Standard equipment

WELDING PACKAGE SELECTION GUIDE

AN **EASY CHOICE**

This selection guide will assist you in choosing the machine package that best suits your application requirements for welding.

Specific questions about your process and application help identify a Package Folder most appropriate for your needs. Features and benefits of each welding package are provided to help simplify your choice.

Package Folder

The Package Folder cover page provides an overview of the various package options offered. The centre spread explains the features and benefits of each welding package in detail from a welder's perspective. The back page presents optional accessories to enhance quality and increase productivity.

Introduction to Welding Packages

ESAB offers a wide range of solutions for MMA, TIG and MIG/MAG welding.

This selection guide presents packages designed to address basic welding functionality for service and maintenance applications up to the most advanced welding needs.

Selecting a welding package with greater functionality provides more flexibility in the materials you can weld and in the advanced settings offered.

Customized packages include a multitude of accessories and offer even greater process flexibility.

Please refer to the ESAB website or product catalogue for complete details for each package or product.

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Stick welding or MMA is more than 100 years old. The MMA welding method has the lowest investment cost, does not require shielding gas, and is highly portable, both indoor and outdoor, due to its relatively low weight and resistance to the elements.

TIG – Introduction and Overview 12

TIG welding offers an attractive bead appearance and the highest penetration, which results in strong weld joints. The TIG welding method has the highest investment cost and is a relatively slow welding process.

MIG/MAG – Introduction and Overview 24

MIG/MAG welding is the most common welding process in use today. The MIG/MAG welding method typically offers the highest productivity and lowest operating cost. Shielding gas is generally required to protect the weld pool, but specific self-shielding flux-cored wires are also available.

Introduction to MMA Welding Packages

To identify the most suitable welding package for your application consider the following:

- What electrode dimension will be used? The thicker the electrode, the more welding current is required.
- Does the application require adjustment of the welding current during welding? If so, select a power source equipped with a remote control outlet to connect a separate remote control.
- Will the machine be used on a domestic grid? If yes, choose a machine that can be connected to a 10 A fuse.

For certain applications, more than one package may be suitable. In these cases please refer to the package information sheet in this binder.

Benefits

Electrodes with larger diameters are more productive due to a higher deposition rate but also require a higher welding current. A larger diameter electrode reduces the number of passes required when filling up the welding joint. When welding thinner materials, a smaller diameter electrode is preferable as it reduces the risk of burn through and is easier to strike.

Remote-controlled systems allow adjustment of the welding current during welding by using a separate remote control. Details are provided with each welding package.

The fuse size required on a domestic grid (1 ph, 230V, less then 16A fuse) is lower than on an industrial grid (1 ph, 230V, 16A fuse). Depending on local conditions, the industrial grid is also likely to offer 3 ph, 400V, which allows the use of welding equipment with higher welding output.

Material	Electrode Diameter	Remote Control Outlet	Model	Mains Supply	Page
Mild Steel/ Stainless Steel	Ø 1.6-2.5mm	No	Buddy™ Arc 145	1ph / 240V	7
	Ø 1.6-3.2mm	No	Caddy® Arc 151i A31,	1ph / 240V	7
			Buddy™ Arc 180	1ph / 240V	7
		Yes	Caddy® Arc 151i A33,	1ph / 240V	7
	Ø 1.6-4.0mm	Yes	Caddy® Arc 201i A33,	1ph / 240V	7
	Ø 1.6-5.0mm	No	Caddy® Arc 251i A32,	3ph / 400V	7
		Yes	Caddy® Arc 251i A34,	3ph / 400V	7

MMA
WELDING PACKAGES

ESAB's portable MMA packages provide the flexibility to weld most metals, including alloyed and non-alloyed steel, stainless steel and cast iron. A compact design and easy-to-use control panel make these machines handy to take along to any job.

Buddy™ Arc 145/180

- Buddy Arc 145 welds electrodes up to Ø2.5mm
- Buddy Arc 180 welds electrodes up to Ø3.2mm
- Competitively priced
- 230V 1ph, requires 16A fuse

Caddy® Arc 151i A31 & Caddy® Arc 151i/201i A33

- Caddy Arc 151i welds Ø3.2mm electrodes with a 10A fuse
- Caddy Arc 201i welds electrodes up to Ø4.0mm
- Allows for 100m mains cable
- For adjustable Arc Force, Hot Start, two memories and remote control facility, choose the A33 panel
- 230V 1ph, requires 10A fuse (Arc 151i), 16A fuse (Arc 201i)

Caddy® Arc 251i A32/A34

- Welds all types of electrodes up to Ø5.0mm
- For adjustable Arc Force and Hot Start, electrode type selector, two memories and remote control facility, choose the A34 panel
- 400V 3ph, requires 10A fuse

MMA WELDING PACKAGES

GENERAL FEATURES

All ESAB MMA machines offer a smooth direct weld current and excellent welding performance across the amperage range for welding most metals such as alloyed and non alloyed steel, stainless steel and cast iron using basic and rutile electrodes.

Portable design – A practical and compact design featuring a carry handle makes ESAB's portable MMA machines easy to transport to the work site. To further facilitate transportation, the Caddy offers an optional shoulder strap with an integrrated cable holder solution. The Buddy machines come equipped with a basic shoulder strap.

Durability – The design in combination with a robust composite and metal housing offer IP23 classification making the machines suitable for outdoor use. Sturdy OKC 50 cable connectors ensure efficient current transfer with minimum power loss. Buddy Arc 145 features OKC 25 cable connectors.

TIG option – The Buddy Arc 180 and the Caddy Arc series offer basic TIG welding with the addition of a TIG torch including a gas valve, a gas regulator and a cylinder of gas. Mild steel or stainless steel can be welded with or without filler material.

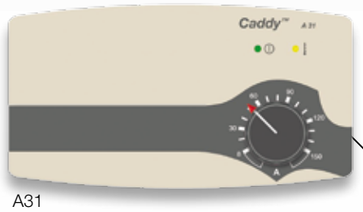
Complete and Ready-to-use – All MMA machines come complete with a 3m mains cable with plug, 3m welding cable with electrode holder and a 3m return cable with clamp.

Buddy Arc 145/180

The Buddy Arc series are compact, competetively priced MMA machines. Buddy Arc features a simple, intuitive analogue panel and easy-to-use functions, making the machine ideally suited for both shop or offsite steel fabrication. Buddy Arc 145 welds electrodes up to Ø2.5mm. Buddy Arc 180 welds electrodes up to Ø3.2mm. A 16 amp slow fuse is required.

Caddy Arc 151i/201i/251i

Caddy Arc comes equipped with large OKC 50 welding current connections to withstand heavy loads. The efficient cooling of the machine and the carefully thought out design ensure a long working life and allow use under the toughest working conditions. Caddy Arc is equipped with automated power factor correction (PFC) allowing for welding of 3.2mm electrodes using only a 10A slow fuse. Mains cable up to 100m can be used for additional reach.



A31

Caddy Arc 151i with A31 control panel is an extremely user-friendly machine featuring a one knob setting of the weld current. The machine also provides automatic Hot Start for easy striking and Arc Force for improved welding performance.

A33

Caddy Arc 151i/201i with A33 control panel offers adjustable Hot Start and Arc Force. The two individual memory settings can be used to store the most frequently applied parameters, saving time when switching between jobs and ensuring high repeatability. The remote control mode enables the weld current to be set remotely from the power source. The current can be adjusted during welding for a more precise result.

A32

Caddy Arc 251i with A32/A34 control panel is a 400A 3ph machine capable of welding with up to 5.0mm electrodes. The remote control mode enables the weld current to be set remotely from the power source.

The A32 digital panel is extremely user friendly with a one knob setting of the weld current.

A34

The A34 digital panel features adjustable Hot Start and Arc Force. The two individual memory settings can be used to store the most frequently applied parameters, saving time when switching between jobs ensuring high repeatability. The electrode type selector optimises the machine characteristics according to the electrode to be welded.

		Basic and Rutile Electrodes				High recovery and Cellulosic Electrodes	Max Length Mains Cable ($2.5mm^2$)	Remote Control Connection	Memory	Panel		Hot Start		Arc Force		Basic TIG	Fuse		230V	400V	OKC 25	OKC50
		2.5	3.2	4.0	5.0		100m			Analogue	Digital	Auto	Adjustable	Auto	Adjustable		10A	16A	1ph	3ph		
Buddy™ Arc 145	0700 300 884	●								●		●		●				●	●		●	
Buddy™ Arc 180	0700 300 680	●	●							●		●		●		●		●	●			●
Caddy® Arc 151i A31	0460 445 881	●	●				●			●		●		●		●	●		●			●
Caddy® Arc 151i A33	0460 445 883	●	●				●	●	●		●		●		●	●	●		●			●
Caddy® Arc 201i A33	0460 445 884	●	●	●			●	●	●		●		●		●	●		●	●			●
Caddy® Arc 251i A32	0460 300 880	●	●	●	●	●	●	●			●	●		●		●	●			●		●
Caddy® Arc 251i A34	0460 300 881	●	●	●	●	●	●	●	●		●		●		●	●	●			●		●

Accessories MMA

Remote Controls

MMA1 incl. 10m connection cable	0349 501 024
AT1	0459 491 896
AT1 CoarseFine	0459 491 897
Connection cables for remote controls	
5 m cable	0459 552 880
10 m cable	0459 552 881
15 m cable	0459 552 882
25 m cable	0459 552 883

Welding and return cable kit

Welding cable kit	
Up to 150A Twist type 16 mm^2 OKC50 3m	0700 006 898
Up to 200A Twist type 25 mm^2 OKC50 3m	0700 006 900
Up to 300A Twist type 35 mm^2 OKC50 3m	0700 006 902
Up to 300A Twist type 35 mm^2 OKC50 5m	0700 006 888
Return cable kit	
Up to 150A 16 mm^2 OKC50 3m	0700 006 899
Up to 200A 25 mm^2 OKC50 3m	0700 006 901
Up to 300A 35 mm^2 OKC50 3m	0700 006 903
Up to 300A 35 mm^2 OKC50 5m	0700 006 889

