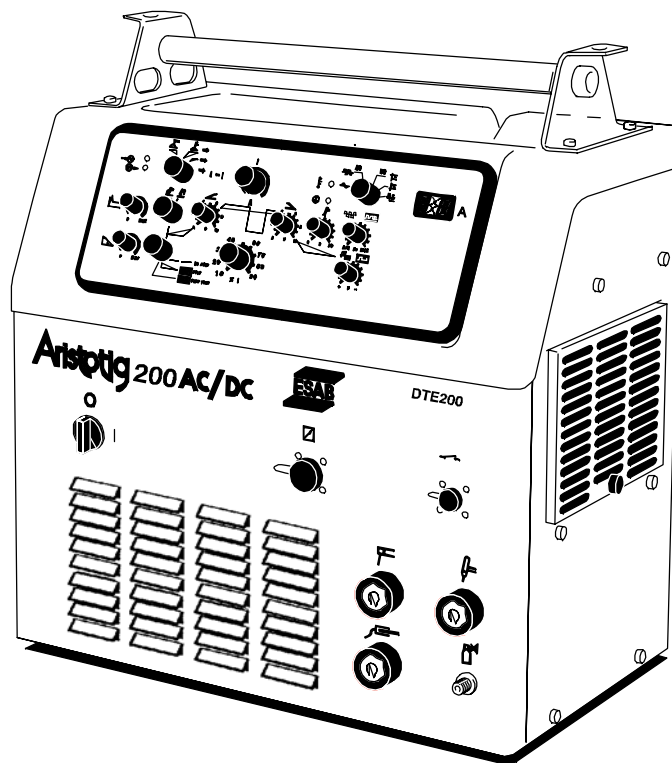


Spare parts list



Valid for serial no. 914-xxx-xxxx, 246-xxx-xxxx

Ordering number

0301 070 880 DTE 200 with central connection for the TIG torch

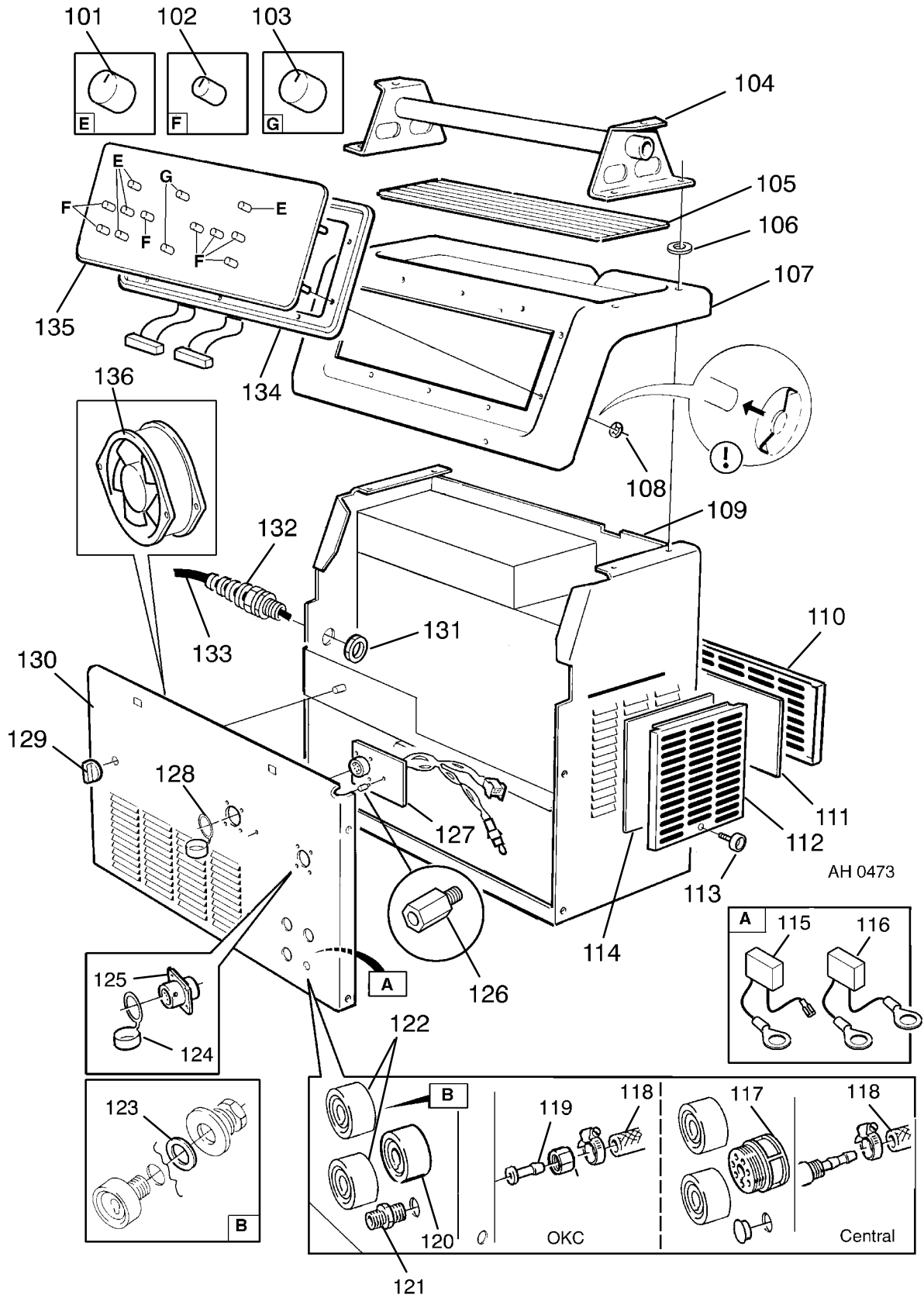
0301 070 881 DTE 200 with OKC connection for the TIG torch

