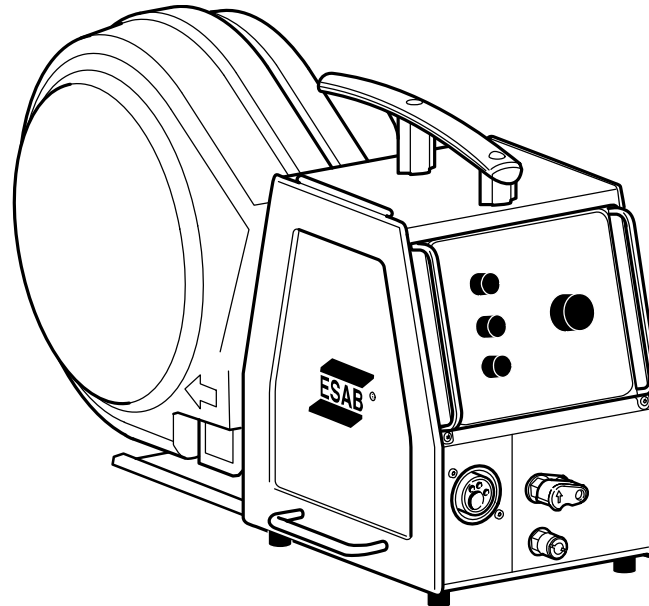


Spare parts list

Edition 101103



Valid for serial no. 238-xxx-xxxx, 410-xxx-xxxx, 440-xxx-xxxx, 620-xxx-xxxx, 917-xxx-xxxx,

The wire feed unit is renamed:

New name	Old name
Origo™ Feed 302, M11	ESABFeed 30-2 M11

Ordering no.	Product
0459 116 781	Feed 302, M11
0459 116 381	Feed 302, M11, US version
0459 116 791	Feed 302, M11, with water cooling

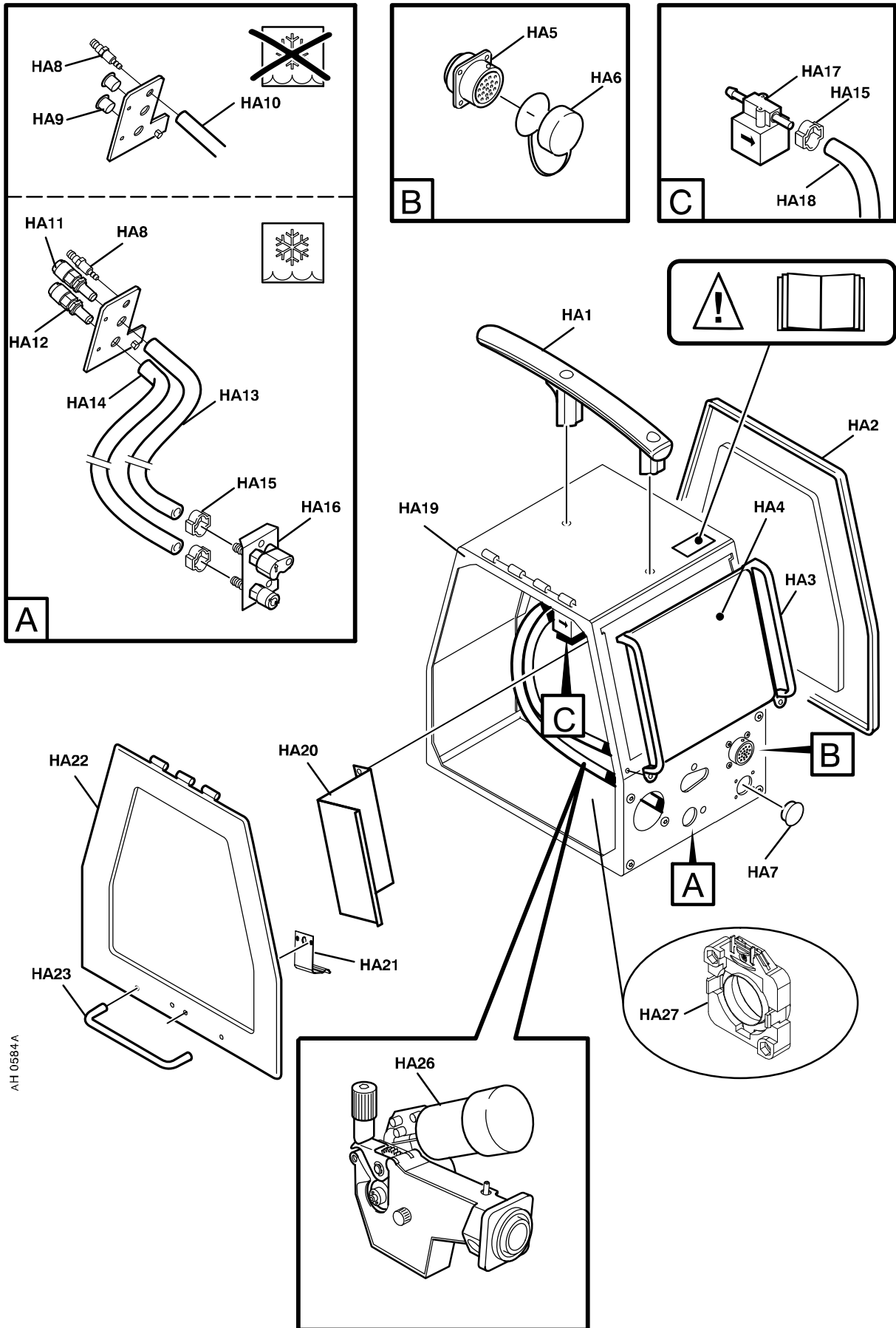
Spare parts are to be ordered through the nearest ESAB agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

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

Rights reserved to alter specifications without notice.