Electrode holder

Crocodile-type	
Confort 200	0700 006 004
Confort 300	0700 006 005

Twist-type	
Handy 200	0700 006 003
Handy 300	0700 006 016
ESAB 200	0333 249 001
ESAB 400	0369 849 880

Return clamps

MP 200	0367 558 880
Eco clamp 250	0700 006 001
MP 300	0682 103 803

Consumables

Mild steel - Basic electrode	
OK48.00 Ø2.0mm x 300mm (carton of 10.2 kg)	4800202010
OK48.00 Ø2.5mm x 350mm (carton of 12.9 kg)	4800253000
OK48.00 Ø3.2mm x 450mm (carton of 18.0 kg)	4800324000
Stainless steel	
OK63.30 Ø2.0mm x 300mm (carton of 9.6 kg)	6330202030
OK63.30 Ø2.5mm x 300mm (carton of 10.2 kg)	6330252030
OK63.30 Ø3.2mm x 350mm (carton of 12.3 kg)	6330323020

Dry-storage container

PK 1 230V	0000 515 064

Pneumatic shipping hammer

HCB	0193 305 001

Shoulder strap Caddy®

Padded shoulder strap	0460 265 003

TIG torches (OKC50)

	4m	8m
ET 17V (for Buddy™ Arc 180 only)	0700 300 861	0700 300 865
TXH™ 151V	0700 300 539	0700 300 545
TXH™ 201V	0700 300 553	0700 300 556
Wear part kit for TXH™ 151/201/ET17		0368 846 881

Introduction to TIG Welding Packages

To identify the most suitable welding package for your application consider the following:

- What material will be welded? TIG welding aluminium requires a power source with AC functionality. If welding only mild and/or stainless steel, a DC power source is sufficient.
- What is the thickness of the material being welded? This determines the required output of the machine. Welding material less than 1.0mm thick will require pulse functionality (TA34 panel).
- Does the application require a water-cooled system? This determines the size of the welding torch required.
- Does the application require adjustment of the welding current during welding? If so, select a power source equipped with a remote control outlet to connect an adapter for a welding torch (this enables adjusting of the weld current) or add a separate remote control.

Benefits

Water-cooled systems allow use of a smaller size welding torch without the risk of overheating the torch (only available on >200A packages). The smaller sized torch provides better access to confined spaces and better ergonomics for the welder. In comparison, an air-cooled system has a lower investment cost and reduced maintenance cost.

Remote-controlled systems allow adjustment of the welding current during welding by using a welding torch with a remote control function, a foot pedal or a separate remote control. Details are provided with each welding package.

Pulse functionality is required when welding materials with a thickness less than 1.0mm. Thin materials are more likely to deform due to the heat input. By using pulsed TIG welding, the welding current is automatically adjusted during welding to reduce the heat input.

For certain applications, more than one package may be suitable. For additional details, please refer to the package information sheet in this binder.

DC TIG

Material	Plate Thickness	Cooling	Model	Pulse / Remote Control Outlet	Page
Mild Steel / Stainless Steel	<1.0mm	Air	Caddy® Tig 1500i TA34	• / •	15
			Caddy® Tig 2200i TA34	• / •	15
		Water	Caddy® Tig 2200iw TA34	• / •	15
	1.0-5.0mm	Air	Buddy™ Tig 160	- / -	15
			Caddy® Tig 1500i TA33	- / -	15
			Caddy® Tig 1500i TA34	• / •	15
	1.0-7.0mm	Air	Caddy® Tig 2200i TA33	- / -	15
			Caddy® Tig 2200i TA34	• / •	15
		Water	Caddy® Tig 2200iw TA33	- / -	15
			Caddy® Tig 2200iw TA34	• / •	15

AC/DC TIG

Material	Plate Thickness	Cooling	Model	Pulse / Remote Control Outlet	Page
Aluminium (mild and stainless steel)	0.5-5.5mm (Alu) 0.5-7.0mm (Fe/SS)	Air	Caddy® Tig 2200i AC/DC TA34	• / •	19
		Water	Caddy® Tig 2200iw AC/DC TA34	• / •	19
	1.0-5.5mm (Alu) 1.0-7.0mm (Fe/SS)	Air	Caddy® Tig 2200i AC/DC TA33	- / •	19
		Water	Caddy® Tig 2200iw AC/DC TA33	- / •	19

DC TIG
WELDING PACKAGES

ESAB's DC TIG packages are ideal for welding mild and stainless steels. These complete welding packages consist of a compact and powerful power source with an easy-to-use control panel and ergonomic torch.

Buddy™ Tig 160

- Competitively priced
- Analogue panel
- Adjustable slope down
- Automatic post gas flow

Caddy® Tig 1500i/2200i with TA33 user interface

- Automatic settings - Simply set the plate thickness and the machine optimises the parameters
- Adjustable slope up/down and pre/post gas flow
- Option to use smaller sized TIG-torch
- Digital display

Caddy® Tig 1500i/2200i with TA34 user interface

- Pulsed functionality for controlled heat input
- Ideal for thin plate welding and special alloys
- Remote control ready
- Two individual memory settings
- Adjustable slope up/down and pre/post gas flow
- Option to use smaller sized TIG-torch
- Digital display

DC TIG WELDING PACKAGES

GENERAL FEATURES

Portable design – All ESAB DC TIG machines are portable and lightweight, making them easy to transport to indoor and outdoor work sites. The compact design makes them easy to store when not in use.

Durability – The design in combination with the robust, composite and metal housing offer IP23 classification making the machines suitable for outdoor use. Sturdy OKC 50 cable connectors ensure efficient current transfer with minimum power loss.

TIG welding – All ESAB TIG machines offer High Frequency (HF) and LiftArc™ starts. The arc is struck by pressing the trigger on the torch, so the electrode never touches the surface of the work piece. This eliminates the risk of contamination and improves the start properties making the machine user friendly. The 4-stroke mode ("push & release" to start – weld – "push & release" to stop) is commonly used on longer welds while the 2-stroke mode ("push" to start – weld – "release" to stop) is used on shorter welds such as tack welding. Both Caddy and Buddy offer this functionality and both weld most metals, including alloyed and non-alloyed steel, stainless steel and cast iron.

MMA option – Both Caddy Tig and Buddy Tig can be used for MMA (stick welding). A complete welding cable kit is included.

Complete and Ready-to-use – All portable TIG machines listed in this folder are delivered complete with a 3m mains cable with plug, 4.0m TIG Torch, MMA kit, return cable, 1.5m gas hose and carry handle.

Buddy Tig 160

ESAB's Buddy Tig 160 is a compact DC TIG machine that is competitively priced. Buddy Tig features a simple, intuitive analogue panel and easy-to-use functions making the machine ideally suited for both shop or offsite steel fabrication.The automatic slope down function (gradual decrease of the weld current) provides a smooth high-quality finish to the weld with reduced risk of craters. The post gas-flow is set automatically based on the selected weld current. A 16 amp slow fuse is required.

Caddy Tig 1500i & Caddy Tig 2200i

The Caddy Tig product is offered in multiple versions. The output power determines the maximum thickness that can be welded and the functionality is in the control panel (TA33 or TA34). On the more powerful Caddy Tig 2200i, an optional water cooling unit enables the use of a smaller sized water-cooled torch, suitable for those difficult to access welds.

The digital display allows the operator to set and view the welding parameters. It also provides the actual current (which might differ from the set current) for a more accurate reading. This is an important quality factor when welding according to a standard or a WPS.

TA33

The TA33 control panel offers intelligent and automatic settings to reduce set up time. Simply set the plate thickness and the machine adjusts the optimal welding parameters. The slope up and slope down time as well as the pre/post gas-flow time can be manually adjusted to suit the welder's preference.

TA34

The TA34 control panel provides pulse functionality which is recommended when welding thin material (<1.0mm). When the pulse functionality is activated, the weld current switches between the set peak and background current, thus minimising the heat input and reducing the risk of deformation of the work piece. The remote control mode on the TA34 enables the weld current to be set remotely from the power source. The current can be adjusted during welding for a more precise result.

The TA34 offers two individual memory settings. The most frequently used parameters may be stored to save time when switching between jobs and to ensure high repeatability.

		Plate Thickness Mild steel: Argon 100% Stainless steel: Argon 100%			Pulse	Remote Control Connection	Water-cooled Torch	Memory	Panel		Stick Electrode 3.2mm		Max Length Mains Cable ($2.5mm^2$)
		< 1.0	1.0 - 5.5	5.5 - 7.3					Analogue	Digital	10A fuse	16A fuse	100m
Buddy™ Tig 160	0700 300 681		●						●			●	
Caddy® Tig 1500i TA33	0460 450 880		●							●	●		●
Caddy® Tig 2200i TA33	0460 450 881		●	●						●	●		●
Caddy® Tig 2200iw TA33	0460 450 884		●	●			●			●	●		●
Caddy® Tig 1500i TA34	0460 450 882	●	●		●	●		●		●	●		●
Caddy® Tig 2200i TA34	0460 450 883	●	●	●	●	●		●		●	●		●
Caddy® Tig 2200iw TA34	0460 450 885	●	●	●	●	●	●	●		●	●		●

Self-cooled or water-cooled?
You always have the option of upgrading your Caddy Tig 2200i machine with a water cooling unit. Please contact your local ESAB dealer for details. The following items are required.

CoolMini	0460 144 880
Connection kit	0460 509 880
TXH™ 251w / 251wF torch	See next page.