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.

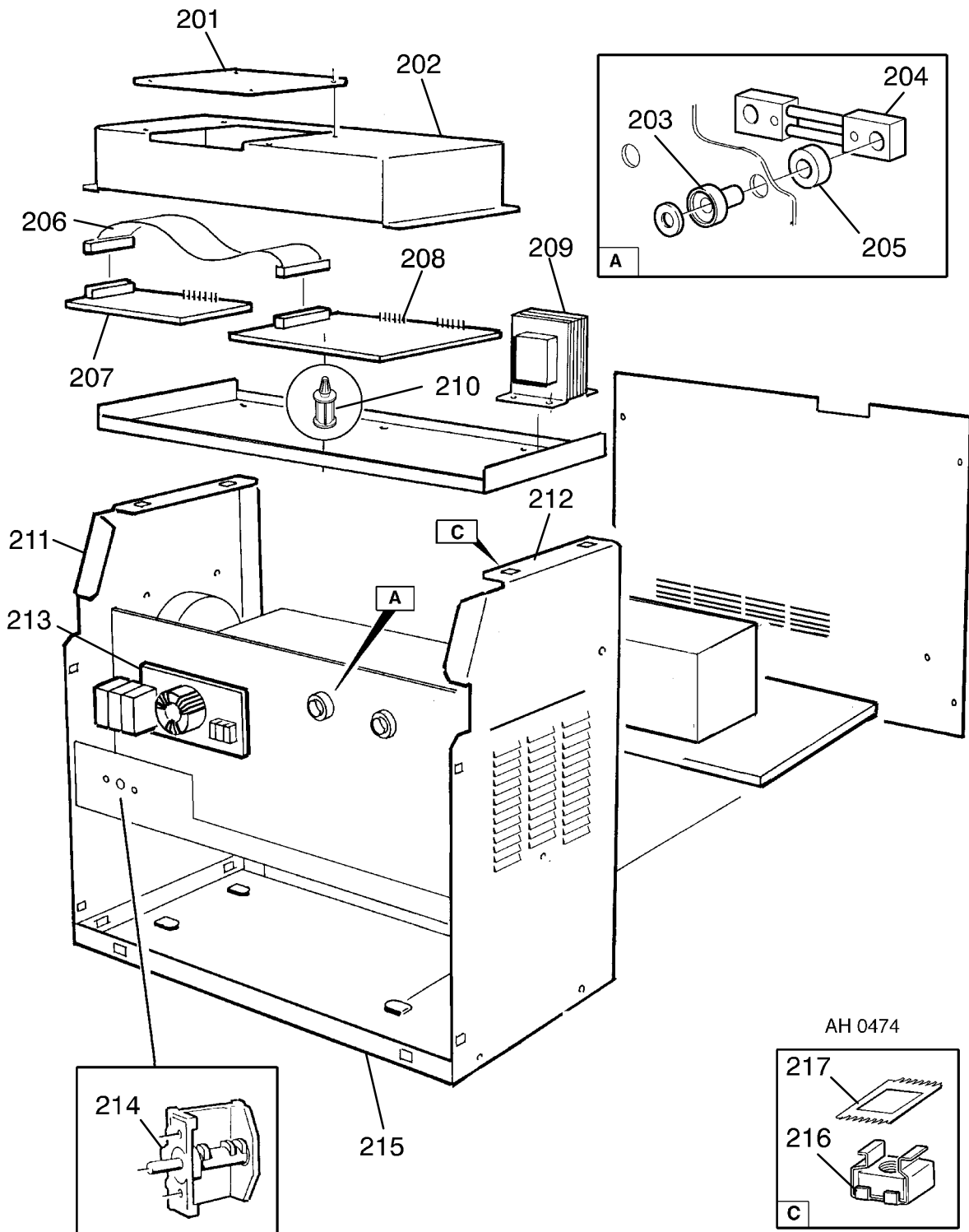
C = component designation in the circuit diagram

