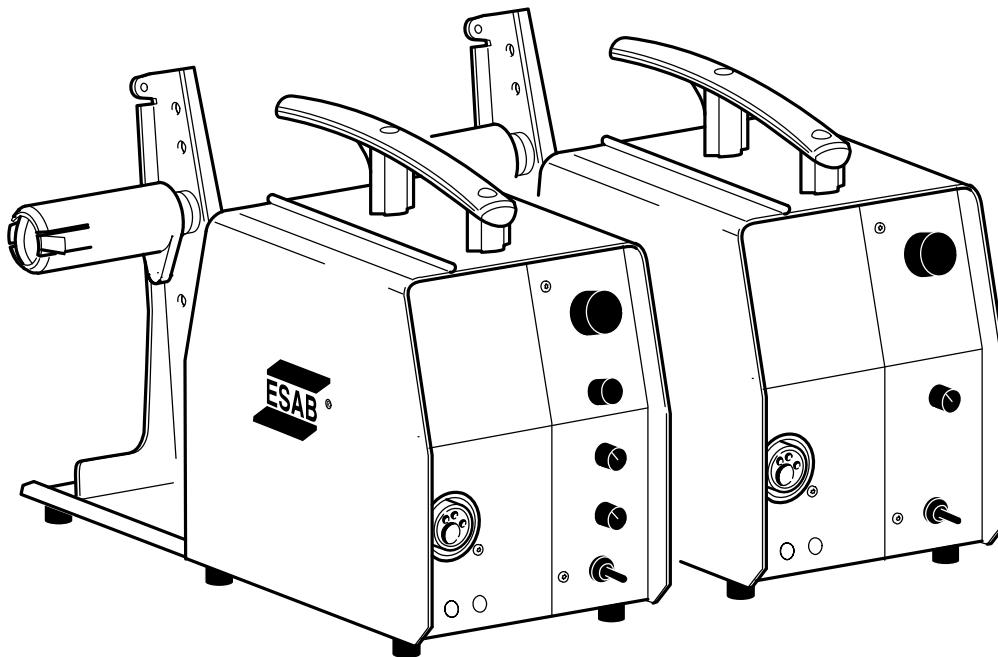


Spare parts list

Edition 121009



Valid for serial no. 418-xxx-xxxx, 435-xxx-xxxx, 533-xxx-xxxx, 620-xxx-xxxx

The wire feed units are renamed:

New name	Old name
Origo™ Feed L302 , M08	OrigoFeed 30-2
Origo™ Feed L304 , M09	OrigoFeed 30-4

Ordering no.	Product
0459 495 782	Feed L302
0459 495 882	Feed L304
0459 495 892	Feed L304 with water cooling connections

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.

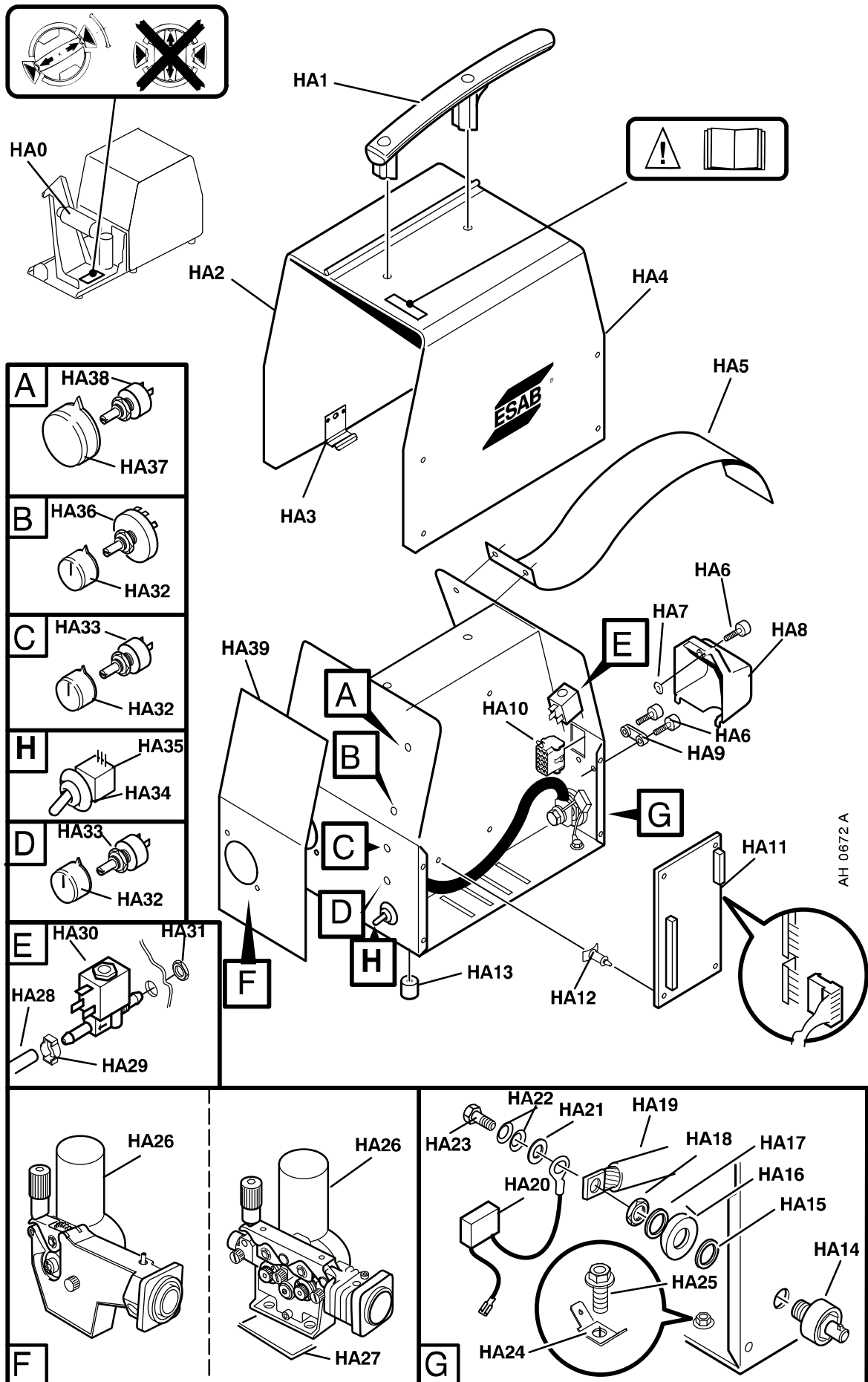
Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

