooling of internal components
- Large heat sinks and innovative design make these Caddy machines run cooler – promotes longer machine life even when used in harsh environments
- Designed to keep sensitive interior parts clean and dust free
- Built in accordance with IP23 for outdoor use, even in wet-weather conditions – makes machine ideal for on-site work
- Equipped with a PFC (Power Factor Correction) circuit – allows the machine to perform a full range of functions on a 16 A fuse, protects against fluctuating input voltage, and makes it safer to use with a generator



The TA34 panel also includes dual memory settings, switchable from the panel or torch trigger, and the capacity to set slope up/down and post-gas.

The control panel of the Caddy™ Tig TA33 simplifies TIG welding. All you do is set the plate thickness, and the machine does the rest, making it easy to produce quality TIG welds. Welding current, slope down and post-gas can be manually controlled.

Control Panels

Two control panel options are available – both with all functions required for TIG (DC), with HF-start or LiftArc™, and MMA welding. The Caddy™ Tig TA34 features an advanced control panel with Pulsed TIG, which provides better control of the heat input, and Micro Pulse, which allows pulse time settings down 0.001 seconds.

MMA with ArcPlus™ II

Caddy™ Tig supplies direct current and allows you to weld most metals including alloy and non alloy steel, stainless steel and cast iron. The Caddy™ Tig 2200i welds electrodes up to 5/32" diameter.



Caddy™ Tig 2200i

Power Source



Specifications

	Caddy™ Tig 2200i
Input Voltage	230/1 ph. 50/60Hz
Fuse (slow), A	16
Recommended generator size, kVA	12
Permitted load at 40°C (104°F),	TIG
25% duty cycle, A/V	220/18.8
60% duty cycle, A/V	150/16
100% duty cycle A/V	110/14.4
Permitted load at 40°C (104°F),	MMA
25% duty cycle, A/V	170/26.8
60% duty cycle, A/V	130/25.2
100% duty cycle A/V	110/24.4
Setting range TIG (DC), A	3-220
Setting range MMA (DC), A	4-170
Open circuit voltage, V	72 V
Power factor at max. current (TIG)	0.99
Power factor at max. current (MMA)	0.99
Efficiency at max. current (TIG)	75%
Efficiency at max. current (MMA)	81%
Dimensions L x W x H	16.46 x 7.40 x 8.19 in. (418 x 188 x 208 mm)
Weight	20.72 lbs (9.4kg)
Enclosure class	IP23

Control Panels

	TA34	TA33
Slope up, sec	0-10	0-9.9*
Slope down, sec	0-10	0-10
Gas pre-flow*, sec	0-5	0-5
Gas post-flow, sec	0-25	0-25
Pulse, background time, sec	0.01-2.5	-
MicroPulse* time, sec	0.001-0.250	-
Frequency AC, Hz	10-152	65
AC balance, %	50-98	70
Plate thickness setting	-	(0.1 – 7.3mm) (0.004-0.287in.)

*Hidden functions

Ordering Information

Caddy™ Tig 2200i, TA34 package with TXH™ 200

13 ft. (4 m) TIG torch 0460450883

Packages include 10 ft. (3 m) of mains cable, no plug, 5 ft.

(1.5 m) of gas hose with 2 hose clamps, 10 ft. (3m) return cable with work clamp and a 10 ft. MMA cable.

To complete a ready-to-weld package, order from the following:

R33-FM-580-HB 0558005172

Choose one accessory kit to match the TXH torch:

Accessory Kit

TXH150 999126

TXH200 999126

TXH250 999127

Options

Shoulder Strap 0460265003

2 Wheel Trolley

Small gas bottle 0459366885

Gas bottle on side 0460330880

Remote Controls

AT 1 CAN 0459491883

AT1 CoarseFine CAN 0459491884

MTA1 CAN 0459491880

Foot Pedal T1 CAN, with 16.5 ft. (5m) cable 0460315880

Connection cables for Remote Controls

16.5 ft. (5 m) CAN 0459554880

33 ft. (10 m) CAN 0459554881

49 ft. (15 m) CAN 0459554882

82 ft. (25 m) CAN 0459554883

TIG Torches TXH™ OKC50

200, 13 ft. (4m) 0460012840

200f, 13 ft. (4m) 0460012842

200r, 13 ft. (4m)* 0462012840

200fr, 13 ft. (4m)* 0462012842

Remote Adapter Kit, (required for*)

Includes holder for remote models 0459491912



TIG torch holder 0760022400

Tig / Stick
Power Sources



Caddy™ Tig 2200i AC/DC

Power Source

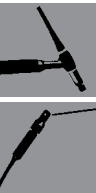
1 Phase DC CC 3 YEAR WARRANTY 100% SATISFACTION GUARANTEE

- Unparalleled performance in a mobile machine for a wide range of TIG and Stick welding applications
- Designed for quality TIG welding with all types of metals
- Extremely easy to use – all welding parameters displayed in an easy-to-understand format
- Innovative QWave™ feature – enables AC welding with exceptional arc stability and low noise
- AC frequency and balance control – optimizes weld pool
- Electrode preheating – facilitates excellent starts and extends electrode life
- ESAB 2-Program function – allows pre-programming and program changes during welding
- DC Pulsed TIG welding – for easy control of heat input and weld pool
- DC Micro Pulse – minimizes area affected by heat, particularly when working with thin metals
- Hot start, Arc force and polarity switch (DC) – create true MMA (Stick) characteristics in AC and DC mode
- Equipped with large OKC 50 cable connectors – for greater durability
- Features compact design with impact resistant polymer and aluminum casing – makes the unit lightweight and easy to carry
- Small size does not compromise vital cooling of internal components
- Large heat sinks and innovative design make these Caddy™ machines run cooler – promotes longer machine life even when used in harsh environments
- Designed to keep sensitive interior parts clean and dust free
- Built in accordance with IP23 for outdoor use, even in wet-weather conditions – makes this machine ideal for on-site work
- Equipped with a PFC (Power Factor Correction) circuit – allows the machine to perform a full range of functions on a 16 A fuse, protects against fluctuating input voltage, and makes it safer to use with a generator



Control Panel

The Caddy™ Tig TA34 AC/DC features an advanced control panel with Pulse TIG, AC Balance to control arc cleaning and penetration, AC Frequency to control arc width, and a special setting to control electrode preheating for better starts with a variety of electrodes.



Caddy™ Tig 2200i AC/DC

Power Source



Specifications

	Caddy™ Tig 2200i AC/DC
Input Voltage	230/1 ph. 50/60 Hz
Fuse (slow), A	16
Maximum Output	
20% duty cycle, TIG, A/V	220/18.8
60% duty cycle, TIG, A/V	150/16
100% duty cycle TIG, A/V	140/15.6
Setting range TIG AC/DC	3-220A
Setting range MMA	4-160A
Open circuit voltage, V DC	70 V
Power factor at 100%, TIG mode	0.99
Efficiency at 100%, TIG mode	66%
Enclosure class	IP 23
Dimensions L x W x H	16.46 x 7.40 x 13.58 in. (418x188x345mm)
Weight	33.07 lbs (15 kg)
CoolMini water cooling unit	
Cooling capacity, W	700W/0.264 g.p.m. at 104°F (700W/1 l.p.m. at 40°C)
Coolant volume	0.581 gal. (2.2 l)
Maximum flow	0.528 g.p.m. (2.0 l.p.m.)
Maximum pressure, 50/60 Hz	33.4 p.s.i. (2.3 bar)
Weight	9.92/14.77 lbs. (4.5/6.7 kg)
Dimensions L x W x H	16.46 x 7.40 x 5.39 in. (418x188x137mm)

MMC Panel

	TA34 AC/DC
Slope up, sec	0-10
Slope down, sec	0-10
Gas pre-flow*, sec	0-5
Gas post-flow, sec	0-25
Pulse,	
background time, DC, sec	0.01-2.5
MicroPulse* sec	0.001-0.250
Frequency AC, Hz	10-152
AC balance, %	50-98

*Hidden functions

Ordering Information

Caddy™ Tig 2200i AC/DC, TA34 AC/DC
 TXH™ 200 13 ft. Torch, 10ft. MMA Kit 0460150883
 Caddy™ Tig 2200iw AC/DC, TA34 AC/DC TXH™ 250w 13 ft.,
 CoolMini water cooler (includes 2 wheel trolley)
 10ft. MMA Kit 0460150884
 Packages include 10 ft. (3 m) of mains cable, no plug, 5 ft.
 (1.5 m) of gas hose with 2 hose clamps, 10 ft. (3 m) return cable
 with work clamp.
 To complete a ready-to-weld package, order from
 the following:
R33-FM-580-HB 0558005172
 Choose one accessory kit to match the TXH torch:
Accessory Kit
 TXH200 999126
 TXH250 999127

Options

CoolMini cooling unit 0460144880
2 Wheel Trolley
 Small gas bottle 0459366885
 Gas bottle on side 0460330880
Remote Controls
 AT 1 CAN 0459491883
 AT1 CoarseFine CAN 0459491884
 MTA1 CAN 0459491880
 T1 Foot CAN 0460315880
Connection cables for Remote Controls
 16.5 ft. (5 m) CAN 0459554880
 33 ft. (10 m) CAN 0459554881
 49 ft. (15 m) CAN 0459554882
 82 ft. (25 m) CAN 0459554883
TIG Torches TXH OKC50
 250w, 13 ft. (4 m) 0460013840
 250wF, 13 ft. (4 m) 0460013841
 200, 13 ft. (4 m) 0460012840
 200F, 13 ft. (4 m) 0460012842
 250wr, 13 ft. (4 m)* 0462013840
 250wrFr, 13 ft. (4 m)* 0462013841
 200r, 13 ft. (4 m)* 0462012840
 200Fr, 13 ft. (4 m)* 0462012842
Remote Adapter Kit, (required for*)
 Includes holder for remote models 0459491912



