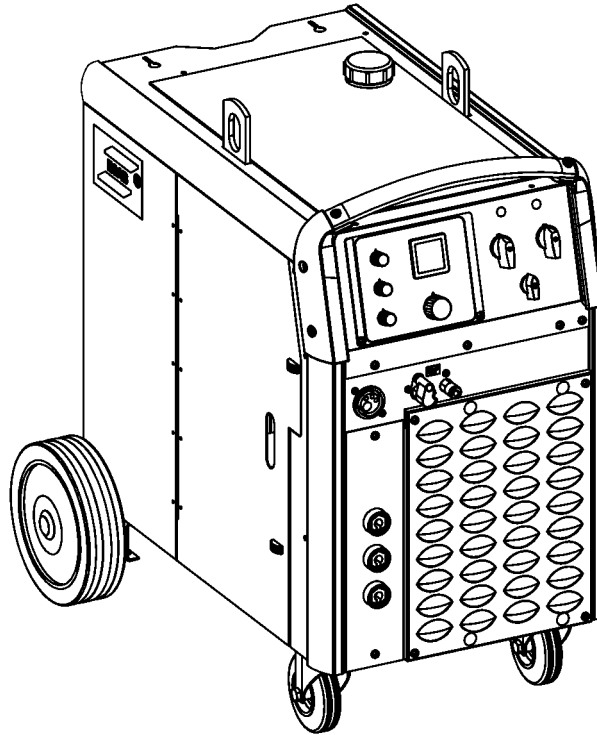


**Spare parts list**

**Valid for serial no. 237-xxx-xxxx**

**Ordering number**

0349 302 655	ESABMig C420	400-415V 3~50Hz
0349 303 079	ESABMig C420w	400-415V 3~50Hz; with water cooler
0349 303 196	ESABMig C420	230/400-415/500V 3~50Hz; 230/440-460V 3~60Hz
0349 303 080	ESABMig C420w	230/400-415/500V 3~50Hz; 230/440-460V 3~60Hz; with water cooler
0349 302 656	ESABMig C420s	400-415V 3~50Hz; synergetic
0349 303 081	ESABMig C420sw	400-415V 3~50Hz; synergetic, with water cooler

Spare parts are to be ordered through the nearest ESAB agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