| Item | Qty | Ordering no. | Denomination | Notes | C |
|------|-----|--------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|
| 101 | 4 | 0192 296 104 | Knob | | |
| 102 | 7 | 0191 508 102 | Knob | | |
| 103 | 2 | 0192 296 102 | Knob | | |
| 104 | 1 | 0468 543 882 | Handle | | |
| 105 | 1 | 0468 529 001 | Rubber mat | | |
| 106 | 4 | 0365 534 001 | Sealing washer | | |
| 107 | 1 | 0301 015 001 | Cover | When the cover is replaced, items 108 and 134 must also be replaced | |
| 108 | 10 | 0192 859 006 | Locking washer | Must be pressed with 50 kg pressure when fitted. | |
| 109 | 1 | 0301 021 001 | Rear plate | | |
| 110 | 1 | 0301 028 001 | Grill | | |
| 111 | 1 | 0301 054 001 | Filter | | |
| 112 | 1 | 0301 027 001 | Grill | | |
| 113 | 3 | 0441 819 001 | Screw | | |
| 114 | 1 | 0301 053 001 | Filter | | |
| 115 | 1 | 0457 817 881 | Capacitor | 47 nF, 275 V AC, with cable lugs | C06 |
| 116 | 1 | 0457 817 880 | Capacitor | 47 nF, 1000 V AC, with cable lugs | C07 |
| 117 | 1 | 0367 258 880 | Central connection | For machines with central TIG connection | XS12 |
| 118 | | 0190 209 114 | Hose | To be ordered per metre | |
| 119 | 1 | 0252 103 501 | Hose nipple | For machines with OKC TIG connection | |
| 120 | 1 | 0156 868 880 | OKC-TIG | For machines with OKC TIG connection | XS12 |
| 121 | 1 | 0156 867 001 | Gas outlet bushing | For machines with OKC TIG connection | |
| 122 | 2 | 0160 362 881 | OKC | | XS13, XS14 |
| 123 | 2 | 0466 325 001 | Gasket | For machines with central TIG connection | |
| | 3 | 0466 325 001 | Gasket | For machines with OKC TIG connection | |
| 124 | 1 | 0457 626 001 | Cap | | |
| 125 | 1 | 0538 500 902 | Connector socket | For machines with OKC TIG connection | XS15 |
| 126 | 1 | 0394 516 005 | Spacer | | |
| 127 | 1 | 0486 634 880 | Circuit board | With connector XB | AP06 |
| | 2 | 0193 260 150 | Connector | 2-pole | XA, XD |
| | 1 | 0193 260 153 | Connector | 5-pole | XC |
| 128 | 1 | 0366 285 001 | Cap | | |
| 129 | 1 | 0366 296 003 | Knob | | |
| 130 | 1 | 0301 049 002 | Front plate | | |
| 131 | 1 | 0212 602 202 | Nut | | |
| 132 | 1 | 0193 307 105 | Cable clamp | Cable inlet | |
| 133 | 1 | 0467 696 886 | Mains cable | | |
| - | 2 | 0194 034 002 | Ferrite ring core | To be fitted close to the mains cable inlet | L04 |
| 134 | 1 | 0468 304 001 | Rubber seal | | |
| 135 | 1 | 0301 069 883 | Panel complete | Front panel, circuit board AP05, 13 knobs (items 101, 102 and 103) and 12 locking washers (item 108) are included. When replacing item 135, item 134 must also be replaced. NOTE: This panel does only fit in machines having processor board AP04 with part no. 0486 770 880. If the machine has a processor board with part no. 0486 665 880, this must also be replaced. | AP05 |
| | 1 | 0193 260 160 | Connector | 12-pole | XA |
| 136 | 1 | 0466 109 001 | Fan | | |