TIG torch holder 0760022400



Caddy™

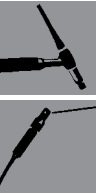
Selection Guide

Selection Guide

Part Number	Description	3m Welding Cable w/Screw Type Holder	3m Return Cable w/Clamp	3m Mains Cable No Plug	Tig Torch	1.5m Gas Hose And 2 Hose Clamps	CoolMini	Trolley	Delivery
0460150883	Caddy Tig 2200i AC/DC, TA34 AC/DC TXH 200 13 ft. Torch, 10 ft. MMA Kit	•	•	•	TXH 200 4m	•			One Box
0460150884	Caddy Tig 2200iw AC/DC, TA24 AC/DC, with Cables, Torch, Cooler and Trolley	•	•	•	TXH 250w 4m	•	•	•	Kit Contains 0460150880 0460013840 0700006900 0460144880 0460330880
0460445884	Caddy Arc 201i, A33 with Cables	•	•	•					One Box
0460450883	Caddy Tig 2200i, TA34 with Cables and Torch	•	•	•	TXH 200 4m	•			One Box



Tig / Stick
Power Sources



TXH™ Air/Water Cooled Torches



- Ergonomic design, user friendly controls at fingertip
- Rugged construction - trouble-free operation with low maintenance
- Flexible heads offer un limited versatility for hard to reach applications (TXH 120F, 150F, 200F and 250F only)
- Effective cooling system
- For use with Caddy Tig and Caddy Arc machines with OKC connectors
- Remote control models available



Ordering Information

Air Cooled Torches - 25mm OKC Connector

Use with HW-17 Consumables

TXH 150, 13 ft.....	0460011840
TXH 150, 26 ft.....	0460011880
TXH 150V, 13 ft.....	0460011841

Use with HW-26 Consumables

TXH 200F, 26 ft.....	0460012882
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Air Cooled Torches - 50mm OKC Connector

Use with HW-9 Consumables

TXH 120, 13 ft.....	0460010842
TXH 120, 26 ft.....	0460010882
TXH 120F, 13 ft.....	0460010844
TXH 120F, 26 ft.....	0460010884

Use with HW-17 Consumables

TXH 150, 13 ft.....	0460011842
TXH 150, 26 ft.....	0460011882
TXH 150V, 13 ft.....	0460011843
TXH 150V, 26 ft.....	0460011883
TXH 150F, 13 ft.....	0460011845
TXH 150F, 26 ft.....	0460011885

Use with HW-26 Consumables

TXH 200, 13 ft.....	0460012840
TXH 200, 26 ft.....	0460012880
TXH 200V, 13 ft.....	0460012841
TXH 200V, 26 ft.....	0460012881
TXH 200F, 13 ft.....	0460012842
TXH 200F, 26 ft.....	0460012882

Air Cooled Torches with Remote Function - 50mm OKC Connector*

Use with HW-9 Consumables

TXH 120r, 13 ft.....	0462010842
TXH 120r, 26 ft.....	0462010882
TXH 120Fr, 13 ft.....	0462010844
TXH 120Fr, 26 ft.....	0462010884

Use with HW-17 Consumables

TXH 150r, 13 ft.....	0462011842
TXH 150Fr, 13 ft.....	0462011845
TXH 150Fr, 26 ft.....	0462011885

Use with HW-26 Consumables

TXH 200r, 13 ft.....	0462012840
TXH 200r, 26 ft.....	0462012880
TXH 200Fr, 26 ft.....	0462012882

Water Cooled Torches - 50mm OKC Connector

Use with HW-20 Consumables

TXH 250w, 13 ft.....	0460013840
TXH 250w, 26 ft.....	0460013880
TXH 250wF, 13 ft.....	0460013841
TXH 250wF, 26 ft.....	0460013881

Use with HW-18 Consumables

TXH 400w, 13 ft.....	0460014840
TXH 400w, 26 ft.....	0460014880
TXH 400w HD, 13 ft.....	0460014841
TXH 400w HD, 26 ft.....	0460014881

Water Cooled Torches with Remote Function - 50mm OKC Connector *

Use with HW-20 Consumables

TXH 250wr, 13 ft.....	0462013840
TXH 250wr, 26 ft.....	0462013880
TXH 250wFr, 13 ft.....	0462013841
TXH 250wFr, 26 ft.....	0462013881

Use with HW-18 Consumables

TXH 400wr, 13 ft.....	0462014840
TXH 400wr, 26 ft.....	0462014880
TXH 400wr HD, 13 ft.....	0462014841
TXH 400wr HD, 13 ft.....	0462014881

F = Flexible head V = Gas valve r = Remote

Note: See Genuine Heliarc Accessories pages for cups, collets, collet bodies

* Requires Remote Adaptor Kit RA T1

Accessories

Remote Adaptor Kit RA T1, for Remote Function torches only

Includes holder and 0,25 m cable

12-pole	0459491912
10-pole	0459491913

Accessory Kits

TXH-150, 200, 400	999126
TXH-120, 250	999127



TIG torch holder0760022400



Genuine Heliarc

Tig Torch Selection Guide

Gas-Cooled Torches

Description	Rating @ 50% Duty Cycle	Hard Body ¹ w/HFC	Silicon Rubber ²	60° Head Angle	70/75° Head Angle	90° Head Angle	180° Head Angle	Flex Head	with valve	without valve	Comments
HW-24	80 A	•		•		•				•	miniature, ultra light torch
HW-90	120 A	•			•		•			•	small, lightweight torch
HW-9	140 A	•			•					•	compact, air-cooled version of HW-20
HW-9RV-2	140 A		•		•				•		separate power cable / gas hose
HW-9RV	140 A		•		•				•		rotary valve
HW-9F	140 A		•					•		•	flexible head version of HW-20A
HW-17	150 A	•		•		•			•	•	rotary valve / sliding valve avail.
HW-17-2	150 A	•		•					•	•	separate power cable / gas hose
HW-17R	150 A		•	•		•			•	•	rotary valve available
HW-17R-2	150 A		•	•					•	•	separate power cable / gas hose
HW-17F	150 A		•					•	•	•	flexible head version
HW-17F-2	150 A		•					•	•	•	separate power cable / gas hose
HW-26	220 A	•			•				•	•	popular heavy duty air-cooled torch
HW-26-2	220 A	•			•				•	•	separate power cable / gas hose
HW-26R	220 A		•		•				•	•	concentric power cable
HW-26R-2	220 A		•		•				•	•	separate power cable / gas hose
HW-26F	220 A		•					•	•	•	flexible head version
HW-26F-2	220 A		•					•	•		separate power cable / gas hose

Water-Cooled Torches

Description	Rating@ 50% Duty Cycle	Hard Body ¹ w/HFC	Silicon Rubber ²	60° Head Angle	70/75° Head Angle	90° Head Angle	180° Head Angle	Flex Head	with valve	without valve	Comments
HW-20	300 A	•			•					•	compact, high current torch
HW-20R	300 A		•		•					•	compact, high current torch
HW-18	425 A	•		•		•				•	general purpose
HW-18R	425 A		•	•						•	general purpose
HW-25F	200 A		•				•	•		•	flexable head, water torch
HW-27	400 A	•					•			•	rear loading machine torch

Hard Body Torches with HFC™ (High temperature Fiber reinforced Composite material) provide the best performance, heat resistance, abrasion resistance, and high frequency resistance.

Rubber bodies provide improved resistance to breakage in rough duty.

ESAB has made a model change on the HW-9 series torches. The new designation for that series of torches is HW-90.

ESAB has made a model change on the HW-20A series torches. The new designation for that series of torches is HW-9.

Old Designation	New Designation
HW-9	HW-90
HW-20A	HW-9
HW-20AR	HW-9R
HW-20AF	HW-9F
HW-20ARV	HW-9RV
HW-20ARV2	HW-9RV2

HW-24 Torch Family - 80 Amp

Gas-Cooled Torches



- Designed to reach into tight places
- Ideal for confined, cramped areas
- High flexibility one-piece cable
- Miniature head provides maximum accessibility to corners and tight joints
- Excellent visibility
- Gas lens available for improved shielding



Specifications

	HW-24
Gun Capacity	75 A, 100% duty cycle ac or dc with standard accessories
	100 A, 100% duty cycle ac or dc with gas lens accessories
	80 A, 50% duty cycle ac or dc with standard accessories
Dimensions	
Length	7 3/4 in. (197 mm)
Length of Head	1 1/16 in. (27 mm)
Diameter of Head	5/8 in. (16 mm)
Head Angle	60 or 90 degree
Handle Diameter	3/4 in. (19 mm)
Weight (less service lines)	2.5 oz. (71 gm)

Ordering Information

Concentric cable

60° head, 12 1/2 ft.	45V17
90° head, 12 1/2 ft.	527712

Cups, Collets and Collet Bodies

Electrode Size		.020	.040	1/16	—
Standard Collet		53N15	53N16	53N14	—
Standard Collet Body		53N17	53N18	53N19	—
Gas Lens Collet		53N62	53N63	53N64	—
Gas Lens Collet Body**		45V41	45V42	45V43	—
Cup Number	.165 in. I.D.	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16
Ceramic Cup	53N23	53N24	53N25	53N27	—
Gas Lens High-Impact Cup	—	53N58	53N59	53N60	53N61

**Also order insulator 53N66



HW-24 Torch Family - 80 Amp

Gas-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	45V16	Body, HW-24 (60°)
	527713	Body, HW-24 (90°)
2	105Z55	Handle, HW-24
3	–	Collet
4	–	Collet Body*
5	–	Gas Cups
6	53N66	Insulator, Gas Lens (Required for gas lens)
7	53N22	Insulator Gasket - Standard
8	–	Gas Lens Collet
9	–	Gas Lens Collet Body
10	–	Gas Lens Cup
11	53N43	Power Cable Adaptor
12	56Y38	Power Cable, 12 ½ ft.