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

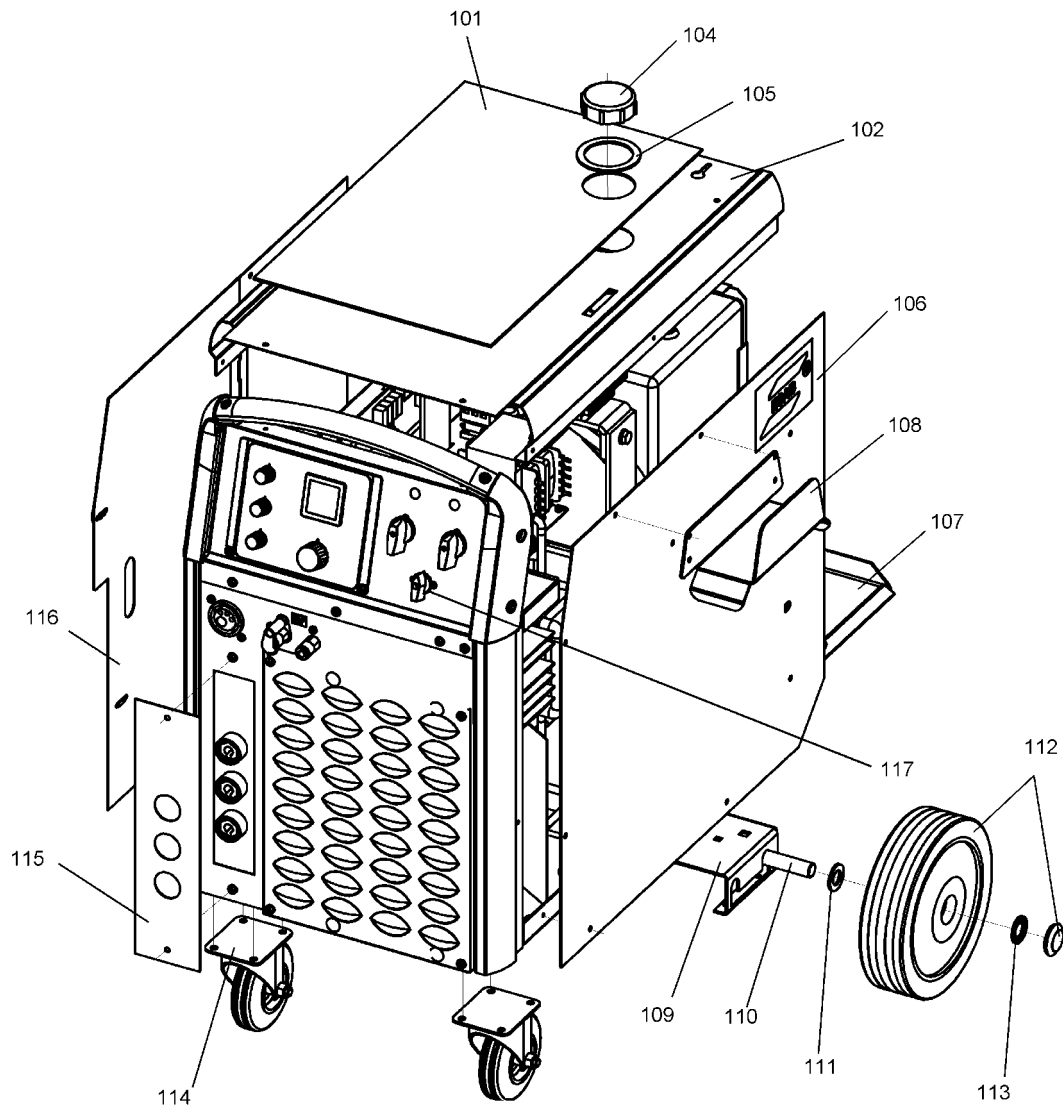
# ESABMig C420

(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
101	1	-	1	-	0349 303 097	Rubber mat		
102	1	1	1	1	0349 303 185	Cover		
103								
104	1	-	1	-	0469 689 002	Cover		
105	1	-	1	-	0366 481 004	Seal		
106	1	1	1	1	0349 303 178	Side panel - Right		
107	1	1	1	1	0349 302 267	Shelf		
108	1	1	1	1	0349 303 362	Holder for weld.gun		
109	1	1	1	1	0349 302 268	Clamp		
110	1	1	1	1	0469 516 005	Shaft		
111	2	2	2	2	0215 100 037	Washer	Ø 36/21x3	
112	2	2	2	2	0469 872 001	Wheel	Ø 250	
113	2	2	2	2	0192 859 126	Locking washer		
114	2	2	2	2	0349 304 853	Link wheel	Ø 125	
115	1	1	1	1	0349 303 102	Panel		
116	1	1	1	1	0349 303 015	Side panel - Left		
117	1	1	1	1	0349 302 305	Switch		QF1

# ESABMig C420

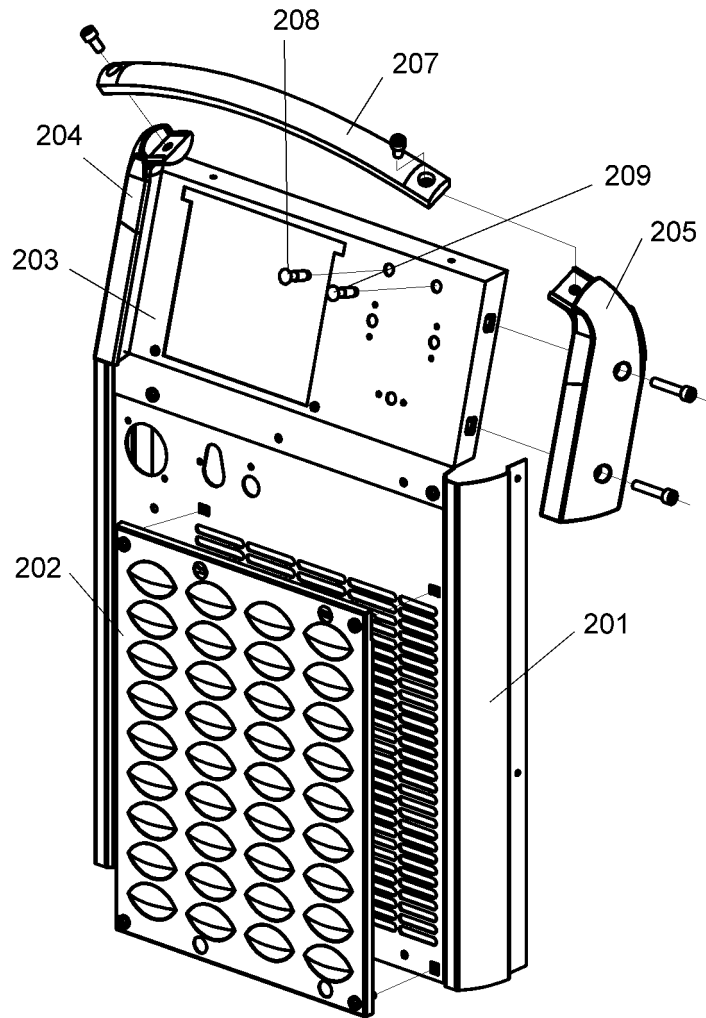


# ESABMig C420

(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
201	1	1	1	1	0349 302 947	Front panel plate		
202	1	1	1	1	0349 302 285	Grill		
203	1	1	1	1	0349 302 948	Front panel		
204	1	1	1	1	0349 302 282	Left corner		
205	1	1	1	1	0349 302 283	Right corner		
206								
207	1	1	1	1	0349 302 284	Handle		
208	1	1	1	1	0349 302 712	Lamp	green	H1
209	1	1	1	1	0369 733 005	Lamp	yellow	H2



