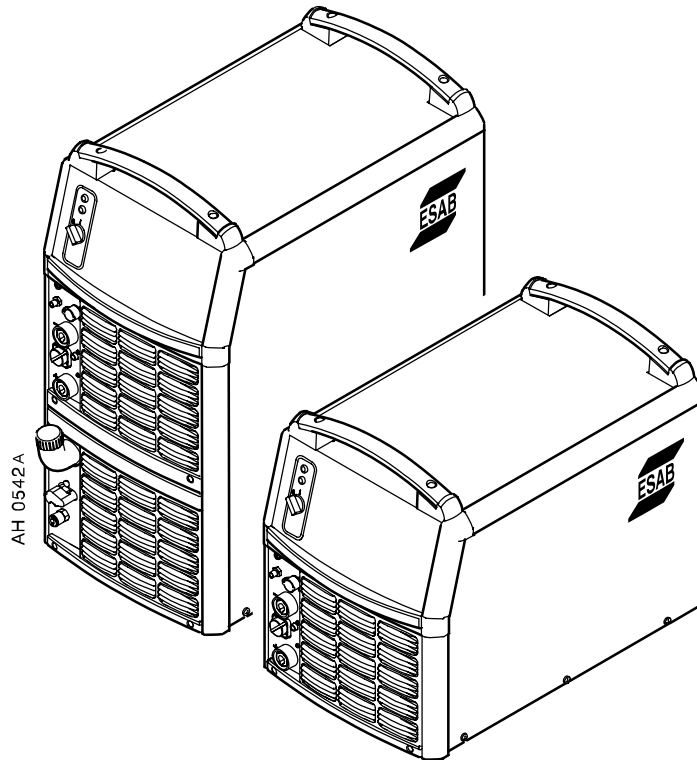


Spare parts list

Edition 090525



Valid for serial no. 322-xxx-xxxx, 334-xxx-xxxx, 347-xxx-xxxx, 445-xxx-xxxx, 524-xxx-xxxx, 620-xxx-xxx, 640-xxx-xxxx, 802-xxx-xxxx

The AristoMig power source is renamed:

New name	Old name
Mig U4000i	AristoMig U400

Ordering no.	Product
0458 625 885	Mig U4000i with cooling unit
0458 625 884	Mig U4000i without cooling unit

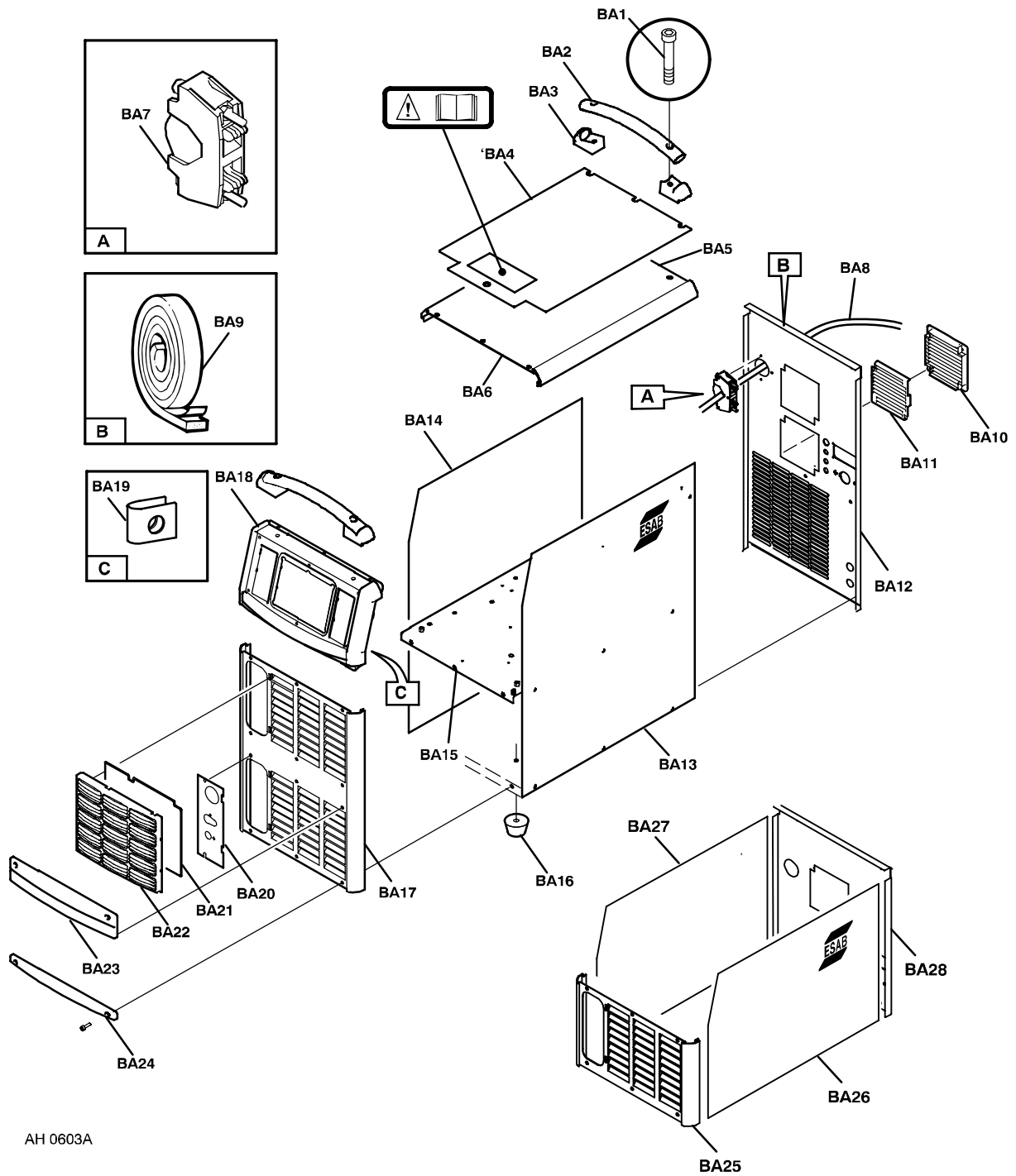
Spare parts are to be ordered through the nearest ESAB agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

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.