*Note: Order wrench (53N20) for HW-24 collet body.

HW-90 Torch Family - 120 Amp

Gas-Cooled Torches



- HW-90 is designed for small, confined areas where accessibility is the primary concern
- High flexibility one-piece cable
- Available in 60/120 degree heads by exchanging cap and cup. Also available in Pencil style (180 degree)
- Excellent visibility
- Gas lens available for improved shielding



Specifications

	HW-90	
Gun Capacity	110 A, 100% duty cycle ac or dc with standard accessories	
	110 A, 100% duty cycle ac or dc with gas lens accessories	
	120 A, 50% duty cycle ac or dc	
Dimensions	60°	Pencil
Length	6 3/4 in. (171 mm)	7 1/8 in. (181 mm)
Length of Head		
Short Cap	3 1/8 in. (79 mm)	1 1/16 in. (27 mm)
Long Cap	7 1/8 in. (181 mm)	
Diameter of Head	1 9/32 in. (15 mm)	5/8 in. (16 mm)
Head Angle	60/120°	180°
Handle Diameter	3/4 in. (19 mm)	3/4 in. (19 mm)
Weight (less service lines)	3 oz. (84 gm)	5 oz. (140 gm)

Ordering Information

60°

Concentric cable

12 1/2 ft. 16X28

25 ft. 16X44

Pencil

Concentric cable, 12 1/2 ft. 16X47

Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	—
Standard Collet	—	84Z35	84Z33	—
Standard Collet Body	—	105Z27	—	—
Gas Lens Collet Body*	45V41	45V42	45V43	—
Cup Number	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16
High-Impact Cup	14N65	14N66	14N67	—
Gas Lens High-Impact Cup	53N58	53N59	53N60	53N61

* Also order adaptor 45V52 / insulator 53N85

Helarc®
Torches



HW-90 Torch Family - 120 Amp

Gas-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	56Y35	Body, HW-90 (60/120°)
	86Z24	Body, HW-90P (180°)
2	105Z55	Handle, HW-90 / HW-90P
3	56Y40	Long Torch Cap w/o O-Ring (85W49)
4	84Z31	Short Torch Cap w/o O-Ring (85W49)
5	–	Collet
6	85W49	O-Ring
7	105Z27	Collet Body
8	105Z26	Insulator Sleeve
9	–	High-Impact Cup
10	–	Ceramic Cup
11	–	Gas Lens Cup
12	–	Gas Lens Collet Body
13	53N85	Gas Lens Insulator
14	45V52	Gas Lens Adaptor
15	53N43	Power Cable Adaptor
16	56Y38	Power Cable, 12 ½ ft.
	56Y97	Power Cable, 25 ft.

HW-9 Torch Family - 140 Amp

Gas-Cooled Torches



- Compact body provides greater access to weld in confined or restricted areas
- Hard body provides superior heat and abrasion resistance for longest life
- Silicon rubber body provides improved resistance to breakage in rough duty
- Flexible head models provide added versatility for reaching hard-to-get-at applications



Specifications

	HW-9
Gun Capacity	120 A, 100% duty cycle dc
	85 A, 100% duty cycle, ac
	140 A, 50% duty cycle, dc
	100 A, 50% duty cycle, ac
Dimensions	
Length	6 7/8 in. (175 mm)
Length of Head	
Short Cap	2 19/64 in. (58 mm)
Medium Cap	3 3/32 in. (83 mm)
Long Cap	7 5/16 in. (186 mm)
Diameter of Head	3/4 in. (19 mm)
Head Angle	70° HW Variable HW-9F
Handle Diameter	3/4 in. (19 mm)
Weight (less service lines)	3.5 oz. (100 gm)

Ordering Information

Torch Assemblies	HW-9 Hard Body	HW-9R Silicon Rubber	HW-9F Flex Head
70° Head without Gas Value			
1 pc. cable assembly, 12 1/2 ft.	19684	—	19922
1 pc. cable assembly, 25 ft.	19685	—	19923
70° Head with Gas Value			
1 pc. cable assembly, 25 ft.	—	—	19611
2 pc. cable/hose assembly, 12 1/2 ft.	—	34561	—
2 pc. cable/hose assembly, 25 ft.	—	34562	—

Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	3/32	1/8	—
Standard Collet	13N20	13N21	13N22	13N23	13N24	—
Standard Collet Body	13N25	13N26	13N27	13N28	13N29	—
Gas Lens Collet Body	45V41	45V42	45V43	45V44	45V45	—
Cup Number	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16	8 = 1/2	10 = 5/8
High-Impact Cup	13N08	13N09	13N10	13N11	13N12	13N13
Gas Lens High-Impact Cup	53N58	53N59	53N60	53N61	—	—



HW-9 Torch Family - 140 Amp

Gas-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	19686	Body, HW-9
	34563	Body, HW-9RV with Valve (19621)
	9924	Body, HW-9F
	9609	Body, HW-9FV, 125 A Flex Value
2	105Z55R	Ribbed Handle, HW-9 (for rubber torches)
	05Z55	Handle, HW-9 (for flex torches)
3	41V24	Long Torch Cap with O-Ring (181W53)
4	41V33	Short Torch Cap with O-Ring (181W53)
5	41V35	Medium Torch Cap with O-Ring (18W153)
6	53N06	Handle, HW-9 (for hard body torches)
7	598882	Cup Gasket
8	–	Collet
9	–	Collet Body
10	–	Gas Cups
11	–	Gas Lens Collet Body
12	–	Gas Lens Cup
13	105Z57	Power Cable Adaptor
14	997022*	1 pc. Power Cable, 12 ½ ft.
	97023*	1 pc. Power Cable, 25 ft.
15	33946	2 pc. Power Cable/Hose Assembly, 12 ½ ft.
	33947	2 pc. Power Cable/Hose Assembly, 25 ½ ft.
	4651	2 pc. Power Cable Repair Kit (not shown)
	3N42	2 pc. O-Ring Assembly Tool (not shown)

Note: For chamber welding, replace 598882 with gasket 598563 for standard cup; with O-Ring 526185 for gas lens cup

*Optional PVC power cable 57Y01 (12 ½ ft.); 57Y03 (25 ft.)

HW-17 Torch Family - 150 Amp

Gas-Cooled Torches



- Quick release of electrodes
- Hard body provides superior heat and abrasion resistance for longest life
- Silicon rubber body provides improved resistance to breakage in rough duty
- Flexible head models provide added versatility for reaching hard-to-get-at applications



Specifications

HW-17	
Gun Capacity	130 A, 100% duty cycle, ac or dc 150 A, 50% duty cycle, ac or dc with std. accessories
Dimensions	
Length	6 7/8 in. (175 mm)
Length of Head	
Short Cap	3 13/16 in. (97 mm)
Medium Cap	5 1/4 in. (133 mm)
Long Cap	7 7/16 in. (189 mm)
Diameter of Head	5 5/64 in. (20 mm)
Head Angle	60° or 90° HW-17, HW-17R Variable HW-17F
Handle Diameter	3/4 in. (19 mm)
Weight (less service lines)	4.8 oz. (137 gm)

Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	3/32	1/8	—	—	—
Standard Collet	10N21	10N22	10N23	10N24	10N25	—	—	—
Standard Collet Body	10N29	10N30	10N31	10N32	10N28	—	—	—
Gas Lens Collet Body	45V29	45V24	45V25	45V26	45V27	—	—	—
Lg. Diameter Lens Collet Body	—	—	—	45V64	995795	—	—	—
Cup Number	4=1/4	5=5/16	6=3/8	7=7/16	8=1/2	10=5/8	12=3/4	Short
High-Impact Cup	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
Gas Lens High-Impact Cup	54N18	54N17	54N16	54N15	54N14	—	—	54N19
Lg. Dia. Gas Lens, High-Impact Cup	—	—	—	—	—	53N88	53N87	53N89