C = component designation in the circuit diagram

| Item | Qty | Ordering no. | Denomination | Notes | C |
|------|-----|--------------|---------------------|------------------------------------------------------------|------------|
| 201 | 1 | | Cover | Replaced by item 202 | |
| 202 | 1 | 0301 075 001 | Screening box | New design with built-in cover, fits to all machines | |
| 203 | 2 | 0162 414 001 | Insulating tube | | |
| 204 | 1 | 0301 041 001 | Shunt | 250 A / 60 mV | RS01 |
| 205 | 2 | 0163 139 001 | Bushing | | |
| 206 | 1 | 0193 700 401 | Ribbon cable | Connectors AP01:XD and AP04:X1/XA are included | |
| 207 | 1 | 0486 770 880 | Circuit board | Replacing circuit board 0486 665 880, fits in all machines | AP04 |
| | 1 | 0193 260 153 | Connector | 5-pole | X4/XD |
| | 1 | 0193 260 155 | Connector | 7-pole | X9/XB |
| 208 | 1 | 0486 810 880 | Circuit board | Replacing circuit board 0486 657 880 | AP01 |
| | 1 | 0193 260 151 | Connector | 3-pole | XA |
| | 1 | 0193 260 158 | Connector | 10-pole | XB |
| | 1 | 0193 494 003 | Ferrite ring core | | L05 |
| | 3 | 0193 260 150 | Connector | 2-pole | XE, XF, XG |
| | 1 | 0193 260 153 | Connector | 5-pole | XI |
| | 2 | 0193 260 152 | Connector | 4-pole | XK, XL |
| 209 | 1 | 0301 006 001 | Control transformer | | TC01 |
| 210 | 10 | 0192 790 103 | Spacer | | |
| 211 | 1 | 0301 016 001 | Side panel (left) | | |
| 212 | 1 | 0301 017 001 | Side panel (right) | | |
| 213 | 1 | 0486 577 880 | Circuit board | EMC filter | AP08 |
| 214 | 1 | 0366 295 004 | Switch | | QF01 |
| 215 | 1 | 0301 033 001 | Base plate | | |
| 216 | 4 | 0192 562 105 | Cage nut | M6 | |
| 217 | 6 | 0320 029 002 | Ground stud | | |

