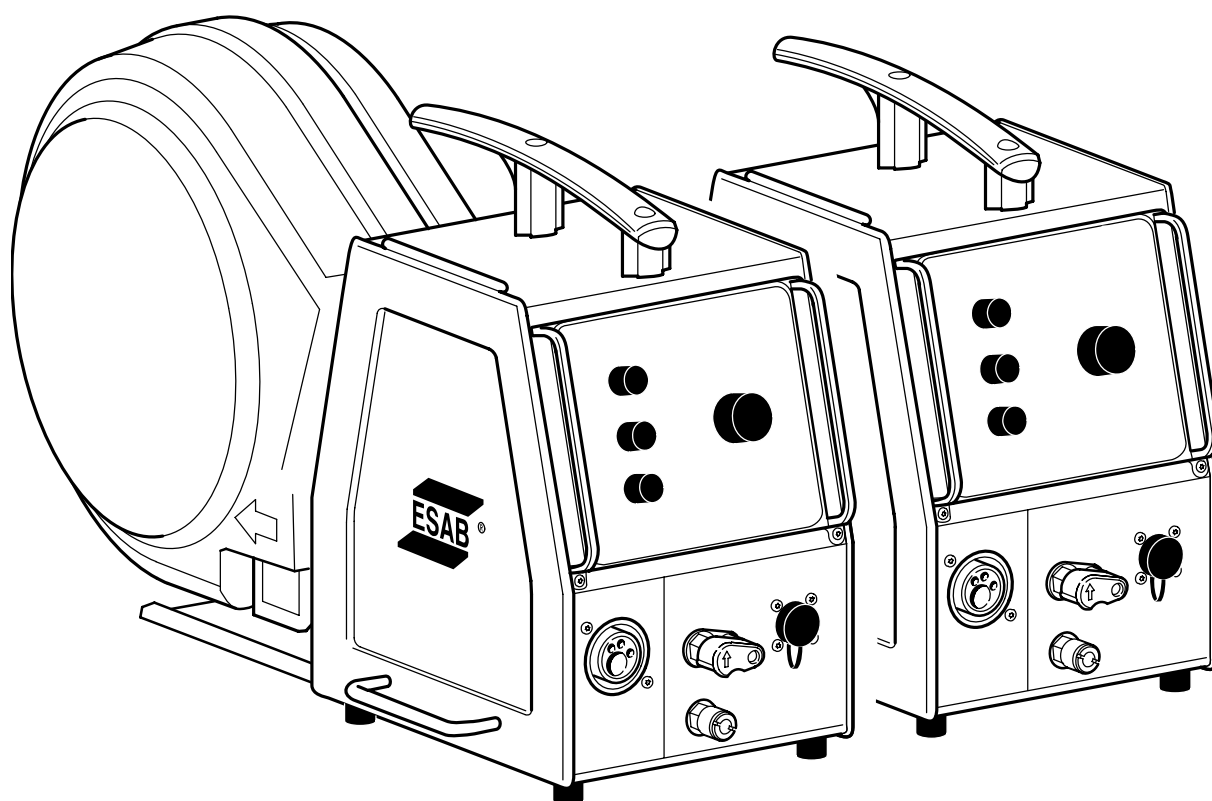


**Origo™ M12**

**Feed 304**

**Feed 484**



**Instruction manual**



## DECLARATION OF CONFORMITY

according to the Low Voltage Directive 2006/95/EC, according to the EMC Directive 2004/108/EC

## FÖRSÄKRAN OM ÖVERENSSTÄMMELSE

enligt Lågspänningsdirektivet 2006/95/EG, enligt EMC-Direktivet 2004/108/EG

**Type of equipment** Materialslag

Wire feeder

**Brand name or trade mark** Fabrikatnamn eller varumärke

ESAB

**Type designation etc.** Typbeteckning etc.

Feed 304, Feed 304w with MMC panels M12 & M13, from serial number 620 xxx xxxx (2006 week 20)

Feed 484, Feed 484w with MMC panels M12 & M13, from serial number 620 xxx xxxx (2006 week 20)

Feed 304 and Feed 484 with and without water are members of the ESAB product family Origo

**Manufacturer or his authorised representative established within the EEA**

**Name, address, telephone No, telefax No:** Tillverkarens namn, adress, telefon, telefax:

ESAB AB, Welding Equipment

Esabvägen, SE-695 81 LAXÅ, Sweden

Phone: +46 584 81 000, Fax: +46 584 411 924

**The following harmonised standard in force within the EEA has been used in the design:**

Följande harmoniserande standarder har använts i konstruktionen:

EN 60974-5, Arc welding equipment – Part 5: Wire feeders

EN 60974-10, Arc welding equipment – Part 10: Electromagnetic compatibility (EMC) requirements

Additional information: Restrictive use, Class A equipment, intended for use in locations other than residential

**By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.**

Genom att underteckna detta dokument försäkras undertecknad såsom tillverkare, eller tillverkarens representant inom EES, att angiven materiel uppfyller säkerhetskraven angivna ovan.

Date / Datum  
Laxå 2007-03-14

Signature / Underskrift

Kent Eimbrodt

Clarification

Position / Befattning  
Global Director  
Equipment and Automation

<b>1 SAFETY</b> .....	<b>4</b>
<b>2 INTRODUCTION</b> .....	<b>5</b>
2.1 Equipment .....	6
<b>3 TECHNICAL DATA</b> .....	<b>6</b>
<b>4 INSTALLATION</b> .....	<b>7</b>
4.1 Lifting instructions .....	7
<b>5 OPERATION</b> .....	<b>8</b>
5.1 Connections and control devices .....	9
5.2 Water connection .....	9
5.3 Starting procedure .....	9
5.4 Function explanations .....	10
5.5 Wire feed pressure .....	11
5.6 Changing / loading wire Feed 304 .....	11
5.7 Changing / loading wire Feed 484 .....	11
5.8 Changing feed rollers on Feed 304 .....	12
5.9 Changing feed rollers on Feed 484 .....	12
<b>6 MAINTENANCE</b> .....	<b>13</b>
6.1 Inspection and cleaning .....	13
<b>7 ORDERING SPARE PARTS</b> .....	<b>13</b>
<b>DIAGRAM</b> .....	<b>14</b>
<b>ORDERING NUMBER</b> .....	<b>18</b>
<b>WEAR PARTS</b> .....	<b>20</b>
<b>ACCESSORIES</b> .....	<b>24</b>


# 1 SAFETY

Users of ESAB welding equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of welding equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the welding equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.


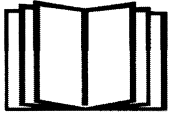
1. Anyone who uses the welding equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding
2. The operator must ensure that:
  - no unauthorized person is stationed within the working area of the equipment when it is started up.
  - no-one is unprotected when the arc is struck
3. The workplace must:
  - be suitable for the purpose
  - be free from drafts
4. Personal safety equipment
  - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves. **Note!** *Do not use safety gloves when replacing wire.*
  - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. General precautions
  - Make sure the return cable is connected securely.
  - Work on high voltage equipment **may only be carried out by a qualified electrician.**
  - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
  - Lubrication and maintenance must **not** be carried out on the equipment during operation.


**ESAB can provide you with all necessary welding protection and accessories.**



**CAUTION!**

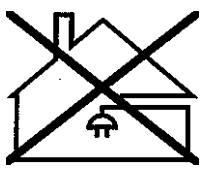
*Read and understand the instruction manual before installing or operating.*







**CAUTION!**

*Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility of class A equipment in those locations, due to conducted as well as radiated disturbances.*





**CAUTION!**

*This product is solely intended for arc welding.*



# WARNING



**Arc welding and cutting can be injurious to yourself and others. Take precautions when welding. Ask for your employer's safety practices which should be based on manufacturers' hazard data.**

**ELECTRIC SHOCK - Can kill**

- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

**FUMES AND GASES - Can be dangerous to health**

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.

**ARC RAYS - Can injure eyes and burn skin.**

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

**FIRE HAZARD**

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

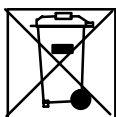
**NOISE - Excessive noise can damage hearing**

- Protect your ears. Use earmuffs or other hearing protection.
- Warn bystanders of the risk.

**MALFUNCTION - Call for expert assistance in the event of malfunction.**

**Read and understand the instruction manual before installing or operating.**

**PROTECT YOURSELF AND OTHERS!**



**Do not dispose of electrical equipment together with normal waste!**

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative.

By applying this European Directive you will improve the environment and human health!

## 2 INTRODUCTION

The **Feed 304** and **Feed 484** wire feed units with control panel **M12** are intended for MIG/MAG-welding together with stepped welding power sources.

They come in different variants, see the spare parts list on page 18.

The wire feed units are sealed and contain four-wheel drive wire feed mechanisms as well as control electronics.