Mig U4000i, AristoMig U400

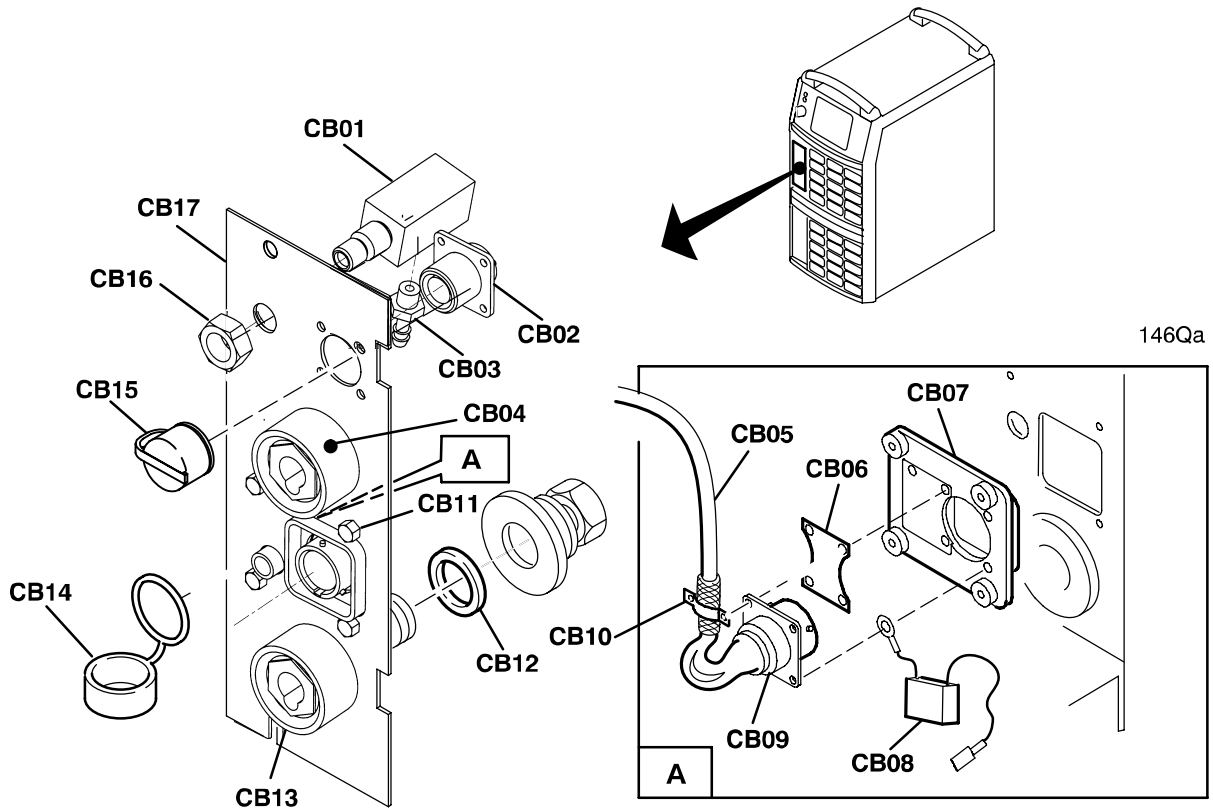
Item	Qty	Ordering no.	Denomination	Notes
BA1	4		Screw	High-tensile steel, included in item BA2
BA2	2	0459 307 881	Handle set	
-	2		Nut	M8, included in item BA2
BA3	4		Handle corner	Included in item BA2
BA4	1	0458 399 002	Rubber mat	
BA5	1	0458 390 005	Cover	
BA6	4	0458 310 001	Gasket	Seal
BA7	1	0469 950 880	Cable clamp	
-	3		Screw	RXPT 8-16x20
BA8	1	0468 516 886	Mains cable	
BA9	1	0192 526 002	Sealing strip	To be ordered per metre
BA10	2	0458 533 001	Rear grille	
	4		Screw	RXS B6x9.5
BA11	1	0458 641 001	Water cover	
	4		Screw	RXS B6x25
BA12	1	0458 394 002	Rear plate middle size	Rear panel, medium
BA13	1	0458 387 002	Side cover middle	Side panel, medium, right
BA14	1	0458 388 002	Side cover middle	Side panel, medium, left
BA15	1	0458 385 001	Bottom plate	
BA16	4	0458 683 001	Foot	
-	4		Screw	M6x19
BA17	1	0458 390 003	Front profile middle size	Front panel, medium
BA18	1	0458 396 001	Front frame	
BA19	5	0469 381 001	Fast lock nut	
BA20	1	0458 623 004	Connection plate, cooler	
BA21		0458 398 001	Filter	
BA22		0458 383 001	Front grille	
BA23	1	0458 511 001	Middle beam	Bracket
BA24	1	0458 509 001	Lower beam	Bracket
-	2		Screw	M6x20
BA25	1	0458 390 002	Front profile, low	
BA26	1	0458 387 001	Side cover, low	right
BA27	1	0458 388 001	Side cover, low	left
BA28	1	0458 394 001	Rear plate low	



AH 0603A

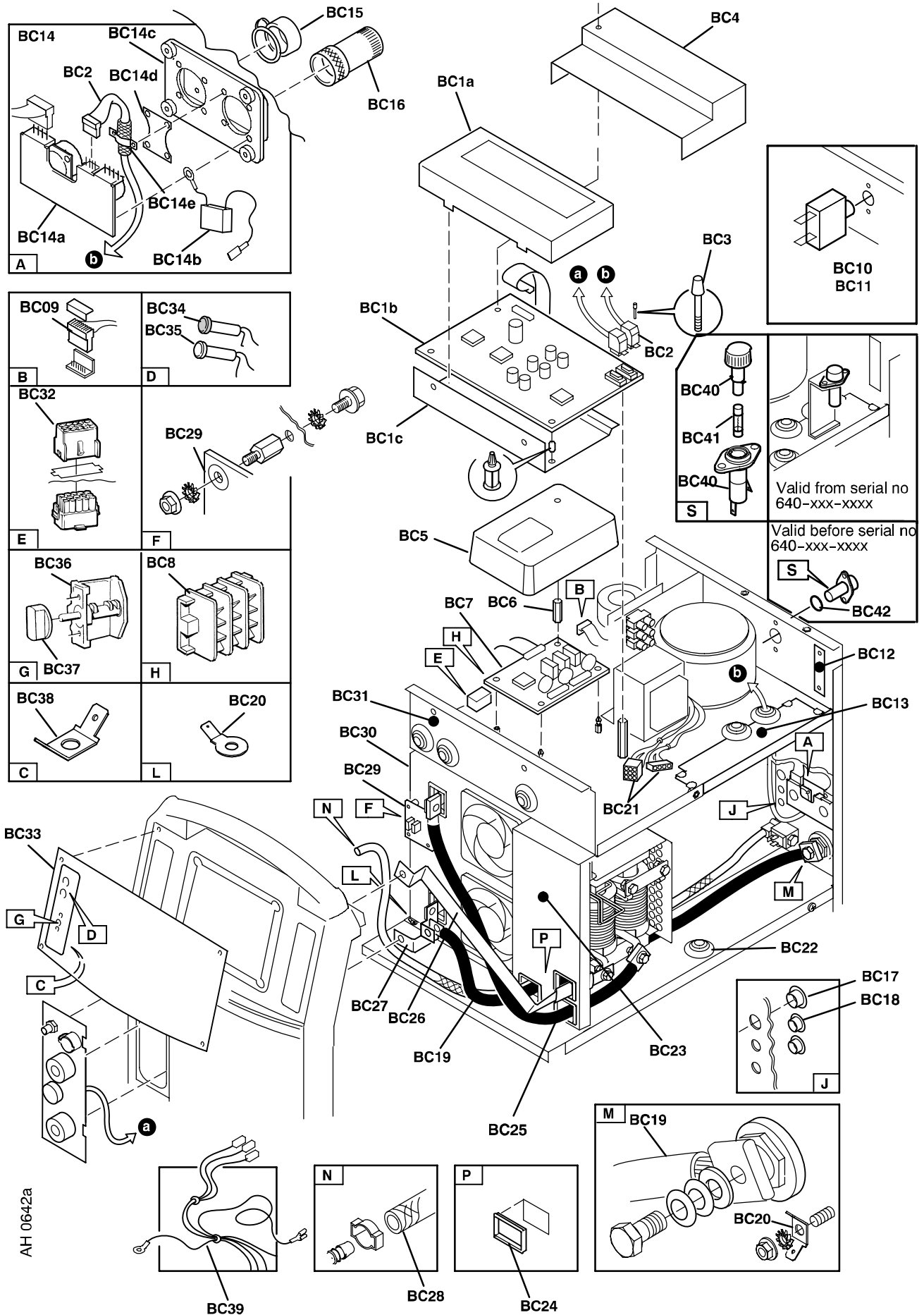
C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
CB1	1	0458 879 001	Inlet plug		
CB2	1	0538 500 902	Sleeve terminal	2-pole	XS4
	4		Screw	RXPT 6-19x8	
CB3	1	0192 713 001	Hose nipple		
CB4	1	0156 868 880	Welding cable connector	OKC	XS2
CB5	1	0458 681 883	Cable single		XP1, XS3
CB6	1	457 799 001	Screen plate		
CB7	1	0458 969 001	Insulation		
	4		Screw	MRX M4x12	
CB8	1	0467 911 883	Capacitor	100 nF 250 V, with cable lugs	C3
CB9	1	0368 544 003	Socket	12-pole	XS3
	3		Screw	RXPT 6-19x8	
CB10	1	0456 686 880	Clamp		
CB11	4	0194 142 412	Nut	M4 domed, plastic	
CB12	2	0466 325 001	Gasket		
CB13	1	0160 362 881	Cable connector	OKC	XS1
CB14	1	0366 285 001	Cap		
CB15	1	0457 626 001	Cap		
CB16	1		Nut	M12	
CB17	1	0458 623 002	Connection plate		