Rights reserved to alter specifications without notice.

Feed L302, Feed L304, OrigoFeed 30-2, OrigoFeed 30-4

C = component designation in the circuit diagram

Item	Feed L302	Feed L304	Ordering no.	Denomination	Notes	C
HA0	1	1	0146 967 881	Brake hub		
HA1	1	1	0459 119 001	Handle		
HA2	1	1	0459 497 001	Side panel		
HA3	1	1	0459 547 001	Spring lock		
HA4	1	1	0459 498 001	Side panel		
HA5	1	1	0156 633 003	Reel cover		
HA6	3	3	0458 689 002	Pole screw	M4x25	
HA7	1	1		O-ring	OR 3.6 x 1.6	
HA8	1	1	0459 489 001	Connection cover		
HA9	1	1	0040 936 901	Clamp		
HA10	1	1	0192 784 016 0192 784 102	Sleeve plug Sleeve	15 pole panel socket For 15 pole socket	13XS12
HA11	1	-	0487 254 880	Circuit board	For all OrigoFeed 30-2, Feed L302	13AP1
	-	1	0487 254 880	Circuit board	From serial no. 533-xxx-xxxx	13AP1
	-	1	0349 304 491	Circuit board	For serial no. 418-xxx-xxxx and 435-xxx-xxx	13AP1
HA12	4	4		Circuit board holder	6.3 mm	
HA13	4	4	0467 695 001	Rubber foot	Ø 20/6.4x3, When ordering: 4 pieces delivered.	
HA14	1	1	0160 609 881	Welding current terminal		13XP2
HA15	1	1	0466 325 001	Gasket		
HA16	1	1		Spacer ring	Included in item HA14	
HA17	1	1		Washer	Included in item HA14	
HA18	1	1		Nut	Included in item HA14	
HA19	1	1	0459 147 881	Cable set		
HA20	1	1	0467 911 881	Capacitor	0.1 µF 250V with cable lugs	13C1
HA21	1	1		Washer	Ø 22/10.5x2	
HA22	2	2		Spring washer	Ø 20/10.2x1.1	
HA23	1	1		Screw	M10x20	
HA24	2	2		Flat pin	6.3x0.8	
HA25	4	4		Screw	M6x8	
HA26	1	-	0455 890 889	Wire feed mechanism	OrigoFeed 30-2, Feed L302, See page 4	
	-	1	0459 000 887	Wire feed mechanism	OrigoFeed 30-4, Feed L304, See page 6	
HA27	-	1	0459 256 001	Insulating plate		
HA28	1	1	0456 496 001	Hose, red	L=0.50, Ø 9/5mm, to be ordered per metre	
HA29	1	1		Hose clamp	Ø 11.3/10.8	
HA30	1	1	0193 054 006	Solenoid valve		13YV1
HA31	1	1	0194 130 120	Nut	MF10x1	
HA32	1	3	0321 475 885	Knob		
HA33	1	2	0349 485 758	Potentiometer	2.2 kΩ	13RP2, 13RP3
HA34	1	1	0147 866 009	Cover rubber		
HA35	1	1	0147 866 008	Switch	2-position	13SA2
HA36	-	1	0194 055 009	Rotary switch	5-position	13SA1
HA37	1	1	0321 475 893	Knob		
HA38	1	1	0349 302 094	Potentiometer	100 kΩ	13RP1
HA39	1	-	0459 505 009	Label	For wire feed unit without water	
	-	1	0459 505 007	Label	For wire feed unit without water	