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
HA1	1	0459 119 001	Handle		
HA2	1	0459 069 004	Side panel		
		0459 213 001	Label for side panel		
HA3	1		Protection frame	For further information see page 10.	
HA4	1		MMC module	Panel M11. For further information see page 10.	
HA5	1	0368 544 005	Socket	23 pole panel socket	
		0323 945 003	Sleeve	For 23 pole socket	
HA6	1	0455 516 001	Cap	23 pole	
HA7	1		Cover plug	Ø 26	
HA8			Quick connection	Male, Included in item HA17a from ser.no xxx-526-xxxx	
	1	0367 149 001	Quick connection	Male. For serial no 238-xxx-xxxx to xxx-525-xxxx	
HA9	2	0192 230 105	Cover plug		
HA11	1	0365 803 016	Quick connection	Female, Red	
HA12	1	0365 803 017	Quick connection	Female, Blue	
HA13	1	0456 496 002	Hose, blue	L=0.33, Ø 9/5mm, to be ordered per metre	
HA14	1	0456 496 001	Hose red	L=0.33, Ø 9/5mm, to be ordered per metre	
HA15			Hose clamp	Ø 11.3/10.8	
HA16	1		Water outlet with lock	For futher information see page 9.	13S1
HA17a	1	0193 054 007	Solenoid valve	From serial no. xxx-526-xxxx	13YV1
HA17b	1	0193 054 002	Solenoid valve	For serial no 238-xxx-xxxx to xxx-525-xxxx	13YV1
HA18	1	0456 496 001	Hose, red	L=0.27, Ø 9/5mm, to be ordered per metre	
HA19	1	0192 526 002	Sealing strip	L=1.34	
HA20	1	0459 148 001	Protective cover MMC panel		
HA21	1	0459 547 001	Locking device	Replacing 0367 902 001	
HA22	1	0459 069 003	Side panel		
-		0459 213 001	Label for side panel		
HA23	1	0458 777 002	Protection clamp	Handle	
HA26	1		Wire feed mechanism	Type MEK 2, see page 6.	
HA27	1	0458 918 880	Front flange	Current relay	