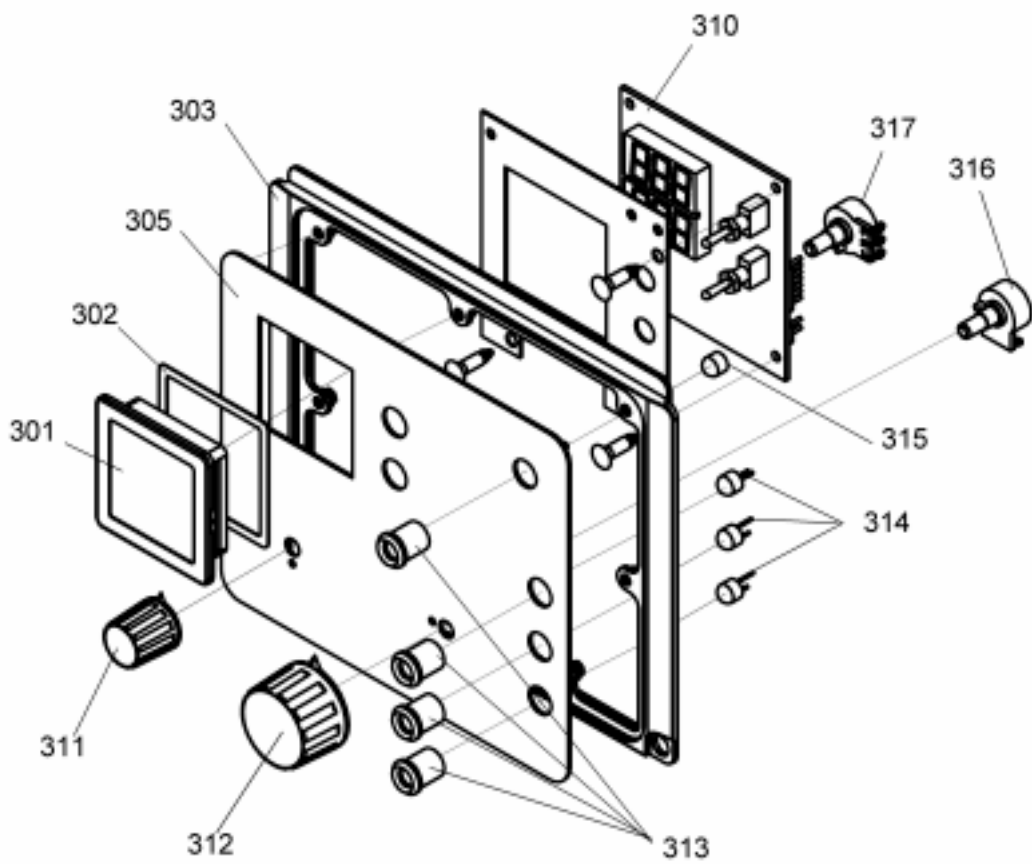
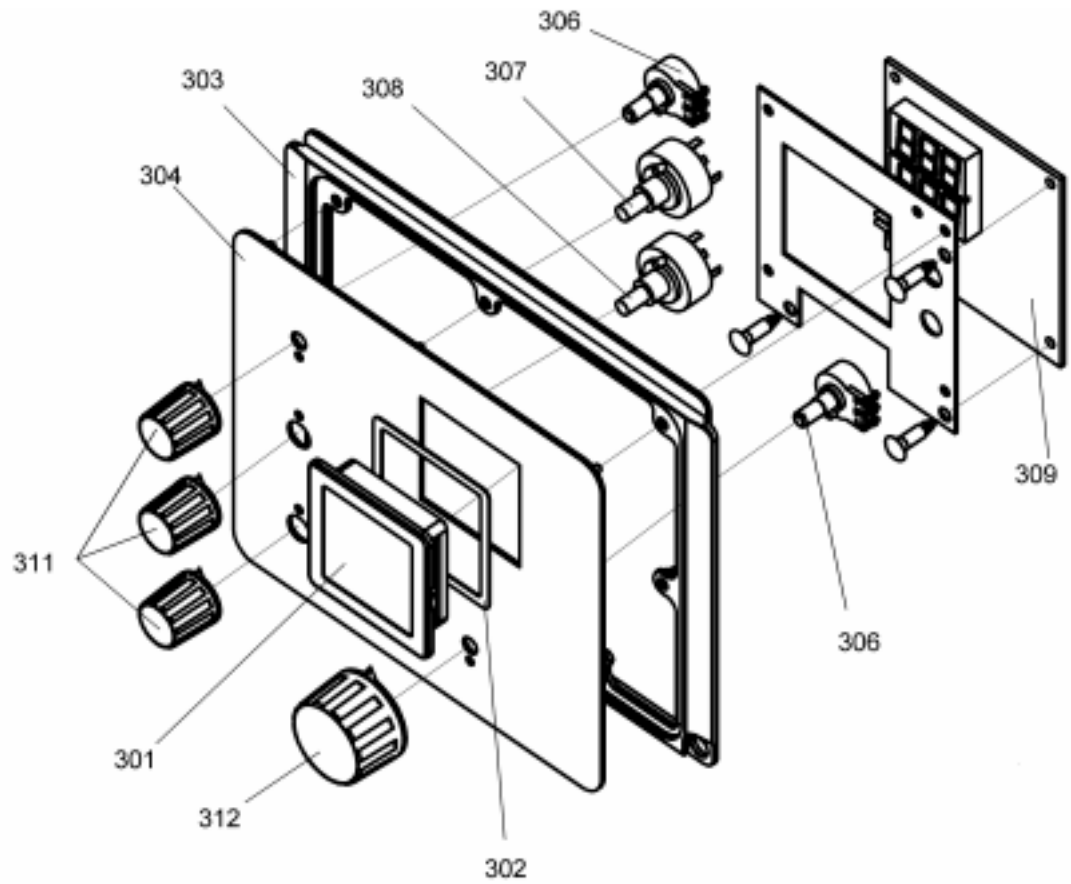
# ESABMig C420

(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
301	1	1	1	1	0455 172 001	Glass		
302	1	1	1	1	0455 174 001	Gasket		
303	1	1	1	1	0459 118 002	Plastic frame		
304	1	1	–	–	0349 302 912	Panel MMC–B2		
305	–	–	1	1	0349 302 939	Panel MMC–C		
306	2	2	–	–	0349 302 908	Potentiometer		RP1, RP2
307	1	1	–	–	0349 302 909 0349 303 985	Switch	for AP1 No: 0486 205 882 0486 205 886	SP1
308	1	1	–	–	0349 302 910	Switch		SP2
309	1	1	–	–	0349 302 451	V/A–Meter		AP2
	1	1	–	–	0349 495 934	Circuit – board (A)	Included in digital instrument (A)	AP2
310	–	–	1	1	0349 303 193	Digital instrument		AP2
311	3	3	1	1	0321 475 881	Knob		
312	1	1	1	1	0321 475 882	Knob		
313	–	–	4	4	0457 290 003	LED holder		
314	–	–	1 cpl	1 cpl	0349 303 073	Diode green–set		H5, H6, H7
315	–	–	1	1	0349 303 072	Diode green/red		H4
316	–	–	1	1	0349 303 180	Potentiometer		RP4
317	–	–	1	1	0349 303 179	Potentiometer		RP3