They can be used together with wire on ESAB's MarathonPac™, or on wire bobbin (standard Ø 300 mm, accessory Ø 440 mm).

The wire feed unit can be installed either at the power source, suspended above the workplace, on a support arm or on the floor with or without wheel set.

**ESAB's accessories for the product can be found on page 24.**



## 2.1 Equipment

**The Feed 304 wire feed unit is supplied with:**

- Instruction manual
- Stickers with recommended wear parts.

**The Feed 484 wire feed unit is supplied with:**

- Spacer (4)
- Hex key wrench (4 mm)
- Instruction manual
- Stickers with recommended wear parts.

## 3 TECHNICAL DATA

	Feed 304	Feed 484
<b>Power supply</b>	42 V 50 - 60 Hz	42 V 50 - 60 Hz
<b>Power requirement</b>	336 VA	378 VA
<b>Motor current I<sub>max</sub></b>	8 A	9 A
<b>Settings data</b>		
Wire feed speed	1.9-25.0 m/min	1.9-25.0 m/min
Burnback time	0-0.5 s	0-0.5 s
Creep start	OFF or ON	OFF or ON
2/4 stroke	2 stroke or 4 stroke	2 stroke or 4 stroke
<b>Welding gun connection</b>	EURO	EURO
<b>Max. diameter wire bobbin</b>	300 mm (*440mm)	300 mm (*440mm)
<b>Wire dimension</b>	0.6-1.6 mm	0.6-2.4 mm
<b>Weight</b>		
basic version	11.5 kg	14.5 kg
with sealed bobbin holder	15 kg	19 kg
<b>Dimensions (l x w x h)</b>		
basic version	380 x 275 x 400 mm	380 x 275 x 400 mm
with sealed bobbin holder	690 x 275 x 420 mm	690 x 275 x 420 mm
<b>Shielding gas</b>	All types intended for MIG/MAG welding	All types intended for MIG/MAG welding
max pressure	5 bar	5 bar
<b>Coolant</b>	50% water / 50% glycol	50% water / 50% glycol
max pressure	5 bar	5 bar
<b>Permissible load at</b>		
60% duty cycle	630 A	630 A
<b>Enclosure class</b>	IP23	IP23
with wire bobin *440mm	IP2X	IP2X

\* Accessory, see page 24.

### Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld at a certain load without overloading. The duty cycle is valid for 40° C.

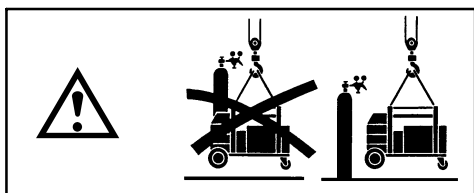
### Enclosure class

The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP23** is designed for indoor and outdoor use.

Equipment marked **IP2X** is designed for indoor use.

## 4 INSTALLATION

*The installation must be executed by a professional.*




### CAUTION!

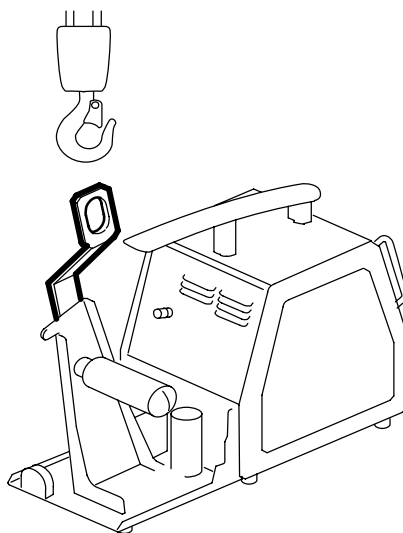
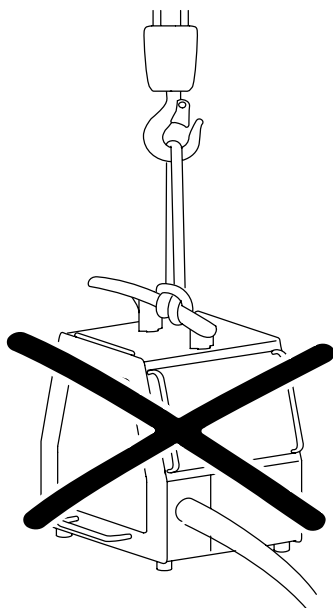
*This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.*



### WARNING!

*When welding in an environment with increased electrical danger, only power sources intended for this environment may be used. These power sources are marked with the symbol *

### 4.1 Lifting instructions



Ordering number for the lifting eye can be found on page 24.

**Note!** If another mounting device is used, this should be insulated from the wire feed unit.

## 5 OPERATION

*General safety regulations for the handling of the equipment can be found on page 4. Read through before you start using the equipment!*



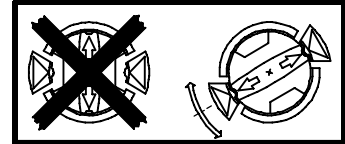
**WARNING!**

*Assure that the side panels are closed during operation.*



**WARNING!**

*To prevent the reel from sliding off the hub: Lock the reel in place by turning the red knob as shown on the warning label attached next to the hub.*



**WARNING!**

*Rotating parts can cause injury, take great care.*



**WARNING!**

*Risk of crushing! Do not use safety gloves when replacing wire, feed rollers and wire bobbins.*



**WARNING!**

*There is a risk of tipping if the wire feed unit is fitted with a counterbalance arm. Secure the equipment, especially if used on an uneven or sloping surface.*

**NOTE!** *When moving the equipment use intended handle. Never pull on the gun.*

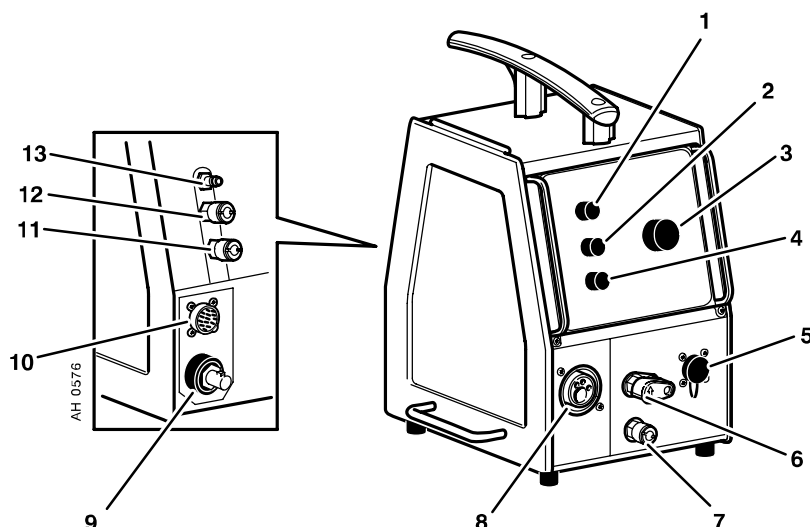


## 5.1 Connections and control devices

- |   |   |
|---|---|
| 1 Knob for setting burnback time                              | 8 Connection for welding gun  |
| 2 Switch for creep start OFF / ON                             | 9 Connection for welding current from power source, (OKC)             |
| 3 Knob for setting wire feed speed                            | 10 Connection for control cable from power source                     |
| 4 Switch for 2-stroke / 4-stroke                              | 11 Connection RED for cooling water to power source (cooling unit)    |
| 5 Connection for remote control unit                          | 12 Connection BLUE for cooling water from power source (cooling unit) |
| 6 Connection BLUE, with ELP* for cooling water to welding gun | 13 Connection for shielding gas                                       |
| 7 Connection RED for cooling water from welding gun           |   |

NOTE! Cooling water connections only available on certain models.

\* ELP = ESAB Logic Pump, see point 5.2.



## 5.2 Water connection

When connecting a water-cooled welding gun, the power source's main power supply switch must be in the Off position and the cooling unit switch must be in position "ELP/0".

The wire feed unit with water connection is equipped with a detection system **ELP** (**ESAB Logic Pump**) which checks that the water hoses are connected. When connecting a water-cooled welding gun, the water pump starts.

Detection only works with power sources that are equipped with ELP.

## 5.3 Starting procedure

When the wire feed starts, the power source generates welding voltage.

If there is no welding current flow within three seconds, the power source switches the welding voltage off. The wire feed continues until the welding gun's switch is switched off.

## 5.4 Function explanations



### Burnback time

Burnback time is a delay between the time when the wire starts to brake until the time when the power source switches off the welding voltage. Too short burnback time results in a long wire stickout after completion of welding, with a risk of the wire being caught in the solidifying weld pool. Too long a burnback time results in a shorter stickout, with increased risk of the arc striking back to the contact tip.



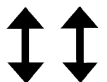
### Creep start

Creep start means that the wire is fed at low speed until it comes into electrical contact with the workpiece and then the speed increases to the set speed.