Ordering Information

Torch Assemblies	HW-17 Hard Body	HW-17R Silicon Rubber	HW-17F Flex Head
60° Head, 12 1/2 ft.			
1 pc. cable/hose assembly	16X48	—	19881
2 pc. cable/hose assembly	33855	—	—
2 pc. cable/hose assembly twist lock	35782	—	—
60° Head, 25 ft.			
1 pc. cable/hose assembly	16X50	—	—
2 pc. cable/hose assembly	33856	—	—
60° Head with Slide Value			
12 1/2 ft., 1 pc. cable/hose assembly	634705	—	—
25 ft., 1 pc. cable/hose assembly	634706	—	—
60° Head with Rotary Value, 12 1/2 ft.			
1 pc. cable/hose assembly	16X48LV	634705R	19882
2 pc. cable/hose assembly	—	33813R	—
2 pc. cable/hose assembly twist lock	35857	—	—
60° Head with Rotary Value, 25 ft.			
1 pc. cable/hose assembly	16X50LV	634706R	19884
TIG torch outfit	—	—	600997
2 pc. cable/hose assembly	—	33814R	—
2 pc. cable/hose assembly twist lock	35856	—	—
90° Head, 25 ft.			
1 pc. cable/hose assembly	634720	—	—
90° Head w/Slide Value, 25 ft.	601152	—	—



HW-17 Torch Family - 150 Amp

Gas-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	57Y06	Body, HW-17
	57Y06LV	Body, HW-17V with valve 19621
	57Y06R	Body, HW-17R
	19576R	Body, HW-17RV with valve 19621
	19885	Body, HW-17F
	19886	Body, HW-17FV with valve 19621
	601477	Body, HW-17N (90°)
2	105Z55	Handle, HW-17, HW-17V, HW-17R, HW-17F
	105Z55R	Handle, Ribbed (optional)
3	57Y02	Long Torch Cap with O-Ring (98W18)
4	34015	Medium Torch Cap with O-Ring (98W18)
5	57Y04	Short Torch Cap with O-Ring (98W18)
6	17732	Argon Shut Off Slide Value Assembly
7	-	Collet
8	-	Collet Body
9	-	Gas Cup
10	54N01	Insulator, required for Gas Lens
	54N63	Insulator, required for Gas Lens, Lg. Diameter
11	-	Gas Lens Collet Body
12	-	Gas Lens Cup
13	105Z57	Power Cable Adaptor
14	997022*	1 pc. Power Cable, 12½ ft.
	997023*	1 pc. Power Cable, 25 ft.
15	33946	2 pc. Power Cable / Hose Assembly, 12½ ft.
	33947	2 pc. Power Cable / Hose Assembly, 25½ ft.
16	35873	2 pc. Power Cable / Hose Assembly, T.L. 12½ ft.
	0558002476	2 pc. Power Cable / Hose Assembly, T.L. 25 ft.

*Optional PVC Power Cable 57Y01 (12 ½ ft.); 57Y03 (25 ft.)

HW-26 Torch Family - 220 Amp

Gas-Cooled Torches



- Quick release of electrodes
- Hard body provides superior heat and abrasion resistance for longest life
- Silicon rubber body provides improved resistance to breakage in rough duty
- Flexible head models provide added versatility for reaching hard-to-get-at applications



Specifications

	HW-26
Gun Capacity	160 A, 100% duty cycle, ac or dc with std. accessories
	200 A, 100% duty cycle, ac or dc with std. accessories
	150 A, 50% duty cycle, ac or dc with std. accessories
Dimensions	
Length	8 7/8 in. (225 mm)
Length of Head	
Short Cap	3 3/4 in. (95 mm)
Medium Cap	5 3/8 in. (136 mm)
Long Cap	7 3/8 in. (187 mm)
Diameter of Head	29/32 in. (23 mm)
Head Angle	75° HW-26 Variable HW-126F
Handle Diameter	1 1/2 in. (31 mm)
Weight (less service lines)	7.75 oz. (221 gm)

Ordering Information

Torch Assemblies	HW-26 Hard Body	HW-26R Silicon Rubber	HW-26F Flex Head
75° Head, 12 1/2 ft. without Value			
1 pc. cable / hose assembly	17137	—	33848
2 pc. cable / hose assembly	33857	—	—
75° Head, 25 ft. without Value			
1 pc. cable / hose assembly	46V29	—	33849
2 pc. cable / hose assembly	948127	—	—
75° Head w/Rotary Value, 12 1/2 ft.			
1 pc. cable / hose assembly	17138	17138R	33850
2 pc. cable / hose assembly	—	—	33852
2 pc. cable / hose assembly twist lock	35858		
75° Head w/Rotary Value, 25 ft.			
1 pc. cable / hose assembly	46V27	46V27R	33851
2 pc. cable / hose assembly	948128	948128R	33853

Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	3/32	1/8	—	—	—
Standard Collet	10N21	10N22	10N23	10N24	10N25	—	—	—
Standard Collet Body	10N29	10N30	10N31	10N32	10N28	—	—	—
Gas Lens Collet Body	45V29	45V24	45V25	45V26	45V27	—	—	—
Lg. Diameter Lens Collet Body	—	—	—	45V64	995795	—	—	—
Cup Number	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16	8 = 1/2	10 = 5/8	12 = 3/4	Short
High-Impact Cup	10N50	10N49	10N48	10N47	10N46	10N45	10N44	
Gas Lens High-Impact Cup	54N18	54N17	54N16	54N15	54N14	—	—	54N19
Lg. Dia. Gas Lens, High-Impact Cup	—	—	—	—	—	53N88	53N87	53N89



HW-26 Torch Family - 220 Amp

Gas-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	45V65	Body, HW-26
	598478	Body, HW-26V with valve (598279)
	45V65R	Body, HW-26R
	598478R	Body, HW-26RV with valve (19622)
	34014	Body, HW-26F Flex Head
	34013	Body, HW-26FV with valve (34074)
2	19624	Ribbed Handle, HW-26R (for rubber body)
	10N15	Handle, HW-26F (for flex body)
3	57Y02	Long Torch Cap with O-Ring (98W18)
4	34015	Medium Torch Cap with O-Ring (98W18)
5	57Y04	Short Torch Cap with O-Ring (98W18)
6	54N84	Handle, HW-26 (for hard body)
7	–	Collet
8	–	Collet Body
9	–	Gas Cup
10	54N01	Insulator, required for Gas Lens
	54N63	Insulator, required for Gas Lens, Lg. Diameter
11	–	Gas Lens Collet Body
12	–	Gas Lens Cup
13	45V62	Power Cable Adaptor
14	46V28	1 pc. Power Cable, 12 ½ ft.
	46V30	1 pc. Power Cable, 25 ft.
15	33697	2 pc. Power Cable / Hose Assembly, 12 ½ ft.
	33698	2 pc. Power Cable / Hose Assembly, 25 ½ ft.
	35874	2 pc. Power Cable / Hose Assembly, T.L. 12 ½ ft.

HW-20 Torch Family - 300 Amp

Water-Cooled Torches



- Compact water-cooled design for higher current applications in confined areas
- Hard body w/HFCTM (HW-20) provides superior heat and abrasion resistance - available in 2 versions
- Economical silicon rubber body (HW-20R) provides resistance to breakage



Specifications

	HW-20
Gun Capacity	240 A, 100% duty cycle, ac or dc with std. accessories
	250 A, 100% duty cycle, ac or dc with gas lens accessories
	300 A, 50% duty cycle, ac or dc
Dimensions	
Length	6 7/8 in. (175 mm)
Length of Head	
Short Cap	2 19/64 in. (58 mm)
Medium Cap	3 3/32 in. (83 mm)
Long Cap	7 5/16 in. (186 mm)
Diameter of Head	3/4 in. (19 mm)
Head Angle	70°
Handle Diameter	3/4 in. (19 mm)
Weight (less service lines)	3.5 oz. (100 gm)
Cooling Requirements	1 qt. min. (0.94 l/min)

Ordering Information

Torch Assemblies	HW-20 Hard Body	HW-20 Silicon Rubber
70° Head		
Cable / hose assembly, 12 1/2 ft.	948084	948084R
Cable / hose assembly, 25 ft.	948085	948085R

Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	3/32	1/8	—
Standard Collet	13N20	13N21	13N22	13N23	13N24	—
Standard Collet Body	13N25	13N26	13N27	13N28	13N29	—
Gas Lens Collet Body	45V41	45V42	45V43	45V44	45V45	—
Cup Number	4=1/4	5=5/16	6=3/8	7=7/16	8=1/2	10=5/8
High-Impact Cup	13N08	13N09	13N10	13N11	13N12	13N13
Gas Lens High-Impact Cup	53N58	53N59	53N60	53N61	—	—

For selection of special ceramic or sleeved cups, see Accessories following Torches.