ESABMig C420



# ESABMig C420

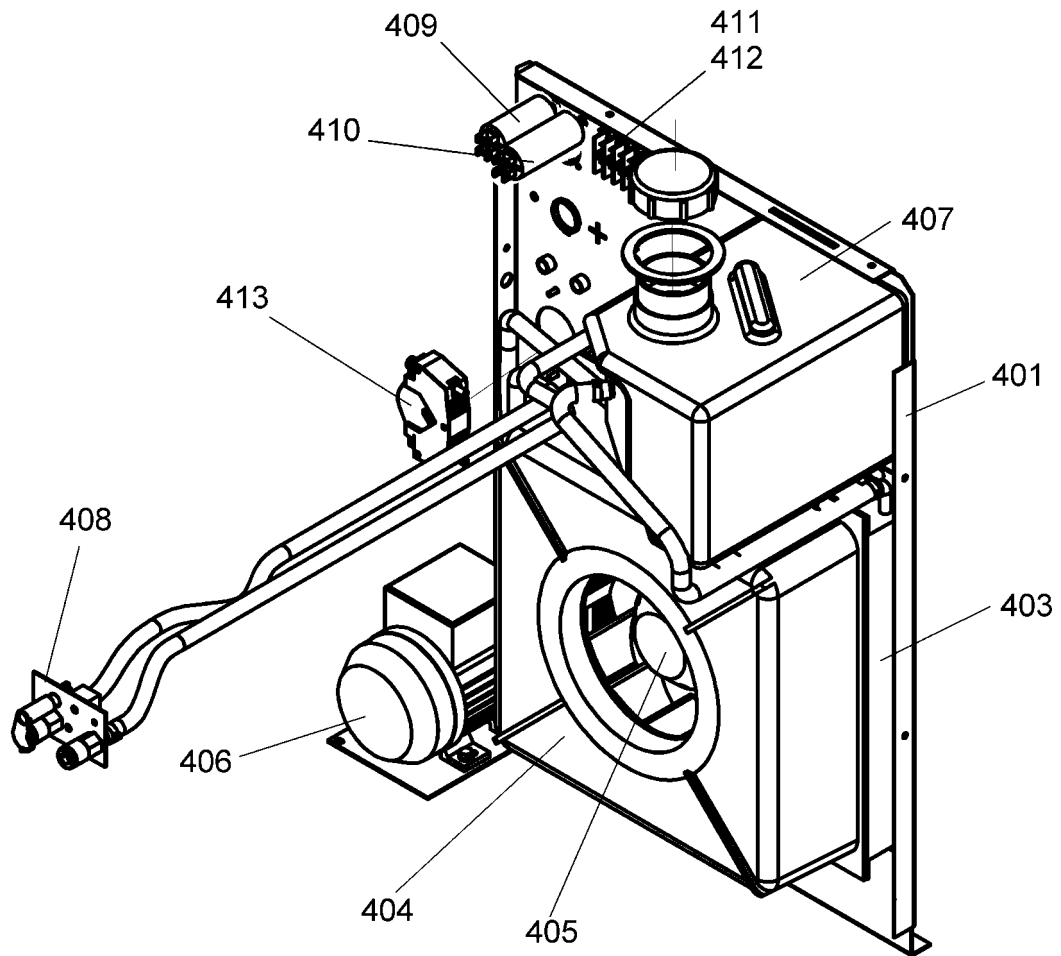
(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
401	1	1	1	1	0349 302 935	Rear plate		
402								
403	1	-	1	-	0469 688 001	Radiator		
404	1	1	1	1	0469 893 001	Fan Housing		
405	1	1	1	1	0369 827 001	Fan		EV1
406	1	-	1	-	0459 288 001	Pump		M1
407	1	-	1	-	0469 689 001	Water tank		
408	1	-	1	-	0458 370 900	Water conn - spare kit		S2
409	1	1	1	1	0191 085 203	Capacitor 400V	3uF	C4
410	1	1	1	1	0191 085 206	Capacitor 400V	6uF	C5
411	1	-	1	-	0466 884 008	Connection 8 pole		XT1
412	-	1	-	1	0466 884 003	Connection 3 pole		XT1
413	1	1	1	1	0469 950 880	Cable clamp		