### 2 stroke

With **2 stroke**, the gas flow and wire feed start when the trigger switch is pressed in and end when it is released.



### 4 stroke

With **4 stroke**, the gas flow starts when the trigger switch is pressed in and the wire feed starts when it is released. The welding process continues until the switch is pressed in again, the wire feed stops and when the switch is released the gas stops flowing.

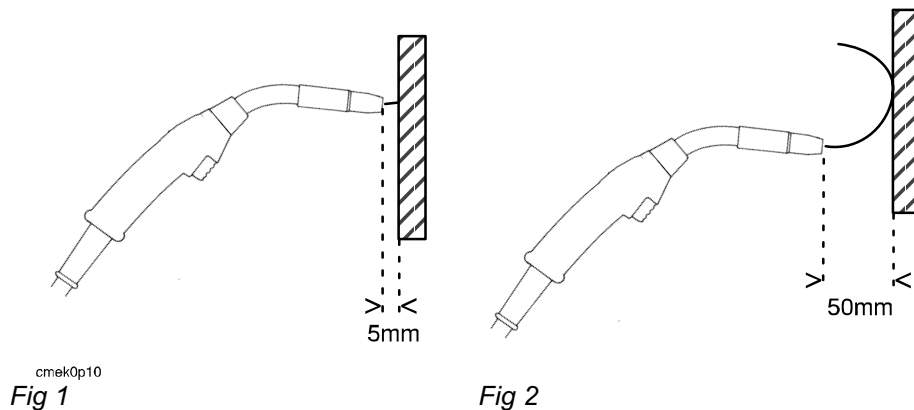


### Wire feed speed

This sets the required feed speed of the filler wire in m/minute.

## 5.5 Wire feed pressure

Start by making sure that the wire moves smoothly through the wire guide. Then set the pressure of the wire feeder's pressure rollers. It is important that the pressure is not too great.



To check that the feed pressure is set correctly, you can feed out the wire against an insulated object, e.g. a piece of wood.

When you hold the gun approx. 5 mm from the piece of wood (fig. 1) the feed rollers should slip.

If you hold the gun approx. 50 mm from the piece of wood, the wire should be fed out and bend (fig. 2).

## 5.6 Changing / loading wire Feed 304

- Open the side panel.
- Disconnect the pressure sensor by folding it backwards, the pressure rollers slide up.
- Straighten out the new wire 10-20 cm. File away burrs and sharp edges from the end of the wire before inserting it into the wire feed unit.
- Make sure that the wire goes properly into the feed roller's track and into the outflow nozzle or wire guide.
- Secure the pressure sensor.
- Close the side panel.

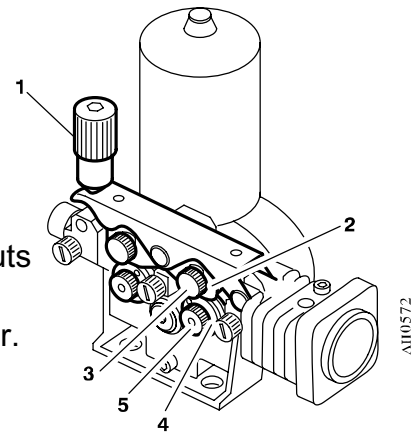
## 5.7 Changing / loading wire Feed 484

- Open the side panel.
- Press down and pull the pressure device towards you and up.
- Pull out the bogie.
- Straighten out the new wire 10-20 cm. File away burrs and sharp edges from the end of the wire before inserting it into the wire feed unit.
- Make sure that the wire goes properly into the feed roller's track and into the outflow nozzle or wire guide.
- Reinstall the bogie.
- Close the side panel.

## 5.8 Changing feed rollers on Feed 304

- Open the side panel.
- Disconnect the pressure sensor (1) by folding it backwards, the pressure rollers slide up.
- Disconnect the pressure rollers (2) by turning the axle (3) 1/4 turn clockwise and pulling out the axle. The pressure rollers disconnect.
- Disconnect the feed rollers (4) by unscrewing the nuts (5) and pulling out the rollers.

During installation, repeat the above in the reverse order.



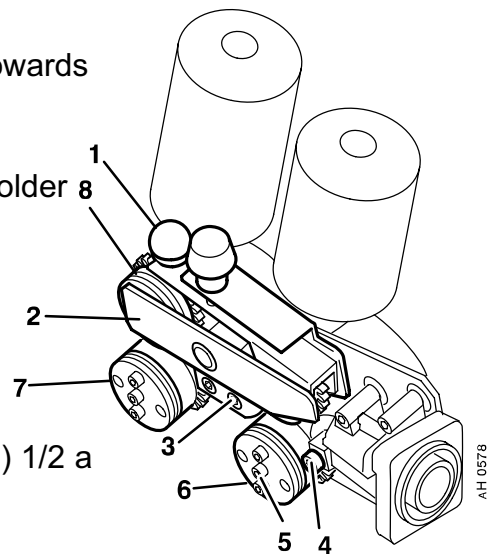
### Choice of tracks in the feed rollers

Turn the feed roller with the dimensioning mark for the required track towards you.

## 5.9 Changing feed rollers on Feed 484

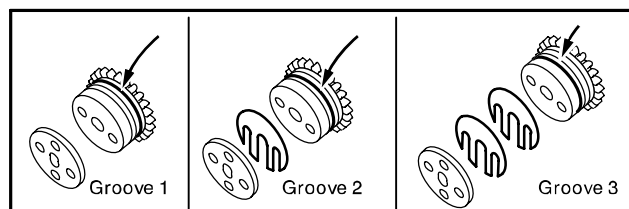
- Open the side panel.
- Press down and pull the pressure device (1) towards you and up.
- Pull out the bogie (2).
- Undo the socket head cap screws (3) on the holder 8 for the intermediate nozzle and remove the holder.
- Undo the screw for the outlet nozzle (4) and push back the nozzle.
- Completely undo the socket head cap screw (5) in the centre.
- Undo the two outer socket head cap screws (6) 1/2 a turn.
- Pull out the feed rollers (7).

During installation, repeat the above in the reverse order.



### Choice of tracks in the feed rollers

Place no, one or two driving washers between the outer washer and the feed roller. *Note!* When replacing the pressure rollers (8), the entire bogie is replaced.



## 6 MAINTENANCE

Regular maintenance is important for safe, reliable operation.



### CAUTION!

All guarantee undertakings from the supplier cease to apply if the customer himself attempts any work in the product during the guarantee period in order to rectify any faults.

### 6.1 Inspection and cleaning

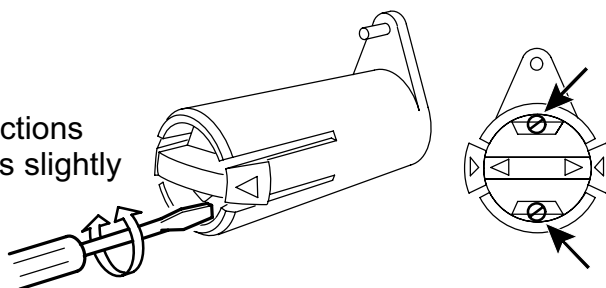
#### Wire feed unit

Check regularly that the wire feed unit is not clogged with dirt.

- Cleaning and replacement of the wire feed unit mechanism's worn parts should take place at regular intervals in order to achieve trouble-free wire feed. Note that if pre-tensioning is set too hard, this can result in abnormal wear on the pressure roller, feed roller and wire guide.

#### The brake hub

The hub is adjusted when delivered, if readjustment is required, follow the instructions below. Adjust the brake hub so that wire is slightly slack when wire feed stops.



- **Adjusting the braking torque:**
  - Turn the red handle to the locked position.
  - Insert a screwdriver into the springs in the hub.

Turn the springs clockwise to reduce the braking torque

Turn the springs counterclockwise to increase the braking torque. **NB:** Turn both springs through the same amount.

#### Welding gun

- Cleaning and replacement of the welding gun's wear parts should take place at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean regularly and clean the contact tip.