HW-20 Torch Family - 300 Amp

Water-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	948020	Body, HW-20 with O-Ring (85W49)
	948020R	Body, HW-20R
2	53N06	Handle, HW-20
3	41V24	Long Torch Cap with O-Ring (181W53)
4	41V33	Short Torch Cap with O-Ring (181W53)
5	41V35	Medium Torch Cap with O-Ring (181W53)
6	598882	Cup Gasket
7	–	Collet
8	–	Collet Body
9	–	Gas Cup
10	–	Gas Lens Collet Body
11	–	Gas Lens Cup
12	45V11	Power Cable Adaptor
13	45V03	Power Cable, 12 ½ ft.
	45V04	Power Cable, 25 ft.
14	45V09	Gas Hose, 12 ½ ft.
	45V10	Gas Hose, 25 ft.
15	45V07	Water Hose, 12 ½ ft.
	45V08	Water Hose, 25 ft.
16	53N04	Hose Clamp
	13N42	O-Ring Assembly Tool (not shown)
	11N16	Water Adaptor (½" - 18 LH to ¼ NPT) (not shown)
17	85W49	O-Ring

HW-18 Torch Family - 425 Amp

Water-Cooled Torches



- The industry standard water-cooled general purpose torch
- Ideal for production welding
- Lightweight - reduces operator fatigue
- Watertight - brazed, closed cooling system
- Gas lens available for improved shielding
- Hard body w/HFCTM (HW-18) provides superior heat and abrasion resistance for the longest life
- Economical silicon rubber body (HW-18R) provides resistance to breakage



Specifications

	HW-18
Gun Capacity	300 A, 100% duty cycle, ac or dc with std. accessories
	375 A, 100% duty cycle, ac or dc with gas lens accessories
	425 A, 50% duty cycle, ac or dc
Dimensions	
Length	10 1/2 in. (267 mm)
Length of Head	
Short Cap	3 3/16 in. (81 mm)
Medium Cap	5 7/16 in. (138 mm)
Long Cap	7 7/16 in. (189 mm)
Diameter of Head	29/32 in. (23 mm)
Head Angle	60°
Handle Diameter	1 1/16 in. (27 mm)
Weight (less service lines)	7 oz. (200 gm)
Cooling Requirements	1 qt. min. (0.94 l/min)

Ordering Information

Torch Assemblies	HW-18 Hard Body	HW-18 Silicon Rubber
60° Head		
Cable / hose assembly, 12 1/2 ft.	948361	948361R
Cable / hose assembly, 25 ft.	948362	948362R

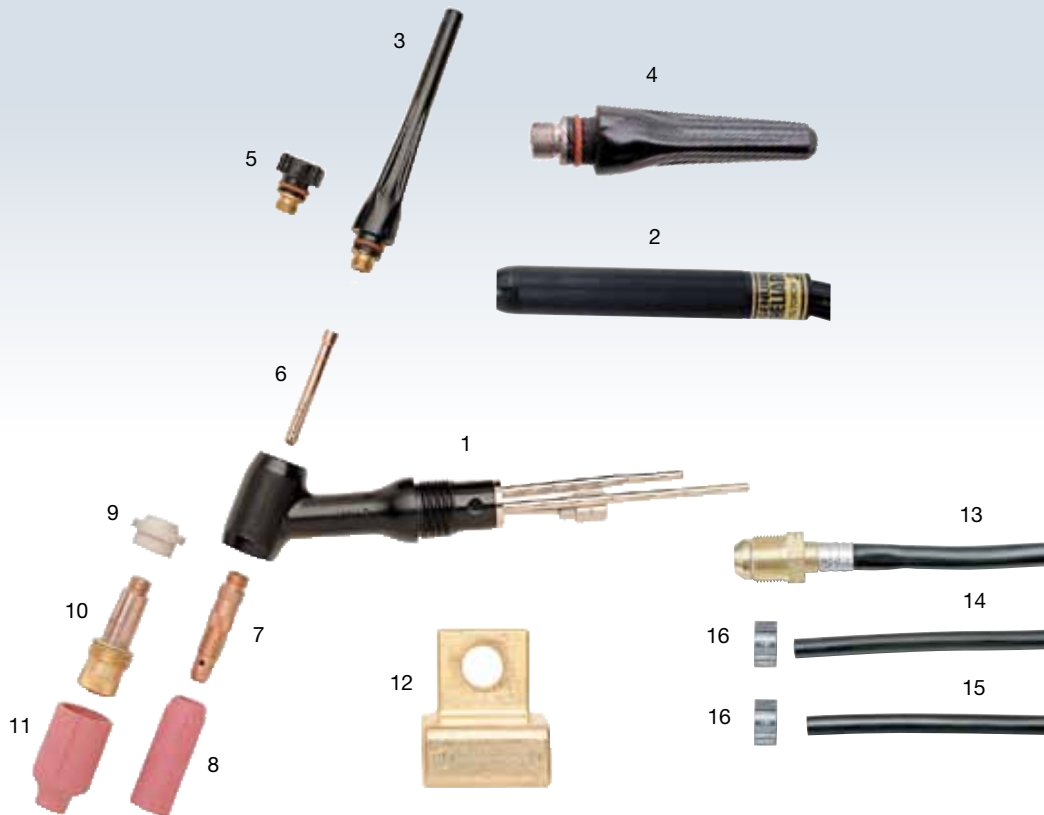
Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	3/32	1/8	—	—	—
Standard Collet	10N21	10N22	10N23	10N24	10N25	—	—	—
Standard Collet Body	10N29	10N30	10N31	10N32	10N28	—	—	—
Gas Lens Collet Body	45V29	45V24	45V25	45V26	45V27	—	—	—
Lg. Diameter Lens Collet Body	—	—	—	45V64	995795	—	—	—
Cup Number	4=1/4	5=5/16	6=3/8	7=7/16	8=1/2	10=5/8	12=3/4	Short
High-Impact Cup	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
Gas Lens High-Impact Cup	54N18	54N17	54N16	54N15	54N14	—	—	54N19
Lg. Dia. Gas Lens, High-Impact Cup	—	—	—	—	—	53N88	53N87	53N89



HW-18 Torch Family - 425 Amp

Water-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	948350	Body, HW-18
	948350R	Body, HW-18R
2	10N15	Handle, HW-18
	10N15A	Handle, HW-18R
3	57Y02	Long Torch Cap with O-Ring (98W18)
4	34015	Medium Torch Cap with O-Ring (98W18)
5	57Y04	Short Torch Cap with O-Ring (98W18)
6	–	Collet
7	–	Collet Body
8	–	Gas Cups
9	54N01	Insulator, required for Gas Lens
	54N63	Insulator, required for Gas Lens, Lg. Diameter
10	–	Gas Lens Collet Body
11	–	Gas Lens Cup
12	45V11	Power Cable Adaptor
13	40V64	Power Cable, 12 ½ ft.
	41V29	Power Cable, 25 ft.
14	40V75	Gas Hose, 12 ½ ft.
	41V30	Gas Hose, 25 ft.
15	40V74	Water Hose, 12 ½ ft.
	41V32	Water Hose, 25 ft.
16	98W43	Hose Clamp
	11N16	Water Adaptor (5/8" LH to 1/4" NPT) (not shown)

HW-25 Torch Family - 200 Amp

Water-Cooled Torches



- Small, Lightweight
- Flexible head to access difficult joints



Specifications

	HW-25
Gun Capacity	200 A, 100% duty cycle, ac or dc with std. accessories
	210 A, 50% duty cycle, ac or dc with std. or gas lens
Dimensions	
Length	10 ½ in. (267 mm)
Length of Head	4 7/8 in. (124 mm)
Diameter of Head	¾ in. (19 mm)
Head Angle	Flexible
Handle Diameter	¾ in. (19 mm)
Weight (less service lines)	14 oz. (400 gm)
Cooling Requirements	1 qt. min. (0.94 l/min)

Ordering Information

Torch Assemblies	HW-25 Silicon Rubber
Flexible Head	
HW-25 – 12 with 12 ft. cable	45V36
HW-25 – 25 with 25 ft. cable	45V37

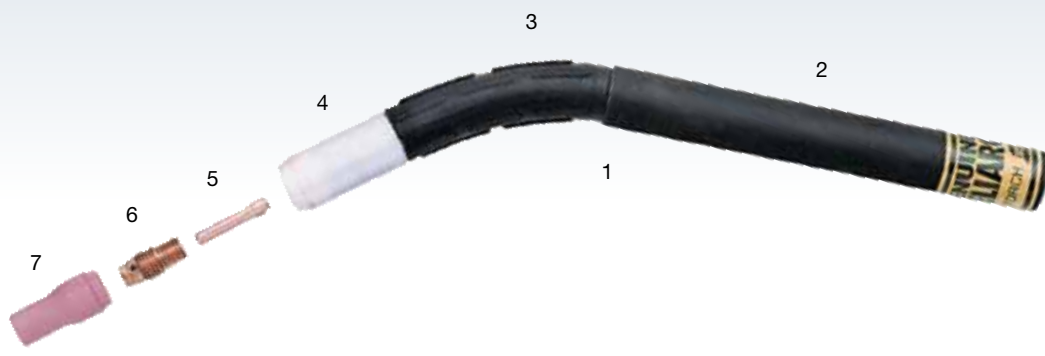
Cups, Collects and Collect Bodies

Electrode Size	.020	.040	1/16	3/32	1/8	—
Standard Collet	13N20	13N21	13N22	13N23	13N24	—
Standard Collet Body	13N25	13N26	13N27	13N28	13N29	—
Gas Lens Collet Body	45V41	45V42	45V43	45V44	45V45	—
Cup Number	4 = 1/4	5 = 5/16	6 = 3/8	7 = 7/16	8 = 1/2	10 = 5/8
High-Impact Cup	13N08	13N09	13N10	13N11	13N12	13N13
Gas Lens High-Impact Cup	53N58	53N59	53N60	53N61	—	—



HW-25 Torch Family - 200 Amp

Water-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	45V38	Body, HW-25
2	53N55	Handle, HW-25
3	53N45	Flex Sleeve Insulator
4	53N47	Insulator
5	–	Collet
6	–	Collet Body
7	–	Ceramic Cup
	45V03	Power Cable, 12 ½ ft.
	45V04	Power Cable, 25 ft.
	45V07	Water Hose, 12 ½ ft.
	45V08	Water Hose, 25 ft.
	45V09	Gas Hose, 12 ½ ft.
	45V10	Gas Hose, 25 ft.
	11N16	Water Adaptor (5/8 18 LH TO 1/4 NPT) (not shown)