**ESABMig C420**

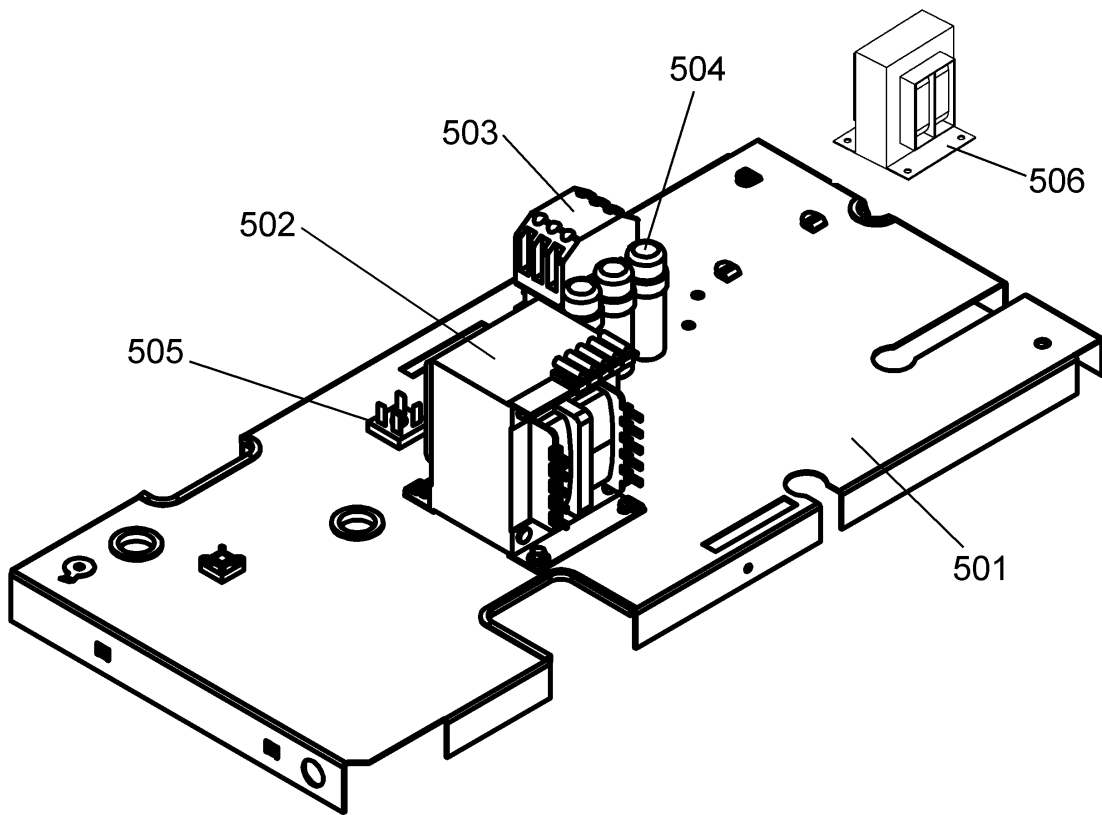


# ESABMig C420

(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
501	1	1	1	1	0349 302 937	Intermediate plate		
502	1	1	1	1	0469 882 001	Control transformer	400-415V	TC1
	1	1	-	-	0455 306 001	Control transformer	230-500V	TC1
	1	1	-	-	0349 303 749	Control transformer	230-575V	TC1
503	1	1	1	1	0193 502 101	Contactactor	400-415V	KM1
	1	1	-	-	0193 503 101	Contactactor	230-575V	KM1
504	1	1	1	1	0349 303 025	Filter unit		C1, C2, C3
505	1	1	1	1	0457 290 046	Bridge		V2
506	1	1	1	1	0349 302 250	Transformer for CO <sub>2</sub> heater kit		TC2

