



EN

Wire feed unit

Drive XQ IC D200

099-005637-EW501

Observe additional system documents!

27.04.2021

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General instructions

WARNING



Read the operating instructions!

The operating instructions provide an introduction to the safe use of the products.

- Read and observe the operating instructions for all system components, especially the safety instructions and warning notices!
- Observe the accident prevention regulations and any regional regulations!
- The operating instructions must be kept at the location where the machine is operated.
- Safety and warning labels on the machine indicate any possible risks. Keep these labels clean and legible at all times.
- The machine has been constructed to state-of-the-art standards in line with any applicable regulations and industrial standards. Only trained personnel may operate, service and repair the machine.
- Technical changes due to further development in machine technology may lead to a differing welding behaviour.

In the event of queries on installation, commissioning, operation or special conditions at the installation site, or on usage, please contact your sales partner or our customer service department on +49 2680 181-0.

A list of authorised sales partners can be found at www.ewm-group.com/en/specialist-dealers.

Liability relating to the operation of this equipment is restricted solely to the function of the equipment. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning the equipment.

The manufacturer is unable to monitor whether or not these instructions or the conditions and methods are observed during installation, operation, usage and maintenance of the equipment.

An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, we do not accept any responsibility or liability for losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way.

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The content of this document has been prepared and reviewed with all reasonable care. The information provided is subject to change; errors excepted.

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2 For your safety

2.1 Notes on using these operating instructions

DANGER

Working or operating procedures which must be closely observed to prevent imminent serious and even fatal injuries.

- Safety notes include the "DANGER" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol on the edge of the page.

WARNING

Working or operating procedures which must be closely observed to prevent serious and even fatal injuries.

- Safety notes include the "WARNING" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol in the page margin.

CAUTION

Working or operating procedures which must be closely observed to prevent possible minor personal injury.

- The safety information includes the "CAUTION" keyword in its heading with a general warning symbol.
- The risk is explained using a symbol on the edge of the page.

























Technical aspects which the user must observe to avoid material or equipment damage.

Instructions and lists detailing step-by-step actions for given situations can be recognised via bullet points, e.g.:

- Insert the welding current lead socket into the relevant socket and lock.

2.2 Explanation of icons

| Symbol | Description | Symbol | Description |
|---|---|---|----------------------------------|
|  | Indicates technical aspects which the user must observe. |  | Activate and release / Tap / Tip |
|  | Switch off machine |  | Release |
|  | Switch on machine |  | Press and hold |
| | |  | Switch |
|  | Incorrect / Invalid |  | Turn |
|  | Correct / Valid |  | Numerical value – adjustable |
|  | Input |  | Signal light lights up in green |
|  | Navigation |  | Signal light flashes green |
|  | Output |  | Signal light lights up in red |
|  | Time representation (e.g.: wait 4 s / actuate) |  | Signal light flashes red |
|  | Interruption in the menu display (other setting options possible) | | |
|  | Tool not required/do not use | | |
|  | Tool required/use | | |

2.3 Safety instructions

WARNING



Risk of accidents due to non-compliance with the safety instructions!
Non-compliance with the safety instructions can be fatal!

- Carefully read the safety instructions in this manual!
- Observe the accident prevention regulations and any regional regulations!
- Inform persons in the working area that they must comply with the regulations!



Risk of injury from electrical voltage!

Voltages can cause potentially fatal electric shocks and burns on contact. Even low voltages can cause a shock and lead to accidents.

- Never touch live components such as welding current sockets or stick, tungsten or wire electrodes!
- Always place torches and electrode holders on an insulated surface!
- Wear the full personal protective equipment (depending on the application)!
- The machine may only be opened by qualified personnel!
- The device must not be used to defrost pipes!



Hazard when interconnecting multiple power sources!

If a number of power sources are to be connected in parallel or in series, only a technical specialist may interconnect the sources as per standard IEC 60974-9:2010: Installation and use and German Accident Prevention Regulation BVG D1 (formerly VBG 15) or country-specific regulations.