Accessories TIG

Remote Controls TA34

T1 Foot CAN incl. 5m connection cable	0460 315 880
AT1 CAN	0459 491 863
AT1 CoarseFine CAN	0459 491 884
MTA1 CAN	0459 491 880

Connection cables for remote controls	
5 m cable CAN	0459 554 880
10 m cable CAN	0459 554 881
15 m cable CAN	0459 554 882
25 m cable CAN	0459 554 883

TIG consumables

Mild steel	
OK Tigrod 12.64 Ø1.6mm x 1000mm (carton 5.0 kg)	1264 16R 150
OK Tigrod 12.64 Ø2.4mm x 1000mm (carton 5.0 kg)	1264 24R 150
OK Tigrod 12.64 Ø3.2mm x 1000mm (carton 5.0 kg)	1264 32R 150
Stainless steel	
OK Tigrod 316LSi Ø1.6mm x 1000mm (carton 5.0 kg)	1632 16R 150
OK Tigrod 316LSi Ø2.4mm x 1000mm (carton 5.0 kg)	1632 24R 150
OK Tigrod 316LSi Ø3.2mm x 1000mm (carton 5.0 kg)	1632 32R 150

Tungsten electrodes

Gold Plus, 1,5% Lanthan (AC/DC):	
WL15 1,0 x 175mm Gold Plus (Lanthanated) Gold	0151 574 050
WL15 1,6 x 175mm Gold Plus (Lanthanated) Gold	0151 574 051
WL15 2,4 x 175mm Gold Plus (Lanthanated) Gold	0151 574 052
WL15 3,2 x 175mm Gold Plus (Lanthanated) Gold	0151 574 053
WL15 4,0 x 175mm Gold Plus (Lanthanated) Gold	0151 574 054
WL15 4,8 x 175mm Gold Plus (Lanthanated) Gold	0151 574 055

Tungsten grinders

G-Tech Handy II	0700 009 886
G-Tech	0700 009 880

Shoulder strap Caddy®

Padded shoulder strap	0460 265 003

Trolleys Caddy®

2-wheel, large gas bottle 20-50 liters (forward facing panel)	0460 330 880
2-wheel, large gas bottle 20-50 liters (sideways facing panel)	0459 366 887
2-wheel, small gas bottle 5-10 liters	0459 366 885

Torches (OKC50)

	4m	8m
ET 17 (for Buddy™ Tig only)	0700 300 860	0700 300 864
TXH™ 121	0700 300 524	0700 300 529
TXH™ 121F Flexible head	0700 300 526	0700 300 531
TXH™ 151	0700 300 538	0700 300 544
TXH™ 151F Flexible head	0700 300 541	0700 300 547
TXH™ 201	0700 300 552	0700 300 555
TXH™ 201F Flexible head	0700 300 554	0700 300 557
TXH™ 251w Water-cooled	0700 300 561	0700 300 563
TXH™ 251wF Flexible head	0700 300 562	0700 300 564

A TIG torch is included with all TIG welding packages listed.

Remote control torches	4m	8m
TXH™ 121r	0700 300 620	0700 300 622
TXH™ 121Fr Flexible head	0700 300 621	0700 300 623
TXH™ 151r	0700 300 624	0700 300 626
TXH™ 151Fr Flexible head	0700 300 625	0700 300 627
TXH™ 201r	0700 300 628	0700 300 630
TXH™ 201Fr Flexible head	0700 300 629	0700 300 631
TXH™ 251wr Water-cooled	0700 300 632	0700 300 634
TXH™ 251wFr Flexible head	0700 300 633	0700 300 635
Remote Adapter kit RAT!, 12-pole, incl 0,25m cable		0459 491 812

Wear part kit for TXH™ 121/251w	0368 846 880
Wear part kit for TXH™ 151/201/ET17	0368 846 881

AC/DC TIG
WELDING PACKAGES

ESAB's AC/DC TIG packages weld aluminium, mild steel, stainless steel and most other metals. These complete welding packages consist of a compact and powerful power source with an easy-to-use control panel and ergonomic torch.

Caddy® Tig 2200i AC/DC with TA33 user interface

- Automatic settings - Simply set the plate thickness and the machine optimises the parameters
- Pre-set AC frequency
- Pre-set AC balance
- Remote control ready

Caddy® Tig 2200i AC/DC with TA34 user interface

- Pulsed functionality for controlled heat input
- Ideal for thin plate welding and special alloys
- Adjustable AC Frequency optimises the arc width
- Adjustable AC Balance optimises the arc penetration
- Electrode preheating for improved starting properties and extended electrode life
- Two individual memory settings
- Remote control ready

AC/DC TIG WELDING PACKAGES

GENERAL FEATURES

Portable design – All ESAB Caddy AC/DC Tig machines are small and lightweight, making them easy to transport to indoor and outdoor work sites. The compact design makes them easy to store when not in use.

Durability – The design in combination with the robust composite and metal housing offer IP23 classification making the machines suitable for outdoor use. Sturdy OKC 50 cable connectors ensure efficient current transfer with minimum power loss.

TIG welding – All ESAB TIG machines offer High Frequency (HF) and LiftArc™ starts. The arc is struck pressing the trigger on the torch and the electrode will never touch the surface of the work piece. This eliminates the risk of contamination and improves the start properties, making the machine user friendly. For longer welds the 4-stroke mode ("push & release" to start – weld – "push & release" to stop) is commonly used while the 2-stroke mode ("push" to start – weld – "release" to stop) is used on shorter welds such as tack welding. Caddy Tig welds most metals, including alloyed and non alloyed steel, stainless steel and cast iron.

MMA option – Caddy Tig can be used for MMA (stick welding). A complete welding cable kit is included.

Complete and Ready-to-use – All portable TIG machines featured are delivered complete with a 3m mains cable with plug, 4m TIG Torch, MMA kit, return cable, 1.5m gas hose and carry handle.

Caddy Tig 2200i AC/DC

The Caddy Tig 2200i AC/DC is available with two panel options, TA33 and TA34. The 2200i model can weld aluminium up to 5.5mm and mild and stainless steels up to 7.3mm. The water-cooled 2200i allows the use of a smaller sized water-cooled torch, suitable for those difficult to access welds.

The digital display allows the operator to set and view the welding parameters. It also provides the actual current (which might differ from the set current) for a more accurate reading. This is an important quality factor when welding according to a standard or a WPS.

TA33 AC/DC

TA34 AC/DC

The TA33 control panel offers intelligent and automatic settings to reduce set up time. Simply set the plate thickness and the machine will adjust to the optimal welding parameters. The slope up and slope down time as well as the pre/post gas-flow time can be manually adjusted to suit the individual welder's preferred settings.

The TA34 control panel provides DC TIG pulse functionality which is recommended when welding thin material (<1.0mm). When pulse functionality is activated, the weld current switches between the set peak and background current, thus minimising the heat input and reducing the risk of deformation of the work piece. When welding aluminium, the adjustable AC Frequency optimises the arc width and the adjustable AC Balance optimises the penetration, providing full control of the weld pool. In addition, electrode preheating improves the start properties and extends the life of the electrode.

The TA34 offers two individual memory settings. The most frequently used parameters may be stored to save time when switching between jobs and to ensure high repeatability.

The remote control mode enables the weld current to be set remotely from the power source. This is often required when switching between different welding positions (ex. pipe welding).

		Plate Thickness Aluminium: Argon 100%		Plate Thickness Mild steel: Argon 100% Stainless steel: Argon 100%		Pulse	Remote Control Connection	Water-cooled Torch	Memory	Panel	Stick Electrode 3.2mm	Max Length Mains Cable ($2.5mm^2$)
		< 1.0	1.0 - 5.5	< 1.0	1.0 - 7.3					Digital	10A fuse	100m
Caddy® Tig 2200i AC/DC TA33	0460 150 882		●		●		●			●	●	●
Caddy® Tig 2200iw AC/DC TA33	0479 100 264		●		●		●	●		●	●	●
Caddy® Tig 2200i AC/DC TA34	0460 150 883	●	●	●	●	●	●		●	●	●	●
Caddy® Tig 2200iw AC/DC TA34	0479 100 263	●	●	●	●	●	●	●	●	●	●	●
Caddy® Tig 2200iw AC/DC TA34*	0460 150 884	●	●	●	●	●	●	●	●	●	●	●

* with trolley

Self-cooled or water-cooled?
You always have the option of upgrading your Caddy Tig 2200i AC/DC machine with a water cooling unit. Please contact your ESAB dealer for details. The following items are required.

CoolMini incl. connection kit	0460 144 880
TXH™ 251w / 251wF torch	See next page.

Accessories TIG

Remote Controls TA34

T1 Foot CAN incl. 5m connection cable	0460 315 880
AT1 CAN	0459 491 863
AT1 CoarseFine CAN	0459 491 884
MTA1 CAN	0459 491 880

Connection cables for remote controls	
5 m cable CAN	0459 554 880
10 m cable CAN	0459 554 881
15 m cable CAN	0459 554 882
25 m cable CAN	0459 554 883

TIG consumables

Mild steel	
OK Tigrod 12.64 Ø1.6mm x 1000mm (carton 5.0 kg)	126416R150
OK Tigrod 12.64 Ø2.4mm x 1000mm (carton 5.0 kg)	126424R150
OK Tigrod 12.64 Ø3.2mm x 1000mm (carton 5.0 kg)	126432R150

Stainless steel	
OK Tigrod 316LSi Ø1.6mm x 1000mm (carton 5.0 kg)	163216R150
OK Tigrod 316LSi Ø2.4mm x 1000mm (carton 5.0 kg)	163224R150
OK Tigrod 316LSi Ø3.2mm x 1000mm (carton 5.0 kg)	163232R150

Aluminium	
OK Tigrod 53.56 Ø1.6mm x 1000mm (carton 2.5 kg)	181516R120
OK Tigrod 53.56 Ø2.4mm x 1000mm (carton 2.5 kg)	181524R120
OK Tigrod 53.56 Ø3.2mm x 1000mm (carton 2.5 kg)	181532R120

Tungsten electrodes

Gold Plus, 1,5% Lanthan (AC/DC):	
WL15 1,0 x 175mm Gold Plus (Lanthanated) Gold	0151 574 050
WL15 1,6 x 175mm Gold Plus (Lanthanated) Gold	0151 574 051
WL15 2,4 x 175mm Gold Plus (Lanthanated) Gold	0151 574 052
WL15 3,2 x 175mm Gold Plus (Lanthanated) Gold	0151 574 053
WL15 4,0 x 175mm Gold Plus (Lanthanated) Gold	0151 574 054
WL15 4,8 x 175mm Gold Plus (Lanthanated) Gold	0151 574 055

Tungsten grinders

G-Tech Handy II	0700 009 886
G-Tech	0700 009 880

Trolleys Caddy®

2-wheel, large gas bottle 20-50 liters (forward facing panel)	0460 330 880
2-wheel, large gas bottle 20-50 liters (sideways facing panel)	0459 366 887
2-wheel, small gas bottle 5-10 liters	0459 366 885

Torches (OKC50)

	4m	8m
ET 17 (for Buddy™ Tig only)	0700 300 860	0700 300 864
TXH™ 121	0700 300 524	0700 300 529
TXH™ 121F Flexible head	0700 300 526	0700 300 531
TXH™ 151	0700 300 538	0700 300 544
TXH™ 151F Flexible head	0700 300 541	0700 300 547
TXH™ 201	0700 300 552	0700 300 555
TXH™ 201F Flexible head	0700 300 554	0700 300 557
TXH™ 251w Water-cooled	0700 300 561	0700 300 563
TXH™ 251wF Flexible head	0700 300 562	0700 300 564

A TIG torch is included with all TIG welding packages listed.