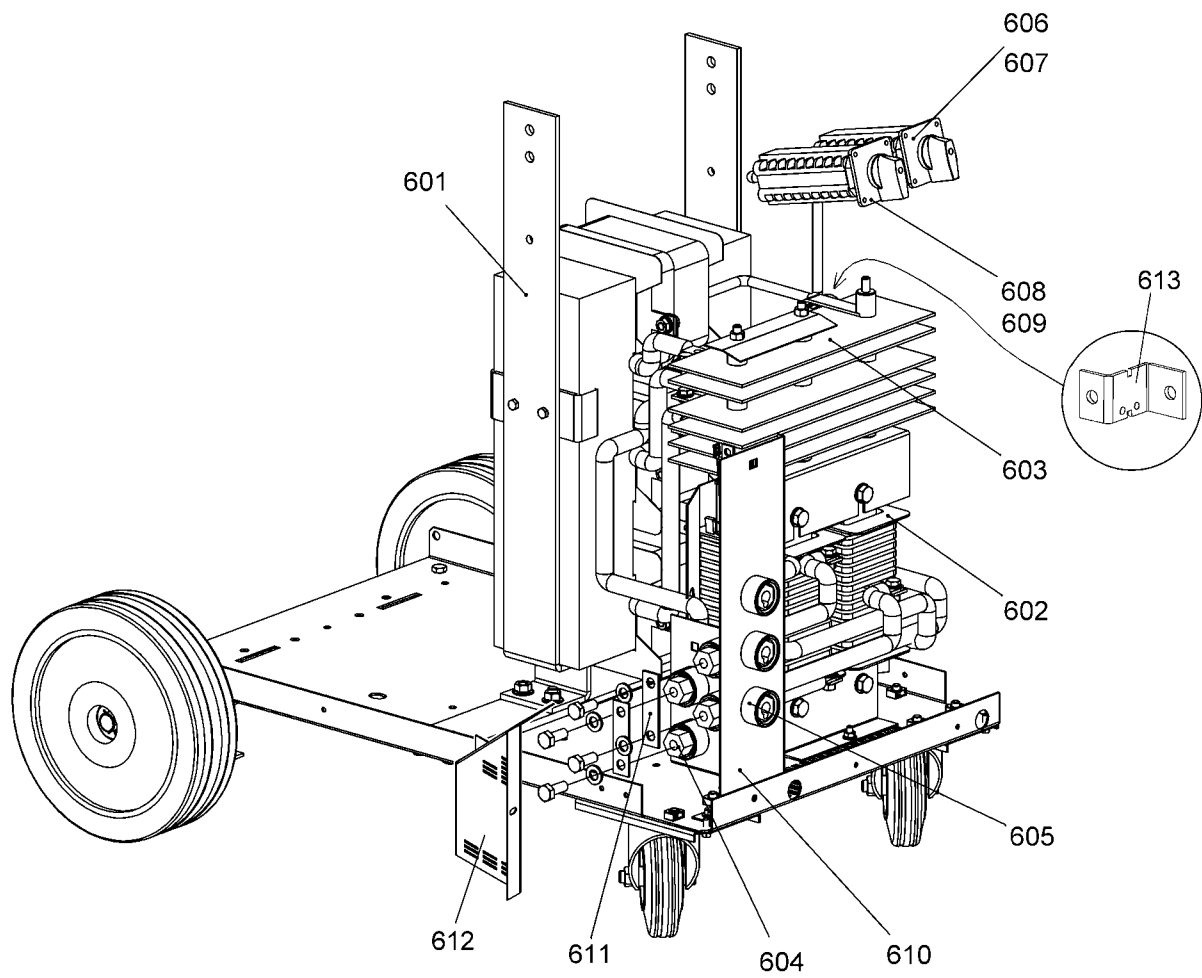


# ESABMig C420

(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
601	1	1	-	-	0349 302 957	Transformer with switches	400-415V	TM1
	-	-	1	1	0349 302 958	Transformer with switches	400-415V	TM1
	1	1	-	-	0349 302 959	Transformer with switches	230-500V	TM1
	-	1	-	-	0349 304 332	Transformer with switches	230-575V	TM1
	1	1	1	1	0349 302 961	Transformer	400-415V	TM1
	1	1	-	-	0349 303 198	Transformer	230-500V	TM1
	-	1	-	-	0349 304 333	Transformer	230-575V	TM1
	602	1	1	1	1	0349 303 019	Inductor	
603	1	1	1	1	0349 303 192	Bridge 3ph		V1
604	4	4	4	4	0349 303 689	Current connection cpl		XTP
605	3	3	3	3	0160 362 881	Cable connector OKC50-95		XB2-XB 4
606	1	1	-	-	0349 302 831	Cam switch	400-415V	QF3
	1	1	-	-	0349 304 078	Cam switch	230-575V	QF3
607	-	-	1	1	0349 302 996	Cam switch	400-415V	QF3
608	1	1	-	-	0349 302 832	Cam switch	400-415V	QF2
	1	1	-	-	0349 304 079	Cam switch	230-575V	QF2
609	-	-	1	1	0349 302 997	Cam switch	400-415V	QF2
610	1	1	1	1	0349 302 289	Bracket		
611	2	2	2	2	0349 303 688	Current rail		
612	1	1	1	1	0349 303 685	Connection shield with label		
613	-	-	1	1	0456 027 880	Shunt	Optional for C420/C420w as part of Digital Instrument	RS