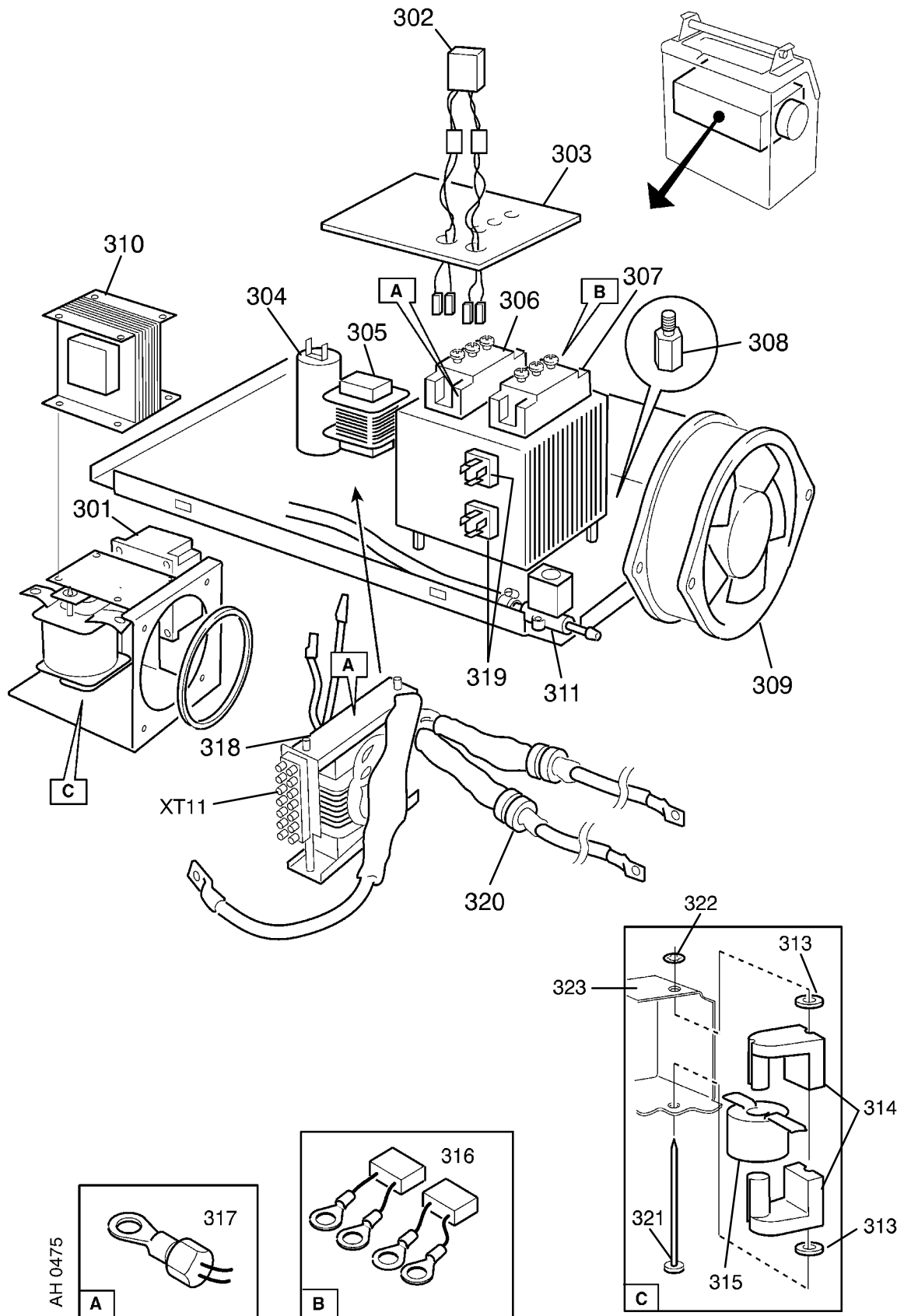


C = component designation in the circuit diagram

| Item | Qty | Ordering no. | Denomination | Notes | C |
|------|-----|--------------|--------------------|--------------------------------------|----------------|
| 301 | 1 | 0367 268 001 | HF unit | | AP13 |
| 302 | 1 | 0486 603 880 | IGBT connection | | AP11, AP12 |
| 303 | 1 | 0486 681 880 | Circuit board | IGBT | AP02 |
| | 4 | 0193 260 150 | Connector | 2-pole | XA, XB, XE, XF |
| 304 | 1 | 0191 085 208 | Capacitor | 10 μ F, 450 V AC | C04 |
| 305 | 1 | 0365 591 882 | Primary inductor | | L01 |
| 306 | 1 | 0194 080 001 | IGBT module | | Q5 |
| | | 0192 058 101 | Thermal compound | For fitting of Q01, Q02, Q05 and V07 | |
| 307 | 1 | | Diode module | See item 350 | V07 |
| 308 | 4 | 0394 516 031 | Spacer screw | | |
| 309 | 1 | 0466 109 001 | Fan | 230 V | EV01 |
| 310 | 1 | 0301 026 880 | Secondary inductor | | L02 |
| 311 | 1 | 0193 054 002 | Solenoid valve | | YV01 |
| 313 | 4 | 0365 534 001 | Spacer washer | | |
| 314 | 2 | 0193 312 101 | Ferrite core | | |
| 315 | 1 | 0455 043 880 | HF coil | | TV01 |
| 316 | 2 | 0320 805 887 | Capacitor | 0.01 μ F, 1000 V | C10, C11 |
| 317 | 2 | 0194 050 001 | PTC resistor | Thermal sensor | ST01, ST03 |
| 318 | 1 | 0301 007 880 | Main transformer | Item 320 is included | TM01 |
| 319 | 2 | 0193 316 208 | Rectifier bridge | | V01, V02 |
| 320 | 4 | 0193 494 004 | Ferrite ring cores | Included in TM01 | L03 |
| 321 | 2 | 0365 584 002 | Nail | | |
| 322 | 2 | 0192 859 006 | Locking washer | | |
| 323 | 1 | 0468 527 001 | Bracket | | |