C = component designation in the circuit diagram

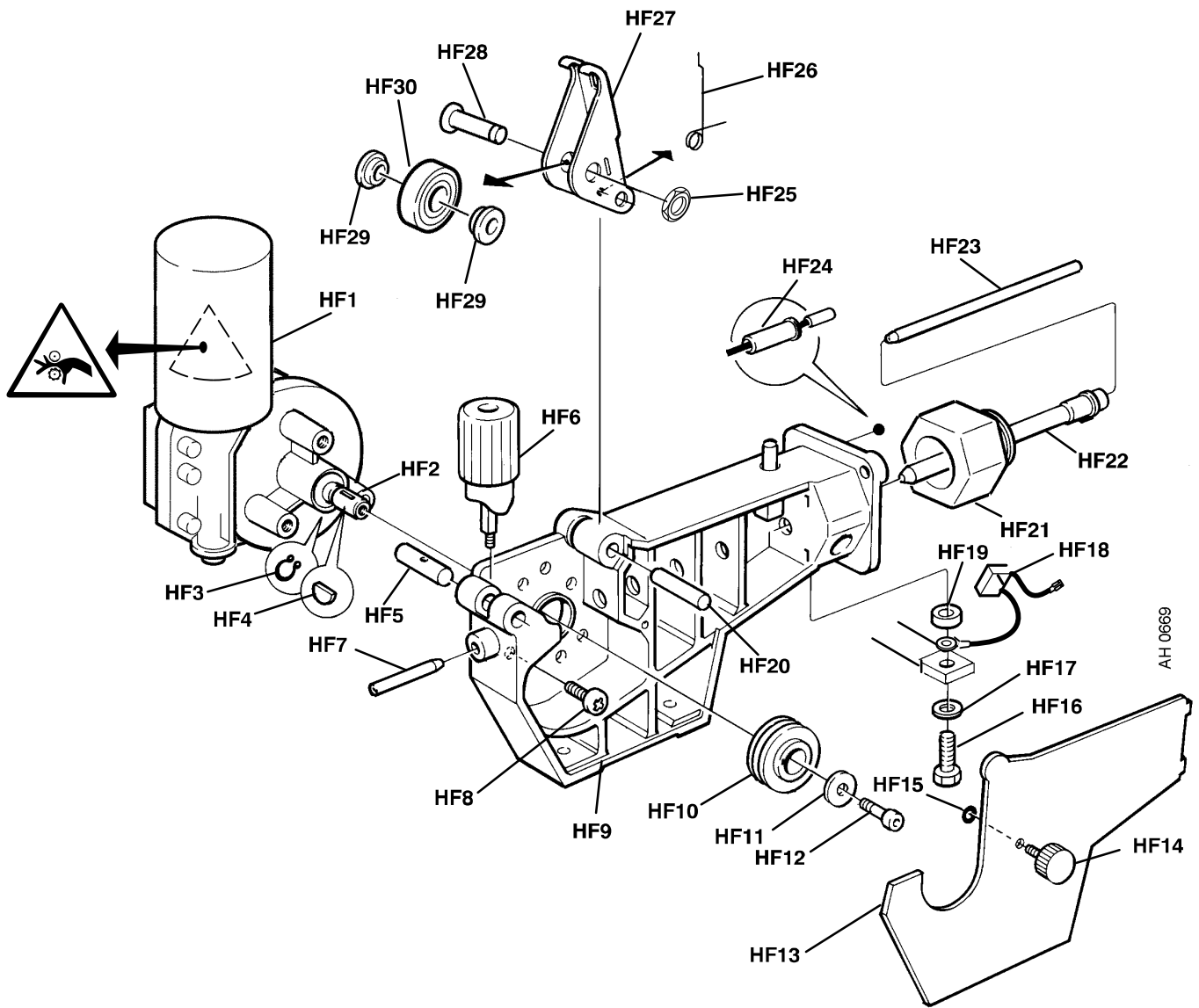
(W) = wear part

Item	Qty	Ordering no.	Denomination	Notes	C
		0455 890 889	Wire feed mechanism	Type MEK 2 Includes items HF1 - HF29	
HF1	1	0466 489 001	Drive unit		13M1
HF2	1	0332 351 013	Axle shaft	Drive shaft with pinion. Included in item HF1.	
HF3	1	0215 701 007	Circlips	Locking washer. Included in item HF1	
HF4	1	0191 496 114	Woodruff wedge	Included in item HF1	
HF5	1		Pin bolt	See item HF101	
HF6	1		Pressure device	See item HF101	
HF7	1	(W)	Insert tube	Inlet nozzle	
HF8	3		Screw	M6x16	
HF9	1	0455 884 001	Wire feeder housing		
HF10	1	(W)	Feed roller		
HF11	1	0193 104 002	Washer		
HF12	1		Screw	M4x12	
HF13	1	0455 881 001	Cover plate		
HF14	1	0455 898 001	Screw	(M5x12)	
HF15	1	0215 201 202	O-ring		
HF16	1		Screw	M8x25	
HF17	2		Washer	Ø 16/8.4x1.5	
HF18	1	0467 911 880	Capacitor	0.1 µF 250V with cable lugs	13C2
HF19	1	0455 883 001	Spacer sleeve	Ø 16/8.2x0.9	
HF20	1	0455 893 001	Cyl. roller	Shaft	
HF21	1	0455 882 001	Current sleeve		
HF22	1	(W)	Outlet nozzle		
HF23	1	(W)	Insert tube		
HF24	2	0368 750 001	Insulating sleeve		
HF25	1		Nut	M8	
HF26	1	0455 896 001	Spring		
HF27	1	0469 835 001	Holder		
HF28	1	0456 608 001	Pressure shaft		
HF29	2	(W)	Spacer sleeve		
HF30	1	(W)	Pressure roller flat		