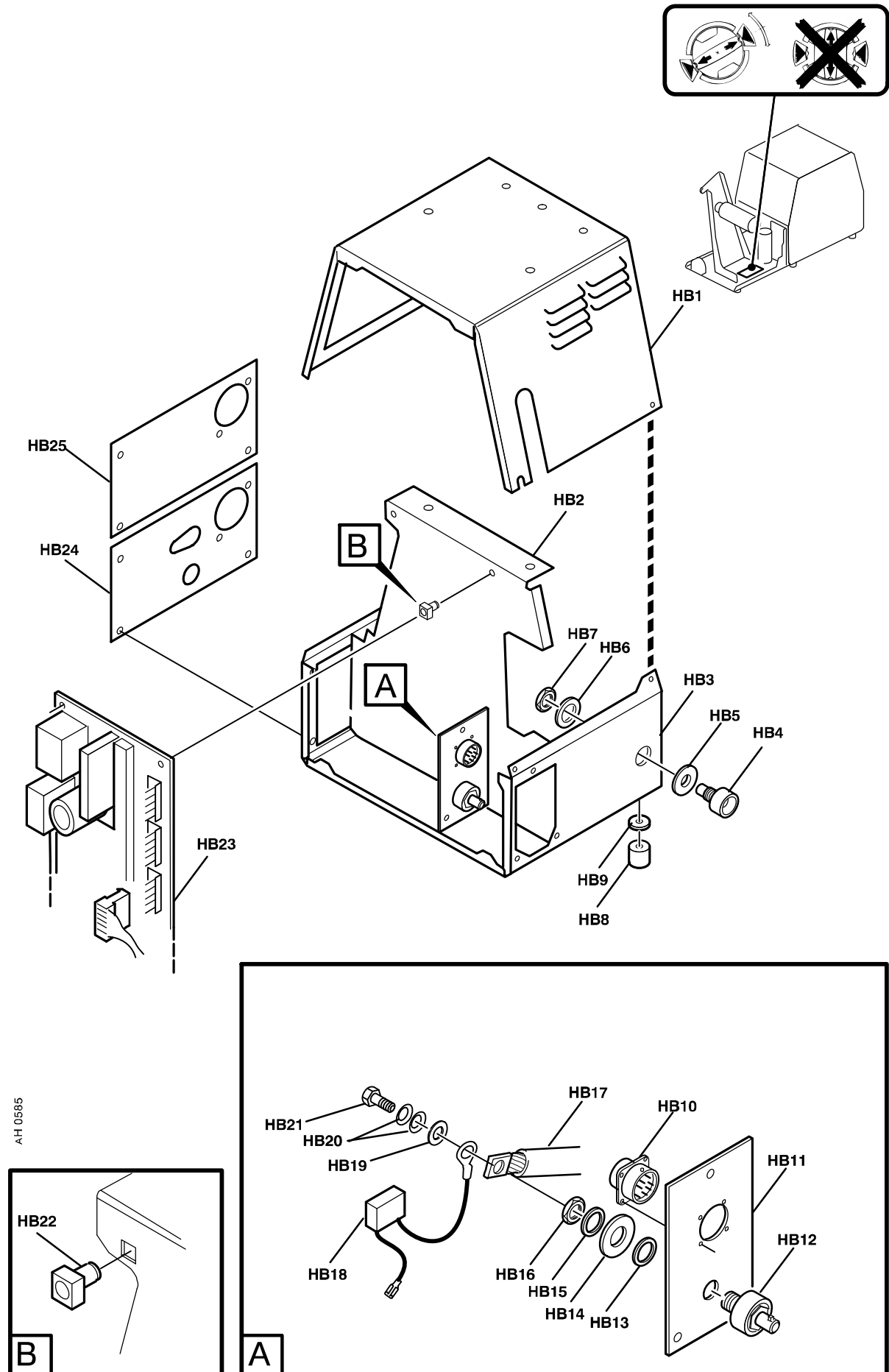


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**C = component designation in the circuit diagram
(W) = wear part**

Item	Qty	Ordering no.	Denomination	Notes	C
HB1	1	0459 071 885	Cover		
HB2	1	0459 099 001	Middle plate		
HB3	1	0458 662 880	Bottom plate		
HB4	1	(W)	Inlet nozzle		
HB5	1	0458 748 001	Insulating bushing		
HB6	1	0458 748 002	Insulating washer		
HB7	1		Nut	M 10	
HB8	4	0467 695 001	Rubber foot	Ø 20/6.4x3, When ordering: 4 pieces delivered.	
HB10	1	0368 543 005	Pin socket	23 pole panel plug	13XP1
		0323 945 004	Pin	For 23 pole panel plug	
HB11	1	0459 102 001	Rear plate		
HB12	1	0160 609 881	Welding current terminal		
HB13	1	0466 325 001	Gasket		
HB14	1		Spacer ring	Included in item HB12	
HB15	1		Washer	Included in item HB12	
HB16	1		Nut	Included in item HB12	
HB17	1	0459 147 880	Cable set		
HB18	1	0467 911 881	Capacitor		13C4
HB19	1		Washer	Ø 22/10.5x2	
HB20	2		Spring washer	Ø 20/10.2x1.1	
HB21	1		Screw	M10x20	
HB22	4	0194 019 005	Spacer		
HB23	1	0487 162 880	Circuit board	Before ser.no. 917-xxx-xxxx Feed 302 with tachometer	13AP1
	1	0487 162 885	Circuit board	For ser.no. 917-xxx-xxxx Feed 302 with encoder	13AP1
HB24	1	0459 108 002	Front plate water		
HB25	1	0459 108 004	Front plate air		

For wear parts see page 12.