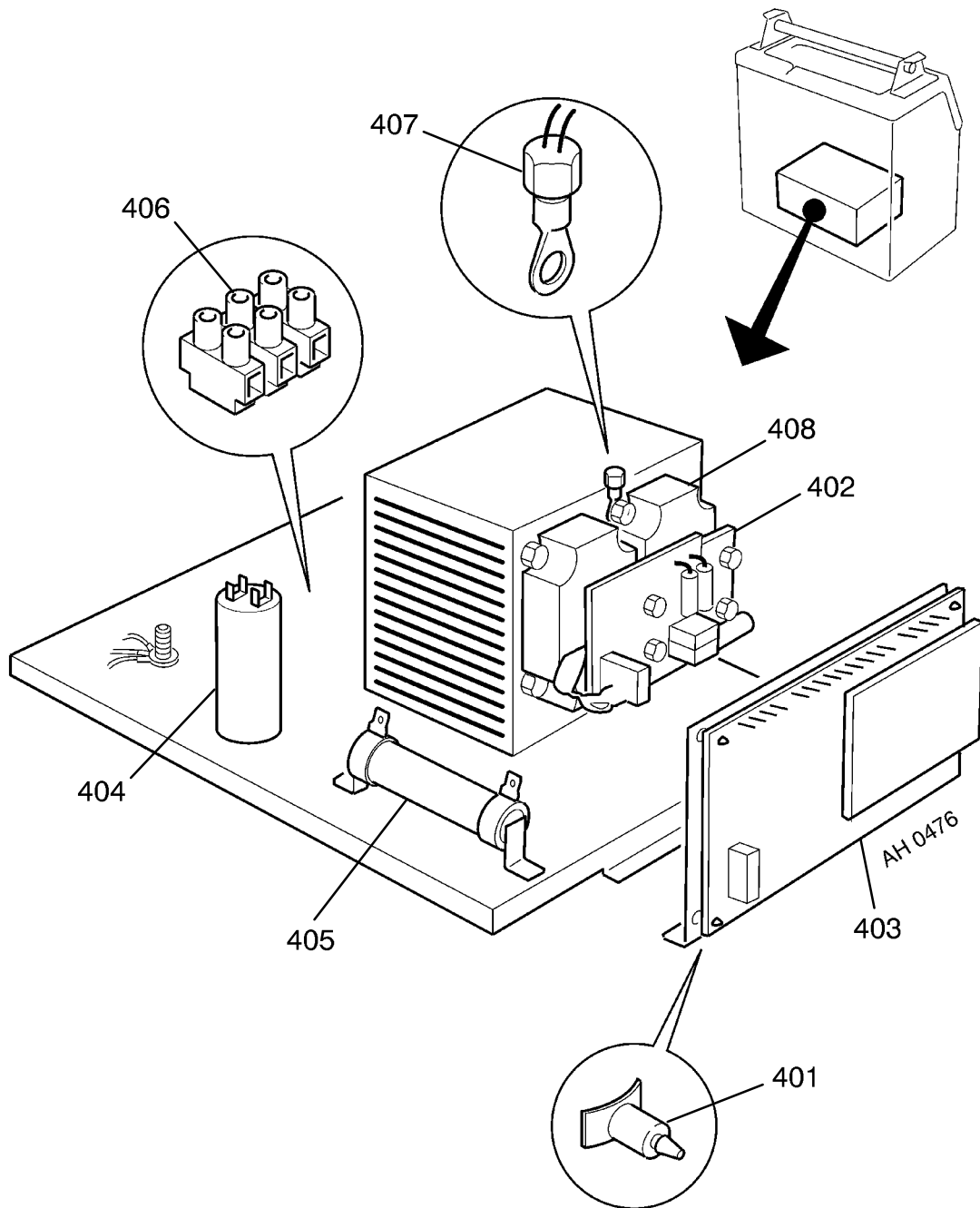
SPARE PARTS SET

| Item | Ordering no. | Denomination | Notes |
|------|--------------|------------------|------------------------------------------------------------------------------------|
| 350 | 0458 920 882 | Diode module set | Includes item 307 diode module, thermal compound, roller and mounting instruction. |
| - | 0458 910 002 | Roller handle | For the roller in the spare parts set above. |

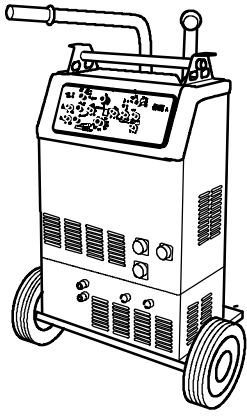
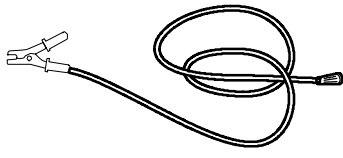
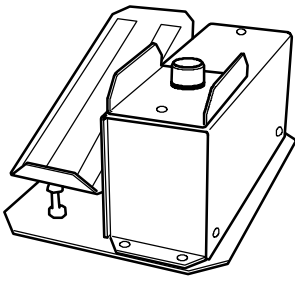
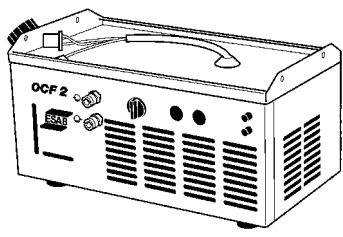
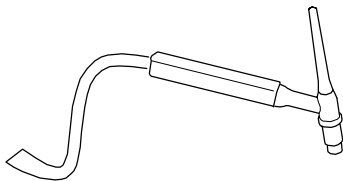


C = component designation in the circuit diagram

| Item | Qty | Ordering no. | Denomination | Notes | C |
|------|-----|--------------|----------------|--------------------------------------|----------|
| 401 | 6 | 0455 226 004 | Spacer | | |
| 402 | 1 | 0486 693 880 | Circuit board | | AP09 |
| 403 | 1 | 0486 829 880 | Circuit board | Replacing circuit board 0486 648 880 | AP07 |