Remote control torches	4m	8m
TXH™ 121r	0700 300 620	0700 300 622
TXH™ 121Fr Flexible head	0700 300 621	0700 300 623
TXH™ 151r	0700 300 624	0700 300 626
TXH™ 151Fr Flexible head	0700 300 625	0700 300 627
TXH™ 201r	0700 300 628	0700 300 630
TXH™ 201Fr Flexible head	0700 300 629	0700 300 631
TXH™ 251wr Water-cooled	0700 300 632	0700 300 634
TXH™ 251wFr Flexible head	0700 300 633	0700 300 635
Remote Adapter kit RAT!, 12-pole, incl 0,25m cable		0459 491 812

Wear part kit for TXH™ 121/251w	0368 846 880
Wear part kit for TXH™ 151/201	0368 846 881

Introduction to MIG/MAG Welding Packages

To identify the most suitable welding package for your application consider the following:

- What material will be welded? This will determine the minimum functionality required.
- What consumable will be used? Flux-cored wire (FCW) or solid wire.
- Would a compact machine or a machine with a separate feeding unit be preferred? This is usually determined by the layout of the workplace.
- What is the thickness of the material being welded? This will determine the required output power of the machine.

On the following pages you'll find recommended packages for welding of mild steel, stainless steel and aluminium using either solid or flux-cored wire. For certain combinations, more than one package might be suitable. For further details, please refer to the package information sheet in this binder.

Benefits

Compact machines are smaller and therefore easier to transport. The investment cost is normally less then that of a power source with a separate feeder.

Machines with separate feeders feature interconnection cables between 1.7 and 35m for increased reach. Counterbalance arms improve ergonomics and minimise the weight of the torch package. The feeder can be suspended in cranes for improved reach. Wheels kits for the feeder are available for improved maneuverability on the floor.

Portable machines are lightweight and easy to carry to the work site. A smaller spool size reduces the size and weight of these machines (200mm, weight up to 5kg).

Material	Type	Wire Ø / Plate thickness		Model	Page
Mild Steel Solid Wire	Compact	0.8mm / <6mm	Portable	Caddy® Mig 160i	27
			Portable	Caddy® Mig 200i	27
				Origo™ Mig C151	31
				Origo™ Mig C170	31
				Origo™ Mig C250	31
		1.0mm / <10mm		Origo™ Mig C250	35
				Origo™ Mig C280 PRO	35
				Origo™ Mig C340 PRO	35
		1.2mm / >10mm		Origo™ Mig C340 PRO	35
				Origo™ Mig C420 PRO	35
	Separate Feeder	1.0mm / <10mm 1.2mm / >10mm		400A Advanced	39
				400A Synergic	43
Mild Steel Flux-cored Wire	Compact	1.0mm / <10mm 1.2 - 1.4mm / >10mm		Origo™ Mig C420 PRO	35
	Separate Feeder	1.0mm / <10mm 1.2 - 1.4mm / >10mm		400A Advanced	39
				400A Synergic	43
Stainless Steel Solid Wire	Compact	0.8mm / <6mm		Caddy® Mig C200i	27
	Separate Feeder	1.0mm / <10mm 1.2mm / >10mm		400A Pulse	47
Stainless Steel Flux-cored Wire	Compact	1.0mm / <10mm 1.2 - 1.4mm / >10mm		Origo™ Mig C420 PRO	35
	Separate Feeder	1.0mm / <10mm 1.2 - 1.4mm / >10mm		400A Advanced	39
				400A Synergic	43
Aluminium Solid Wire	Compact	1.0mm / <6mm		Caddy® Mig C200i	27
	Separate	1.0mm / <10mm		400A Pulse	47

Note: This selection guide should be viewed as a recommendation for the most common wire combinations. Smaller wire diameters can always be used and in most cases a larger diameter can be an option.

PORTABLE MIG/MAG WELDING PACKAGES

These portable MIG/MAG packages feature built-in wire feeders. An intuitive control panel reduces set up time. The machines are optimised for welding solid wire. Polarity can easily be reversed enabling the use of self-shielded wires. This eliminates the need for shielding gas, making the machine truly portable.

Caddy® Mig C160i

- Automatic settings - Simply set the plate thickness and the machine optimises the parameters
- Convenient single-knob heat adjustment
- Analogue panel
- Optimised for welding mild and stainless steel plates from 0.5 - 4.0mm

Caddy® Mig C200i

- QSet™ - Intelligent welding system
- Automatic settings - Simply set the plate thickness and the machine optimises the parameters
- Convenient single-knob heat adjustment
- MIG brazing capability
- Digital panel for exact settings of current and voltage
- Optimised for welding mild/stainless steel and aluminium plates from 0.5 - 6.0mm

PORTABLE MIG/MAG WELDING PACKAGES

GENERAL FEATURES

Portable design – ESAB Caddy Mig machines are lightweight and easy to carry to the work site. They use a smaller spool size of 200mm/max weight of 5 kg, which reduces the machine's size and weight. The machine's can operate with extra long mains cables of 50m. For additional freedom of movement, Caddy Mig machines can be used on generators with AVR with 5.5 kVA for full output or min 3.0 kVA for 100A output (required for OK 12.51 0.8mm).

Gasless MIG welding – The polarity of the Caddy Mig machines can easily be reversed, enabling the use of self-shielded wires such as Coreshield 15. This eliminates the need to transport a gas bottle to the work site making the machine truly portable. Optimised for plate thicknesses >1.5mm.

Durability – A durable design in combination with a corrosion-resistant flame-proof composite housing with IP23 classification makes the machines suitable for outdoor use. The recessed panel provides extra protection of the knobs.

Accessible and easy to service - The built-in wire feeder mechanism and Ø200 mm wire spool are easily accessed from the side panel. Feeder rolls can be changed without using any tools.

System management – The smart design of the housing offers a storage tray on the top surface. Integrated cables holders in the front and rear panels and a built-in shoulder strap make transport easy.

Delivered Ready-to-use, including wire - Caddy Mig machines come with 1kg OK Autrod 12.51 0.8mm solid wire included.The package contains a 3m MIG torch (MXL™ 180), a 3m return cable and clamp, 3m mains cable with plug, 4.5m gas hose with clamp and quick connector and a carrying strap.

Caddy Mig C160i

The Caddy Mig C160i is optimised for welding mild and stainless steels using up to 0.8mm solid wire.

An analogue panel allows the operator to easily set the thickness of the material to weld. The machine then automatically sets the optimum amperage and voltage. Heat input can be controlled by the turn of a knob. As a result, set up time is kept to a minimum and a quality weld is easy to achieve.

Caddy Mig C200i

The Caddy Mig C200i package is optimised for mild/stainless steel, aluminium and MIG brazing applications. Welding parameters can be set either manually or fully automatically using the QSet functionality. Either way, the intuitive control panel and large LCD display provide a clear overview of the settings even from a distance. This makes it easy to identify the optimal parameters and consequently reduces set up time.

Automatic mode / QSet is a built-in function which provides a unique way of setting welding parameters in short arc mode when welding mild steel. Simply set the material type to Fe/SS and plate thickness and QSet will sense the wire/gas combination and automatically select the correct welding parameters. QSet will also adjust for changes in wire stick out to maintain optimal arc characteristics. QSet give the following advantages:

- Consistent, high weld quality regardless of operator skill level
- Low spatter level, minimum after treatment
- Constant arc length – maintained weld quality also in hard to reach corners
- Quick set up – easy to get started
- Easy weld pool heat adjustment with a simple turn of the knob

In manual mode the wire feed speed and voltage may be adjusted manually with a simple turn of the knob. The corresponding amperage value is also displayed on the digital panel which enables exact readings.

To further **fine-tune arc characteristics** the C200i also offers a stepless inductance setting function. The inductance is pre-set to simplify for the welder. Typically, a higher inductance delivers a more crisp and focused arc suitable for position welding, while a lower inductance generates a smoother arc with less spatter.

Aluminium welding require adjustments of the machine and torch. The liner, feed rolls and contact tip should be replaced (see next page). The wire end has to be cut between welds for optimal start properties. For production welding in aluminium ESAB recommend the Aristo Mig 4004i Pulse package.

		Plate Thickness		Mild Steel Argon/Mix or CO_2	Stainless Argon 98% O_2 2%	Aluminium Argon 100%	MIG Brazing Argon 99% O_2 1%	Panel		QSet™
		0.5-4.0	0.5 - 6.0					Analogue	Digital	
Caddy® Mig C160i	0349 310 850	●		●	●			●		
Caddy® Mig C200i	0349 312 030		●	●	●	●	●		●	●

Accessories MIG/MAG

Consumables 200mm wire spools

Mild steel solid wire		
OK Autrod 12.51	Ø 0.6/5.0 kg	1251064600
OK Autrod 12.51	Ø 0.8/5.0 kg	1251084600
OK Autrod 12.51	Ø 1.0/5.0 kg	1251004600
Stainless solid wire		
OK Autrod 308LSi	Ø 0.8/5.0 kg	1612084600
OK Autrod 316LSi	Ø 0.8/5.0 kg	1632084600
Aluminium solid wire		
OK Autrod 5183	Ø 1.0/2.0 kg	181610462E
Self-shielded		
Coreshield 15	Ø 0.8/4.5 kg	35UE084630
Brazing		
OK Autrod 19.30	Ø 1.0/5.0 kg	1930104600

MIG/MAG Pliers

Fix 1 Small	0760 022 100
Fix 2 Large	0760 022 200

Wear parts wire feeder

Feed roller Ø0,6-1,0 mm with V-grove (standard)	0349 311 890
Feed roller Ø1,0 mm with U-grove (aluminium)	0349 312 836
Pressure roller	0349 312 062
Inlet nozzle	0455 049 002

For additional information and specifications, visit the ESAB website to download the latest product fact sheet.