C = component designation in the circuit diagram

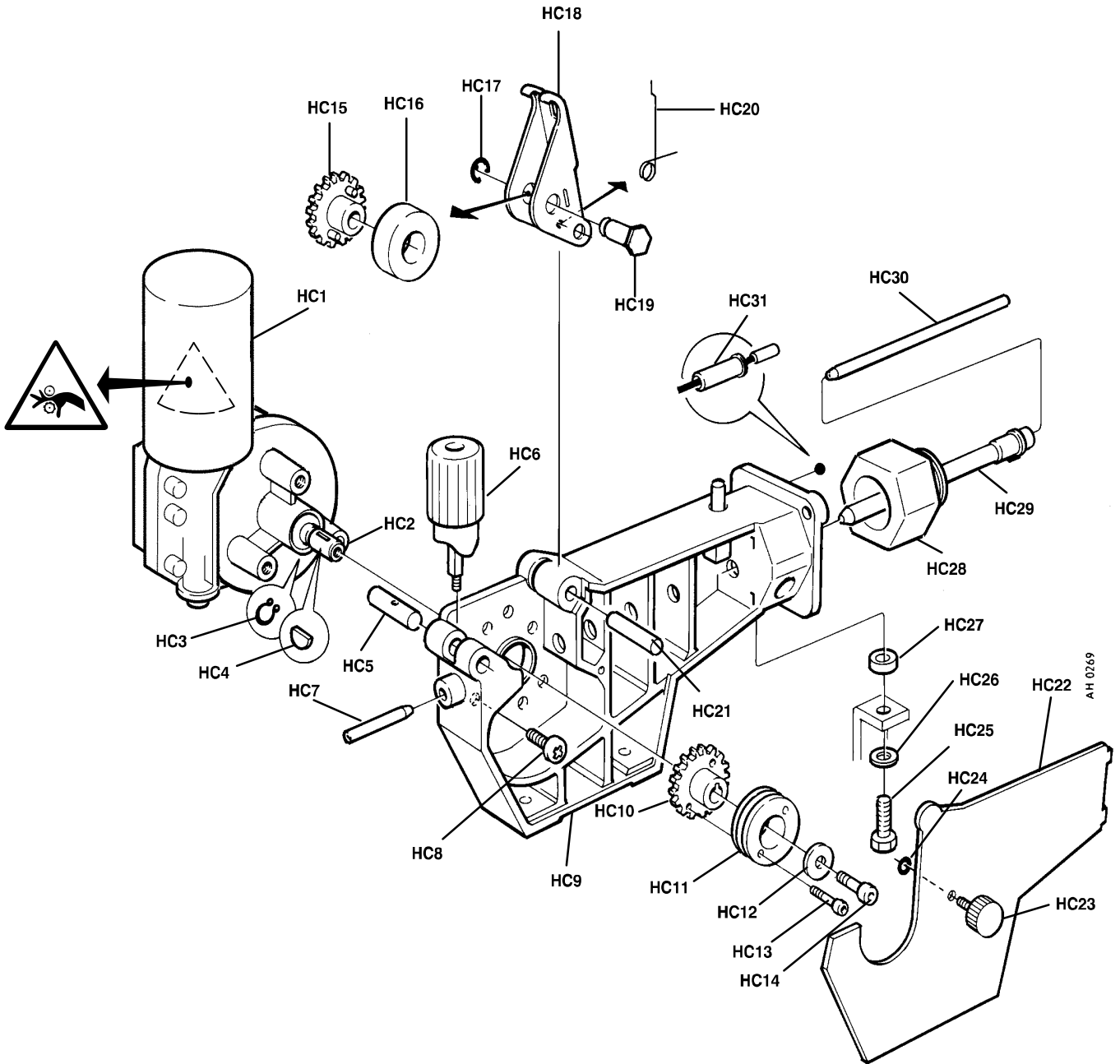
(W) = wear part

Item	Qty	Ordering no.	Denomination	Notes	C
		0455 890 887	Feed mechanism	Before serial no. 917-xxx-xxxx Includes items HC1 - HC31	
		0455 890 901	Feed mechanism	From serial no. 917-xxx-xxxx Includes items HC1 - HC31	
HC1	1	0455 597 001	Drive unit	With tachometer Before serial no. 917-xxx-xxxx	13M1, 13G1
	1	0459 808 002	Drive unit	With encoder From serial no. 917-xxx-xxxx	13M1, 13G1
HC2	1	0332 351 013	Axle shaft	Drive shaft with pinion. Included in item HC1.	
HC3	1	0215 701 007	Circlips	Locking washer. Included in item HC1	
HC4	1	0191 496 114	Woodruff wedge	Included in item HC1	
HC5	1	0367 528 001	Pin bolt		
HC6	1	0368 749 880	Pressure device		
HC7	1	(W)	Insert tube	Inlet nozzle	
HC8	3		Screw	M6x16	
HC9	1	0455 884 001	Wire feeder housing		
HC10	1	(W)	Feed roller geared		
HC11	1	(W)	Feed roller		
HC12	1	0193 104 002	Washer		
HC13	2		Screw	M3x16	
HC14	1		Screw	M4x12	
HC15	1	(W)	Geared adapter		
HC16	1	(W)	Pressure roller flat		
HC17	1		Locking washer	SGA D8	
HC18	1		Holder		
HC19	1		Shaft		
HC20	1	0455 896 001	Spring		
HC21	1	0455 893 001	Cyl. roller	Shaft	
HC22	1	0455 881 001	Cover plate		
HC23	1	0455 898 001	Screw	(M5x12)	
HC24	1	0215 201 202	O-ring		
HC25	1		Screw	M8x20	
HC26	1		Washer	Ø 16/8.4x1.5	
HC27	1	0455 883 001	Spacer sleeve	Ø 16/8.2x0.9	
HC28	1	0455 882 001	Current sleeve		
HC29	1	(W)	Outlet nozzle		
HC30	1	(W)	Insert tube		
HC31	2	0368 750 001	Insulating sleeve		