Before commencing arc welding, a test must verify that the equipment cannot exceed the maximum permitted open circuit voltage.

- Only qualified personnel may connect the machine.
- When taking individual power sources out of operation, all mains and welding current leads must be safely disconnected from the welding system as a whole. (Hazard due to reverse polarity voltage!)
- Do not interconnect welding machines with pole reversing switch (PWS series) or machines for AC welding since a minor error in operation can cause the welding voltages to be combined, which is not permitted.



Risk of injury due to radiation or heat!

Arc radiation can lead to skin and eye injuries.

Contact with hot workpieces and sparks can lead to burns.

- Use hand shield or welding helmet with the appropriate safety level (depends on the application).
- Wear dry protective clothing (e.g. hand shield, gloves, etc.) in accordance with the applicable regulations of your country.
- Persons who are not directly involved should be protected with a welding curtain or suitable safety screen against radiation and the risk of blinding!

WARNING



Risk of injury due to improper clothing!

During arc welding, radiation, heat and voltage are sources of risk that cannot be avoided. The user has to be equipped with the complete personal protective equipment at all times. The protective equipment has to include:

- Respiratory protection against hazardous substances and mixtures (fumes and vapours); otherwise implement suitable measures such as extraction facilities.
- Welding helmet with proper protection against ionizing radiation (IR and UV radiation) and heat.
- Dry welding clothing (shoes, gloves and body protection) to protect against warm environments with conditions comparable to ambient temperatures of 100 °C or higher and arcing and work on live components.
- Hearing protection against harming noise.



Explosion risk!

Apparently harmless substances in closed containers may generate excessive pressure when heated.

- Move containers with inflammable or explosive liquids away from the working area!
- Never heat explosive liquids, dusts or gases by welding or cutting!



Fire hazard!

Due to the high temperatures, sparks, glowing parts and hot slag that occur during welding, there is a risk of flames.

- Be watchful of potential sources of fire in the working area!
- Do not carry any easily inflammable objects, e.g. matches or lighters.
- Ensure suitable fire extinguishers are available in the working area!
- Thoroughly remove any residue of flammable materials from the workpiece prior to starting to weld.
- Only further process workpieces after they have cooled down. Do not allow them to contact any flammable materials!

⚠ CAUTION



Smoke and gases!

Smoke and gases can lead to breathing difficulties and poisoning. In addition, solvent vapour (chlorinated hydrocarbon) may be converted into poisonous phosgene due to the ultraviolet radiation of the arc!

- Ensure that there is sufficient fresh air!
- Keep solvent vapour away from the arc beam field!
- Wear suitable breathing apparatus if appropriate!



Noise exposure!

Noise exceeding 70 dBA can cause permanent hearing damage!

- Wear suitable ear protection!
- Persons located within the working area must wear suitable ear protection!



According to IEC 60974-10, welding machines are divided into two classes of electromagnetic compatibility (the EMC class can be found in the Technical data) > see 8 chapter:



Class A machines are not intended for use in residential areas where the power supply comes from the low-voltage public mains network. When ensuring the electromagnetic compatibility of class A machines, difficulties can arise in these areas due to interference not only in the supply lines but also in the form of radiated interference.



Class B machines fulfil the EMC requirements in industrial as well as residential areas, including residential areas connected to the low-voltage public mains network.

Setting up and operating

When operating arc welding systems, in some cases, electro-magnetic interference can occur although all of the welding machines comply with the emission limits specified in the standard. The user is responsible for any interference caused by welding.

In order to **evaluate** any possible problems with electromagnetic compatibility in the surrounding area, the user must consider the following: (see also EN 60974-10 Appendix A)

- Mains, control, signal and telecommunication lines
- Radios and televisions
- Computers and other control systems
- Safety equipment
- The health of neighbouring persons, especially if they have a pacemaker or wear a hearing aid
- Calibration and measuring equipment
- The immunity to interference of other equipment in the surrounding area
- The time of day at which the welding work must be carried out

Recommendations for reducing interference emission

- Mains connection, e.g. additional mains filter or shielding with a metal tube
- Maintenance of the arc welding system
- Welding leads should be as short as possible and run closely together along the ground
- Potential equalization
- Earthing of the workpiece. In cases where it is not possible to earth the workpiece directly, it should be connected by means of suitable capacitors.
- Shielding from other equipment in the surrounding area or the entire welding system



Electromagnetic fields!