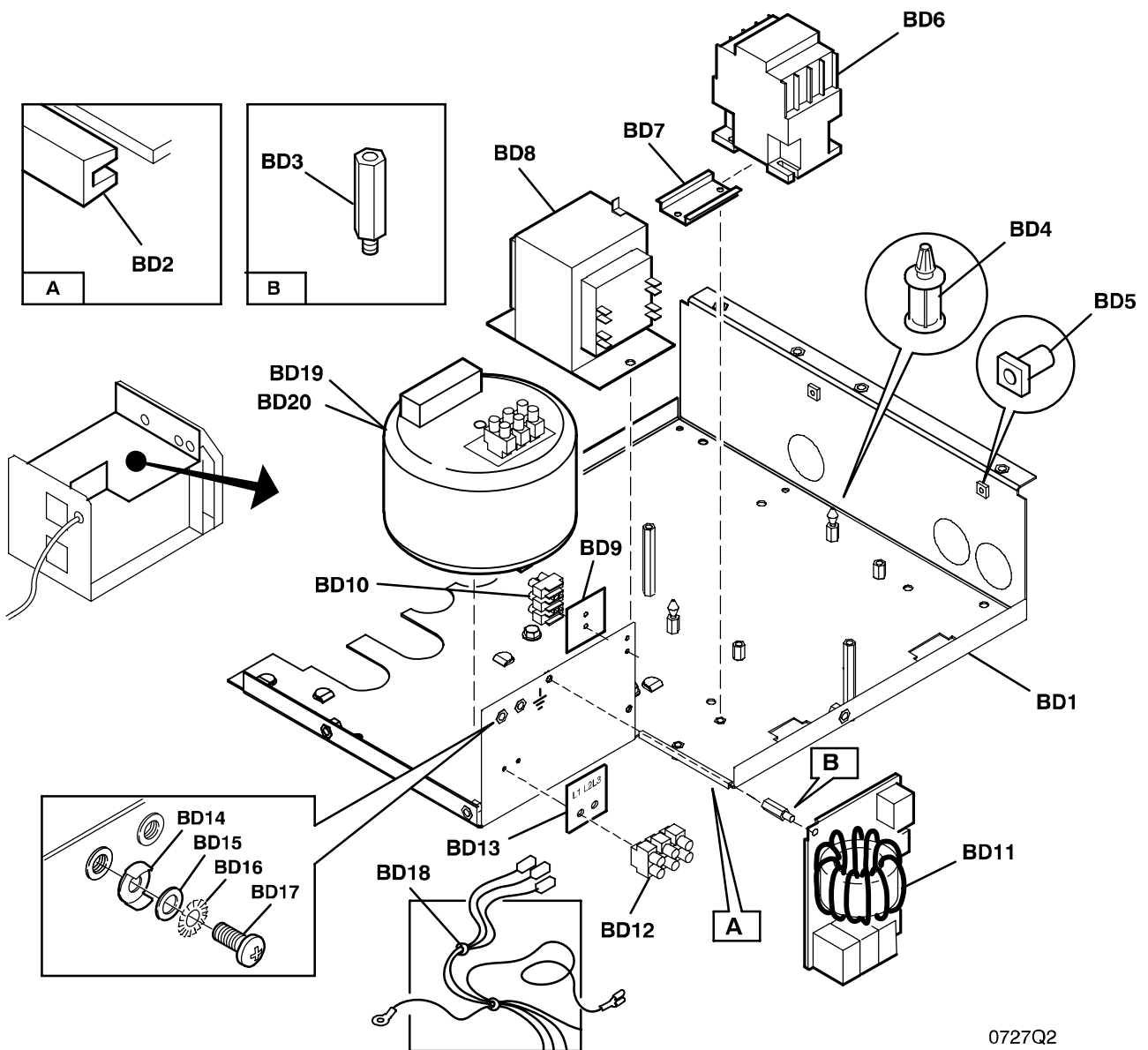
C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
BC1a	1	0458 312 001	Top box		
BC1b	1	0487 201 880	Circuit board	Configured	20AP1
BC1c	1	0458 313 001	Bottom box		
BC2	1	0458 681 884	Cable double burndy	Included in item BC14	XP2, XS30
BC3	2	0193 052 980	Screw		
BC4	1	0458 881 001	Protection cap		
BC5	1	0458 314 001	Dust protection		
BC6	1	0394 516 038	Spacer screw	M5x30	
BC7	1	0486 855 884	Printed circuit board	Relay board, replacing 0486 855 880	20AP2
	2		Screw	M5x8	
BC8	1	0466 884 003	Connection	Included in BC39	
BC9	9		Connector	Included in item BC39	
BC10	1	-	Automatic fuse	MCB; 5 A. Replaced by items BC40, BC41, BC42	2FU1
BC11	1	0455 376 001	Protection cap	For item BC10	
BC12	1	0456 806 001	Cover plate		
BC13	1	0458 709 003	Cover 3-hole		
BC14	1	0458 679 881	Contact CAN doub.	Items BC2, BC14a, BC14b, BC14c, BC14d and BC14e included	AP1, C4
BC14a	1	0486 388 880	Circuit board	Connection board	AP1
BC15	2	0366 285 001	Dust cap		
BC16	1	0459 314 880	Terminal resistor	Termination resistor	
BC17	1	0192 230 107	Blind plug P-625		
BC18	2	0192 230 105	Blind plug		
BC19	1	0458 610 882	Cable set coarse		
BC20	2	0191 548 009	Flat pin connector	Ø 6.3x0.8	
BC21	1	0458 629 886	Cable set TIG	Connectors included: XS10, XS11, XS16, XS17, XS18, XS26, XS29, XS31	<-----
BC22	3	0194 069 003	Rubber inlet	Grommet	
BC23	1		TIG module	See page 10	
BC24	1	0458 074 001	Inlet		
BC25	1	0458 610 883	Cable set coarse		
BC26	1	0458 952 001	Rail HF		
BC27	1	0458 624 001	Connection rail		
	2		Washer	Ø 22/10.5x2	
	4	0219 504 307	Spring washer	T=1.1, Ø 20/10.2	
	2		Screw	M10x20	
BC28	1	0456 496 001	Hose red	L= 0.97 m to be ordered per meter	
BC29	1	0486 892 880	Printed circuit board		AP2
BC30	1		Power module	See page 12	
	4		Screw	M6x16	
BC31	1		Mains module	See page 8	
	6		Screw	M6x16	
BC32	2		Socket	Included in item BC39	
BC33	1	0458 802 003	Front panel		
	3		Washer	Ø 4.3X8	
	7		Nut	M4	
BC34	1	0369 733 005	Lamp	Orange LED	D1
BC35	1	0369 733 010	Indicating diode lamp	White 28 V	HL1
BC36	1	0458 601 001	Switch		2QF1
	2		Screw	FXS ST3.5x9.5	
BC37	1	0366 296 003	Knob		
BC38	1	0192 038 102	Flat pin connector	5.3 mm	
BC39	1	0458 629 884	Cable set common	Connectors included: XP6, XS7, XS8, XS15, XS20, XS21, XS22, XS23, XS24, XS25, XS27, XS28	<-----
BC40	1	0459 284 001	Fuse holder	From ser.no. 347-351-xxxx	
BC41	1	0459 285 001	Fuse 4 A slow	From ser.no. 347-351-xxxx	2FU1
BC42	1	0190 680 218	O-ring	Valid from ser.no. 347-351-xxxx to 620-xxx-xxxx	