Trolley

Trolley, 2-wheel for large gas bottles	0459 366 887

Wear parts torch

Gas nozzle (1)	0700 200 054
Contact tip (2) for 0.6mm wire	0700 200 063
Contact tip (2) for 0.8mm wire	0700 200 064
Contact tip (2) for 1.0mm wire	0700 200 066
Insulator for self-shielded wire 0.8mm (6)	0700 200 105
Nozzle spring (3)	0700 200 078
Tip adapter (5)	0700 200 072
Steel liners for mild steel, stainless steel, cored wire and MIG brazing	
Steel liner (4), 0.6-0.8mm	0700 200 085
Steel liner (4), 0.9-1.2mm	0700 200 087
PTFE liners for aluminium	
PTFE Liner(4), 0.9-1.2mm	0700 200 091

COMPACT MIG/MAG WELDING PACKAGES

ESAB's compact MIG/MAG packages feature built-in wire feeders ideal for workshops and repair and maintenance applications. All machines are delivered ready for use and include a professional welding torch, shelf for gas cylinder and wheel kit for easy maneuverability.

Origo™ Mig C151

- 230V 1ph for welding up to 0.8mm solid wire
- Easy to change polarity enables welding with gasless corded wire
- Low investment cost
- Analogue display

Origo™ Mig C170

- 400V 3ph for welding up to 0.8mm solid wire
- Optional polarity change kit enables welding with gasless cored wire and optional digital V/A meter kit
- Adjustable burnback time and creep start functionality
- Tack welding functionality

Origo™ Mig C250

- 400V 3ph for welding up to 1.2mm solid wire
- Easy to change polarity enables welding with gasless cored wire
- Adjustable burnback time and creep start functionality
- Tack welding functionality
- Optional digital V/A meter

COMPACT MIG/MAG WELDING PACKAGES

GENERAL FEATURES

The compact and competitively priced Origo Mig machines with built-in wire feeder are designed for the workshop environment. A two-wheel drive wire feed mechanism also make these machines ideal for repair and maintenance applications.

Ready-to-use – Origo Mig machines are delivered ready for use, equipped with a professional welding torch, wheel kit and gas bottle shelf for easy maneuverability.

Robust – The machines have a strong galvanized casing and large wheels to withstand harsh environments. A compact design makes them easy to transport between work sites.

Serviceable – Proven technology ensures high reliability and low maintenance costs.

Origo Mig C151

Origo Mig C151 is a 1-phase machine ideal for welding up to 0.8mm solid wire using small spools (max. 200mm/5kg) which make the unit lightweight.

The polarity can easily be reversed enabling welding with gasless corded wire, no need to bring a gas bottle. The machine comes equipped with a 2.5m (MXL 150v) welding torch with fixed connection. The machine is easy to operate and comes at a low investment cost.

Origo Mig C170

Origo Mig C170 is a 3-phase machine ideal for welding up to 0.8mm solid wire.The use of large spools (max. 300mm/18kg) increases productivity with fewer workflow interruptions for spool changes. The 8-step voltage setting makes it easy for the welder to find the optimal welding parameneters. The machine's creep start function provides a soft wire speed start which reduces spatter.

The optional digital V/A meter provides a clear, accurate reading of the weld parameters, even in poor light conditions. The adjustable burnback time maintains a consistent wire stick out which in turn ensure optimal starting properties. Tack welding time can be set between 0.2 seconds and 2.5 seconds.

Optional polarity change kit enables welding with gasless cored wire, no need to bring a gas bottle.

Origo Mig C250

Origo Mig C250 is a 3-phase machine ideal for welding up to 1.2mm solid wire. The use of large spools (max. 300mm/18kg) increases productivity with fewer work-flow interruptions for spool changes. The 10-step voltage setting and two inductance outlets makes it easy for the welder to find the optimal welding parameters. The machine's creep start function provides a soft wire speed start which reduces spatter.

The optional digital V/A meter provides a clear, accurate reading of the weld parameters, even in poor light conditions. The adjustable burnback time gives a consistent wire stick out, which in turn ensure optimal starting properties. Tack welding time can be set between 0.2 seconds and 2.5 seconds.

The polarity can easily be reversed enabling welding with gasless corded wire, no need to bring a gas bottle.

	230V 1ph	400V 3ph	Maximum Solid Wire Ø (mm)	Gasless Cored Wire Ø (mm)	Polarity inversion kit Included	Spool Size	# of Voltage Steps	# of inductance Outlets	Optional Digital Display	Adjustable Burnback Time	Tack Welding	Torch	Torch Connection
Origo Mig C151	0349 311 180	-	0.8	0.8	●	200mm/5kg	7	1				MXL 150v, 2.5m	Fixed
Origo Mig C170	-	0349 308 670	0.8	0.8	optional	300mm/18kg	8	1	●	●	●	MXL 200, 3m	Euro
Origo Mig C250	-	0349 307 840	1.2	0.8	●	300mm/18kg	10	2	●	●	●	MXL 270, 3m	Euro

Origo Mig machines are delivered with feed mechanism and torch components (drive rolls, liners, contact tips etc.) suitable for the following wire dimensions:

	Wire dimension Ø (mm)
Origo Mig C151	0.8
Origo Mig C170	0.8
Origo Mig C250	1.0

For alternative wire dimensions, components in the feed mechanism and torch will have to be replaced. See separate fact sheets for machine and torch.

MIG/MAG PACKAGES

Accessories MIG/MAG

Consumables 200mm wire spools

Mild steel solid wire		
OK Autrod 12.51	Ø 0.6/5.0 kg	1251064600
OK Autrod 12.51	Ø 0.8/5.0 kg	1251084600
Stainless solid wire		
OK Autrod 308LSi	Ø 0.8/5.0 kg	1612084600
OK Autrod 316LSi	Ø 0.8/5.0 kg	1632084600
Self-shielded		
Coreshield 15	Ø 0.8/4.5 kg	35UE084630

Consumables 300mm wire spools

Mild steel solid wire		
OK Autrod 12.51	Ø 0.8/15 kg	1251086700
OK Autrod 12.51	Ø 1.0/18 kg	1251106710
OK Autrod 12.51	Ø 1.2/18 kg	1251126710
Stainless solid wire		
OK Autrod 308LSi	Ø 0.8/15 kg	1612089820
OK Autrod 308LSi	Ø 1.0/15 kg	1612109820
OK Autrod 308LSi	Ø 1.2/15 kg	1612129820
OK Autrod 316LSi	Ø 0.8/15 kg	1632089820
OK Autrod 316LSi	Ø 1.0/15 kg	1632109820
OK Autrod 316LSi	Ø 1.2/15 kg	1632129820

Digital display

V/A meter kit for C170 / C250	0349 302 598

Polarity inversion kit

For C170	0349 309 310

For additional information and specifications, visit the ESAB website to download the latest product fact sheet.

Wear parts torch

Contact tips (Pos. 2) MXL 150v / 200

Argon/Mix	M6 x 25 (Cu)	
	10 pcs / pk	
0.6	0700 200 063	
0.8	**0700 200 064**	
0.9	0700 200 065	
1.0	0700 200 066	

Contact tips (Pos. 2) MXL 270

Argon/Mix	M6 x 28 (CuCrZr)	
	10 pcs / pk	100 pcs / pk
0.8	0700 200 068	0349 501 008
0.9	0700 200 069	-
1.0	**0700 200 070**	0349 501 009
1.2	0700 200 071	0349 501 010

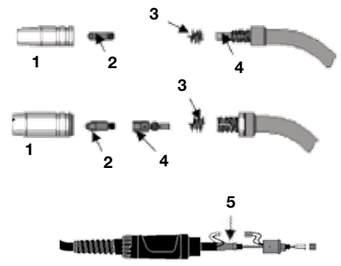
Gas nozzle (Pos. 1)	MXL 150v	MXL 200	MXL 270
Standard Ø12mm	**0700 200 054**	**0700 200 054**	-
Standard Ø15mm	-	-	**0700 200 055**
Straight Ø16mm	0700 200 057	0700 200 057	-
Straight Ø18mm	-	-	0700 200 058
Conical Ø9,5mm	0700 200 060	0700 200 060	-
Conical Ø11,5mm	-	-	0700 200 061

Spring (Pos. 3)	MXL 150v	MXL 200	MXH 270
	0700 200 078	**0700 200 078**	**0700 200 079**

Tip adapter (Pos. 4)	MXL 150v	MXL 200	MXH 270
M6	**0700 200 076**	**0700 200 072**	**0700 200 073**

Liners (Pos. 5)	MXL 150v	MXL 200	MXH 270
Steel Length			
w0.6-0.8mm 2.5m	**0700 200 099**	-	-
w0.6-0.8mm 3.0m	-	**0700 200 085**	**z0700 200 085**
w0.9-1.2mm 3.0m	-	**0700 200 087**	**0700 200 087**

Bold = included in standard delivery



MXL 150/200

MXL 270

COMPACT PRO MIG/MAG WELDING PACKAGES

ESAB's compact MIG/MAG packages feature built-in wire feeders and digital panel for exact reading of current and voltage. Designed for production welding in harsh environments. The wheel drive mechanism ensures consistent and trouble-free welding. All Origo Mig are delivered ready for use and include a professional and ergonomic 4.5m welding torch, shelf for gas cylinder and wheel kit for easy maneuverability.