For wear parts see page 8.

SPARE PARTS SET

Item	Ordering no.	Denomination	Notes
HF100	0367 529 001	Pressure arm compl. (W)	Includes item HF25, HF27, HF28, HF29 and HF30
HF101	0459 228 881	Pressure device set	Includes item HF5, HF6 and one screw M3x12



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C = component designation in the circuit diagram

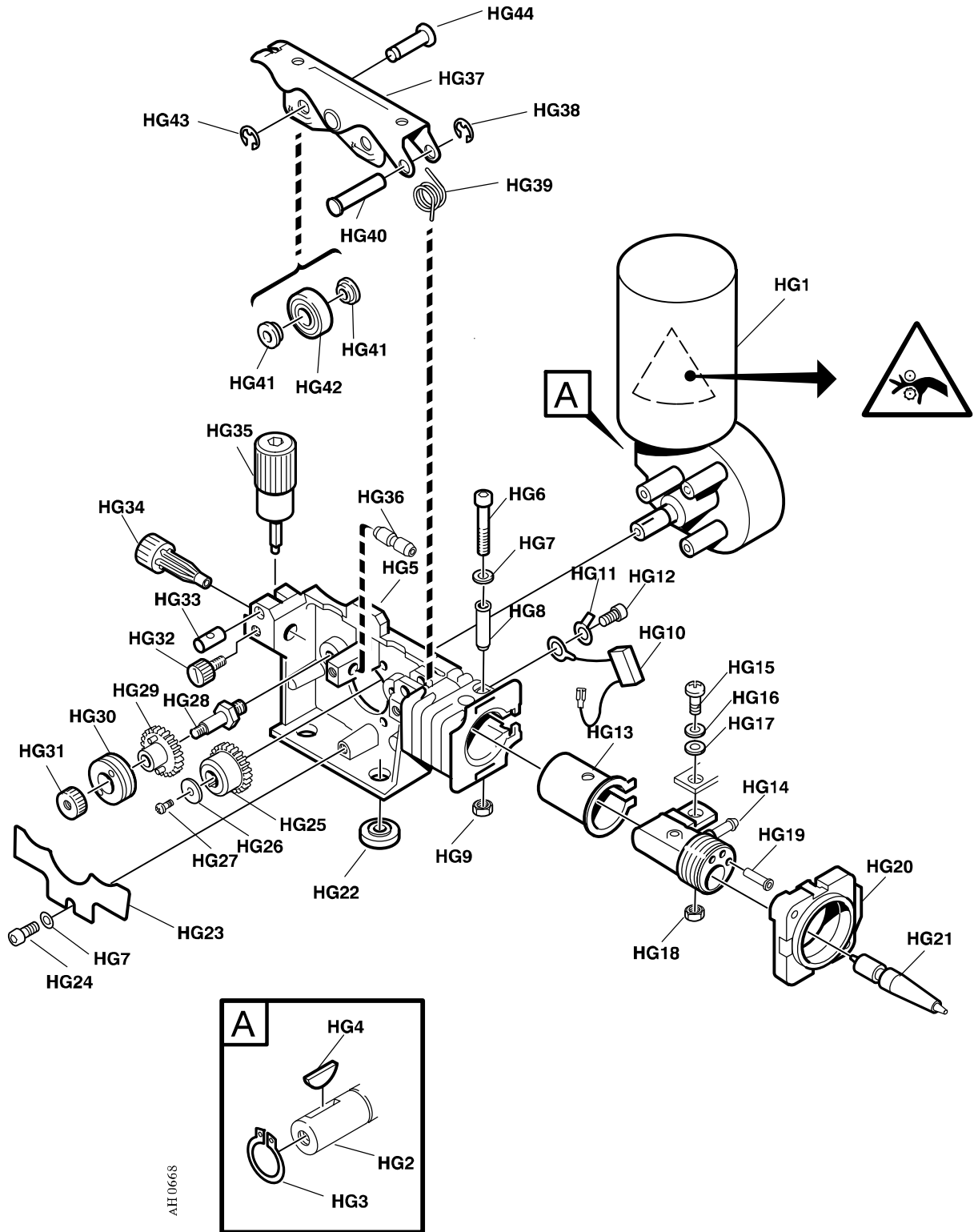
(W) = wear part

Item	Qty	Ordering no.	Denomination	Notes	C
		0459 000 887	Wire feed mechanism	Type MEM 30 Includes items HG1 - HG21 and HG23 - HG44	
HG1	1	0466 489 001	Drive unit		13M1
HG2	1	0332 351 013	Shaft (with pinion)	Included in item HG1	
HG3	1	0215 701 007	Locking washer	Included in item HG1	
HG4	1	0191 496 114	Woodruff wedge	Included in item HG1	
HG5	1	0455 046 003	Gear housing		
HG6	1		Screw	M6x40	
HG7	2		Washer	Ø 12/6.4x1.5	
HG8	1	0455 048 001	Insulating tube		
HG9	1		Nut	M6	
HG10	1	0467 911 880	Capacitor	0.1 µF 250V with cable lugs	13C2
HG11	1		Flat pin	6.3x0.8 M6	
HG12	4		Screw	M6x12	
HG13	1	0455 045 001	Insulating sleeve		
HG14	1	0455 044 001	Current connection		
HG15	1		Screw	M8x25	
HG16	1		Washer	Ø 16/8.4x1.5	
HG17	1		Belleville washer	Ø 16/8.2x0.9	
HG18	1		Nut	M8	
HG19	1	0459 224 883	Cable set	Includes sleeves and insulating sleeves.	
HG20	1	0458 918 880	Front flange with PC-board	Current relay	
HG21	1	(W)	Outlet nozzle		
HG22	4	0153 043 002	Insulating washer		
HG23	1	0469 838 001	Cover		
HG24	2		Screw	M6x12	
HG25	1	(W)	Drive gear		
HG26	1		Washer	Ø 16/5x1	
HG27	1		Screw	M4x12	
HG28	2		Axle feed roll	See item HG102	
HG29	2	(W)	Gear adapter		
HG30	2	(W)	Feed roller		
HG31	2		Locking nut	See item HG102	
HG32	3	0458 689 001	Screw for nozzle		
HG33	1		Pin bolt	See item HG101	
HG34	1	(W)	Inlet nozzle		
HG35	1		Pressure device	See item HG101	
HG36	1	(W)	Intermediate nozzle		
HG37	1		Pressure arm	See item HG100	