C = component designation in the circuit diagram

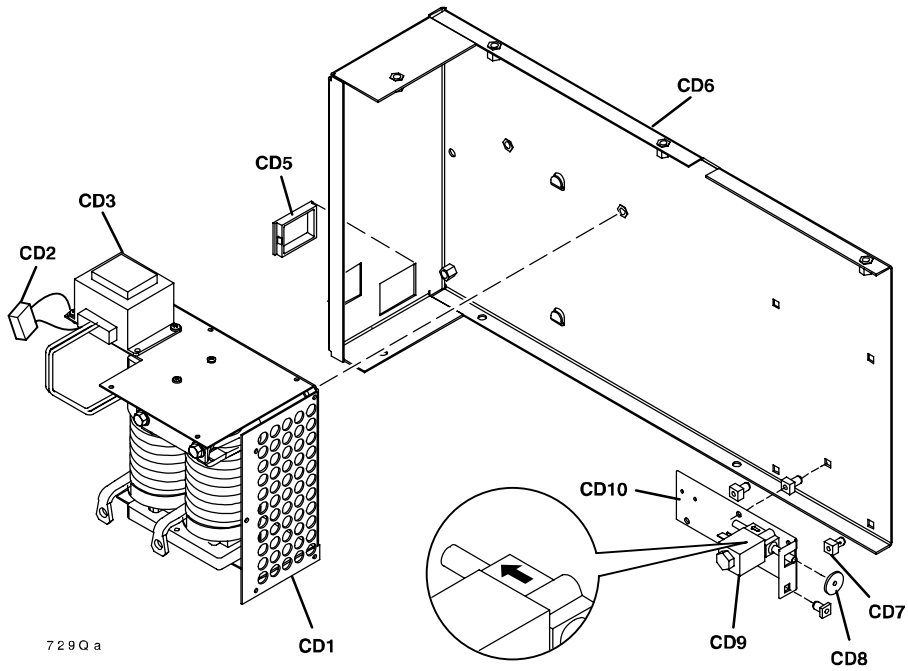
Item	Qty	Ordering no.	Denomination	Notes	C
BD1	1	0458 392 001	Circuit board shelf		
BD2	1	0193 350 101	Grommet strip	L = 50 mm. To be ordered per metre	
BD3	2		Distance screw	Spacer screw M5x12	
-	2		Distance screw	Spacer screw M5x20	
-	2		Washer	Ø 10/5.3	
-	2		Screw	M5x8	
-	2		Distance screw	Spacer screw M5x60	
BD4	2	0192 790 104	Spacer	12.7 mm	
BD5	2	0194 019 003	Spacer	3.2	
BD6	1	0193 502 105	Contacteur	400 V	2KM1
BD7	1	0193 298 101	Bar for contacteur		
-	2		Screw	M5x8	
BD8	1	0458 607 001	Control transformer	With fuses 2FU2 and 2FU3	2TC1
-	2		Screw	M6x16	
BD9	1	0191 409 019	Insulating washer		
BD10	1	0193 655 012	Terminal block	Delivered as 12 pole, to be cut to 6 pole	2XT2
-	2		Screw	RXS B8x19	
BD11		0455 803 880	PC-board	EMC	2AP1
BD12	1	0320 378 011	Mans select block	Terminal block Delivered as 12 pole, to be cut to 3 pole	2XT1
-	2		Screw	M4x25	
BD13	1	0468 882 004	Sign		
BD14	1	0264 300 404	Washer	KB6.5	
BD15	1		Washer	Ø 16/8.4x1.5	
BD16	2		Washer lock AZ	Ø 11/6.4x2.1	
BD17	2		Screw	M6x16	
BD18	1	0458 611 881	Cable set mains module	Connectors included	2XS1, 2XS2, 2XT2
BD19	1	0458 608 001	Control transformer MIG	Only for MIG and MechTig machines	2TC2
-	1	0567 900 151	Fuse 8 A slow		2FU4
-	1	-	Fuse 2 A slow		2FU5
-	1		Screw	M8x110	
-	1		Nut	M8	
BD20	1	0458 613 001	Control transformer TIG	Only for TIG machines (not MechTig)	2TC2
-	1	-	Fuse 0.5 A slow		2FU4
-	1	-	Fuse 2 A slow		2FU5
-	1		Screw	M8x90	
-	1		Nut	M8	