SPARE PARTS SET

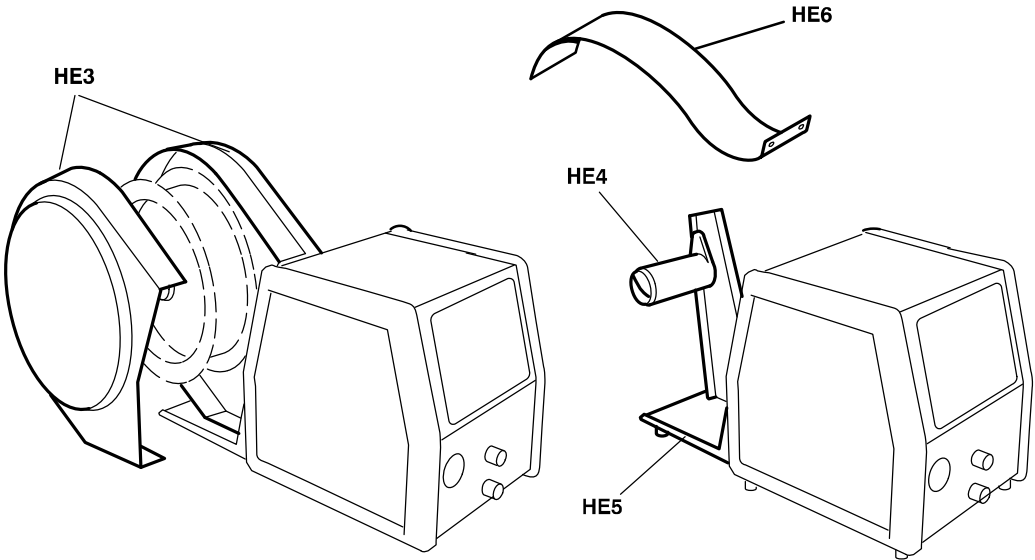
Item	Ordering no.	Denomination	Notes
HC100	(W)	Pressure arm compl.	Includes item HC15, HC16, HC17, HC18 and HC 19

For wear parts see page 12.



Feed 302, ESABFeed 30-2 M11

Item	Qty	Ordering no.	Denomination	Notes
HE3	1	0458 674 880	Bobbin cover	
HE4	1	0146 967 881	Brake hub	
HE5	1	0459 294 881	Spool attachment	
HE6	1	0156 633 003	Reel cover	

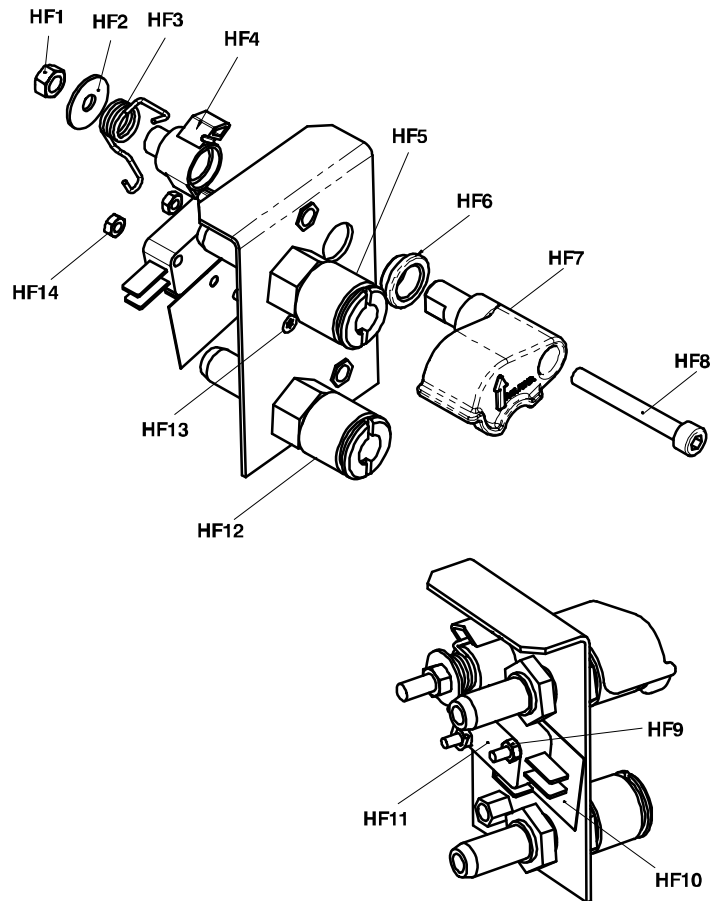


Feed 302, ESABFeed 30-2 M11

Item	Qty	Ordering no.	Denomination	Notes
HF1	1		Nut	M5
HF2	1		Washer	D16/5x1
HF3	1		Spring	
HF4	1		Water lock cam	
HF5	1	0365 803 015	Quick connector	Female, blue
HF6	1		Water lock bushing	
HF7	1		Water lock outlet	
HF8	1		Screw	M5x35
HF9	1		Nut	M3
HF10	1	0458 589 001	Insulation plate	
HF11	1	0458 364 001	Micro switch	
HF12	1	0365 803 014	Quick connector	Female, red
HF13	2		Screw	M3x20
HF14	2		Nut	M3