HG38	1		Locking washer	See item HG100	
HG39	1		Torsion spring	See item HG100	
HG40	1		Shaft	See item HG100	
HG41	4	0455 906 001	Spacer sleeve		
HG42	2	0455 907 001	Pressure roller		
HG43	3	02157 027 08	Locking washer		
HG44	2	0459 518 001	Axel pressure roll		

For wear parts see page 10.

SPARE PARTS SETS

Item	Ordering no.	Denomination	Notes
HG100	0459 227 880	Pressure arm set	Includes items HGH37, HG38, HG39 and HG40
HG101	0459 228 880	Pressure device set	Includes items HG33, HG35 and one screw M3x12.
HG102	0458 722 880	Axle and nut	Includes items HG28 and HG31.



Wear parts

Item	Ordering no.	Denomination	Notes
HM1	0455 889 001* 0455 894 001*	Insert tube Insert tube	For Fe, Ss & cored wire For Al wire
HM2	0455 886 001* 0455 885 001*	Outlet nozzle Outlet nozzle	For Fe, Ss & cored wire For Al wire
HM3	0455 898 001 0215 201 202	Screw O-ring	(M5x12)
HM4	0455 881 001	Cover plate	
HM5		Screw	M4x12
HM6	0193 104 002	Washer	Ø16/5x1
HM7	0367 556 001 0367 556 002 0367 556 003 0367 556 004	Feed roller Feed roller Feed roller Feed roller	For Fe, Ss & cored wire, Ø 0.6 - 0.8 mm, V groove For Fe, Ss & cored wire, Ø 0.8 - 1.0 mm, V groove For Fe, Ss & cored wire Ø 1.0 - 1.2 mm, V groove For Al wire, Ø 1.0 - 1.2 mm, U groove
HM8	0466 074 001	Insert tube	
HM9	0455 906 001	Spacer sleeve	Included in item HM100
HM10	0455 907 001	Pressure roller	Flat, Included in item HM100
HM11		Nut	M8, Included in item HM100
HM12	0469 835 001	Pressure arm	Included in item HM100
HM13	0456 088 001	Shaft	Included in item HM100
HM14	0455 896 001	Spring	
HM15		Nut	M10
HM16	0458 748 002	Insulating washer	
HM17	0458 748 001	Insulating bushing	
HM18	0156 602 001 0332 318 001	Inlet nozzle Inlet nozzle	For Fe, Ss, Al & Cored wire, Ø 2 mm plastic for 0.6-1.6 mm For Fe, Ss & Cored wire, Ø 2.4 mm steel for 1.2-2.0 mm
HM19	0191 496 114	Woodruff wedge	