0727Q2

C = component designation in the circuit diagram

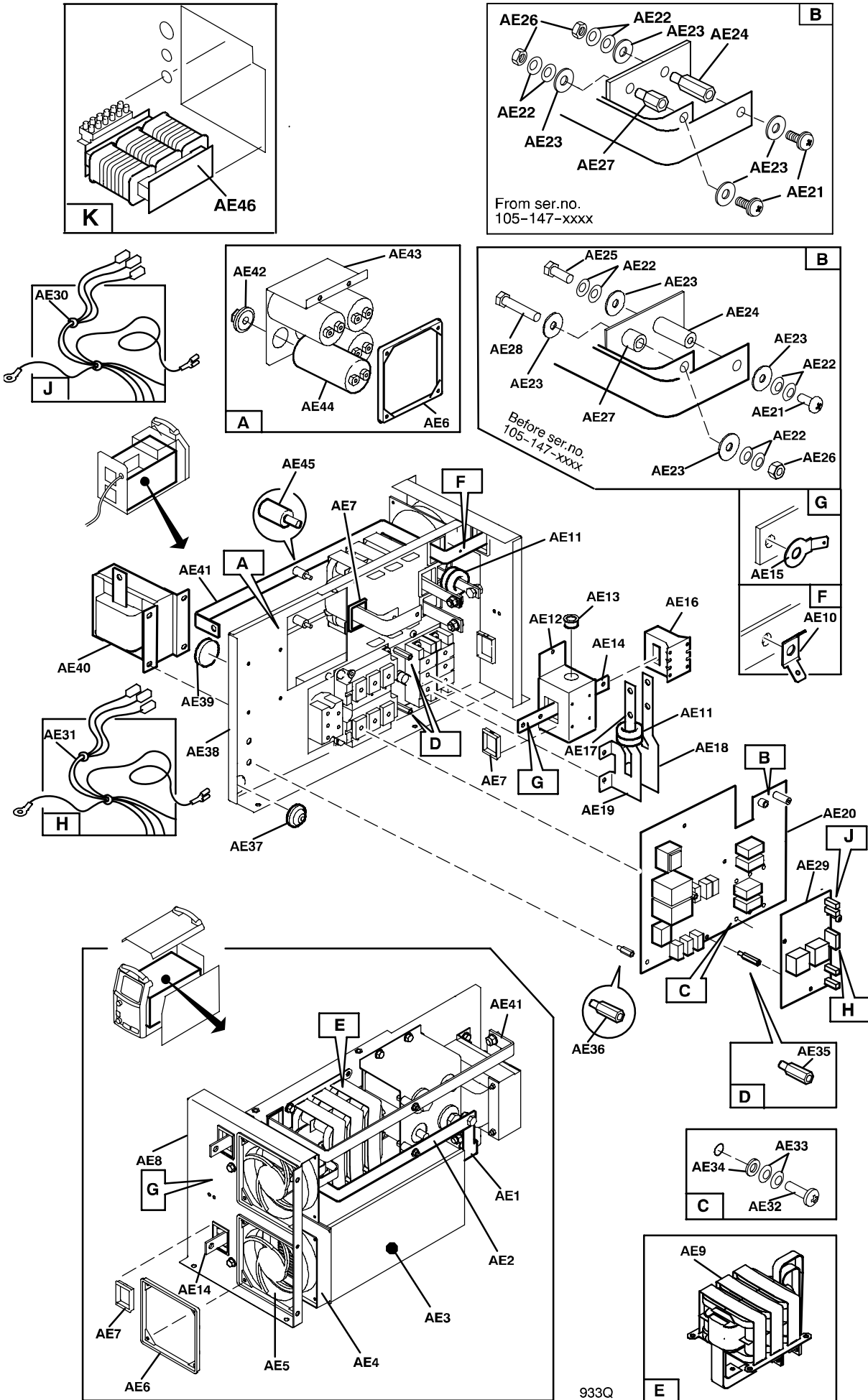
Item	Qty	Ordering no.	Denomination	Notes	C
CD1	1	0467 756 881	HF coils complete		10TV1, 10AP1
	2		Screw	M6x19	
CD2	1		Capacitor	47 nF 250 V	10C1
CD3	1	0367 268 001	HF module	Included in item CD1	10AP1
CD5	2	0458 074 001	Inlet		
CD6	1	0458 593 001	Bracket		
CD7	4	0194 019 005	Spacer 6.4		
	3		Screw	RX-PT 8-16x12	
CD8	1	0365 534 001	Spacer washer		
CD9	1	0193 054 002	Solenoid valve	42 V AC	10YV1
	2		Screw	M4x6	
	1	0193 054 104	Nipple	For solenoid valve	
CD10	1	0458 596 001	Gas valve bracket		



C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
AE1	1	0458 308 001	Rail		
AE2	1	0458 072 001	Rail		
AE3	1		Semiconductor module	See page 14	
AE4	1	0458 055 001	Spacer		
AE5	2	0458 065 001	Fan		15EV1, 15EV2
	4		Screw	MRX-TT M4x8	
AE6	3	0458 076 001	Fan attachment		
AE7	8	0458 074 001	Inlet	Grommet	
AE8	1	0458 059 001	Fan plate		
	3		Screw	M6SF-TT M6x19	
AE9	1	0458 075 880	Transformer module		15TM1
	4		Screw	M6SF-TT M6x14	
AE10	1	0192 038 102	Flat pin	Ø 5.3	
AE11	4	0455 569 001	Ferrit ring core		15L1, 15L2
-			Cable tie	Heat resistant	
AE12	1	0458 077 001	Screen plate		
	2		Screw	MRX-TT M4x8	
AE13	1	0192 041 119	Grommet		
AE14	1	0458 067 001	Rail		
AE15	3	0191 548 009	Flat pin	6.3x0.8	
AE16	1	0458 063 001	Current sensor		15AP3
AE17	1	0190 209 120	Hose	Ø 15.9/14, L= 45mm, to be ordered per metre	
AE18	1	0458 068 002	Rail		
AE19	1	0458 068 001	Rail		
	3		Screw	M8x16	
	3		Nut	M8	
AE20	1	0486 739 880	Circuit board	Note: Read the service manual	15AP1
AE21	26	0194 143 327	Screw	M5x12 See * below	
AE22		0219 504 302	Spring washer	Ø 10/5.2x0.5	
AE23	4		Washer	Ø 16/5x1	
AE24	1	0457 902 001	Spacer	Before ser.no. 105-147-xxxx	
	1	0458 991 001	Spacer screw	From ser.no. 105-147-xxxx	
AE25	2		Screw	M5X16	
AE26	8		Nut	M5	
AE27	1	0301 064 001	Spacer	Before ser.no. 105-147-xxxx	
	1	0458 991 002	Spacer screw	From ser.no. 105-147-xxxx	
AE28	1		Screw	M5x20	
AE29	1	0486 735 880	Circuit board		15AP2
-	2	0193 767 001	Fuse	Fuses S1 and S2 on circuit board 15AP2	
AE30	1	0458 064 881	Cable set gate	Connectors included: 15XS1, 15XS3, 15XS5, 15XS6, 15XS7, 15XS8	<-----
AE31	1	0458 064 880	Cable set 350/400	Connectors included: 15XP7, 15XP8, 15XS4, 15XS9	<-----
AE32	6	0194 143 368	Screw	M6x16 See * below	
AE33	12	0219 504 303	Spring washer	T=0.7. Ø 12.5/6.2 Included in item AE32	
AE34	6		Washer	Ø 12x6.4x1.5 Included in item AE32	
AE35	5	0394 516 038	Spacer screw	M5x30	
AE36	2	0394 516 035	Spacer screw	M5x18	
AE37	1	0194 069 002	Rubber inlet	Grommet	
AE38	1	0458 054 001	Intermediate plate		
AE39	1	0349 134 001	Rubber distance	Rubber spacer	
AE40	1	0458 066 880	Inductor		15L3
AE41	1	0458 069 001	Rail		
AE42	4	0320 901 003	Insulating nut	M12	
AE43	1	0458 058 001	Support plate		
	2		Screw	M6SF-TT, M6x14	
AE44	4	0192 903 505	Capacitor	1000 µF	
AE45	3	0193 609 105	Insulator		
AE46	1	0460 119 001	Primary inductor	Valid from serial no 802-xxx-xxxx	3L1