SPARE PARTS SET

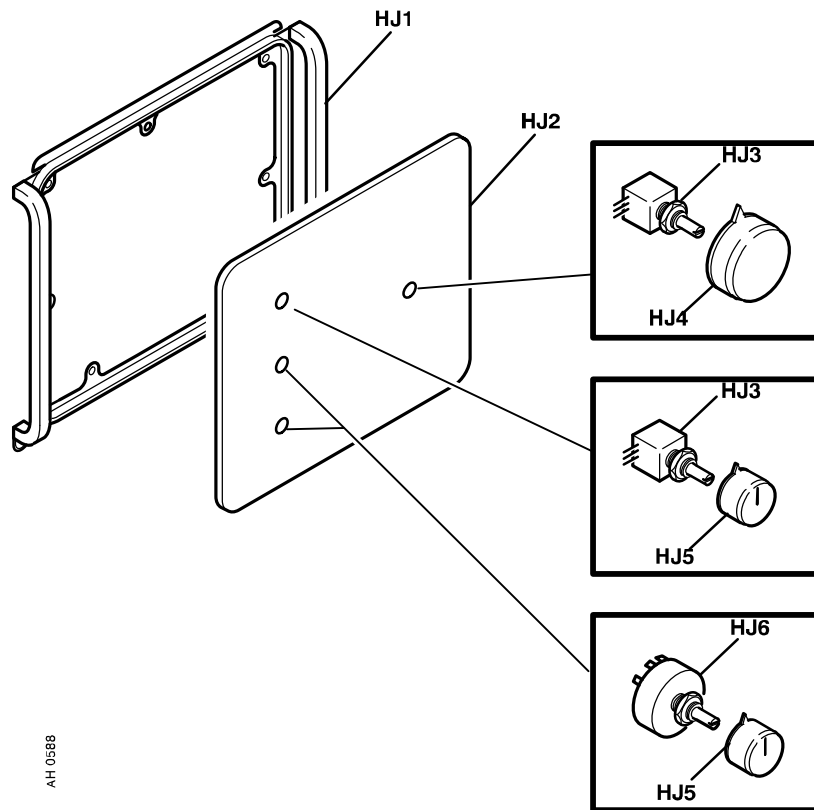
Item	Qty	Ordering no.	Denomination	Notes
HF50	1	0458 370 900	Water connection spare kit	Contains items HF1, HF2, HF3, HF4, HF6, HF7 and HF8



H

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
MMC module					
HJ1	1	0459 118 001	Protection frame		13RP1, 13RP3
HJ2	1	0459 131 014	Label		
HJ3	2	0191 870 616	Potentiometer		
HJ4	1	0321 475 882	Knob	Black	
HJ4	1	0460 600 836	Knob	Grey	
HJ5	3	0321 475 881	Knob	Black	
HJ5	3	0460 600 821	Knob	Grey	13SA1, 13SA2
HJ6	2	0194 055 003	Rotary switch	2 pole	



Wear parts

Item	Ordering no.	Denomination	Wire type	Groove type	Wire dimensions	Notes
HK1	0455 889 001*	Insert tube	Fe, Ss & cored			
	0455 894 001*	Insert tube	Al			
HK2	0455 886 001*	Outlet nozzle	Fe, Ss & cored			
	0455 885 001*	Outlet nozzle	Al			
HK3	0369 716 001	Feed roller geared				
HK4	0369 557 001	Feed roller	Fe, Ss & cored	V	Ø 0.6 - 0.8 mm	
	0369 557 002	Feed roller	Fe, Ss & cored	V	Ø 0.8 - 1.0 mm	
	0369 557 003	Feed roller	Fe, Ss & cored	V	Ø 1.0/1.2 & 1.4/1.6 mm	
	0369 557 004	Feed roller	Cored	V-Knurled	Ø 1.0 - 1.2 mm	
	0369 557 011	Feed roller	Al	U	Ø 0.8 - 0.9 mm	
	0369 557 006	Feed roller	Al	U	Ø 1.0 - 1.2 mm	
HK5	0193 104 002	Washer				
HK6	0455 898 001	Screw				(M5x12)
	0215 201 202	O-ring				
HK7	0455 881 001	Cover plate				
HK8		Screw				M4x12
HK9		Screw				M3x16
HK10	0466 074 001	Insert tube				
HK11	0369 728 001	Pressure roller				Flat
	0466 262 001	Pressure roller				Knurled
HK12	0455 053 880	Geared adapter				
HK13		Locking washer				SGA D8
HK14		Holder				
HK15		Shaft				
HK16	0455 896 001	Spring				
HK17		Nut				M10
HK18	0458 748 002	Insulating washer				
HK19	0458 748 001	Insulating bushing				
HK20	0156 602 001	Inlet nozzle	Fe, Ss, Al & Cored		Ø 2 mm plastic for 0.6-1.6 mm	
	0332 318 001	Inlet nozzle	Fe, Ss & Cored		Ø 2.4 mm steel for 1.2-2.0 mm	
HK21	0191 496 114	Woodruff wedge				