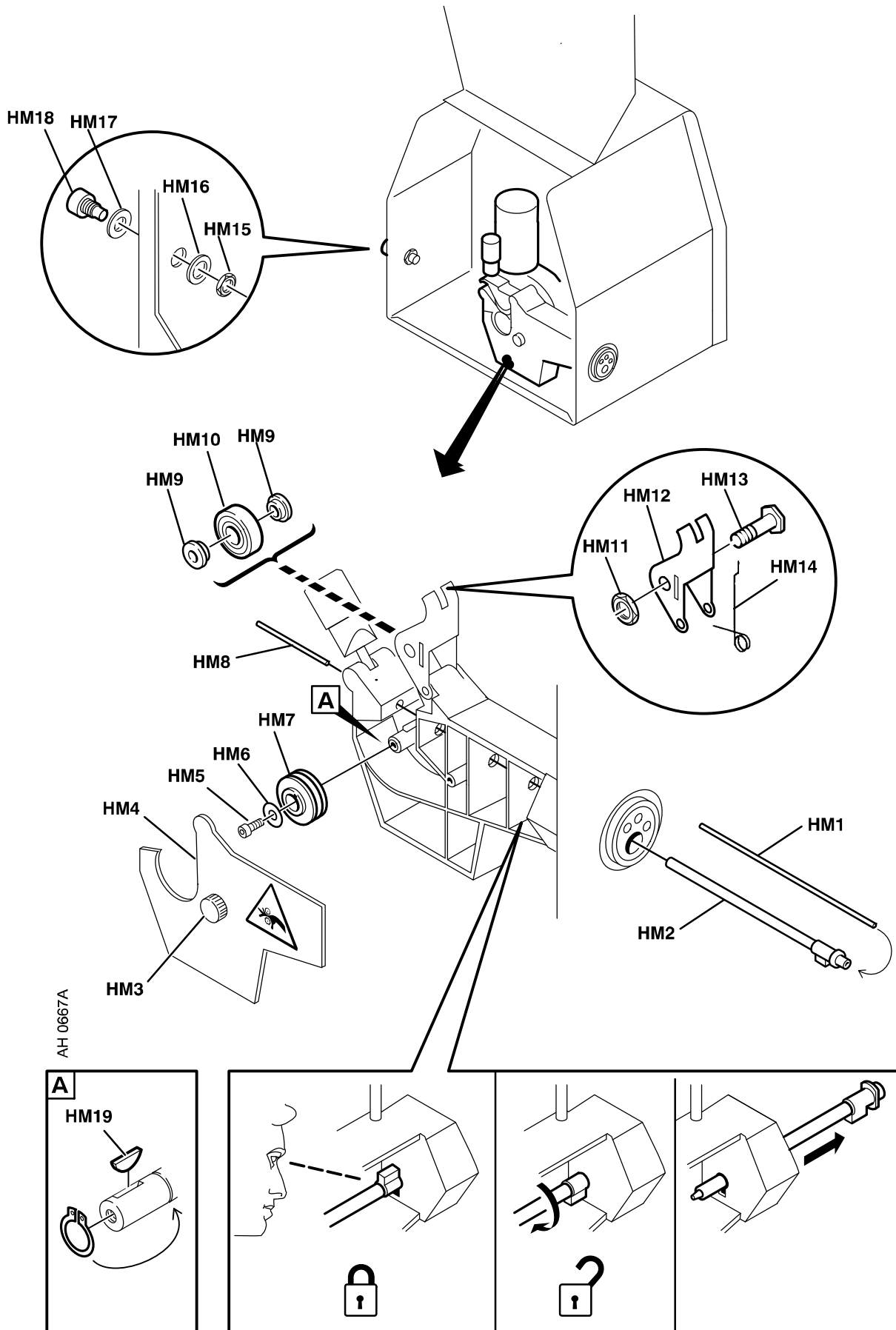
* Insert tube 0455 889 001 and outlet nozzle 0455 886 001 must be used together.
Insert tube 0455 894 001 and outlet nozzle 0455 885 001 must be used together.

PARTS SET

Item	Ordering no.	Denomination	Notes
HM100	0367 529 001	Pressure arm compl.	Includes item HM9, HM10, HM11, HM12 and HM13

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.