* Special screw with inbuilt washer and spring washer function, used from ser.no.105-140-xxxx



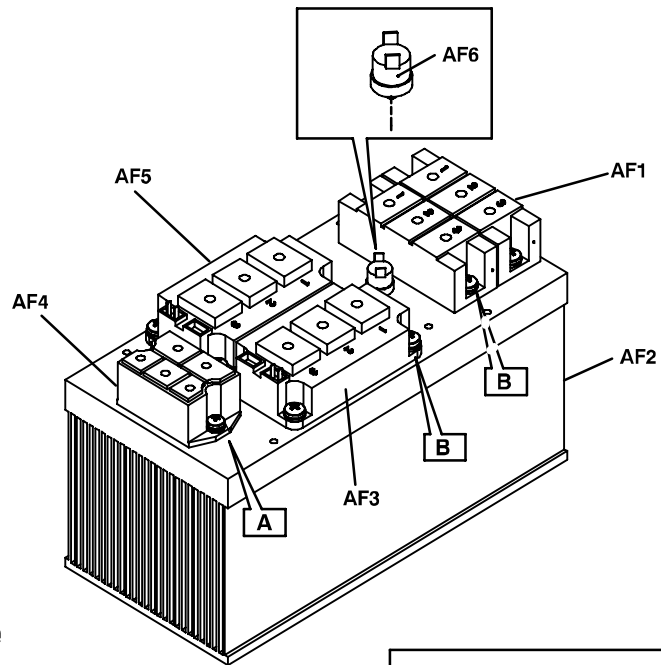
C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
-	1	0458 073 880	Semiconductor module	Complete. Items AF1 – AF12	
AF1	2		Diode module	See item AF52	15D1, 15D2
AF2	1	0301 011 003	Heat sink		
AF3	1		IGBT module	See item AF50	15Q2
AF4	1		Rectifier bridge	See item AF51	15BR1
AF5	1		IGBT module	See item AF50	15Q1
AF6	1	0456 113 886	Thermal switch		15ST2
AF7	2		Screw	M5x16 See * below	
AF8	4		Spring washer	Ø 10/5.2x0.5 Included in item AF7	
AF9	2		Washer	Included in item AF7	
AF10	12		Screw	M6x20 See * below	
AF11	24		Spring washer	T=0.7, Ø 12.5/6.2 Included in item AF10	
AF12	12		Washer	Included in item AF10	
-	1	0192 058 101	Thermal compound	For fitting of items AF1, AF3, AF4, AF5 and AF6	

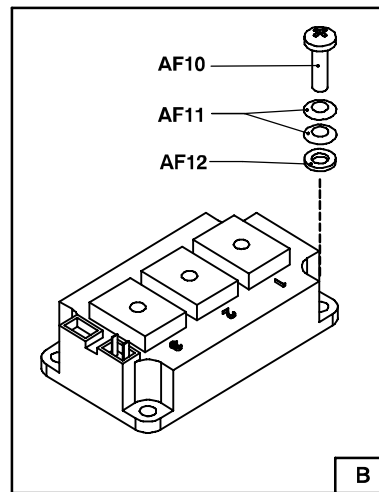
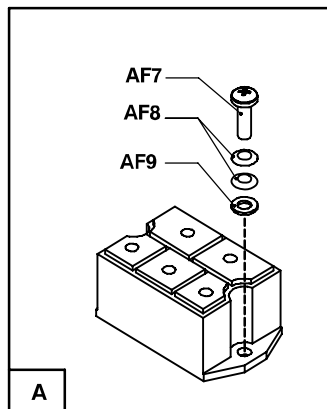
* Special screw with inbuilt washer and spring washer function, used from ser.no.105–140–xxxx

SPARE PARTS SETS

Item	Ordering no.	Denomination	Notes
AF50	0458 920 880	IGBT modules set	Includes: item AF3 IGBT 15Q2, item AF5 IGBT 15Q1, item AF10 screw M6x20, thermal compound, roller and mounting instruction
AF51	0458 920 881	Rectifier set	Includes: item AF4 rectifier bridge 15BR1, item AF7 screw M5x16 thermal compound, roller and mounting instruction
AF52	0458 920 882	Diode module set	Includes: diode module item AF1, AF10 screw M6x20, thermal compound, roller and mounting instruction. Note: there is only one diode module in the set.
-	0458 910 002	Roller handle	For the roller in the spare parts sets above