The power source may cause electrical or electromagnetic fields to be produced which could affect the correct functioning of electronic equipment such as IT or CNC devices, telecommunication lines, power cables, signal lines and pacemakers.



- Observe the maintenance instructions > see 6.2 chapter!
- Unwind welding leads completely!
- Shield devices or equipment sensitive to radiation accordingly!
- The correct functioning of pacemakers may be affected (obtain advice from a doctor if necessary).

CAUTION



Obligations of the operator!

The respective national directives and laws must be complied with when operating the machine!

- Implementation of national legislation relating to framework directive 89/391/EEC on the introduction of measures to encourage improvements in the safety and health of workers at work and associated individual guidelines.
- In particular, directive 89/655/EEC concerning the minimum safety and health requirements for the use of work equipment by workers at work.
- The regulations applicable to occupational safety and accident prevention in the country concerned.
- Setting up and operating the machine as per IEC 60974.-9.
- Brief the user on safety-conscious work practices on a regular basis.
- Regularly inspect the machine as per IEC 60974.-4.



The manufacturer's warranty becomes void if non-genuine parts are used!

- ***Only use system components and options (power sources, welding torches, electrode holders, remote controls, spare parts and replacement parts, etc.) from our range of products!***
- ***Only insert and lock accessory components into the relevant connection socket when the machine is switched off.***

Requirements for connection to the public mains network

High-performance machines can influence the mains quality by taking current from the mains network. For some types of machines, connection restrictions or requirements relating to the maximum possible line impedance or the necessary minimum supply capacity at the interface with the public network (Point of Common Coupling, PCC) can therefore apply. In this respect, attention is also drawn to the machines' technical data. In this case, it is the responsibility of the operator, where necessary in consultation with the mains network operator, to ensure that the machine can be connected.

2.4 Transport and installation

WARNING



Risk of injury due to improper handling of shielding gas cylinders!

Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

- Observe the instructions from the gas manufacturer and any relevant regulations concerning the use of compressed air!
- Do not attach any element to the shielding gas cylinder valve!
- Prevent the shielding gas cylinder from heating up.

⚠ CAUTION**Risk of accidents due to supply lines!**

During transport, attached supply lines (mains leads, control cables, etc.) can cause risks, e.g. by causing connected machines to tip over and injure persons!

- Disconnect all supply lines before transport!

**Risk of tipping!**

There is a risk of the machine tipping over and injuring persons or being damaged itself during movement and set up. Tilt resistance is guaranteed up to an angle of 10° (according to IEC 60974-1).

- Set up and transport the machine on level, solid ground.
- Secure add-on parts using suitable equipment.

**Risk of accidents due to incorrectly installed leads!**

Incorrectly installed leads (mains, control and welding leads or intermediate hose packages) can present a tripping hazard.

- Lay the supply lines flat on the floor (avoid loops).
- Avoid laying the leads on passage ways.

**Risk of injury from heated coolant and its connections!**

The coolant used and its connection or connection points can heat up significantly during operation (water-cooled version). When opening the coolant circuit, escaping coolant may cause scalding.

- Open the coolant circuit only when the power source or cooling unit is switched off!
- Wear proper protective equipment (protective gloves)!
- Seal open connections of the hose leads with suitable plugs.



The units are designed for operation in an upright position!

Operation in non-permissible positions can cause equipment damage.

- ***Only transport and operate in an upright position!***



Accessory components and the power source itself can be damaged by incorrect connection!

- ***Only insert and lock accessory components into the relevant connection socket when the machine is switched off.***
- ***Comprehensive descriptions can be found in the operating instructions for the relevant accessory components.***
- ***Accessory components are detected automatically after the power source is switched on.***



Protective dust caps protect the connection sockets and therefore the machine against dirt and damage.