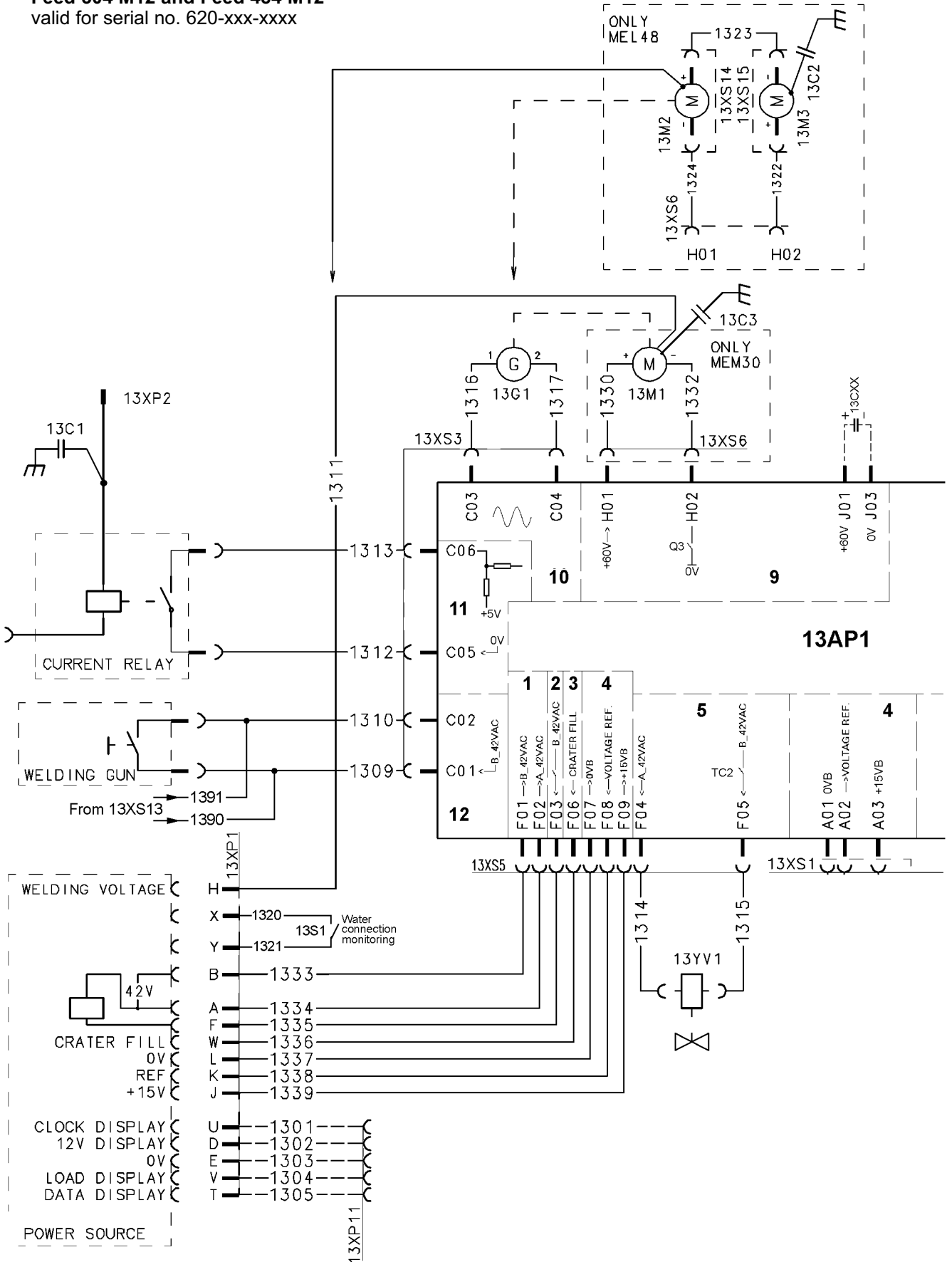
## 7 ORDERING SPARE PARTS

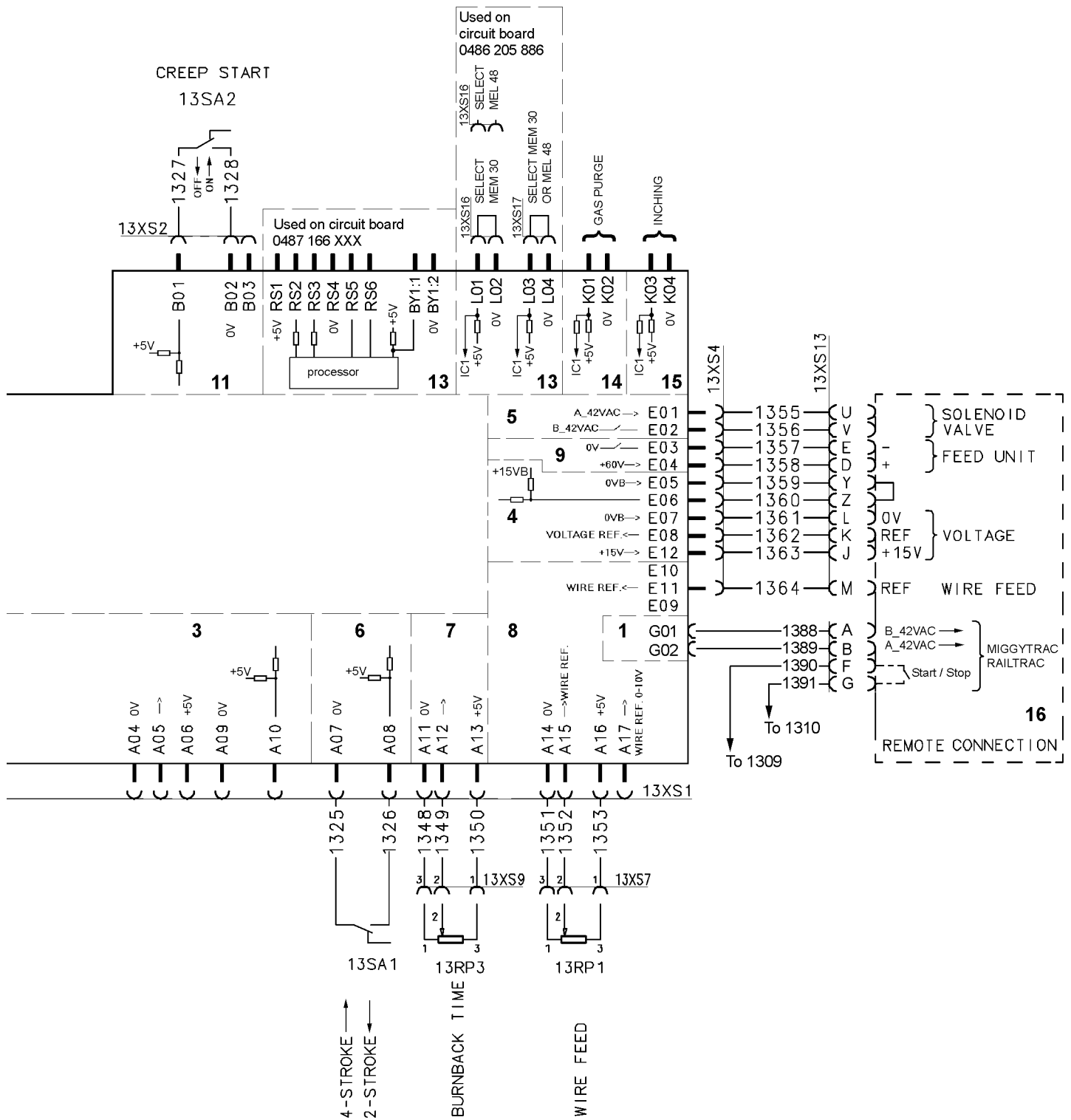
Feed 304 / Feed 484 is designed and tested in accordance with the international and European standards 60974-5 and 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts may be ordered through your nearest ESAB dealer, see the last page of this publication.