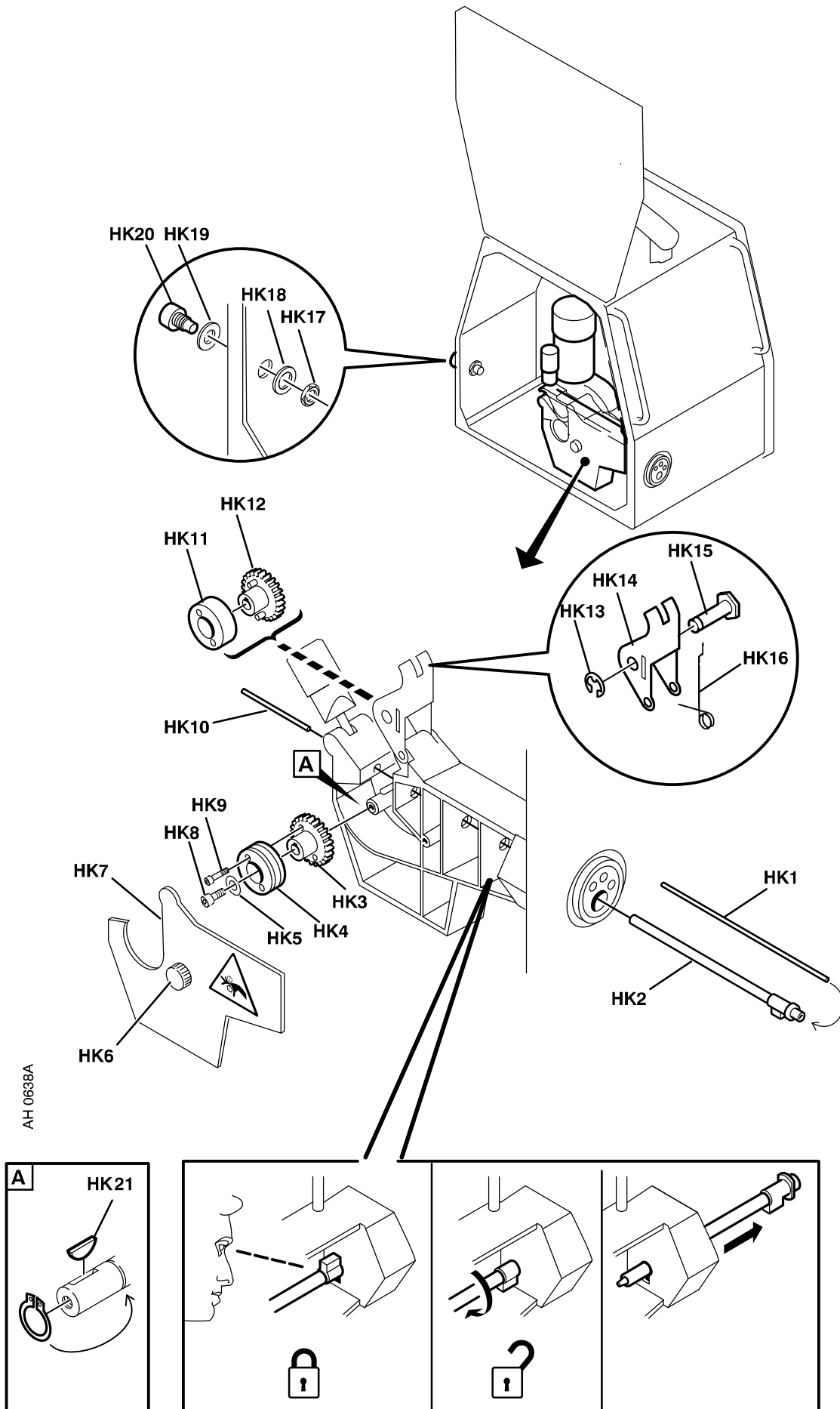
* Insert tube 0455 889 001 and outlet nozzle 0455 886 001 must be used together.
 Insert tube 0455 894 001 and outlet nozzle 0455 885 001 must be used together.

PARTS SET

Item	Ordering no.	Denomination	Notes
HK100	0469 833 880	Pressure arm complete	Includes items HK11 (flat pressure roller), HK12, HK13, HK14 and HK15

Welding with aluminium wire

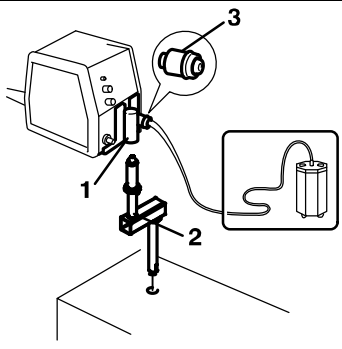
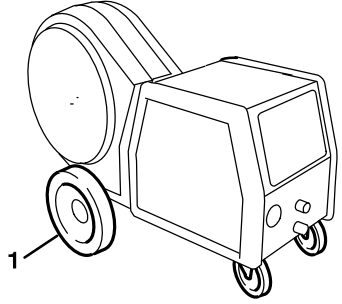
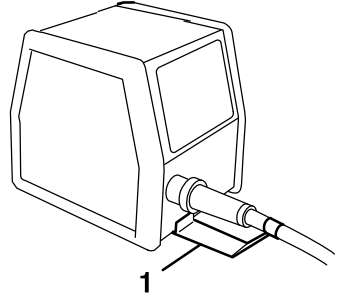
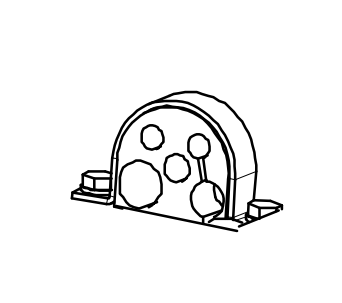
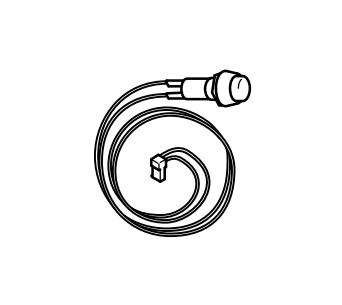
In order to weld with aluminium wire, proper rollers, nozzles and liners for aluminium wire MUST be used, It is recommended to use 3 m long welding gun for aluminium wire, equipped with appropriate wear parts.