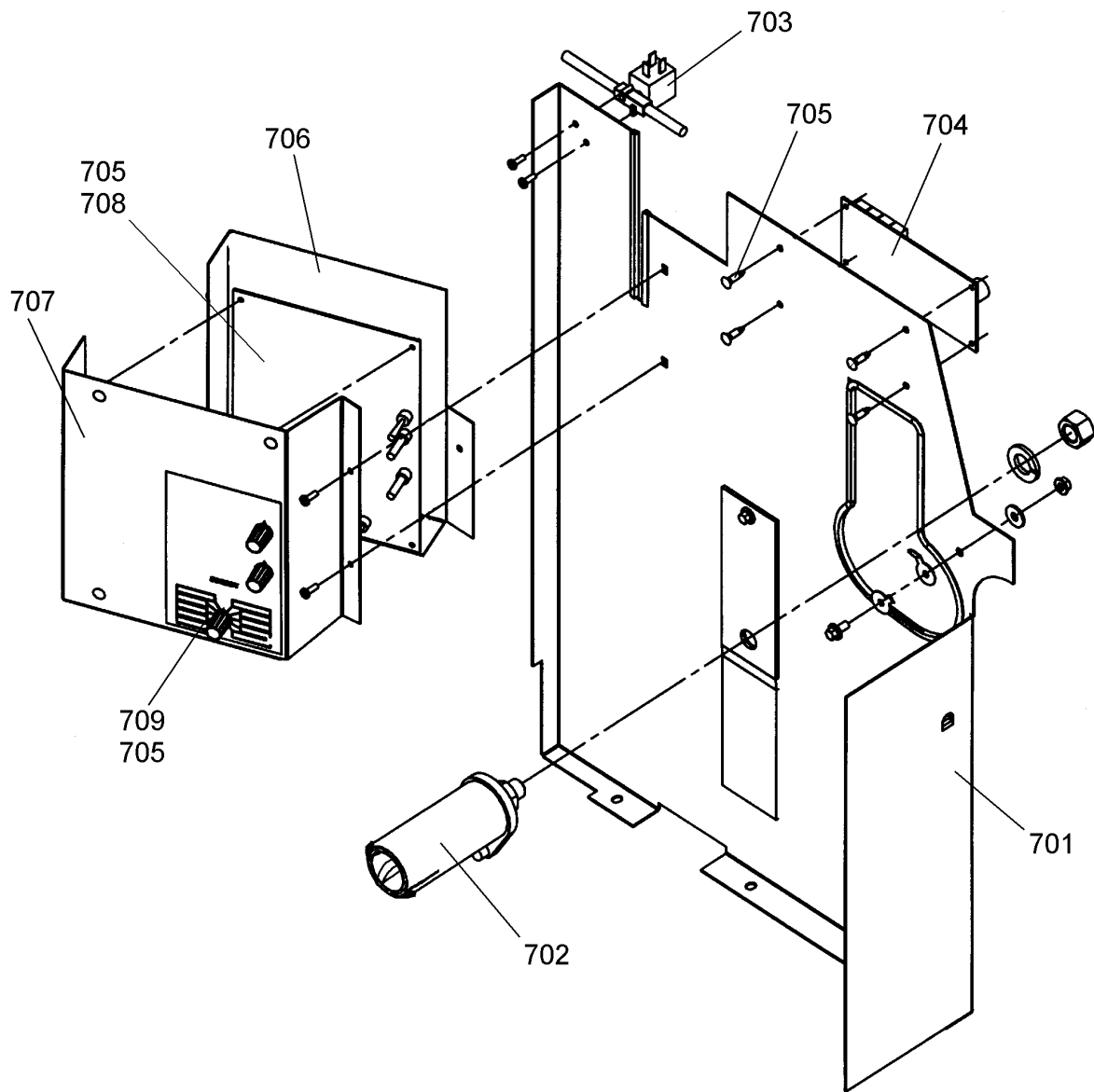


# ESABMig C420

(A) = accessory

C = component designation in the circuit diagram

Item	Qty C420w	Qty C420	Qty C420sw	Qty C420s	Ordering no.	Denomination	Notes	C
701	1	1	1	1	0349 303 007	Intermediate plate (EM C420)		
702	1	1	1	1	0146 967 881	Brake hub Light Duty		
703	1	1	1	1	0349 304 627	Gas module	42V,50-60Hz	YV1
704	1	1	1	1	0349 302 392	Electronic board LA10/1		AP3
705	8	8	8	8	0455 226 004	Spacer KGLS		
706	1	1	1	1	0349 302 980	Bracket (EM C420)		
707	1	1	1	1	0349 302 981	Bracket (EM C420)		
708	1	1	-	-	0486 205 882	PC Board MEK	until May 2003 since June 2003	AP1
					0486 205 886	PC Board ESABFeed MEK4		
709	-	-	1	1	0349 303 176	PC-Board		AP1



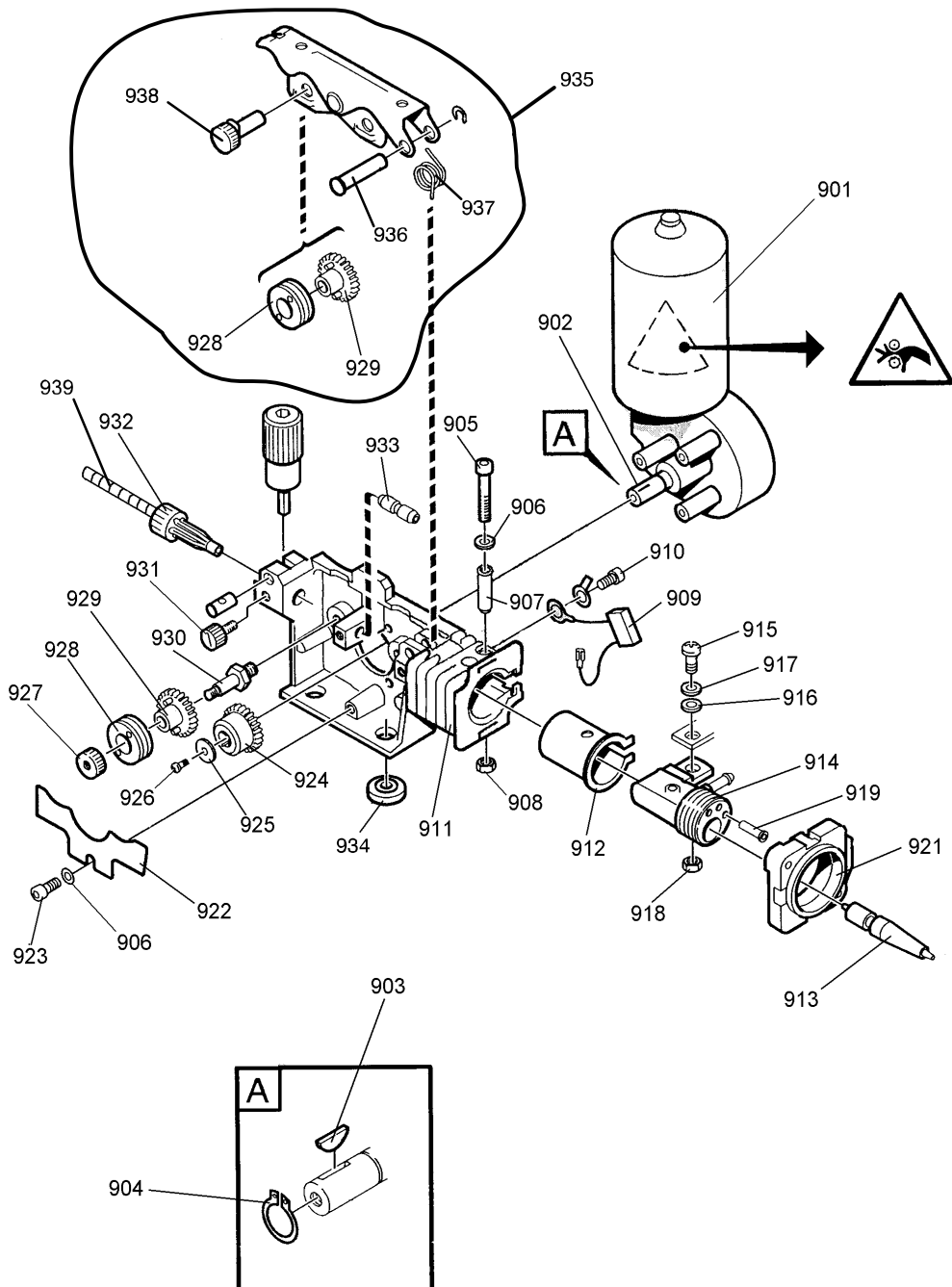
**C = component designation in the circuit diagram**