- ***The protective dust cap must be fitted if there is no accessory component being operated on that connection.***
- ***The cap must be replaced if faulty or if lost!***

3 Intended use

WARNING



Hazards due to improper usage!

The machine has been constructed to the state of the art and any regulations and standards applicable for use in industry and trade. It may only be used for the welding procedures indicated at the rating plate. Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!

- The equipment must only be used in line with its designated purpose and by trained or expert personnel!
- Do not improperly modify or convert the equipment!

3.1 Applications

Wire feeder to feed wire electrodes for gas-shielded metal-arc welding.

3.2 Use and operation solely with the following machines

A suitable power source (system component) is required in order to operate the wire feed unit!

The following system components can be combined with this machine:

- Titan XQ / Phoenix XQ / Taurus XQ

3.3 Documents which also apply

3.3.1 Warranty

For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

3.3.2 Declaration of Conformity



This product corresponds in its design and construction to the EU directives listed in the declaration. The product comes with a relevant declaration of conformity in the original.

The manufacturer recommends carrying out the safety inspection according to national and international standards and guidelines every 12 months.

3.3.3 Service documents (spare parts and circuit diagrams)

WARNING



Do not carry out any unauthorised repairs or modifications!

To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!

The warranty becomes null and void in the event of unauthorised interference.

- Appoint only skilled persons for repair work (trained service personnel)!

Original copies of the circuit diagrams are enclosed with the unit.

Spare parts can be obtained from the relevant authorised dealer.

3.3.4 Calibration/Validation

An original certificate is enclosed with the product. The manufacturer recommends calibration / validation at intervals of 12 months.

3.3.5 Part of the complete documentation

This document is part of the complete documentation and valid only in combination with all other parts of these instructions! Read and observe the operating instructions for all system components, especially the safety instructions!

The illustration shows a general example of a welding system.

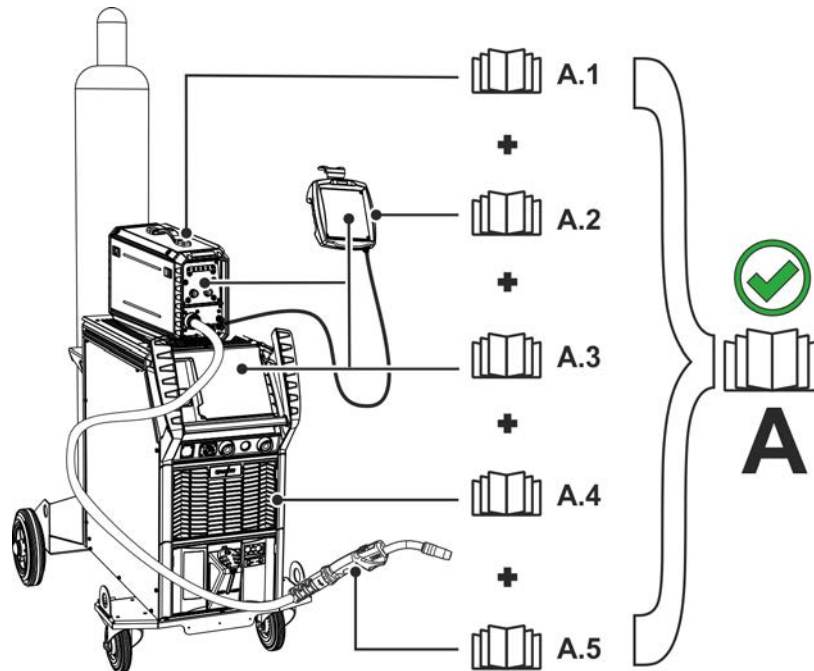


Figure 3-1

| Item | Documentation |
|------|------------------------|
| A.1 | Wire feed unit |
| A.2 | Remote control |
| A.3 | Control |
| A.4 | Power source |
| A.5 | Welding torch |
| A | Complete documentation |

4 Machine description – quick overview

4.1 Front view / rear view

The maximum possible machine configuration is given in the text description.
If necessary, the optional connection may need to be retrofitted > see 9 chapter.