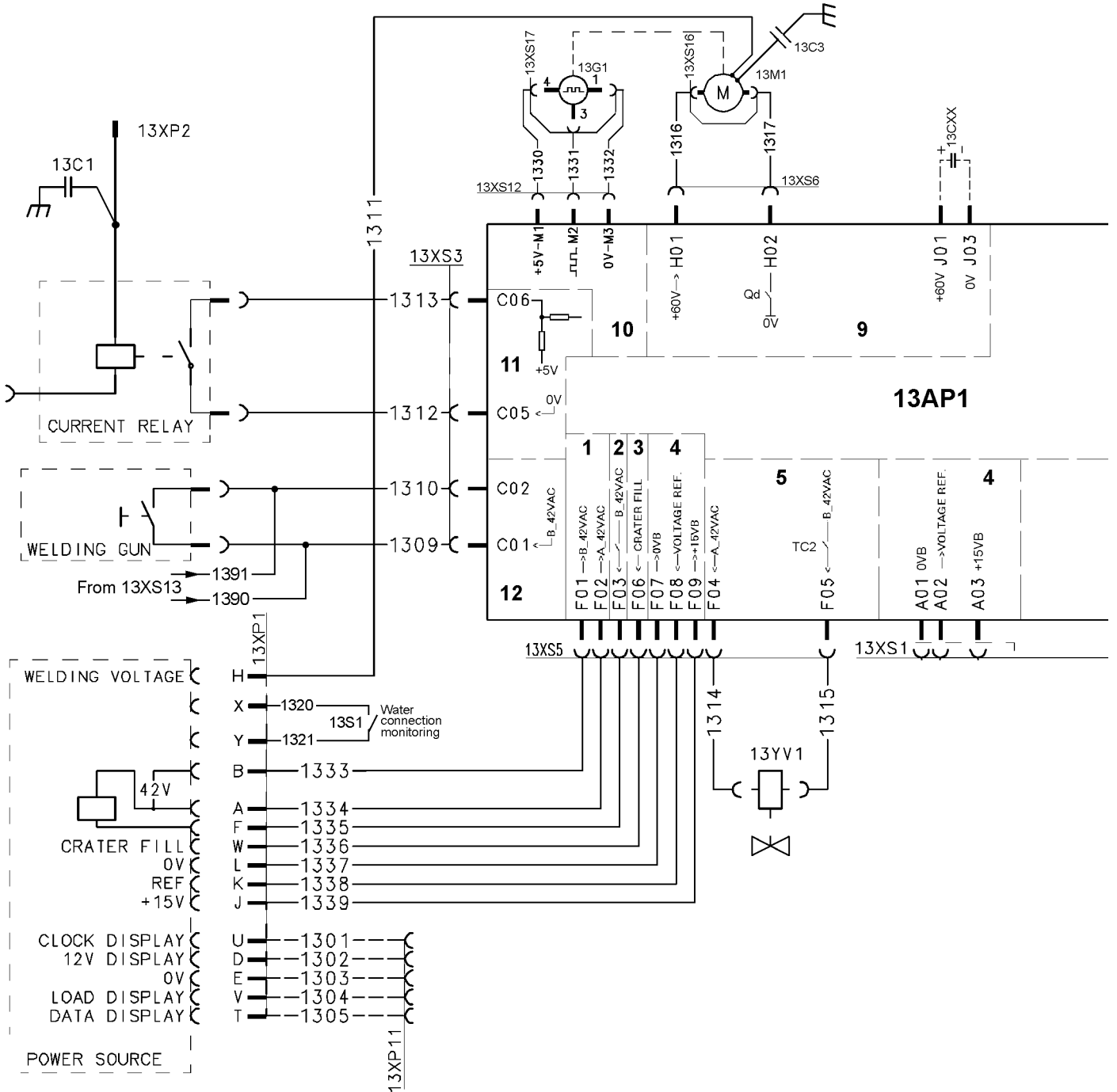
# Diagram

**Feed 304 M12 and Feed 484 M12**  
 valid for serial no. 620-xxx-xxxx





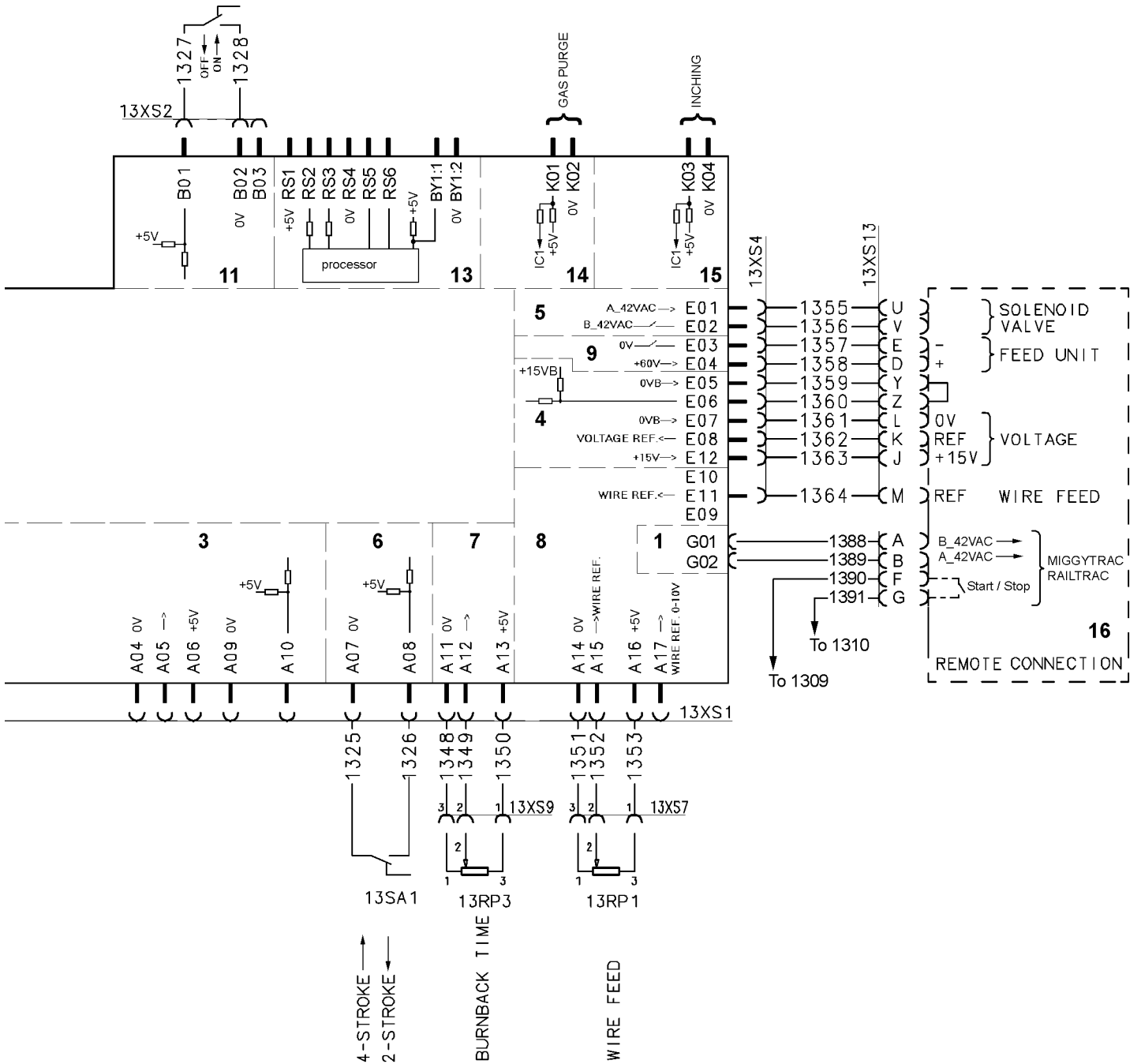
**Feed 304 M12**  
 valid from serial no. 917-xxx-xxxx





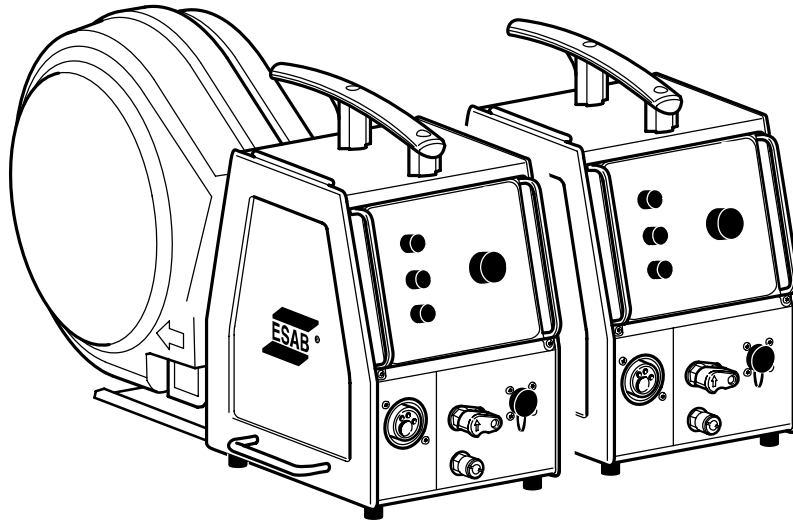
CREEP START

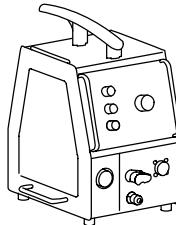
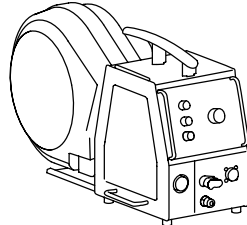
13SA2



## Feed 304, Feed 484

### Ordering number



	Feeder for Marathon Pac™	Feeder with capsuled bobbin
		
Origo™ Feed 304, M12	0459 114 882	0459 116 882
Origo™ Feed 304, M12 with water cooling	0459 114 892	0459 116 892
Origo™ Feed 484, M12	0459 114 982	0459 116 982
Origo™ Feed 484, M12 with water cooling	0459 114 992	0459 116 992

Type	Filename
Spare parts list	0459 161 990

The spare parts list is available on the Internet at [www.esab.com](http://www.esab.com)