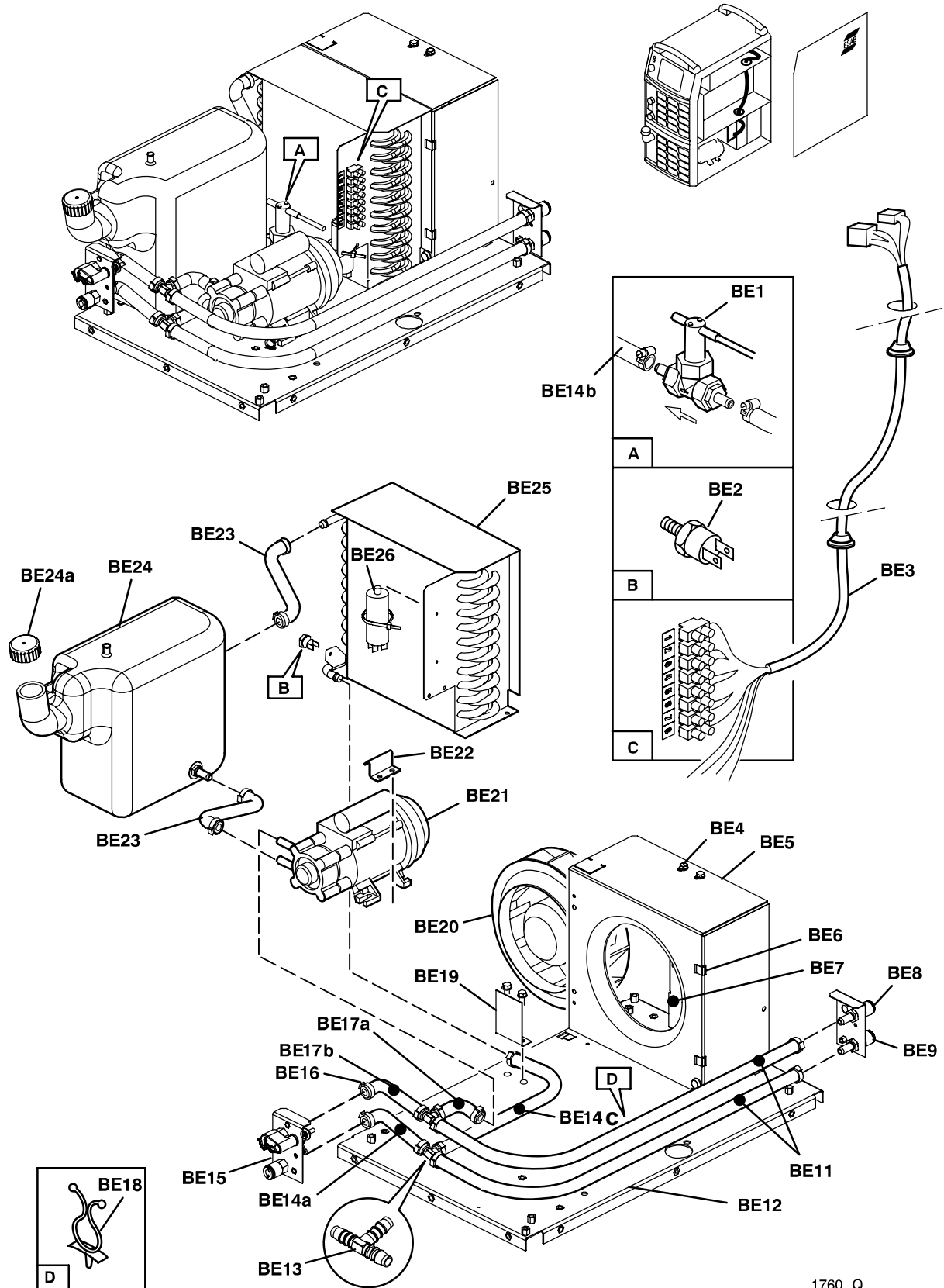
732Q



C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
BE1	1	0467 118 001	Waterflow switch	Option	5SL1
BE2	1	0467 864 007	Thermal switch	Closes at 45 °C, opens at 35 °C Use thermal compound when mounting	5ST1
BE3	1	0458 745 881	Cable set	Connectors included	5XP17, 5XP18, 5XT1
BE4	4		Screw	M6x16	
BE5	1	0458 556 001	Fan plate		
BE6	4	0457 212 001	Clips		
BE7	1	0458 555 001	Fan holder		
BE8	1	0365 803 012	Quick connector	Female, blue	
BE9	1	0365 803 011	Quick connector	Female, red	
BE11	2	0457 987 001	Water hose	L=0.68m D=17/10mm To be ordered per metre	
BE12	1	0458 385 001	Bottom plate		
BE13	2	0458 558 001	T connection		
BE14a	1	0459 025 001	Hose	From red connector.	
BE14b	1	0457 987 002	Hose	To radiator. L=0.075m D=17/10mm To be ordered per metre	
BE14c	1	0457 496 001	Hose		
BE15	1	0458 370 880	Water outlet with lock	Complete, for details see page 18	5S1
BE16	16	0190 484 002	Hose clamp		
BE17a	1	0459 026 001	Hose	From blue connector.	
BE17b	1	0459 025 001	Hose	To pump.	
BE18	3	0455 122 002	Cable saddle	Assemb. hole 4mm	
BE19	1	0458 560 001	Stop plate tank		
BE20	1	0369 827 001	Fan		5EV1
BE21	1	0469 692 002	Pump	Delivered with capacitor. See * below	5M1
-	1		Capacitor	5µF 450V AC	5C2
BE22	1	0458 807 001	Pump clamp	See * below	
BE23	2	0458 554 001	Hose		
BE24	1	0459 044 880	Tank with connections	Water tank	
BE24a	1	0457 245 002	Tank cap	Included in item BE24	
BE25	1	0458 559 001	Radiator		
BE26	1	0191 085 203	Capacitor	3µF 400V	5C1

* When ordering a pump, item BE21, to a machine with serial number prior to 445-508-xxxx, also item BE22 must be ordered.

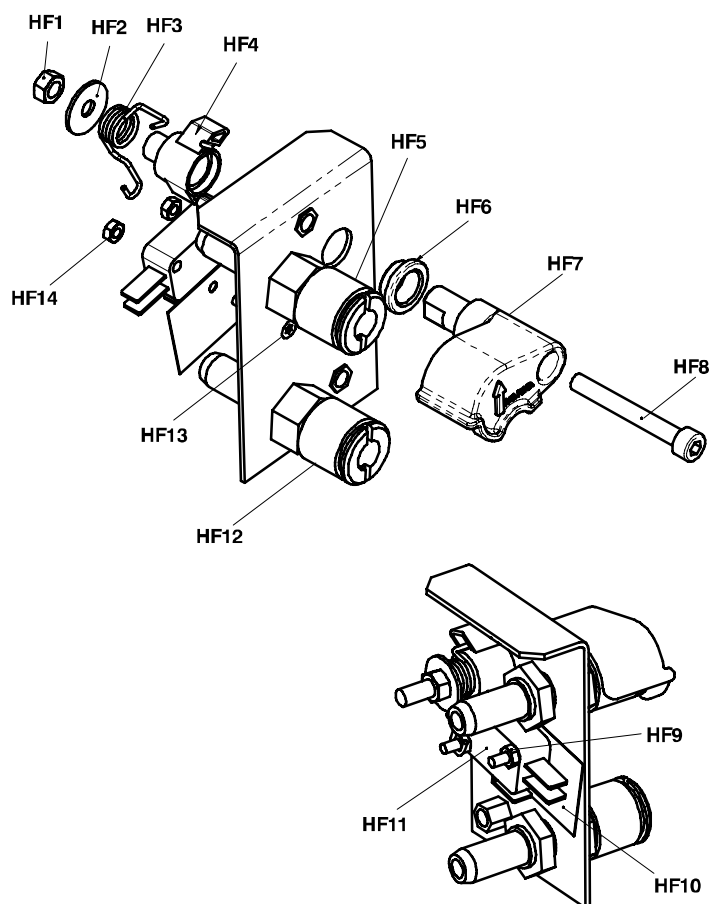


1760 Q

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 Note: only for wire feed units
	1	0365 803 009	Quick connector	Female, blue Note: only for power source cooling units
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 Note: only for wire feed units
	1	0365 803 008	Quick connector	Female, red Note: only for power source cooling units
HF13	2		Screw	M3x20
HF14	2		Nut	M3

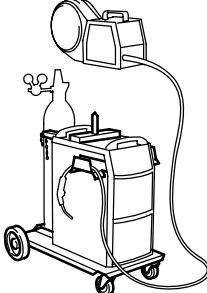
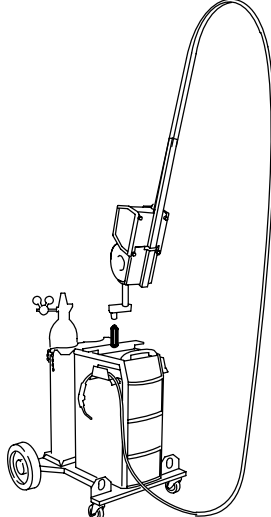
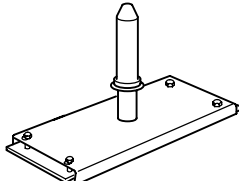
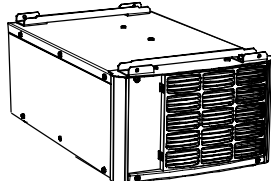
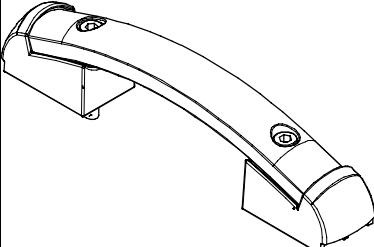
SPARE PARTS SET