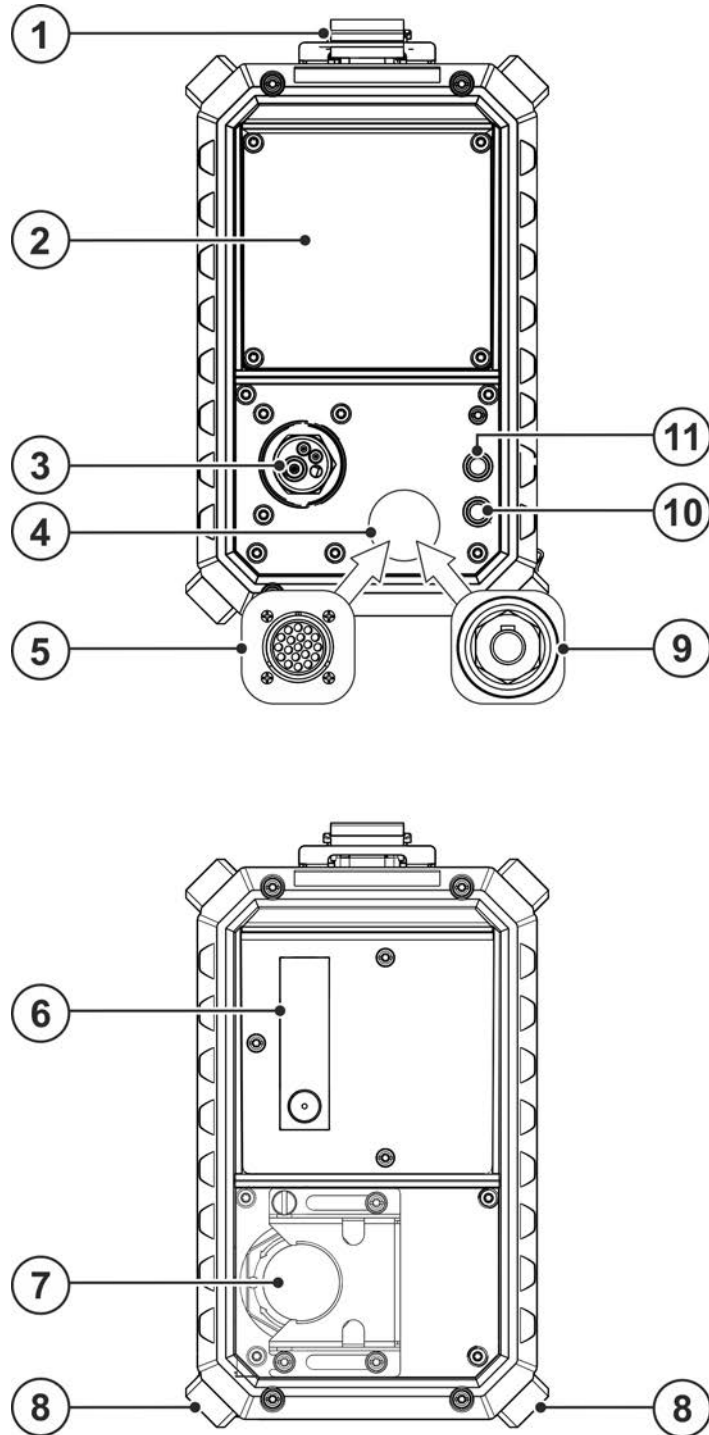






Figure 4-1

| Item | Symbol | Description |
|------|---|--|
| 1 | | Transport elements Transport handle and transport belt > see 5.1.2 chapter |
| 2 | | Machine control (see the relevant control operating instructions) |
| 3 | | Welding torch connection (Euro or Dinse torch connector) Welding current, shielding gas and torch trigger integrated |
| 4 | | Connection depending on the device version |
| 5 |  | 19-pole connection socket - optional For connecting analogue accessory components (remote control, control cable, welding torch, etc.) |
| 6 |  | Analogue gas volume control with gas flow meter - optional |
| 7 | | Intermediate hose package strain relief > see 5.2.1 chapter |
| 8 | | Machine feet, protective rails |
| 9 | | Connection socket for welding current - optional Welding current potential of the torch connector for MMA welding or gouging |
| 10 |  | Quick-connect coupling (blue) - optional Coolant feed |
| 11 |  | Quick-connect coupling (red) - optional Coolant return |