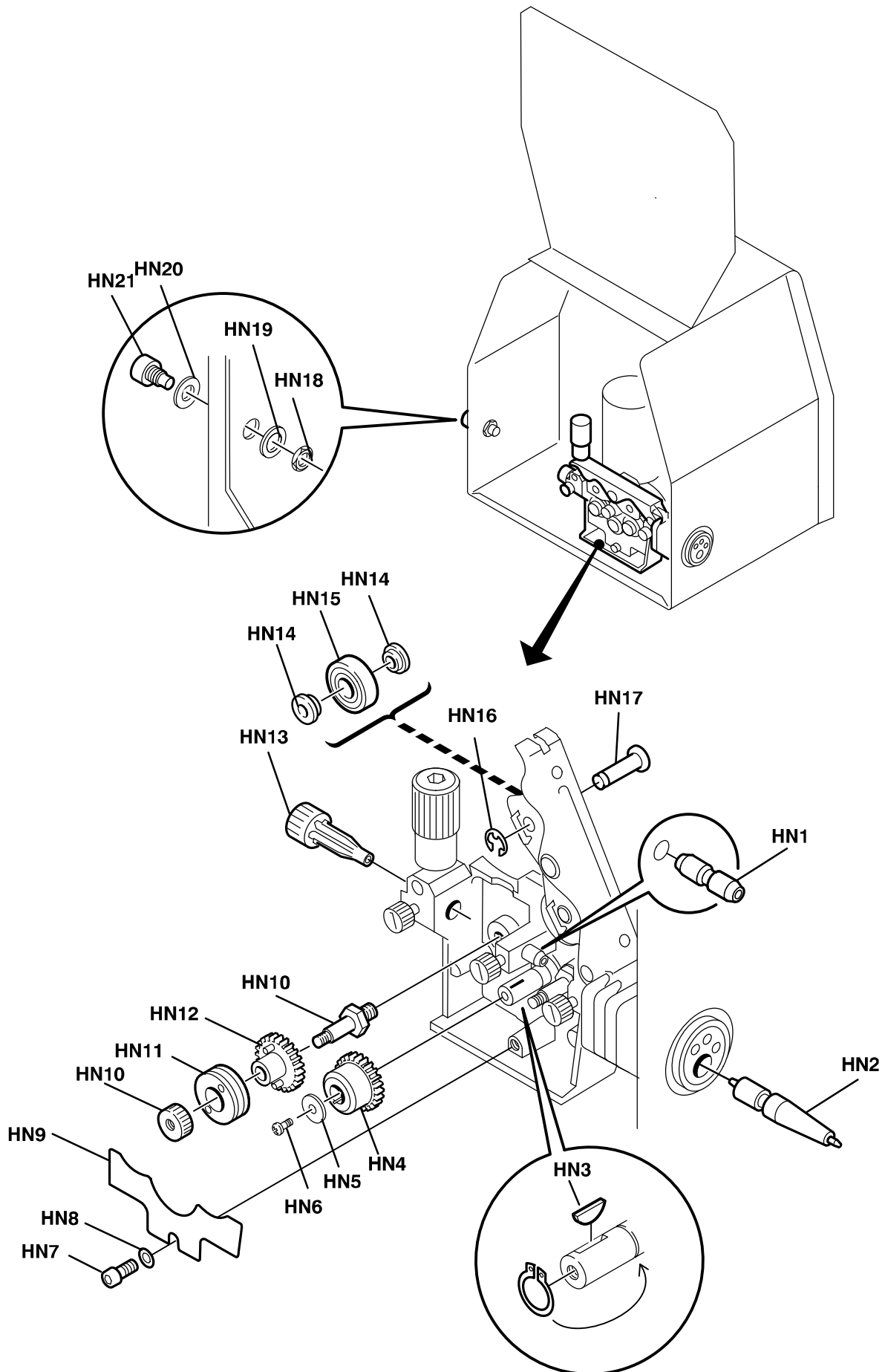


HD = Heavy Duty

Item	Ordering no.	Denomination	Notes
HN1	0455 072 002 0456 615 001	Intermediate nozzle Intermediatenozzle	For Fe, Ss & cored wire For Al Wire
HN2	0469 837 880 0469 837 881	Outlet nozzle Outlet nozzle	For Fe, Ss & cored wire, Ø 2.0 mm steel for 0.6-1.6 mm For Al wire, Ø 2.0 mm plastic for 0.8-1.6 mm
HN3	0191 496 114	Woodruff wedge	
HN4	0459 440 001	Motor gear euro	
HN5		Washer	Ø 16/5x1
HN6		Screw	M4x12
HN7		Screw	M6x12
HN8		Washer	Ø 12/6.4x1.5
HN9	0469 838 001	Cover	
HN10	0458 722 880	Axle and Nut	
HN11	0369 557 001 0369 557 002 0369 557 003	Feed roller Feed roller Feed roller	For Fe, Ss & cored wire, Ø 0.6 & 0.8 mm, V groove For Fe, Ss & cored wire, Ø 0.8 & 1.0 mm, V groove For Fe, Ss & cored wire, Ø 1.0 & 1.2 mm, V groove
	0369 557 004 0369 557 013 0369 557 011 0369 557 006	Feed roller Feed roller Feed roller Feed roller	For Cored wire, Ø 1.0 & 1.2 mm, V-Knurled groove For Cored wire, Ø 1.4 & 1.6 mm, V-Knurled groove For Al wire, Ø 0.8 & 0.9 mm, U groove For Al wire, Ø 1.0 & 1.2 mm, U groove
HN12	0459 441 880	Gear adapter	
HN13	0455 049 001	Inlet nozzle	
HN14	0455 906 001	Spacer sleeve	
HN15	0455 907 001	Pressure roller	Flat
HN16	0215 702 708	Locking washer	
HN17	0459 518 001	Axel pressure roll	
HN18		Nut	M10
HN19	0458 748 002	Insulating washer	
HN20	0458 748 001	Insulating bushing	
HN21	0156 602 001 0332 318 001	Inlet nozzle Inlet nozzle (HD)	For Fe, Ss, Al & Cored wire, Ø 2 mm plastic for 0.6-1.6 mm For Fe, Ss & Cored wire, Ø 2.4 mm steel for 1.2-2.0 mm