Origo™ Mig C280 PRO

- Production welding up to 1.0mm solid wire
- High weld current output 280 A
- 10 step voltage setting
- Tack welding functionality

Origo™ Mig C340 PRO

- Production welding up to 1.2mm solid wire
- High weld current output 340 A
- 40 step voltage setting and creep start functionality
- 2/4 stroke trigger mode

Origo™ Mig C420 PRO

- Production welding up to 1.6mm solid wire and 1.4mm cored wire
- High weld current output 420 A
- 35 step voltage setting and creep start functionality
- 2/4 stroke trigger mode
- Water-cooled option

COMPACT PRO MIG/MAG WELDING PACKAGES

GENERAL FEATURES

The compact Origo Mig PRO machines are designed for medium to heavy-duty welding in a workshop environment. The built-in wire feed mechanism with a 4-wheel drive ensure consistent and trouble free welding. The machines are capable of carrying up to 18 kg wire spool.

Built-in digital V/A meter provides a clear, accurate reading of the exact weld parameter settings, even in poor lighting conditions.

Step-regulated inductance setting – In addition to setting the wire feed speed and voltage, the arc characteristics of these machines can be fine-tuned using the inductance setting. Typically a higher inductance provides a crisp and focused arc suitable for position welding while a lower inductance provides a smooth arc with less spatter.

Adjustable burnback time – Consistent wire stick out after weld ensures optimal starting properties.

Robust – The machines have a strong galvanized casing and large wheels to withstand harsh environments. The compact design makes it easy to transport between work sites.

Origo Mig C280 PRO

Designed for production welding with up to 1.0 mm solid wire at the lowest investment cost. The machine features a tack welding setting between 0.2-2.5 seconds and is ideal for car repair applications.

Origo Mig C340 PRO

For production welding with up to 1.2mm solid wire, a 40-step voltage setting and two inductance outlets makes it easy to achieve the optimal welding parameters. The machine features creep start functionality where the wire speed starts slowly, creating a soft start which reduces spatter.

The machine features a 2-stroke/4-stroke trigger mode. For longer welds the 4-stroke mode (“push & release” to start – weld – “push & release” to stop) is commonly used. The 2-stroke mode (“push” to start – weld – “release” to stop) is applied to shorter welds such as tack welding.

Origo Mig C420 PRO

The Origo Mig C420 PRO is designed for production welding with up to 1.6 solid and 1.4mm cored wire. The 35-step voltage setting and three inductance outlets make it easy for the welder to achieve optimal welding parameters.

Choose between a self-cooled or water-cooled system. The water-cooled system allows the use of a smaller sized water-cooled torch, improving the ergonomic for the welder.

The machine features a 2-stroke/4-stroke trigger mode. For longer welds the 4-stroke mode (“push & release” to start – weld – “push & release” to stop) is commonly used. The 2-stroke mode (“push” to start – weld – “release” to stop) is applied to shorter welds such as tack welding.

	400V 3ph	Multi voltage*	Maximum Wire Ø (mm)	Solid Wire Welding	Cored Wire Welding	# of Voltage Steps	# of Inductance Outlets	2/4 Stroke	Digital Display	Adjustable Burnback Time	Tack Welding	Creep Start	Water-cooled	Torch 4.5m
Origo Mig C280 PRO	0349 312 520	0349 312 530	1.0	●		10	2		●	●	●			PSF 250
Origo Mig C340 PRO	0349 310 830	0349 312 570	1.2	●		40	2	●	●	●		●		PSF 305
Origo Mig C420 PRO	0349 312 590	-	1.6	●	●	35	3	●	●	●		●		PSF 405
Origo Mig C420w PRO	0349 312 580	-	1.6	●	●	35	3	●	●	●		●	●	PSF 410w

* 230 / 400-415 / 500 V, 50 HZ; 230 / 440 - 460 V, 60HZ

These machines are delivered with feed mechanism and torch components (drive rolls, liners, contact tips etc.) suitable for the following wire dimensions:

	Wire dimension Ø (mm)
Origo Mig C280 PRO	1.0
Origo Mig C340 PRO	1.2
Origo Mig C420 PRO	1.2

For alternative wire dimensions, components in the feed mechanism and torch will have to be replaced.

Accessories MIG/MAG

Consumables 300mm wire spools

Mild steel solid wire		
OK Autrod 12.51	Ø 0.8/15 kg	1251086700
OK Autrod 12.51	Ø 1.0/18 kg	1251106710
OK Autrod 12.51	Ø 1.2/18 kg	1251126710
Stainless solid wire		
OK Autrod 308LSi	Ø 0.8/15 kg	1612089820
OK Autrod 308LSi	Ø 1.0/15 kg	1612109820
OK Autrod 308LSi	Ø 1.2/15 kg	1612129820
OK Autrod 316LSi	Ø 0.8/15 kg	1632089820
OK Autrod 316LSi	Ø 1.0/15 kg	1632109820
OK Autrod 316LSi	Ø 1.2/15 kg	1632129820
Mild steel rutile cored wire		
OK Tubrod 15.14	Ø 1.2/16 kg	1514127730
OK Tubrod 15.14	Ø 1.4/16 kg	1514147730
Mild steel metal cored wire		
OK Tubrod 14.11	Ø 1.2/16 kg	1411127730
OK Tubrod 14.11	Ø 1.4/16 kg	1411147730
Stainless rutile cored wire		
SHIELD-BRIGHT 308L	Ø 1.2/16 kg	35BA129840
SHIELD-BRIGHT 316L	Ø 1.2/16 kg	35FA129840

Torch and return cable holder

For C280 / C340 / C420	0349 303 362

Water flow guard

For C420w	0349 302 251

Wear parts wire feeder mechanism

Feed roller	C280	C340	C420w
0.6/0.8mm V-grove	0459 052 001	0459 052 001	0459 052 001
0.8/0.9-1.0mm V-grove	**0459 052 002**	0459 052 002	0459 052 002
0.9-1.0/1.2mm V-grove	0459 052 003	**0459 052 003**	**0459 052 003**
1.4/1.6mm V-grove	-	-	0459 052 013

For additional information and specifications, visit the ESAB website to download the latest product fact sheet.

Wear parts torch

Contact tips PSF 250 / 305

Argon/Mix	CO^2	M6 x 27 (CuCrZr)	
		10 pcs / pk	100 pcs / pk
-	0.6	0468 500 001	-
0.6	-	0468 500 002	-
-	0.8	0468 500 003	0468 500 303
0.8	0.9	0468 500 004	0468 500 304
0.9	1.0	0468 500 005	0468 500 305
1.0	1.2	0468 500 007	0468 500 307

Contact tips PSF 405/410w

Argon/Mix	CO^2	M8 x 37 (CuCrZr)	
		10 pcs / pk	100 pcs / pk
-	0.8	0468 502 003	0468 502 303
0.8	0.9	0468 502 004	0468 502 304
0.9	1.0	0468 502 005	0468 502 305
1.0	1.2	0468 502 007	0468 502 307
1.2	1.4	0468 502 008	0468 502 308
-	1.6	0468 502 009	-
1.6	-	0468 502 010	

Swan neck	PSF 250	PSF 305	PSF 405	PSF 410w
Standard 45°	**0366 315 880**	**0366 388 880**	**0366 389 880**	**0458 403 881**
0°	0469 329 880	0469 333 880	0469 334 880	0458 403 886
60°	0467 985 880	0467 988 881	0467 988 880	0458 403 884

Gas nozzle	PSF 250	PSF 305	PSF 405	PSF 410w
Standard	**0458 464 881**	**0458 464 882**	**0458 464 883**	**0458 464 882**
Straight	0458 470 881	0458 470 882	0458 470 883	0458 470 882
Conical	0458 465 881	0458 465 882	0458 465 883	0458 465 882

	PSF 250	PSF 305	PSF 405	PSF 410w
Spatter protection	0458 471 002	0458 471 003	0458 471 004	0458 471 003
Tack welding adapter	0366 314 001	-	-	-

Tip adapter	PSF 250	PSF 305	PSF 405	PSF 410w
M6	**0700 200 076**	**0366 394 001**	-	-
M8	-	-	**0460 819 001**	**0460 819 001**

Steel liners		PSF 250	PSF 305	PSF 405	PSF 410w
w0.6-0.8mm	3.0m	0366 549 882	0366 549 882	0366 549 882	0366 549 882
w0.6-0.8mm	4.5m	0366 549 883	0366 549 883	0366 549 883	0366 549 883
w0.9-1.0mm	3.0m	0366 549 884	0366 549 884	0366 549 884	0366 549 884
w0.9-1.0mm	4.5m	**0366 549 885**	0366 549 885	0366 549 885	0366 549 885
w1.2mm	3.0m	0366 549 886	0366 549 886	0366 549 886	0366 549 886
w1.2mm	4.5m	0366 549 887	**0366 549 887**	**0366 549 887**	**0366 549 887**
w1.4mm	3.0m	-	0366 549 888	0366 549 888	0366 549 888
w1.4mm	4.5m	-	0366 549 889	0366 549 889	0366 549 889
w1.6mm	3.0m	-	0366 549 890	0366 549 890	0366 549 890
w1.6mm	4.5m	-	0366 549 891	0366 549 891	0366 549 891

Bold = included in standard delivery.

400A ADVANCED
MIG/MAG PACKAGE

ESAB's industrial 400A CC/CV MIG/MAG package features the latest inverter technology and handles both mild steel and stainless steel using solid wire or flux-cored wire.

- Multi-process package - MIG/MAG, MMA, Carbon Arc Gouging and LiveTIG
- Digital display (V/A) in the feeder provides accurate readings close to the weld
- Digital display (V/A) in the power source for MMA and Gouging and LiveTig welding
- TrueArcVoltage™ system - Measures the correct arc voltage at the contact tip

400A ADVANCED MIG/MAG PACKAGE

MULTI-PROCESS CC/CV
- A SINGLE, VERSATILE SYSTEM

The power source and wire feeder in this 400A package combine to form a multi-process system. This system handles the MIG/MAG, MMA, Live TIG and Carbon Arc Gauging processes, providing versatility and performance in a single, highly efficient package that helps future-proof production requirements.