4.2 Side view from left and right

The maximum possible machine configuration is given in the text description.
If necessary, the optional connection may need to be retrofitted > see 9 chapter.

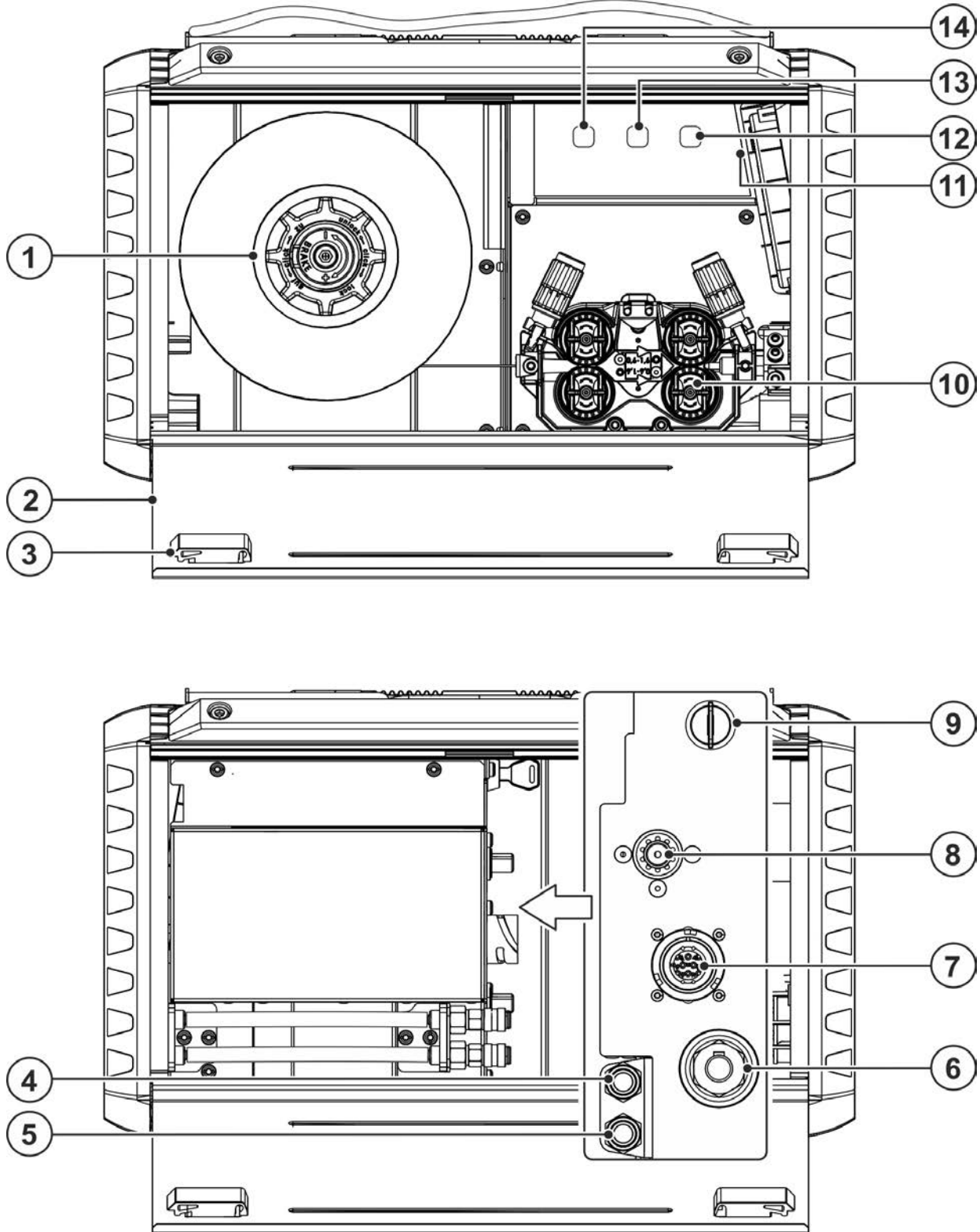













Figure 4-2

| Item | Symbol | Description |
|------|---|--|
| 1 | | Wire spool holder |
| 2 | | Protective cap Cover for the wire feed mechanism and other operating elements. Depending on the machine series, additional stickers with information on the replacement parts and JOB lists will be located on the inside. |
| 3 | | Slide latch, lock for the protective cap |
| 4 |  | Quick-connect coupling (red) - optional Coolant return |
| 5 |  | Quick-connect coupling (blue) - optional Coolant feed |
| 6 |  | Power source welding current connector plug Welding current connection between power source and wire feeder |
| 7 |  | 14-pole connection socket Wire feeder control cable |
| 8 |  | Connection thread - G$\frac{1}{4}$" Shielding gas connection (inlet) |
| 9 |  | Key switch for protection against unauthorised use > see 5.8 chapter <ul style="list-style-type: none">  -----changes possible, G front drive-4x-EX  -----changes not possible. |
| 10 | | Wire feed unit |
| 11 | | Lighting, inside In power-saving mode and with MMA or TIG welding, the lighting is switched off. |
| 12 |  | Wire inching push-button Potential and gas-free inching of the wire electrode > see 5.4.1.3 chapter. |
| 13 |  | Push-button gas test / rinse hose package > see 5.2.2 chapter |
| 14 |  | Push-button, wire return Potential- and gas-free reverse inching of the wire electrode. |

5 Design and function

WARNING



Risk of injury from electrical voltage!

Contact with live parts, e.g. power connections, can be fatal!

- Observe the safety information on the first pages of the operating instructions!
- Commissioning must be carried out by persons who are specifically trained in handling power sources!
- Connect connection or power cables while the machine is switched off!