**Wear parts**

Item	Ordering no.	Denomination	Notes	Wire type	Wire dimensions
HI1	0455 072 002 0456 615 001	Intermediate nozzle Intermediate nozzle		Fe, Ss & cored Al	Ø 2.0 mm steel for 0.6-1.6 mm Ø 2.0 mm plastic for 0.8-1.6 mm
HI2	0469 837 880 0469 837 881	Outlet nozzle Outlet nozzle		Fe, Ss & cored Al	
HI3	0191 496 114	Key			
HI4	0215 701 007	Locking washer			
HI5a	0459 440 001	Motor gear euro	Drive gear		

Item	Ordering no.	Denomination	Wire type	Wire dimensions	Groove typ	Roller markings
HI5b	0459 052 001	Feed/pressure rollers	Fe, Ss & cored	Ø 0.6 & 0.8 mm	V	0.6 <b>S2</b> & 0.8 <b>S2</b>
	0459 052 002	Feed/pressure rollers	Fe, Ss & cored	Ø 0.8 & 1,0 mm	V	0.8 <b>S2</b> & 1.2 <b>S2</b>
	0459 052 003	Feed/pressure rollers	Fe, Ss & cored	Ø 0.9/1.0 & 1.2 mm	V	1.0 <b>S2</b> & 1.2 <b>S2</b>
	0459 052 013	Feed/pressure rollers	Fe, Ss & cored	Ø 1.4 & 1.6 mm	V	1.4 <b>S2</b> & 1.6 <b>S2</b>
	0458 825 001	Feed/pressure rollers	Cored	Ø 0.9/1.0 & 1.2 mm	V-Knurled	1.0 <b>R2</b> & 1.2 <b>R2</b>
	0458 825 002	Feed/pressure rollers	Cored	Ø 1.2 & 1.4 mm	V-Knurled	1.2 <b>R2</b> & 1.4 <b>R2</b>
	0458 825 003	Feed/pressure rollers	Cored	Ø 1.6 mm	V-Knurled	1.6 <b>R2</b> & 2.0 <b>R2</b>
	0458 824 001	Feed/pressure rollers	Al	Ø 0.8 & 0.9/1.0 mm	U	0.8 <b>A2</b> & 1.0 <b>A2</b>
	0458 824 002	Feed/pressure rollers	Al	Ø 1.0 & 1.2 mm	U	1.0 <b>A2</b> & 1.2 <b>A2</b>
	0458 824 003	Feed/pressure rollers	Al	Ø 1.2 & 1.6 mm	U	1.2 <b>A2</b> & 1.6 <b>A2</b>

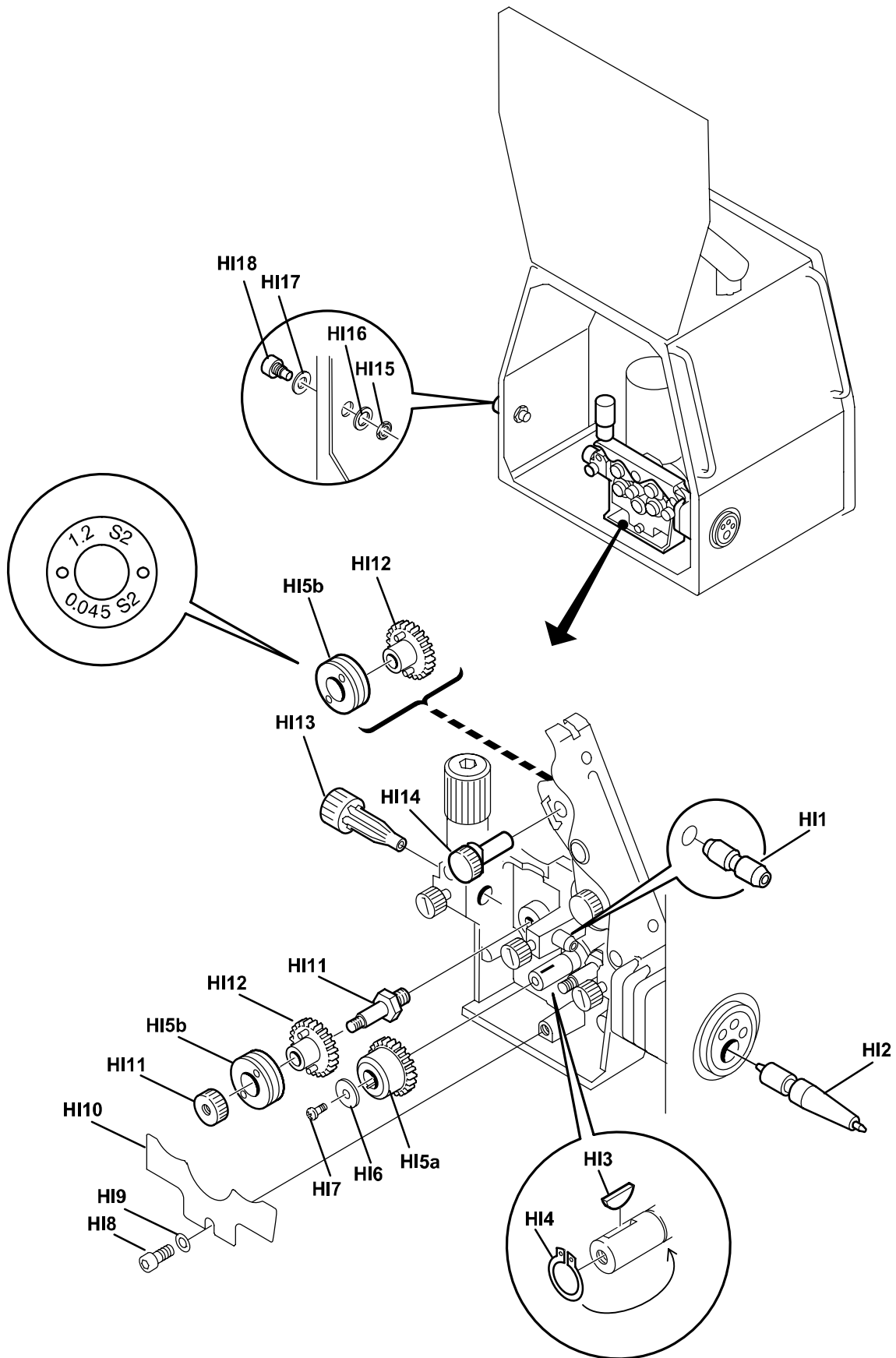
Use only pressure and feed rollers marked **A2**, **R2** or **S2**.  
The rollers are marked with wire dimension in mm, some are also marked with inch.

Item	Ordering no.	Denomination	Notes
HI6		Washer	Ø 16/5x1 M4x12 M6x12 Ø 16/8.4x1.5 Ø 3mm for 0.6-1.6mm Fe, Ss, Al and cored wire M10
HI7		Screw	
HI8		Screw	
HI9		Washer	
HI10	0469 838 001	Cover	
HI11	0458 722 880	Axle and Nut	
HI12	0459 441 880	Gear adapter	
HI13	0455 049 001	Inlet nozzle	
HI14	0458 999 001	Shaft	
HI15		Nut	
HI16	0458 748 002	Insulating washer	
HI17	0458 748 001	Insulating bushing	

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HI18	0156 602 001	Inlet nozzle	Fe, Ss, Al & Cored	Ø 2 mm plastic for 0.6-1.6 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.



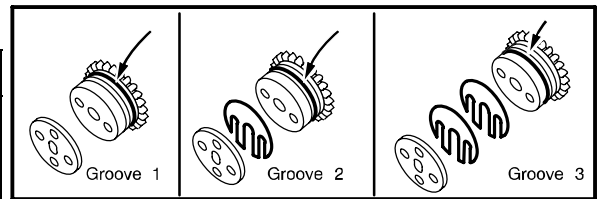
AH 0633 A

## Feed 484

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HK1	0469 837 880 0469 837 881 0469 837 882	Outlet nozzle Outlet nozzle Outlet nozzle	Fe, Ss & cored Al Fe, Ss & cored	Ø 2.0 mm steel for 0.6-1.6 mm Ø 2.0 mm plastic for 1.0-1.6 mm Ø 3.4 mm steel for 2.0-2.4 mm

Item	Ordering no.	Denomination	Wire type	Wire Ø mm	Groove 1	Groove 2	Groove 3	Groove typ	Roller / Bogey markings
HK2	0366 966 880	Feed Roller	Fe, Ss & cored	0.6-1.2	0.6-0.8	0.9-1.0	1.2	V	1
	0366 966 881	Feed Roller	Fe, Ss & cored	1.4-1.6	1.4-1.6	2.0	2.4	V	2
	0366 966 889	Feed Roller	Fe, Ss & cored	1.2	.045" / 1.2	.045" / 1.2	.045" / 1.2	V	.045 / 7
	0366 966 900	Feed Roller	Fe, Ss & cored	0.9-1.6	0.9-1.0	1.2	1.4-1.6	V	6
	0366 966 882	Feed Roller	Cored	1.2-2.0	1.2	1.4-1.6	2.0	V-Knurled	3
	0366 966 883	Feed Roller	Cored	2.4	2.4	not used	not used	V-Knurled	4
	0366 966 885	Feed Roller	Al	1.2	1.2	1.2	1.2	U	U2
	0366 966 899	Feed Roller	Al	1.0-1.6	1.0	1.2	1.6	U	U4