Item	Qty	Ordering no.	Denomination	Notes	C
	1	<b>0459 000 882</b>	<b>Wire feed mechanism</b>		
901	1	0455 077 001	Drive unit	With tachometer	M1
902	1	0332 351 012	Shaft (with pinion)	Included in item 901	
903	1	0191 496 114	Key	Included in item 901	
904	1	0215 701 007	Locking washer	Included in item 901	
905	1		Screw	M6x40	
906	2		Washer	Ø 12/6,4x1,5	
907	1	0455 048 001	Insulating tube		
908	1		Nut	M6	
909	1	0467 911 880	Capacitor		C3
910	4		Screw	M6x12	
911	1	0455 046 003	Gear housing		
912	1	0455 045 001	Insulating sleeve		
913	1	0469 837 880	Outlet nozzle	Ø2.0mm steel for 0.6–1.6mm wire	
	1		Outlet nozzle	Ø2.0mm plastic for 0.8–1.6mm Al wire	
914	1	0455 044 001	Current connection		
915	1		Screw	M8x25	
916	1		Washer	Ø 16/8,4x1,5	
917	1		Spring washer	Ø 16/8,2x0,9	
918	1		Nut	M8	
919	2	0368 750 001	Insulating sleeve		
921	1	0458 918 880	Front flange		
922	1	0469 838 001	Cover		
923	3		Screw	M6x12	
924	1	0459 440 001	Drive gear	Replacing 0455 052 001	
925	1		Washer	Ø 16/5x1M4x12	
926	1		Screw		
927	2	0458 721 001	Locking nut		
928	4	0459 052 001	Feed/pressure roller	Ø 0.6–0.8mm Fe, Ss, Al, cored wire	
	4	0459 052 002	Feed/pressure roller	Ø 0.8–1.0mm Fe, Ss, Al, cored wire	
	4	0459 052 003	Feed/pressure roller	Ø 1.0–1.2mm Fe, Ss, Al, cored wire	
	4	0459 052 013	Feed/pressure roller	Ø 1.4–1.6mm Fe, Ss, cored wire	
	4	0458 825 001	Feed/pressure roller	Ø 1.0–1.2mm V-groove, knurled	
	4	0458 825 002	Feed/pressure roller	Ø 1.2–1.4mm V-groove, knurled	
	4	0458 825 003	Feed/pressure roller	Ø 1.6–2.0mm V-groove, knurled	
	4	0458 824 001	Feed/pressure roller	Ø 0.8–1.0mm Al wire, U-groove	
	4	0458 824 003	Feed/pressure roller	Ø 1.2–1.6mm Al wire, U-groove	
929	4	0459 441 880	Gear adapter	Replacing 0455 053 880	
930	2	0458 722 001	Feed roll axle		
931	3	0458 689 001	Nozzle screw		



# ESABMig C420

Item	Qty	Ordering no.	Denomination	Notes	C
932	1	0455 049 001	Inlet nozzle	Ø 3.0mm plastic for 0.6–1.6mm Fe, Ss, Al, cored wire	
933	1	0455 072 002	Intermediate nozzle	Al	
	1	0456 615 001	Intermediate nozzle		
934	4	0153 043 002	Insulating washer		
935	1	0459 001 880	Pressure arm complete		
936	1	0458 997 001	Shaft		
937	1	0458 993 001	Torsion spring		
938	2	0458 999 001	Shaft		
939	1	0349 303 018	Liner	Fe, Ss, cored wire	
	1	0455 894 001	Liner	Al	



**Wear components****(W. F. Mechanism 0459 000 882)**

Item	Denomination	Ordering no.	Notes
<b>A</b>	Feed / pressure roller	0459 052 001	Ø 0.6 & 0.8 mm; Fe, Ss & cored wire; V-groove
		0459 052 002	Ø 0.8 & 1.0 mm; Fe, Ss & cored wire; V-groove
		0459 052 003	Ø 0.9/1.0 & 1.2 mm; Fe, Ss & cored wire; V-groove
		0459 052 013	Ø 1.4 & 1.6 mm; Fe, Ss & cored wire; V-groove
		0458 825 001	Ø 0.9/1.0 & 1.2 mm; Cored wire; V-groove; knurled
		0458 825 002	Ø 1.2 & 1.4 mm; Cored wire; V-groove; knurled
		0458 825 003	Ø 1.6 & 2.0 mm; Cored wire; V-groove; knurled
		0458 824 001	Ø 0.8 & 0.9/1.0 mm; Al wire; U-groove
0458 824 003	Ø 1.2 & 1.6 mm; Al wire; U-groove		
<b>B</b>	Gear adapter	0459 441 880	Replacing 0455 053 880
<b>C</b>	Inlet nozzle	0455 049 001	
<b>D</b>	Drive gear	0459 440 001	Replacing 0455 052 001
<b>E</b>	Intermediate nozzle	0455 072 002	Fe, Ss & cored wire
		0456 615 001	Al wire
<b>F</b>	Outlet nozzle	0469 837 880	Ø 2.0 mm steel for 0.6–1.6 mm Fe, Ss & cored wire
		0469 837 881	Ø 2.0 mm plastic for 0.8–1.6 mm Al wire
<b>G</b>	Liner	0349 303 018	Fe, Ss & cored wire
		0455 894 001	Al wire

The rollers are marked with wire dimension in mm, some are also marked with inch.

**Welding with aluminium wires.**

In order to weld with aluminium wires, proper rollers, nozzles and liners for aluminium wires **MUST** be used. It is recommended to use 3m long welding gun for aluminium wires, equipped with appropriate wear parts.