The 400A CC/CV package incorporates the latest inverter technology, providing increased energy efficiency and energy savings.

A wide range of auxiliary products offers the flexibility to customize the package to suit specific application requirements.

- Counterbalance arm provides improved ergonomics for the welder
- Wheel kits are offered for both the feeder and power source
- Remote control kit available for high requirement MMA applications

Durable and reliable

A high duty cycle of 400A at 60% provides the power and capability to handle heavy-duty welding.

The dust filter handles tough/dirty working environments and prevents grinding dust and metal particles from entering the chassis.

The power source is designed for nominal input voltage from 380 to 415V AC for a **wide mains input tolerance.**

Improving the weld quality

TrueArcVoltage system – Weld parameters are measured and adjusted automatically at the contact tip. The power source automatically compensates for power loss due to the length of the interconnection cables, length and wear of the welding torch. System requires an ESAB PSF torch.

Continuous inductance setting – In addition to setting the wire feed speed and voltage, the arc characteristics of the 400A CC/CV can be fine-tuned using the inductance setting. Typically a higher inductance provides a crisp and focused arc suitable for position welding while a lower inductance provides a smooth arc with less spatter.

Creep start – The wire speed starts slowly and the shielding gas start to flow, creating a soft start which reduces any spatter. The set wire speed is achieved when the wire comes in contact with the work piece.

User friendly

Short Circuit Termination (SCT) eliminates the need to manually set the burn back time when welding solid wire. SCT produces a minimised ball at the wire end which ensures excellent start properties for the next weld.

Built-in digital V/A meter provides a clear, accurate reading of the exact weld parameter settings, even in poor lighting conditions.

Wire inching & gas purge controls are conveniently located on the wire feeder, making wire set up and change quick and easy.

2-stroke/4-stroke – For longer welds the 4-stroke mode (“push & release” to start – weld – “push & release” to stop) is commonly used. The 2-stroke mode (“push” to start – weld – “release” to stop) is applied to shorter welds such as tack welding.

Flexibility

MMA option – Switch between MIG/MAG and MMA (stick) welding as required, eliminating the need for two separate power sources.

400A CC/CV MIG/MAG Package
0479 000 104

The package includes:

Warrior® 400 CC/CV	0465 350 884
Cool 2	0465 427 880
Warrior® Feed 304w	0465 250 881
Interconnection cable set 2.0m	0459 836 890
Torch PSF™ 410w 4.5m	0458 400 883
Trolley	0465 510 880

Accessories MIG/MAG

Remote Controls

Power source Warrior 400i/500i	
Adapter kit	0465 424 880
Remote control MMA1 incl. 10m cable	0349 501 024
Remote control AT1	0459 491 896
Remote control AT1 CoarseFine	0459 491 897
Connection cables 5.0m	0459 552 880
Connection cables 10m	0459 552 881
Connection cables 15m	0459 552 882
Connection cables 25m	0459 552 883
Warrior Feed	
Adapter kit	0465 451 880
Remote control M1	0459 491 895
Connection cables 5.0m	0459 553 880
Connection cables 10m	0459 553 881

Counterbalance arm

The spring supporter counterbalance arm for the wire feed unit can rotate 360 degrees. The use of a counterbalance will reduce welder fatigue, reduce machine wear and tear and make the torch easily accessible.

Counterbalance arm	0458 705 880
Stabilizer kit Warrior *	0465 509 880

*required to fit to the trolley

Trolleys

Trolley 4-wheel large gas bottle	0465 510 880
Wheel kit power source	0465 416 880
Wheel kit Warrior Feed *	0458 707 880
Guide pin extension kit for Wheel kit *	0465 508 880

* Guide pin extension kit is required to fit Warrior Feed with wheel kit on the 4-wheel trolley

Torches

Self-cooled	
PSF™ 405, 3.0m	0458 401 882
PSF™ 405, 4.5m	0458 401 883
PSF™ 505, 3.0m	0458 401 884
PSF™ 505, 4.5m	0458 401 885
Water-cooled	
PSF™ 410w, 3.0m	0458 400 882
PSF™ 410w, 4.5m	0458 400 883
PSF™ 510w, 3.0m	0458 400 884
PSF™ 510w, 4.5m	0458 400 885

A MIG/MAG torch is included with all MIG/MAG welding packages listed.

Connection cables

70mm²	Air-cooled	Water-cooled
Connection cable 2.0m	0459 836 880	0459 528 890
Connection cable 5.0m	0459 836 881	0459 528 891
Connection cable 10m	0459 836 882	0459 528 892
Connection cable 15m	0459 836 883	0459 528 893
Connection cable 25m	0459 836 884	0459 528 894
Connection cable 35m	0459 836 884	0459 528 895

For additional information and specifications, visit the ESAB website to download the latest product fact sheet.

400A SYNERGIC
MIG/MAG PACKAGE

ESAB's 400A industrial Synergic MIG/MAG welding package features the latest inverter technology to efficiently weld both mild steel and stainless steel using solid wire or cored wire.

- MIG/MAG and MMA process package.
- 35 pre-programmed synergic lines
- QSet™ Intelligent welding system
- 3 individual memory settings
- Crater filling, adjustable burn back time
- Pre/post gas flow
- ESAB LogicPump prevents overheating of the torch
- Digital display (V/A) in the feeder provides accurate readings close to the weld
- Digital display (V/A) in the power source for MMA and Gouging and LiveTig welding (Mig 4004i A44 panel only)
- TrueArcVoltage™ system measures the correct arc voltage at the contact tip

400A SYNERGIC MIG/MAG PACKAGE

POWERFUL AND ENERGY EFFICIENT

The 400A Synergic package features 35 sets of pre-programmed synergic lines which reduce set up time and improve weld quality. Inverter technology makes the system energy efficient, reducing operating cost.

A wide range of auxiliary products offers the flexibility to customize the package to suit specific application requirements.

Durable and reliable

A high duty cycle of 400A at 80% makes the machine powerful and able to handle heavy-duty welding.

The dust filter handles tough/dirty working environments and prevents grinding dust and metal particles from entering the chassis.

ESAB LogicPump ELP water pump starts automatically when the arc is struck. If the connections for the cooling hoses are not properly fitted, the machine will not start. The pump stops automatically 6.5 minutes after the weld, reducing wear, and minimising energy consumption and noise level.

Improving the weld quality

TrueArcVoltage system – Weld parameters are measured and adjusted automatically at the contact tip. The power source automatically compensates for any power loss due to the length of the interconnection cables, length and wear of the welding torch. An ESAB PSF torch is required.

QSet – a built-in function, provides a unique method for setting welding parameters in short arc mode. Simply set the material type and thickness and QSet identifies the proper wire/gas combination and automatically selects the correct welding parameters. QSet also adjusts for changes in wire stick out to maintain optimal arc characteristics.

- Easy weld pool heat adjustment with a simple turn of the knob
- Consistent weld quality regardless of operator skill level
- Low spatter post processing
- Constant arc length ensures high weld quality in hard-to-reach corners
- Quick set up makes it easy to get started

Start properties

- **Creep start** – The wire speed starts slowly and the shielding gas starts to flow creating a soft start which reduces any spatter. The set wire speed is achieved when the wire comes in contact with the workpiece.
- **Gas pre-flow** – The gas starts to flow before the arc is struck, keeping the weld pool well protected thus reducing the risk of weld defects.
- **Hot start** – A short boost of power heats the wire, ensuring a perfect result from the first drop transfer.

Weld termination properties

- **Gas post flow** – Ensures cooling of the wire tip, longer nozzle life and avoids oxidization of the weld (important for titanium and stainless).
- **Crater filling** – Creates a smooth termination of the weld by gradually and automatically reducing the weld current according to your parameter settings. This reduces the risk of cracks at the end of the weld.

User friendly

35 sets of pre-programmed synergic lines reduce set up time and improve weld quality. A wide choice of materials, wire dimensions and gas combinations provide optimal settings for a broad range of applications. Parameters can be fine-tuned manually by the welder and stored for easy access (See Memory settings).

Memory settings – Store up to 3 different individual settings to handle three different jobs without the need to reset all parameters. Memory settings save time when switching between jobs such as horizontal and vertical welding. The set programs can also be activated from the torch by simply pressing/releasing the trigger quickly to advance to the next program.

Built-in digital V/A meter provides a clear, accurate reading of the exact weld parameter settings, even in poor lighting conditions.

2-stroke/4-stroke – For longer welds, the 4-stroke mode (“push & release” to start – weld – “push & release” to stop) is commonly used. The 2-stroke mode (“push” to start – weld – “release” to stop) is applied to shorter welds such as tack welding.

400A Synergic MIG/MAG Package 0479 000 007

The package includes:

Mig 4004i	0465 154 880
Cool 1	0462 300 880
Interconnection cable set 1.7m	0459 528 790
Origo® Feed 3004w, MA24	0460 526 999
Torch PSF™ 410w 4.5m	0458 400 883
Trolley	0462 151 880

For complete details about synergic lines, please refer to the 4004i demo handbook XA00159020.

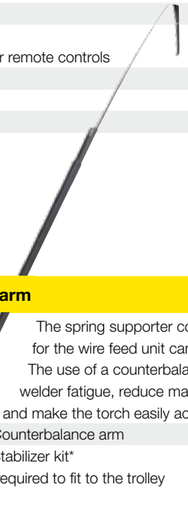
Accessories MIG/MAG

Remote Controls

AT1 CAN	0459 491 863
AT1 CoarseFine CAN	0459 491 884
MTA1 CAN	0459 491 880
M1 10Prog CAN	0459 491 882

Connection cables for remote controls

5.0m cable CAN	0459 554 880
10m cable CAN	0459 554 881
25m cable CAN	0459 554 882



Counterbalance arm

The spring supporter counterbalance arm for the wire feed unit can rotate 360 degrees. The use of a counterbalance will reduce welder fatigue, reduce machine wear and tear and make the torch easily accessible.