HW-27 Torch Family - 400 Amp

Water-Cooled Torches



- Front or back loaded
- Internal tungsten adjustment
- Model A with 9" length is designed for clamp-type fixture
- Model B with 20" length is designed for pinion-type fixture



Specifications

	HW-27	
Gun Capacity	400 A, 100% duty cycle, ac or dc with high impact cups	
	500 A, 100% duty cycle, ac or dc with metal nozzles	
	400 A, 50% duty cycle, ac or dc	
Dimensions	27A	27B
Length	9 in. (230 mm)	20 in. (500 mm)
Diameter of Torch	1 3/8 in. (34 mm)	
Weight (less service lines)	24 oz. (680 gm)	36 oz. (1021 gm)
Cooling Requirements	2 qt. min. (1.91 l/min)	
Maximum Pressure	50 psi	
Electrode Capacity	.040 - 1/4 in. diameter	

Ordering Information

Torch Assemblies	HW-27 Silicon Rubber
HW-27A - 9 in.	
HW-27A - 4 with 4 ft. cable	20955
HW-27A - 12 with 12 ft. cable	20954
HW-27B - 20 in.	
HW-27BL - 4 with 4 ft. cable	20017
HW-27B - 12 with 12 ft. cable	20018

Cups, Collects and Collect Bodies

Electrode Size	.040	1/16	3/32	1/8	5/32	3/16	1/4
Standard Collet	57N45	57N46	57N47	57N48	57N49	57N50	57N51
Standard Collet Body*	—	—	49V24	49V25	49V26	49V27	49V28
Cup Number	6=3/8	8=1/2	10=5/8	12=3/4	15=15/16	Short	—
High-Impact Cup	—	57N75	57N74	53N88	53N87	53N89	—

*Includes gasket - 57N56



HW-27 Torch Family - 400 Amp

Water-Cooled Torches



Torch Parts and Accessories

Item	Part Number	Description
1	Q27A	Body, 9" HW-27
	Q27B	Body, 20" HW-27
2	20957	Shaft / Knob Assembly (A-model)
	20021	Shaft / Knob Assembly (B-model)
3	20956	Barrel (A-model)
	20020	Barrel (B-model)
4	20957	Shaft Assembly (A-model)
	20021	Shaft Assembly (B-model)
5	85W44	O-Ring
6	–	Collet
7	–	Collet Body
8	57N56	Gasket
9	–	Gas Cup
10	20024	Power Cable, 12 ½ ft.
	20023	Power Cable, 4 ½ ft.
	20025	Water Cable, 4 ½ ft.
	20026	Water Cable, 12 ½ ft.
	20027	Gas Hose, 4 ½ ft.
	20028	Gas Hose, 12 ½ ft.
11	20022	Boot
12	20032	Options (HW-27B only) – HW-27B Back (32 pitch), rack length 11 11/16 in.

Collets

Torch	Part Number	Size	
		in.	mm
HW-20, HW-9, HW-25 	13N20	.020	0.5
	13N21	.040	1.0
	13N22	1/16	1.6
	13N23	3/32	2.4
	13N24	1/8	3.2
HW-17, HW-18, HW-26 	10N21	.020	0.5
	10N22	.040	1.0
	10N23	1/16	1.6
	10N24	3/32	2.4
	10N25	1/8	3.2
	54N20	5/32	4.0
HW-24 	53N15	.020	0.5
	53N16	.040	1.0
	53N14	1/16	1.6
	53N62	.020	0.5
	53N63	.040	1.0
	53N64	1/16	1.6
HW-90 	84Z35	.040	1.0
	84Z33	1/16	1.6
HW-27 	57N45	.040	1.0
	57N46	1/16	1.6
	57N47	3/32	2.4
	57N48	1/8	3.2
	57N49	5/32	4.0
	57N50	3/16	4.8
	57N51	1/4	6.4

Large Diameter Gas Lens Collet Bodies

Torch	Part Number	Size	
		in.	mm
HW-17, HW-18, HW-26 	45V64	3/32	2.4
	995795	1/8	3.2
	45V63	5/32	4.0

Collet Bodies

Torch	Part Number	Size	
		in.	mm
HW-20, HW-9, HW-25 	13N25	.020	0.5
	13N26	.040	1.0
	13N27	1/16	1.6
	13N28	3/32	2.4
	13N29	1/8	3.2
	406488	5/32	4.0
HW-17, HW-18, HW-26 	10N29	.020	0.5
	10N30	.040	1.0
	10N31	1/16	1.6
	10N32	3/32	2.4
	10N28	1/8	3.2
	406488	5/32	4.0
HW-24* Standard 	53N17	.020	0.5
	53N18	.040	1.0
	53N19	1/16	1.6
HW-90 	105Z27	All Sizes	
HW-27 	49V24	3/32	2.4
	49V25	1/8	3.2
	49V26	5/32	4.0
	49V27	3/16	4.8
	49V28	1/4	6.4

*Note: Order Wrench (53N20) for HW-24 Collect Body.

Gas Lens Collet Bodies

Torch	Part Number	Size	
		in.	mm
HW-20, HW-9, HW-25 	45V41	.020	0.5
	45V42	.040	1.0
	45V43	1/16	1.6
	45V44	3/32	2.4
	45V45	1/8	3.2
HW-17, HW-18, HW-26 	45V29	.020	0.5
	45V24	.040	1.0
	45V25	1/16	1.6
	45V26	3/32	2.4
	45V27	1/8	3.2
	45V28	5/32	4.0
HW-90*, HW-24** 	45V41	.020	0.5
	45V42	.040	1.0
	45V43	1/16	1.6

*Also order Adaptor 45V52 / Insulator 53N85.

**Also order Insulator 53N66.



Genuine Heliarc Accessories

Gas Lens

To meet increasingly stringent weld quality standards, we developed the patented GENUINE HELIARC Gas Lens. This stack of concentric, fine-mesh stainless steel screens produces an exceptionally stable stream of shielding gas (see Figure 1). By forcing the gas into a coherent stream, an effective shielding pattern can be projected greater distances (see Figure 2). Welding is possible at nozzle distances up to one inch from the plate

surface, allowing greater welder visibility and access to tight joints.

Extending the electrode from the gas cup also increases the current capacity of some torch models. For example, a gas lens increases the 100 percent duty rating of our popular Heliarc HW-18 torch from 300 to 375 A.

Patented Genuine Heliarc Gas Lens

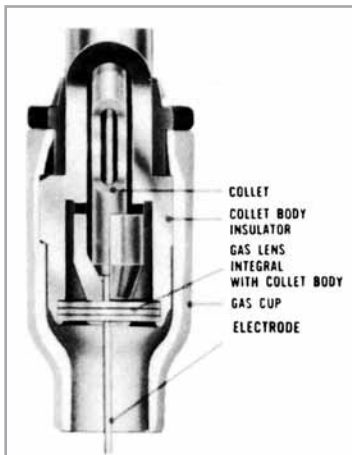


FIG. 1

Conventional Torch

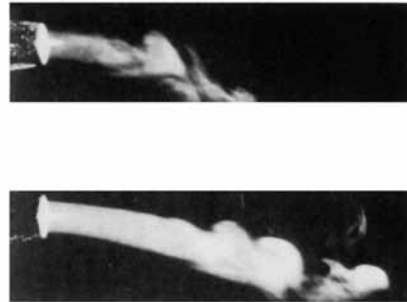


FIG. 2



High Impact Cups

Made from high strength alumina, have very good electrical insulating properties and exceptionally high impact resistance, heat resistance, thermal conductivity

and spatter build-up resistance. They are recommended for most welding operations except for use in confined areas.

Standard High-Impact Cups

Torch	Length (in.)	Part Number	Size	Orifice	
				in.	mm
HW-90 	1 5/16	14N65	4	1/4	6.4
		14N66	5	5/16	8
		14N67	6	3/8	10
HW-17, HW-18, HW-26 	1 27/32	10N50	4	1/4	6.4
		10N49	5	5/16	8
		10N48	6	3/8	10
		10N47	7	7/16	11
		10N46	8	1/2	12.5
		10N45	10	5/8	16
		10N44	12	3/4	19
HW-20, HW-9, HW-25 	1 5/32	13N08	4	1/4	6.4
		13N09	5	5/16	8
		13N10	6	3/8	10
		13N11	7	7/16	11
		13N12	8	1/2	12.5
		13N13	10	5/8	16
HW-27 	1 27/32	57N75	6	3/8	10
		57N74	8	1/2	12.5
		53N88	10	5/8	16
		53N87	12	3/4	19
	1 5/16	53N89	15	15/16	24

Gas Lens High-Impact Cups

Torch	Length (in.)	Part Number	Size	Orifice	
				in.	mm
HW-17, HW-18, HW-26 	1 5/8	54N18	4	1/4	6.4
		54N17	5	5/16	8
		54N16	6	3/8	10
		54N15	7	7/16	11
		54N14	8	1/2	12.5
	1 1/8	54N19	Short	11/16	17
HW-90, HW-20, HW-24, HW-9, HW-25 	1	53N58	4	1/4	6.4
		53N59	5	5/16	8
		53N60	6	3/8	10
		53N61	7	7/16	11
		53N61S	8	1/2	12.7

Large Diameter Gas Lens High-Impact Cups

Torch	Length (in.)	Part Number	Size	Orifice	
				in.	mm
HW-17, HW-18, HW-26 	1 7/8	57N75	6	3/8	10
		57N74	8	1/2	12.5
		53N88	10	5/8	16
		53N87	12	3/4	19
	1 5/16	53N89	Short	15/16	24



Genuine Heliarc

Accessories

Ceramic Cups

Made from Grade "A" lava materials are less impact and heat resistant than the high-impact cups, but can be expected to give very good service and long life. They perform very well in confined areas where excessive heat

is reflected back into the nozzle. These cups can be used at currents up to 250 A dcsp or ac, depending on arc time and cup size.