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

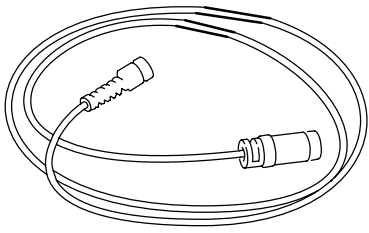
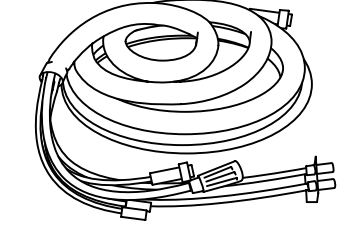
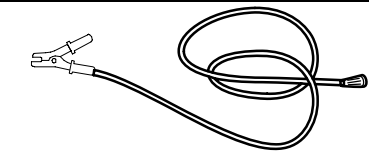
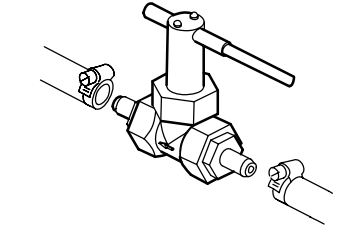


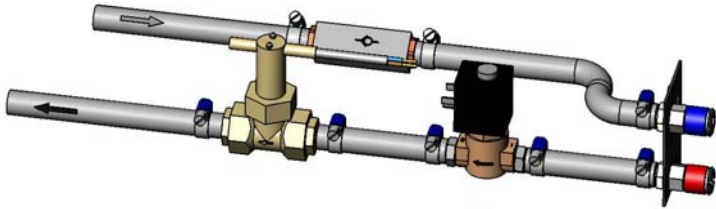
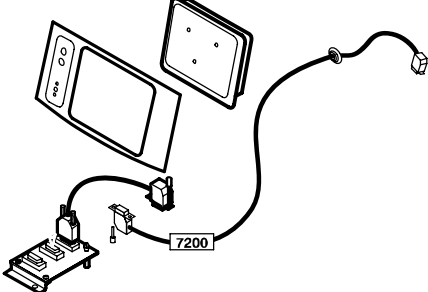
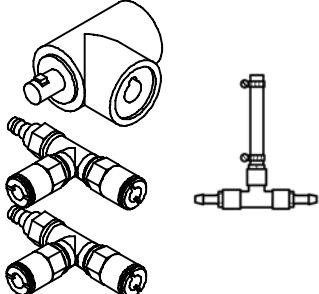
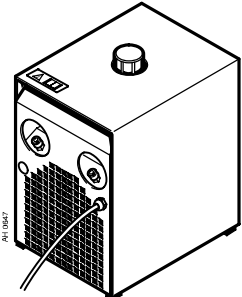
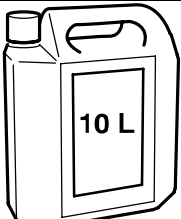
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Accessories

 A line drawing of a trolley with a welding power source mounted on top. The trolley has a handle and four wheels.	<p>Trolley 0458 530 880</p>
 A line drawing of a trolley similar to the first one, but with a long, curved arm extending upwards from the top, likely for a feeder.	<p>Trolley 2 (for feeder with counterbalance device and/or 2 gas bottles) 0458 603 880</p>
 A line drawing of a small, cylindrical pin mounted on a rectangular base plate with four screws.	<p>Guide pin 0458 731 880</p>
 A line drawing of a rectangular metal box, likely an autotransformer, with a cooling fan on the front panel.	<p>Autotransformer TUA2 0459 145 880</p>
 A line drawing of a curved handle with two mounting points, each with a screw hole.	<p>Handle (1 piece) with mounting screws .. 0459 307 881</p>

	<p>Remote control adapter RA12 12 pole 0459 491 910 For analogue remote controls to CAN based equipment.</p>
	<p>Remote control unit MTA1 CAN 0459 491 880 MIG/MAG: wire feed speed and voltage MMA: current and arc force TIG: current, pulse and background current</p>
	<p>Remote control unit M1 10Prog CAN 0459 491 882 Choice of on of 10 programs MIG/MAG: voltage deviation TIG and MMA: current deviation</p>
	<p>Remote control unit AT1 CAN 0459 491 883 MMA and TIG: current</p>
	<p>Remote control unit AT1 CF CAN 0459 491 884 MMA and TIG: rough and fine setting of current.</p>

	<p>Remote control cable 4 pole – 12 pole</p>
	<p>0.25 m 0459 554 884</p>
	<p>5 m 0459 554 880</p>
	<p>10 m 0459 554 881</p>
	<p>15 m 0459 554 882</p>
	<p>25 m 0459 554 883</p>
	<p>Remote cable CAN 4 pole – 10 pole</p>
	<p>0.25 m 0459 960 883</p>
	<p>5 m 0459 960 880</p>
	<p>10 m 0459 960 881</p>
	<p>25 m 0459 960 882</p>
	<p>5 m Heavy Duty 0469 960 980</p>
	<p>10 m Heavy Duty 0459 960 981</p>
<p>25 m Heavy Duty 0469 960 982</p>	
	<p>Connection set CAN 12–12 pole</p>
	<p>1.7 m 0456 528 880</p>
	<p>5 m 0456 528 890</p>
	<p>10 m 0456 528 881</p>
	<p>15 m 0456 528 882</p>
	<p>25 m 0456 528 883</p>
	<p>25 m 0456 528 884</p>
	<p>Connection set water CAN 12–12 pole</p>
	<p>1.7 m 0456 528 885</p>
	<p>5 m 0456 528 895</p>
	<p>10 m 0456 528 886</p>
	<p>15 m 0456 528 887</p>
	<p>25 m 0456 528 888</p>
<p>35 m 0456 528 889</p>	
<p>Connection set water CAN 12–10 pole</p>	
<p>1.7 m 0459 528 970</p>	
<p>5 m 0459 528 971</p>	
<p>10 m 0459 528 972</p>	
<p>15 m 0459 528 973</p>	
<p>25 m 0459 528 974</p>	
<p>35 m 0459 528 975</p>	
	<p>Return cable 5 m, 95 mm² 0700 006 897</p>
	<p>Water flow guard 0.7 l/min 0456 855 880</p>

 A mechanical assembly consisting of two parallel horizontal pipes. The top pipe has a valve with a handle and a flow arrow pointing right. The bottom pipe has a valve with a handle and a flow arrow pointing left. Both pipes are connected to a central vertical pipe that has a black cylindrical component and a red and blue fitting on the right side.	<p>Water return flow guard Mech 7 m 0461 203 880</p>
 A control kit including a rectangular panel with a display and buttons, a smaller square panel, and a black cable with a connector. A small component labeled '7200' is also shown.	<p>MMC kit for power source Mig 0459 579 880</p>
 A set of mechanical components including a cylindrical motor-like part, several threaded fittings, and a T-shaped bracket with a vertical rod.	<p>Connection set for connection of two wire feed units 0459 546 880</p>
 A rectangular metal cooling unit with a fan grille on the front. A cable is plugged into the side. The text 'Air intake' is visible near the fan.	<p>Cooling unit OCE2H 0414 191 881</p>
 A white plastic jerrycan with a handle and a cap. The text '10 L' is printed on the front.	<p>Coolant (Ready mixed) 50 % water and 50% ethylene glycol (10 l) 0007 810 012</p>