Counterbalance arm	0458 705 880
Stabilizer kit*	0460 946 880

*required to fit to the trolley

Connection cables

70mm²	Air-cooled	Water-cooled
Connection cable 2.0m	0459 528 780	0459 528 790
Connection cable 5.0m	0459 528 781	0459 528 791
Connection cable 10m	0459 528 782	0459 528 792
Connection cable 15m	0459 528 783	0459 528 793
Connection cable 25m	0459 528 784	0459 528 794
Connection cable 35m	0459 528 785	0459 528 795

Flow guard for Cool 1

Flow guard	0456 855 881

For additional information and specifications, visit the ESAB website to download the latest product fact sheet.

Trolleys

Standard

Trolley 4-wheel large gas bottles	0462 151 880

For counterbalance arm

Trolley 4-wheel large gas bottles	0465 565 880
Mounting kit	0461 310 880

Torches

Self-cooled

PSF™ 405, 3.0m	0458 401 882
PSF™ 405, 4.5m	0458 401 883
PSF™ 505, 3.0m	0458 401 884
PSF™ 505, 4.5m	0458 401 885

Water-cooled

PSF™ 410w, 3m	0458 400 882
PSF™ 410w, 4.5m	0458 400 883
PSF™ 510w, 3m	0458 400 884
PSF™ 510w, 4.5m	0458 400 885

Push-pull

MXH™ 300 PP, 6m Straight swan neck	0700 200 017
MXH™ 300 PP, 10m Straight swan neck	0700 200 018
MXH™ 300 PP, 10m Swan neck 45º	0700 200 020
MXH™ 400w PP, 6m Straight swan neck	0700 200 015
MXH™ 400w PP, 10m Straight swan neck	0700 200 016
MXH™ 400w PP, 10m Swan neck 45º	0700 200 019
MXH™ PP connection kit	0459 020 883
Remote adapter kit MXH™ PP and PSF™ RS3	0459 681 881

A MIG/MAG torch is included with all MIG/MAG welding packages listed.

400A PULSE
MIG/MAG PACKAGE

ESAB's 400A industrial Pulsed MIG/MAG welding package features the latest inverter technology to efficiently weld mild steel and stainless steel using solid or flux-cored wire and aluminium using solid wire.

- MIG/MAG and MMA process package.
- Pulse functionality for reduced heat input and minimised spatter
- 79 pre-programmed synergic lines
- QSet™ intelligent welding system
- 10 individual memory settings
- Crater filling, adjustable burn back time
- Pre/post gas flow
- ESAB LogicPump prevents overheating of the torch
- Digital display (V/A) in the feeder provides accurate readings close to the weld
- TrueArcVoltage™ system measures the correct arc voltage at the contact tip

400A PULSE MIG/MAG PACKAGE

ADVANCED WELDING IN STAINLESS AND ALUMINIUM

The 400A Pulse package is suitable for the most advanced welding applications, including welding of stainless steel and aluminium. Pulse functionality ensures good control of the heat input, which is essential for advanced welding when weld quality is critical.

A wide range of auxiliary products offers the flexibility to customize the package to suit specific application requirements.

Durable and reliable

A high duty cycle of 400A at 60% with a wide mains input tolerance from 380 to 440 V makes the machine powerful and able to handle heavy-duty welding.

The dust filter handles tough/dirty working environments and prevents grinding dust and metal particles from entering the chassis.

ESAB LogicPump ELP water pump starts automatically when the arc is struck. If the connections for the cooling hoses are not properly fitted, the machine will not start. The pump stops automatically 6.5 minutes after the weld, reducing wear, and minimising energy consumption and noise level.

Improving the weld quality

TrueArcVoltage system – Weld parameters are measured and adjusted automatically at the contact tip. The power source automatically compensates for any power loss due to the length of the interconnection cables, length and wear of the welding torch. An ESAB PSF torch is required.

Pulse functionality reduces the heat input and minimises spatter. It also improves the esthetics of the joint giving it a “TIG look”.

400A Pulse MIG/MAG Package 0479 000 002

The package includes:

Aristo® Mig 4004i Pulse	0465 152 881
Aristo® Feed 3004w, U6	0460 526 896
Cool 1	0462 300 880
Interconnection cable set 2.0m	0459 528 790
Torch PSF™ 410w 4.5m	0458 400 883
Trolley	0462 151 880

QSet – a built-in function, provides a unique method for setting welding parameters in short arc mode. Simply set the material type and thickness and QSet identifies the proper wire/gas combination and automatically selects the correct welding parameters. QSet also adjusts for changes in wire stick out to maintain optimal arc characteristics.

- Easy weld pool heat adjustment with a simple turn of the knob
- Consistent weld quality regardless of operator skill level
- Low spatter post processing
- Constant arc length ensures high weld quality in hard-to-reach corners
- Quick set up makes it easy to get started

Start properties

- **Creep start** – The wire speed starts slowly and the shielding gas starts to flow creating a soft start which reduces any spatter. The set wire speed is achieved when the wire comes in contact with the workpiece.
- **Gas pre-flow** – The gas starts to flow before the arc is struck, keeping the weld pool well protected thus reducing the risk of weld defects.
- **Hot start** – A short boost of power heats the wire, ensuring a perfect result from the first drop transfer.

Weld termination properties

- **Gas post flow** – Ensures cooling of the wire tip, longer nozzle life and avoids oxidization of the weld (important for titanium and stainless).
- **Crater filling** – Creates a smooth termination of the weld by gradually and automatically reducing the weld current according to your parameter settings. This reduces the risk of cracks at the end of the weld.

User friendly

79 sets of pre-programmed synergic lines reduce set up time and improve weld quality. A wide choice of materials, wire dimensions and gas combinations addresses a broad range of market requirements. 45 of the synergic lines are customised for pulsed welding. Parameters can be fine-tuned manually by the welder and stored for easy access (See memory settings).

Memory settings – Store up to 10 different individual settings to handle ten different jobs without the need to reset all parameters. Memory settings save time when switching between jobs such as horizontal and vertical welding. The first three sets of programs can also be activated from the torch by simply pressing/releasing the trigger quickly to advance to the next program.

Built-in digital V/A meter provides a clear, accurate reading of the exact weld parameter settings, even in poor lighting conditions.

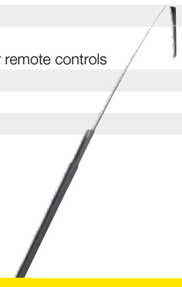
2-stroke/4-stroke – For longer welds the 4-stroke mode (“push & release” to start – weld – “push & release” to stop) is commonly used. The 2-stroke mode (“push” to start – weld – “release” to stop) is applied to shorter welds such as tack welding.

For complete details about synergic lines, please refer to the 4004i demo handbook XA00159020.

Accessories MIG/MAG

Remote Controls

AT1 CAN	0459 491 863
AT1 CoarseFine CAN	0459 491 884
MTA1 CAN	0459 491 880
M1 10Prog CAN	0459 491 882
Connection cables for remote controls	
5.0m cable CAN	0459 554 880
10m cable CAN	0459 554 881
25m cable CAN	0459 554 882



Counterbalance arm

The spring supporter counterbalance arm for the wire feed unit can rotate 360 degrees. The use of a counterbalance will reduce welder fatigue, reduce machine wear and tear and make the torch easily accessible.

Counterbalance arm	0458 705 880
Stabilizer kit*	0460 946 880

*required to fit to the trolley

Connection cables

70mm²	Air-cooled	Water-cooled
Connection cable 2.0m	0459 528 780	0459 528 790
Connection cable 5.0m	0459 528 781	0459 528 791
Connection cable 10m	0459 528 782	0459 528 792
Connection cable 15m	0459 528 783	0459 528 793
Connection cable 25m	0459 528 784	0459 528 794
Connection cable 35m	0459 528 785	0459 528 795

Flow guard for Cool 1

Flow guard	0456 855 881

For additional information and specifications, visit the ESAB website to download the latest product fact sheet.

Trolleys

Standard	
Trolley 4-wheel large gas bottles	0462 151 880
For counterbalance arm	
Trolley 4-wheel large gas bottles	0465 565 880
Mounting kit	0461 310 880

Torches

Self-cooled	
PSF™ 405, 3.0m	0458 401 882
PSF™ 405, 4.5m	0458 401 883
PSF™ 505, 3.0m	0458 401 884
PSF™ 505, 4.5m	0458 401 885
Water-cooled	
PSF™ 410w, 3.0m	0458 400 882
PSF™ 410w, 4.5m	0458 400 883
PSF™ 510w, 3.0m	0458 400 884
PSF™ 510w, 4.5m	0458 400 885

Push-pull	
MXH™ 300 PP, 6m Straight swan neck	0700 200 017
MXH™ 300 PP, 10m Straight swan neck	0700 200 018
MXH™ 300 PP, 10m Swan neck 45°	0700 200 020
MXH™ 400w PP, 6m Straight swan neck	0700 200 015
MXH™ 400w PP, 10m Straight swan neck	0700 200 016
MXH™ 400w PP, 10m Swan neck 45°	0700 200 019
MXH™ PP connection kit	0459 020 883
Remote adapter kit MXH™ PP and PSF™ RS3	0459 681 881

A MIG/MAG torch is included with all MIG/MAG welding packages listed.

World leader in welding and cutting technology and systems

ESAB operates at the forefront of welding and cutting technology. More than one hundred years of continuous improvement in products and processes enables us to meet the challenges of technological advance in every sector in which ESAB operates.

Quality and environment standards

Quality, the environment and safety are three key areas of focus. ESAB is one of few international companies to have obtained the ISO 14001, ISO 9001 and OHSAS 18001 standards in Environmental, Health & Safety Management Systems across all our global manufacturing facilities. At ESAB, quality is an ongoing process that is at the heart of all our production processes and facilities worldwide. Multinational manufacturing, local representation and an international network of independent distributors brings the benefits of ESAB quality and unrivalled expertise in materials and processes within reach of all our customers, wherever they are located.

ESAB Sales and Support offices worldwide

** Includes manufacturing facilities of ESAB North America.*

ESAB®

www.esab.com

COMPANY WITH MANAGEMENT SYSTEM CERTIFIED BY DNV
= ISO 9001 =
= ISO 14001 =
= OHSAS 18001 =