Ceramic Cups

Torch	Length (in.)	Part Number	Size	Orifice	
				in.	mm
HW-24 	5/8	53N23	.165	.165	4
		53N24	4	1/4	6.4
		53N25	5	5/16	8
		53N27	6	3/8	10

Special Ceramic Long Cups

Torch	Length (in.)	Part Number	Size	Orifice	
				in.	mm
HW-20, HW-9, HW-25 	1 7/8	796F70	3L	3/16	4.8
		796F71	4L	1/4	6.4
		796F72	5L	5/16	8
		796F73	6L	3/8	10
HW-20 (X-Long), HW-9, HW-25 	2 1/2	796F74	3XL	3/16	4.8
		796F75	4XL	1/4	6.4

Genuine Heliarc Accessories



Each package contains those accessory items most requested by our customers for use on our most popular Tig Torches, in easy-to-order kit form, packaged in durable plastic boxes.



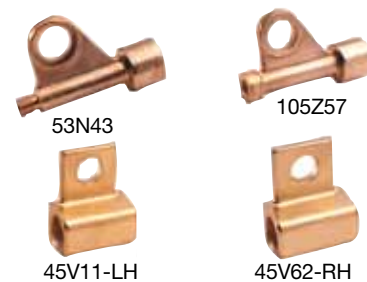
Spare Parts Kit

Description	999126 HW-17, 18, 26	999127 HW-20	999124 HW-90	Quantity
Short Torch Cap	57Y04	-	-	1
Long Torch Cap	-	41V24	56Y40	1
.040 Collet	-	-	84Z35	1
1/16 in. Collet	10N23	13N22	84Z33	1
3/32 in. Collet	10N24	13N23	-	1
1/8 in. Collet	10N25	13N24	-	1
Collet Body	-	-	105Z27	1
1/16 in. Collet Body	10N31	13N27	-	1
3/32 in. Collet Body	10N32	13N28	-	1
1/8 in. Collet Body	10N28	13N29	-	1
No. 4 High-Impact Cup	-	-	14N65	1
No. 5 High-Impact Cup	10N49	13N09	14N66	1
No. 6 High-Impact Cup	10N48	13N10	14N67	1
No. 7 High-Impact Cup	-	13N11	-	1
No. 8 High-Impact Cup	10N46	-	-	1
.040 in. dia. x 7 in. long, Ground Finish Lanthana Electrode	-	-	Q796F55	1
1/16 in. dia. x 7 in. long, Ground Finish Lanthana Electrode	Q796F58	Q796F58	Q796F58	1
3/32 in. dia. x 7 in. long, Ground Finish Lanthana Electrode	Q796F63	Q796F63		1
1/8 in. dia. x 7 in. long, Ground Finish Lanthana Electrode	Q796F68	Q796F68		1



Adaptors/Accessories

Description	Part Number	Used On
Insulator	54N63	HW-17, 18, 26
Insulator	54N01	HW-17, 18, 26
Insulator	53N85	HW-90
Adaptor	45V52	HW-90
Collet Body Insulator	53N66	HW-24
Cup Gasket	598882	HW-20, 9



Power Cable Adaptors

Description	Part Number	Used On
Adaptor	53N43	HW-90, 24
Adaptor	105Z57	HW-17, 9
Adaptor	45V11	HW-18, 20
Adaptor	45V62	HW-26
Fuse Assembly	45V34	HW-18, 20
Replacement Fuses (5/pk)	54N26, 25A 54N30, 60A	HW-18, 20

Heliarc®
Torches



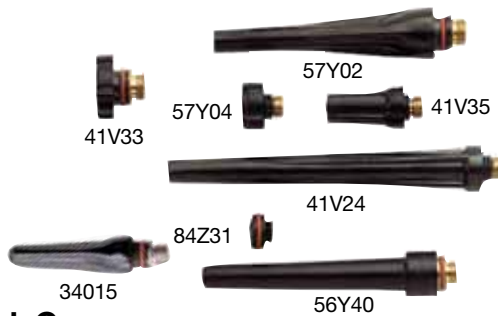
Genuine Heliarc

Accessories

Electrodes - Ground Finish Provides Maximum Smoothness

Diameter (in.)	Length (in.)	Pure (EWP) Green Coded	1% Thoriated (EWTh-1) Yellow Coded	2% Thoriated (EWTh-2) Red Coded	Zirconiated (EWZr-1) Brown Coded	2% Ceriated (EWCe-2) Orange Coded	1 1/2% Lanthana (EWG) Gray Coded
.020	7 (175mm)	—	—	—	—	—	796F53
.040	7 (175mm)	79Z15	—	84Z18	—	—	Q796F55
1/16	3 (75mm)	—	—	—	—	—	—
	6 (150mm)	—	—	—	—	—	—
	7 (175mm)	Q76Z51	Q84Z23	Q84Z19	790F47	Q798F92	796F58
3/32	3 (75mm)	—	—	Q798F08	—	—	—
	6 (150mm)	—	—	—	—	—	—
	7 (175mm)	Q76Z57	—	Q84Z20	Q790F48	Q798F93	Q796F63
1/8	3 (75mm)	—	—	Q798F12	—	—	Q796F66
	6 (150mm)	—	—	—	—	—	—
	7 (175mm)	Q76Z52	Q84Z25	Q81Z79	Q790F49	Q798F94	Q796F68
5/32	6 (150mm)	—	—	—	—	—	—
	7 (175mm)	Q81Z43	—	Q81Z80	Q790F50	Q798F95	Q796F84
3/16	7 (175mm)	—	—	86Z05	Q790F51 (5)	Q799F86 (5)	796F89
	12 (300mm)	—	—	Q798F22 (5)	—	—	—
1/4	7 (175mm)	76Z54 (5)	—	84Z21 (5)	—	—	—

Only the more popular tungsten electrodes are listed. We carry a wide variety of electrodes. For ordering information consult your ESAB Genuine Heliarc® supplier. Each package contains ten electrodes. For additional accessories, consult the Genuine Heliarc® Torch Guide - ARC-23110



Back Caps

Description	Part Number	Used On
Short Cap	41V33	HW-20, 9
Medium Cap	41V35	HW-20, 9
Long Cap	41V24	HW-20, 9
Long Cap	57Y02	HW-17, 18, 26
Medium Cap	34015	HW-17, 18, 26
Short Cap	57Y04	HW-17, 18, 26
Short Cap	84Z31	HW-90
Long Cap	56Y40	HW-90

Hoses/Cable Sheaths

Description	Part Number	Used On
Zippered Nylon		
12 1/2 ft. x 3" wide	35453	all
25 ft. x 3" wide	35454	all
Non-Zippered		
9 ft. x 7/8" I.D.	2075198	HW-20
20 ft. x 7/8" I.D.	2075200	
9 ft. x 1 1/4" I.D.	2075199	HW-18
10 ft. Leather with snaps 6" wide	20812	

* Widths are as flat

Remote Controls



MTA1 CAN

- CAN based multi function remote control for the control panels A2, A4, T4, T6, M2, MA4, MA6, U6 and AristoPendant U8.

Process	Knob 1	Knob 2
MMA	Current control	Arc force
TIG	Pulse current	Background current
MIG/MAG 1	Wire feed speed	Voltage control
MIG/MAG 2	Wire feed speed	Voltage trim 1/2

MTA1 CAN0459491880



M1 10Prog CAN

- CAN based Synergic MIG for control panel MA6, U6 and AristoPendant U8
- MMA/TIG: Memory 1-10 and voltage trim +/-

M1 10Prog CAN0459491882



AT1 CAN

- CAN based standard MMA and TIG for control panel A2, A4, T4, and T6.
- MMA/TIG: Current control

AT1 CAN0459491883



AT1 Coarse/Fine CAN

- CAN based standard MMA and TIG for control panel A2, A4, T4, and T6.
- MMA/TIG: Current control, coarse/fine

AT1 Coarse/Fine CAN0459491884



M1

- Analogue standard MIG for control panel M10, M12, M13, M13i and M14

- MMA/TIG: Wire feed and voltage control

M10459491895



AT1 Coarse

- Analogue standard MMA and TIG for power sources with remote outlet

- MMA/TIG: Current control

AT1 Coarse0459491896



AT1 Coarse/Fine

- Analogue standard MMA and TIG for power sources with remote outlet

- MMA/TIG: Current control, coarse/fine

AT1 Coarse0459491897



Remote Adapters for CAN Based Systems

- For analog MMA and TIG remote controls. For analog MIG/MAG remote controls and 3-step program switch RS3

RA 12 for MMA and TIG0459491910

RA T1 TIG remote torch

12 pole*0459491912

10 pole*0459491913

*includes holder and cable

Remote Controls



Foot Control - TIG

- Complete with 5 m rubber cable and equipped with 12-pole Burndy

FS002 analog 0349090886
T1 CAN for Caddy Tig 0460315880



Remote-Control MMA1

- MMA 1 is equipped with 1 potentiometers for current setting.
- Includes 10 m rubber cable equipped with a 12-pole Burndy and a metal hook