Item	Ordering no.	Denomination	Notes
HK3	0156 707 001	Distance washer	
HK4	0156 707 002	Adjustment spacer	
HK5		Screw	M5x20
HK6		Screw	M5x16



### HD = Heavy Duty

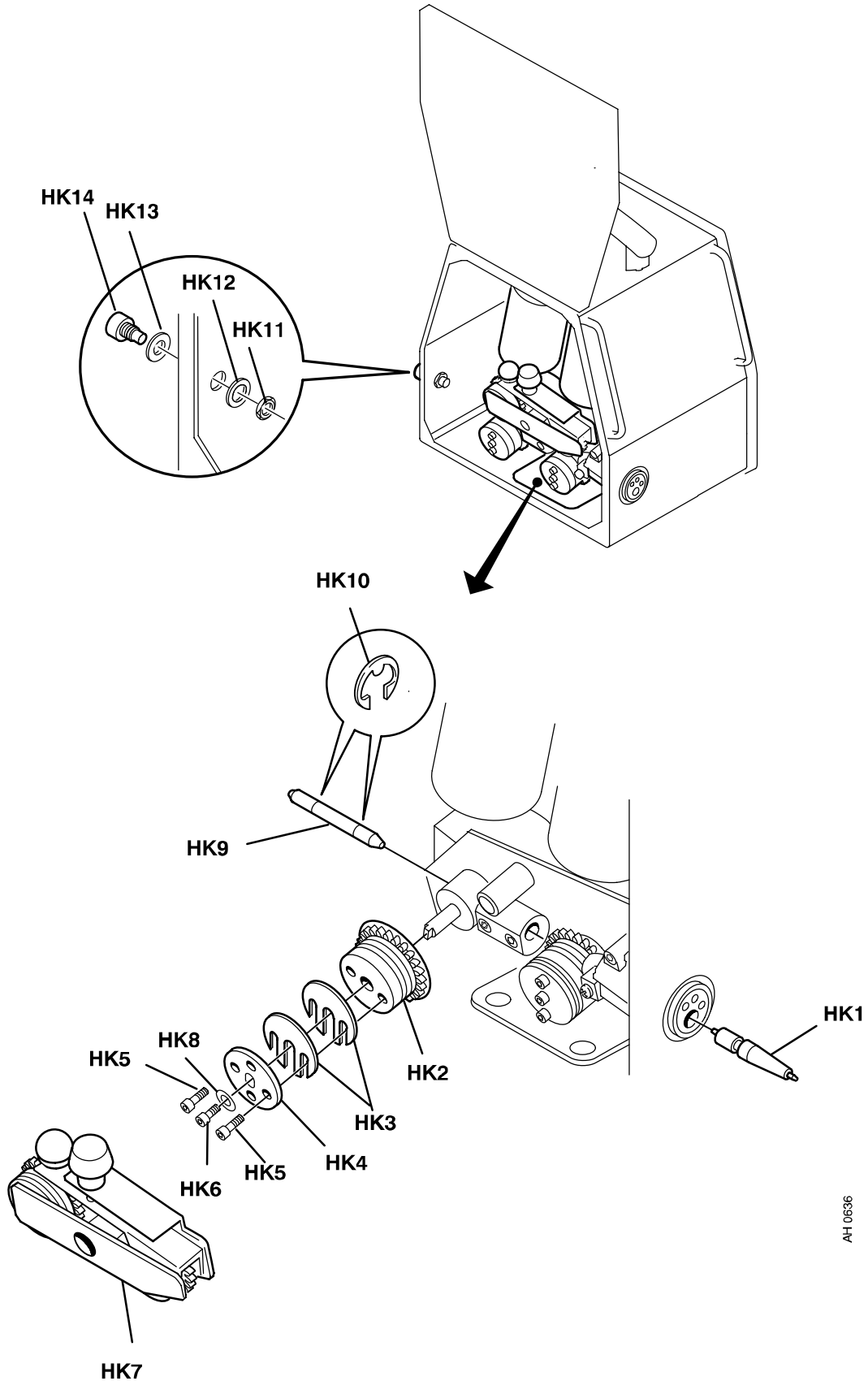
Item	Ordering no.	Denomination	Wire type	Wire dimensions	Groove typ	Roller / Bogey markings
HK7	0366 902 880	Bogey (HD)	Fe, Ss & cored	Ø 0.6 - 1.2 mm	V	1
	0366 902 900	Bogey (HD)	Fe, Ss & cored	Ø 0.9 - 1.6 mm	V	6
	0366 902 881	Bogey (HD)	Fe, Ss & cored	Ø 1.4 - 2.4 mm	V	3
	0366 902 894	Bogey (HD)	Fe, Ss & cored	Ø 1.2 mm	V	.045 / 7
	0366 902 882	Bogey (HD)	Cored	Ø 1.2 - 2.0 mm	V-Knurled	3
	0366 902 883	Bogey (HD)	Cored	Ø 2.4 mm	V-Knurled	4
	0366 902 899	Bogey (HD)	Al	Ø 1.0 - 1.6 mm	U	U4
	0366 902 886	Bogey (HD)	Al	Ø 1.2 mm x 3	U	-

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HK8	0366 944 001	Washer		
HK9	0156 603 001	Intermediate nozzle	Fe, Ss & Al	Ø 2 mm plastic for 0.6-1.6 mm
	0156 603 002	Intermediate nozzle	Fe, Ss & Al	Ø 4 mm plastic for 2.0-2.4 mm
	0332 322 001	Intermediate nozzle	Cored	Ø 2.4 mm copper for 1.2-2.0 mm
	0332 322 002	Intermediate nozzle	Cored	Ø 4 mm copper for 2.4 mm

Item	Ordering no.	Denomination	Note
HK10	0215 702 708	Locking washer	
HK11		Nut	M10
HK12	0458 748 002	Insulating washer	
HK13	0458 748 001	Insulating bushing	

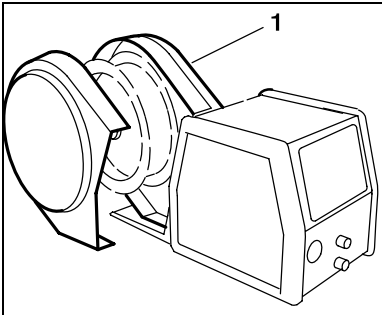
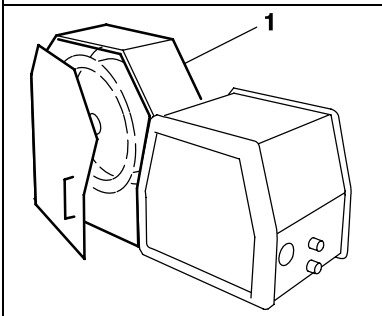
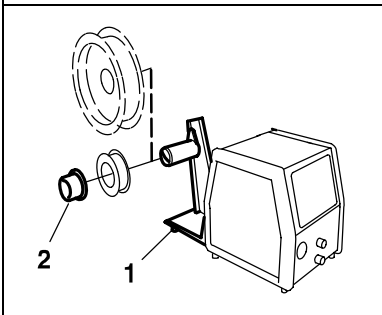
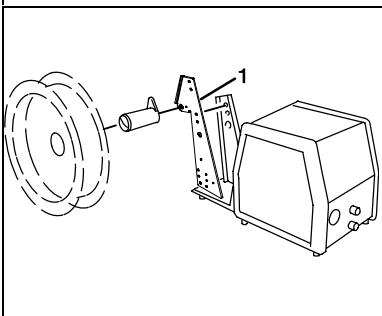
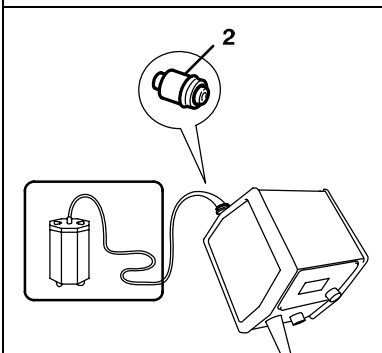
# Feed 484

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HK14	0156 602 001	Inlet nozzle	Fe, Ss, Al & Cored	Ø 2 mm plastic for 0.6-1.6 mm
	0156 602 002	Inlet nozzle	Fe, Ss, Al & Cored	Ø 4 mm plastic for 2.0-2.4 mm
	0332 318 001	Inlet nozzle (HD)	Fe, Ss & Cored	Ø 2.4 mm steel for 1.2-2.0 mm
	0332 318 002	Inlet nozzle (HD)	Fe, Ss & Cored	Ø 4 mm steel for 2.4 mm