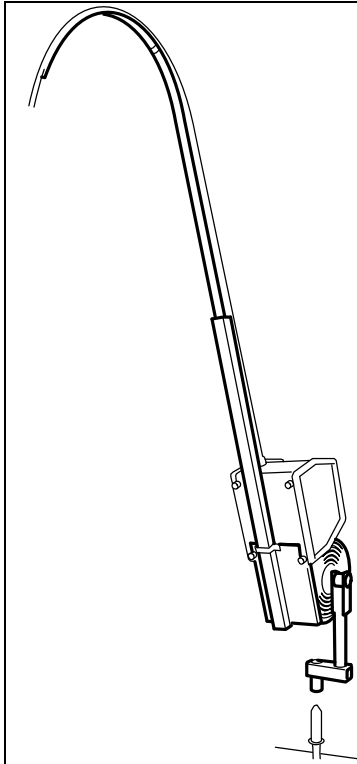


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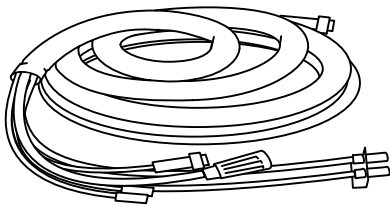
Accessories

	<p>1 Bobbin cover, plastic 18 kg Ø 300mm 0458 674 880</p>
	<p>1 Bobbin cover, metal 18 kg Ø 300mm 0459 431 880</p>
	<p>1 Bobbin holder 0458 704 880 2 Adapter for 5 kg bobbin 0455 410 001</p>
	<p>1 Adapter for 440 mm bobbin 0459 233 880</p>
	<p>1 Lifting eye 0458 706 880 2 Quick connector MarathonPac™ F102 440 880</p>

	<p>1 Turning piece 0458 703 880 2 Guide pin 0156 654 883 3 Quick connector MarathonPac™ F102 440 880</p>
	<p>1 Wheel kit 0458 707 880</p>
	<p>1 Strain relief for welding gun 0457 341 881</p>
	<p>Strain relief bracket for connection set 0459 234 880</p>
	<p>Push button for cold wire feed or gas purging 0459 465 880</p>



Counter balance device 0458 705 880
 (includes mast and counter balance)



Connection set for 400 A power sources

1.7 m	0469 836 880
5 m	0469 836 981
10 m	0469 836 881
15 m	0469 836 882
25 m	0469 836 883
35 m	0469 836 884
1.7 m, water	0469 836 885
5 m, water	0469 836 983
10 m, water	0469 836 886
15 m, water	0469 836 887
25 m, water	0469 836 888
35 m, water	0469 836 889

Connection set for 500 A power sources

1.7 m	0469 836 890
10 m	0469 836 891
15 m	0469 836 892
25 m	0469 836 893
35 m	0469 836 894
1.7 m, water	0469 836 895
10 m, water	0469 836 896
15 m, water	0469 836 897
25 m, water	0469 836 898
35 m, water	0469 836 899



Welding gun with EURO connection

Self cooled

Type	Ordering no.		Max welding current		Wire dimensions			
	Hose length 3 m	Hose length 4.5 m	CO ₂	Mix Ar	Fe	Ss	Cored	Al
PSF 250	0368 100 882	0368 100 883	250A 60%	225A 60%	0.6 - 1.0	0.6 - 1.0	1.0	1.0
PSF 305	0458 401 880	0458 401 881	315A 60%	285A 60%	0.8 - 1.2	0.8 - 1.2	1.0 - 1.2	1.0 - 1.2
PSF 405	0458 401 882	0458 401 883	380A 60%	325A 60%	0.8 - 1.6	0.8 - 1.2	1.0 - 1.6	1.0 - 1.6
PSF 505	0458 401 884	0458 401 885	475A 60%	410A 60%	1.0 - 2.4	1.0 - 1.6	1.0 - 2.4	1.2 - 2.4

Water cooled

Type	Ordering no.		Max welding current		Wire dimensions			
	Hose length 3 m	Hose length 4.5 m	CO ₂	Mix Ar	Fe	Ss	Cored	Al
PSF 410W	0458 400 882	0458 400 883	425A 100%	400A 100%	0.8 - 1.6	0.8 - 1.2	1.0 - 1.6	1.0 - 1.6
PSF 510W	0458 400 884	0458 400 885	500A 100%	440A 100%	1.0 - 2.4	1.0 - 1.6	1.0 - 2.4	1.2 - 2.4