MMA1 0349501024

Interconnection Cables 10 pole

Size	Part Number
0.25 m	0459960883
5 m	0459960880
10 m	0459960881
15 m	NA
25 m	0459960882
5 m HD	0459960880
10 m HD	0459960881
25 m HD	0459960882

Interconnection Cables 12 pole

Size	Part Number
0.25 m CAN	0459554884
5 m CAN	0459554880
10 m CAN	0459554881
15 m CAN	0459554882
20 m CAN	0459554883
5 m ANALOG 23 p	0459553880
5 m ANALOG 12 p	0459552880
10 m ANALOG 12 p	0459552881
15 m ANALOG 12 p	0459552882
25 m ANALOG 12 p	0459552883

	MTA 1 CAN	M 110 Prog CAN	AT1 CAN	AT1 Coarse Fine CAN	M1	AT1 Coarse	AT1 Coarse Fine	Foot Control TIG FS002	MMA1
DTF						x	x	x	x
DTE/DTG						x	x	x	x
LHF						x	x		x
LHN						x	x		x
LTN/LTR						x	x	x	x
CaddyArc						x	x		x
CaddyTig						x	x	x	x
ESABFeed					x				
MEK					x				
AristoFeed	x	x							
AristoArc	x		x	x					
Aristo Tig	x		x	x					
AristoMig U	x	x	x	x					

General Accessories



FC-5C Foot Control



FC-5B EHD

Remote Controls

- For use on 350mpi, SVI 450i, 353cv*, 453cv*, 453cc*, 553cc*, MP 460, 653cvcc*, Heliarc 252 and Heliarc 352

HC-3B Hand Pendant Control

30 ft. (9.1m) cable. Provides remote control of process switch (cv/cc), contactor switch (on/off) and output control (cc-amperes/cv-volts)33838

TC-2B Torch Control

25 ft. (7.5 m) cable. Attach to torch handle. Provides remote current control and contactor (on/off) control33839

TC-3A Remote Torch Switch

30 ft. (9.1 m) cable. Provides on/off contactor control. Includes push button switch and rubber boot to secure switch to torch handle.

HW-9, 17, 20, 20A / 24.....35783

HW-18 / 26R.....36680

FC-5C Foot Control

30 ft. (9.1 m) cable. Provides remote current control and contactor (on/off) control0558004234

FC-5B EHD Foot Control

30 ft. (9.1 m) cable. Extra Heavy Duty foot control provides remote current control and contactor (on/off) control33841

* Requires remote control kit0558001436



Truck Kits and Carts

- Allows for easy mobility of equipment

TR-29 (two cylinder) for ESAB 353cv, 453cv, MP 460, 453cc, 553cc and 653cvcc, Heliarc 252, Heliarc 352.....37924

TR-23A (two cylinder) for Heliarc 252 and Heliarc 352.....36224

Inverter Cart, (two cylinder) for use with MTS-3500i.....31700

R-33 Regulator / Flowmeter

- Regulator with Lexan flow tube, 3000 psi cylinder gauge

R-33-FM-580* - Argon/Argon mixes, 10-50 cfh flow21557

R-33-RM-580HB* - Argon/Argon mixes, 10-50 cfh flow, for gas hoses needing a "B" fitting added.....0558005172

R-33-FM-320* - CO₂, 10-65 cfh flow.....21558

*Refer to Gas section for details

Hoses/Fittings

Gas Hose Assemblies

3 ft. (0.9 m)31504

6 ft. (1.8 m)31503

12 ½ ft. (3.8 m)40V77

25 ft. (7.5 m)34V38

12 ½ ft. (3.8 m) heavy duty (CO₂).....19416

25 ft. (7.5 m) heavy duty (CO₂)19415

Gas Hose Coupler11N17

Gas Hose Coupler, "Y"950356

Water Hose Assemblies

3 ft. (0.8 m)20634

6 ft. (1.8 m)20633

12 1/2 ft. (3.8 m).....40V76

25 ft. (7.5 m).....406196

Water Hose Coupler11N18

1 Gallon Torch Coolant.....156F05



Twist Lock Connectors

- For use on MTS-3500i, Heliarc 252, Heliarc 352, Heliarc 161 AC/DC, Migmaster 275, CaddyArc 151i, CaddyArc 201i, CaddyTig 2200i, CaddyTig 2200i AC/DC, MultiMaster 160 / 260, MultiMaster 300, Origo Mig 4002c/5002c/6502c, Aristo 5000i, U5000i, Origo Mig 320/410/510, Origo Arc 410c/650c.

50 mm Connectors

Quick-acting twist lock connectors for attaching output power cables or torches to power source:

Male for 1/0 to 4/0 cable13792513

Female for 1/0 to 4/0 cable13735631

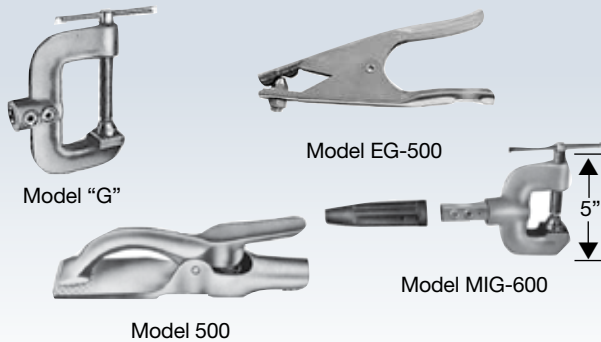
Male for #2 AWG to 1/0 cable13733936

Female for #2 AWG to 1/0 cable13735632

Quick connector with ½ in. threaded stud13735501

Tee connector (1 male, 2 female)13792804

General Accessories



Ground Clamps

- **ESAB Ground clamps provide the largest workpiece-contact area of any clamp on the market. They assure positive connections and slide easily under steel plate. Ground clamps help eliminate arc blow, make it easy to change ground location, and assure proper voltage for maximum weld results with all rods.**

Model	Part Number	Amp Capacity	Type Cable Connection	Weight
200	81F11	200	Mechanical Oval-Point Screw	13 oz.
300	81F12	300	Mechanical Oval-Point Screw	26 oz.
500	81F13	500	Mechanical Oval-Point Screw	35 oz.
MIG-600	0160288001	600	Two Oval-Point Screws	56 oz.
G	82F17	600	Two Oval-Point Screws	52 oz.
EG-500	82F32	500	Bolt and Nut with Support	22 oz.
EG-300	82F31	300	Bolt and Nut with Support	11 oz.

Work/Electrode Holder Cable Assemblies

Includes twist lock 25mm QC plug

- 10 ft. Cable Kit, electrode/work cable assemblies, 150A.....0349501078
- 10 ft. Electrode holder cable assembly, 150A.....0349501079

Includes twist lock 50mm QC plug

- 10 ft. Work cable*, #3AWG.....0700006901
- 15 ft. Work cable*, 2/0AWG.....36253
- 15 ft. Work cable*, 2/0AWG.....35881
- 15 ft. Electrode holder 2/0AWG.....21226

Includes ½" ring lug

- 15 ft. Work cable*, 2/0AWG.....0558001440

* work cables include work clamp

Feeder Cable Assemblies

½" Ring lug to ½" Ring lug

- 15 ft. Feeder cable, 2/0AWG 0558001441

½" Ring lug to 50mm QC

- 15 ft. Feeder cable, 2/0AWG36254

Cam Type Action Here
Makes Positive Stop/Lock

Female Brass Connector Is
Recessed - No Accidental Short



Male Half
Cover Removed



Female Half
Cover Removed

Tight Fit Here — Face to Face Contact



This Plug Fits Female
Half No. LC-40 Connector
LC-1040

Cable Connectors

- **ESAB Cable Connectors offers many advantages over older styles. Metal parts are precision machined from heavy, specially shaped brass extrusion. Cam action design of male half connector pulls the two halves tightly together. Connector covers are molded from a special heat and cold resistant material. Covers have no metal liner to rust or corrode. Easily installed with a ¼ in. Allen wrench.**

Model	Part Number	Cable Connection	Cable Capacity	Weight	Std Pack
LC-40	81F25	Oval-Point Screw Mech.	1/0 thru 3/0	17 oz.	1
Same connector style as above - only one half of the set					
LC-40	81F26	Male half	1/0 thru 3/0		
LC-40	81F27	Female half	1/0 thru 3/0		



Electrode Holder

- **Curved upper lever with low angle design for better hold. Firm electrode grip, fully insulated, high strength spring. High leverage tong designed for easy opening. Heavy-duty shockproof handle.**

Part Number	Amp Capacity	Electrode Capacity	Cable Capacity	Length	Weight
81F02	300	Up to ½ in.	2/0	10 in.	20 oz.
0558008634	500	Up to ¾ in.	4/0	11 in.	26 oz.



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NOTICE:

Test results described above were obtained under controlled laboratory conditions, and are not guarantees for use in the field. Actual use of the product may produce varying results due to conditions and welding techniques over which ESAB has no control, including but not limited to plate chemistry, weldment design, fabrication methods, wire size, welding procedure, service requirements and the environment. The User should confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CAUTION:

Users should be thoroughly familiar with the safety precautions referenced in the product label for the relevant product and the Safety Data Sheet for the product. Safety Data Sheets are available at www.esabna.com or by calling 1-800-ESAB-123.



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