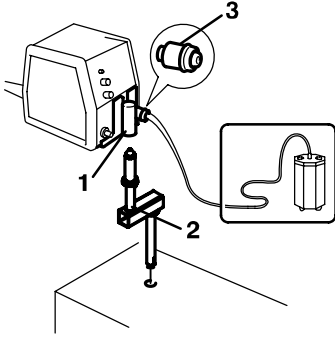
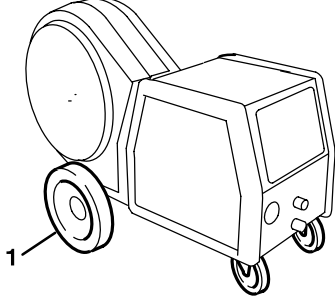
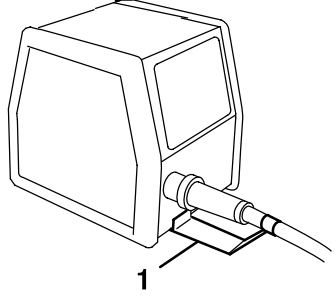
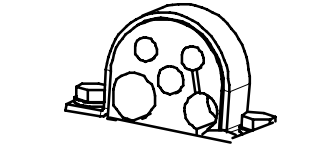
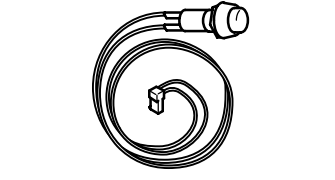

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**Accessories**

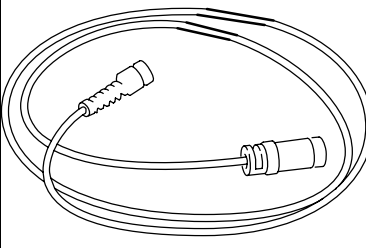
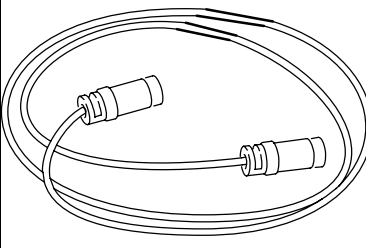
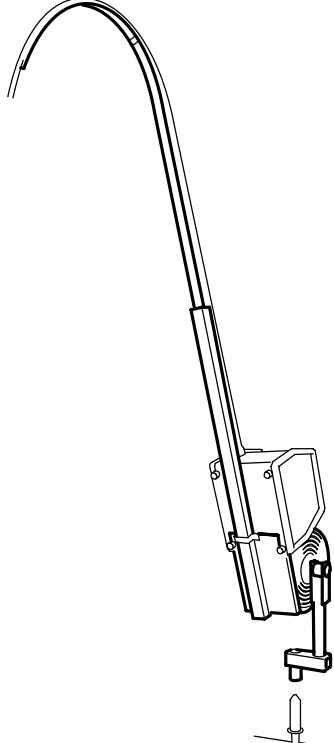
	<p><b>1 Bobbin cover, plastic Ø 300mm</b> ..... 0458 674 880</p>
	<p><b>1 Bobbin cover, metal Ø 300mm</b> ..... 0459 431 880</p>
	<p><b>1 Bobbin holder</b> ..... 0458 704 880  <b>2 Adapter for 5 kg bobbin</b> ..... 0455 410 001</p>
	<p><b>1 Adapter for 440 mm bobbin</b> ..... 0459 233 880</p>
	<p><b>1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

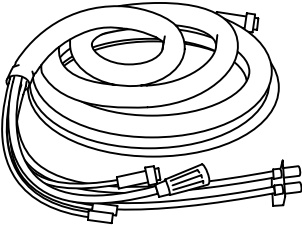


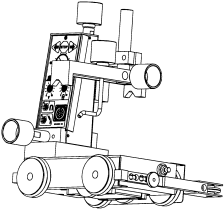
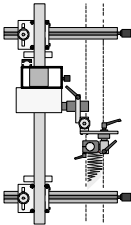
**Feed 304, Feed 484**

	<p>1 <b>Turning piece</b> ..... 0458 703 880                  2 <b>Guide pin</b> ..... 0349 302 303                  3 <b>Quick connector MarathonPac™</b> ..... F102 440 880</p>
	<p>1 <b>Wheel kit</b> ..... 0458 707 880</p>
	<p>1 <b>Strain relief for welding gun</b> ..... 0457 341 881</p>
	<p><b>Strain relief bracket for connection set</b> .... 0459 234 880</p>
	<p><b>Push button</b> for cold wire feed or gas purging 0459 465 880</p>
	<p><b>Remote control unit M1</b> ..... 0459 491 895                  MIG/MAG:wire feed speed and voltage</p>

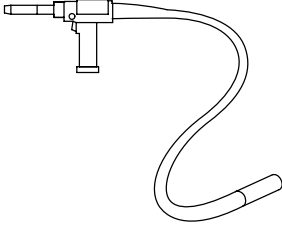
**Feed 304, Feed 484**

 A coiled cable with two connectors: a 23-pin connector on one end and an 8-pin connector on the other.	<p><b>Remote cable 23 pole - 8 pole</b> 5 m ..... 0459 553 880</p>
 A coiled cable with two 23-pin connectors at both ends.	<p><b>Extension cable for remote control 23 pole</b> 8 m ..... 0467 197 880 16 m ..... 0467 197 881</p>
 A mechanical counterbalance device consisting of a long, curved metal arm attached to a motorized base. The base is mounted on a vertical post with a screw.	<p><b>Counter balance device</b> ..... 0458 705 880 (includes mast and counter balance)</p>

	<b>Connection set for 400 A power sources</b>	<b>23 poles</b>	<b>19 poles</b>
	1.7 m .....	0469 836 880	0459 836 880
	5 m .....	0469 836 981	0459 836 881
	10 m .....	0469 836 881	0459 836 882
	15 m .....	0469 836 882	0459 836 883
	25 m .....	0469 836 883	0459 836 884
	35 m .....	0469 836 884	0459 836 885
	1.7 m, water .....	0469 836 885	0459 836 890
	5 m, water .....	0469 836 983	0459 836 891
	10 m, water .....	0469 836 886	0459 836 892
	15 m, water .....	0469 836 887	0459 836 893
	25 m, water .....	0469 836 888	0459 836 894
	35 m, water .....	0469 836 889	0459 836 895
	<b>Connection set for 500 A power sources</b>		
	1.7 m .....	0469 836 890	0459 836 980
	5 m .....	-	0459 836 981
	10 m .....	0469 836 891	0459 836 982
	15 m .....	0469 836 892	0459 836 983
	25 m .....	0469 836 893	0459 836 984
	35 m .....	0469 836 894	0459 836 985
1.7 m, water .....	0469 836 895	0459 836 990	
5 m .....	-	0459 836 991	
10 m, water .....	0469 836 896	0459 836 992	
15 m, water .....	0469 836 897	0459 836 993	
25 m, water .....	0469 836 898	0459 836 894	
35 m, water .....	0469 836 899	0459 836 995	

	<b>Miggytrac 1001, Miggytrac 2000</b> Equipment for mechanized welding .....	More information at the nearest ESAB agency
	<b>Control cable</b> 5.0 m, 23 poles .....	0457 360 880
	<b>Railtrac</b> Equipment for mechanized welding .....	More information at the nearest ESAB agency

**Feed 304, Feed 484**

	<p><b>N.B.: MXH PP only recommended for Feed 304/3004/L3004</b></p> <p><b>Welding gun MXH 400w PP</b></p>	
	6.0 m .....	0700 200 015
10.0 m .....	0700 200 016	
10.0 m, 45° .....	0700 200 019	
<p><b>Welding gun MXH 300w PP</b></p>		
6.0 m .....	0700 200 017	
10.0 m .....	0700 200 018	
10.0 m, 45° .....	0700 200 020	

Information on PSF welding guns can be found in separate brochures.

**Self cooled with RS3 Remote 3-step program switch**

Type	Ordering no.		Max welding current		Wire dimensions
	Hose length 3 m	Hose length 4,5 m	CO <sub>2</sub>	Mix Ar	
<b>PSF 250</b>	0469 798 882	0469 798 883	250A 60%	225A 60%	0.6 - 1.0
<b>PSF 405</b>	0458 401 892	0458 401 893	380A 60%	325A 60%	0.6 - 1.6

**Water cooled with RS3 Remote 3-step program switch**

Type	Ordering no.		Max welding current		Wire dimensions
	Hose length 3 m	Hose length 4,5 m	CO <sub>2</sub>	Mix Ar	
<b>PSF 410W</b>	0458 400 898	0458 400 899	425A 100%	400A 100%	0.6 - 1.6
<b>PSF 510W</b>	0458 400 900	0458 400 901	500A 100%	440A 100%	0.6 - 2.4



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