| | 1 | 0193 260 158 | Connector | 10-pole | XA |
| | 1 | 0193 260 067 | Connector | 8-pole | XB |
| | 1 | 0193 260 153 | Connector | 5-pole | XC |
| | 1 | 0193 260 159 | Connector | 12-pole | XD |
| 404 | 1 | 0191 085 208 | Capacitor | 10 μ F, 450 V AC | C09 |
| 405 | 1 | 0349 061 004 | Resistor | 120 Ω , 80 W | R03 |
| 406 | 1 | 0193 045 011 | Terminal block | | XT23 |
| 407 | 1 | 0194 050 001 | PTC resistor | Thermal sensor | ST02 |
| 408 | 2 | 0194 079 001 | IGBT-module | | Q01, Q02 |



Accessories

| | |
|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Trolley (with room for gas bottle) 0301 100 880</p> |
|  | <p>Return cable 0369 857 888</p> |
|  | <p>Foot control FS 002 0349 090 886</p> |
|  | <p>Cooling unit OCF 2D 0457 216 881</p> |
|  | <p>TIG torches HW 26 R, 4 m with OKC connection 0588 000 738 HW 26 R, 4 m with central connection 0588 000 740 HW 20, 4 m with OKC connection 0588 000 744 HW 20, 4 m with central connection 0588 000 746</p> |