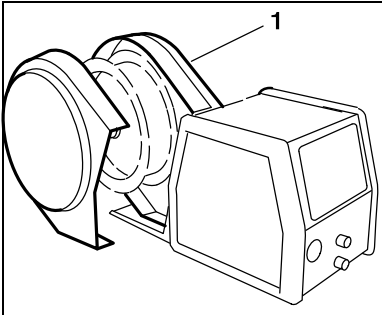
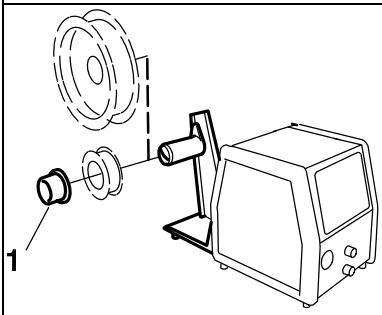
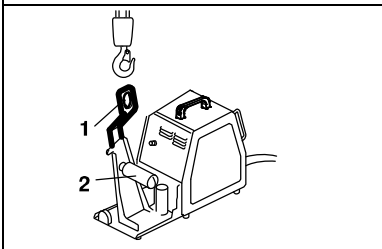
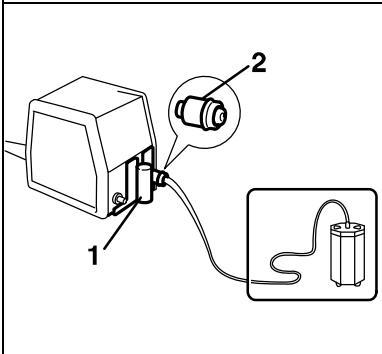
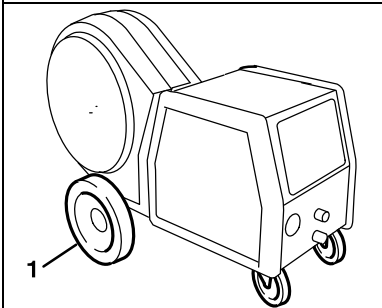
Welding with aluminium wire

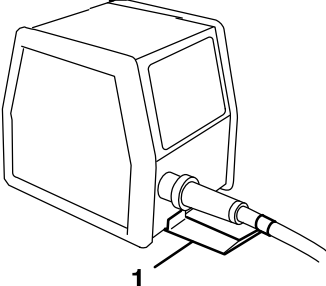

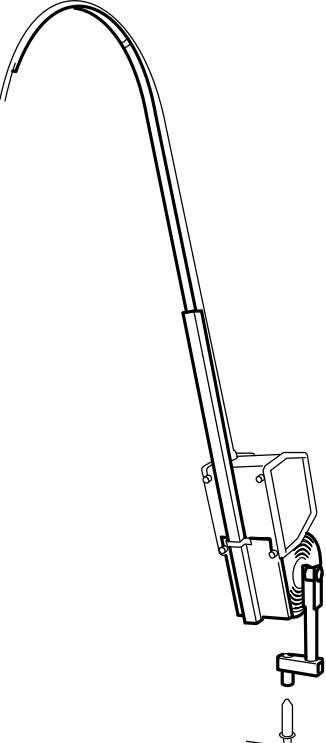
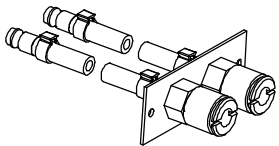
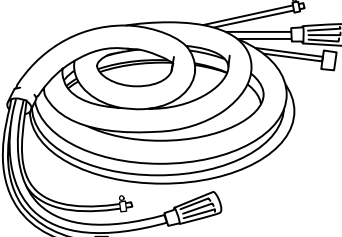
In order to weld with aluminium wire, proper rollers, nozzles and liners for aluminium wire MUST be used, It is recommended to use 3 m long welding gun for aluminium wire, equipped with appropriate wear parts.



AH 0666

Accessories

	<p>1 Bobbin cover, plastic Ø 300mm 0458 674 880</p>
	<p>1 Adapter for 5 kg bobbin 0455 410 001</p>
	<p>1 Lifting eye 0458 706 880 2 Brake hub 0146 967 881</p>
	<p>1 Turning piece 0458 703 880 2 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>Counter balance device 0458 705 880 (includes mast and counter balance)</p>
	<p>Water kit 0459 564 880</p>
	<p>Connection set Connection set 1.7 m 0459 532 880 Connection set 5 m 0459 532 881 Connection set 10 m 0459 532 882 Connection set 10 m, water 0459 532 892</p>