CAUTION



Risk from electrical current!

If welding is carried out alternately using different methods and if a welding torch and an electrode holder remain connected to the machine, the open-circuit/welding voltage is applied simultaneously on all cables.

- The torch and the electrode holder should therefore always be placed on an insulated surface before starting work and during breaks.

Read and observe the documentation to all system and accessory components!

5.1 Transport and installation

WARNING



Risk of accident due to improper transport of machines that must not be lifted!

Do not lift or suspend the machine! The machine can drop and cause injuries! The handles, straps or brackets are suitable for transport by hand only!

- The machine must not be suspended or lifted using a crane.

5.1.1 Ambient conditions



The machine must not be operated in the open air and must only be set up and operated on a suitable, stable and level base!

- The operator must ensure that the ground is non-slip and level, and provide sufficient lighting for the place of work.
- Safe operation of the machine must be guaranteed at all times.



Equipment damage due to contamination!

Unusually high amounts of dust, acids, corrosive gases or substances can damage the machine (observe maintenance intervals > see 6.2 chapter).

- Avoid large amounts of smoke, steam, oily fumes, grinding dust and corrosive ambient air!

5.1.1.1 In operation

Temperature range of the ambient air:

- -25 °C to +40 °C (-13 °F to 104 °F) ^[1]

Relative humidity:

- up to 50 % at 40 °C (104 °F)
- up to 90 % at 20 °C (68 °F)

5.1.1.2 Transport and storage

Storage in a closed room, temperature range of the ambient air:

- -30 °C to +70 °C (-22 °F to 158 °F) ^[1]

Relative humidity

- up to 90 % at 20 °C (68 °F)

^[1] Ambient temperature dependent on coolant! Observe the coolant temperature range of the torch cooling

5.1.2 Transport elements

Depending on the version, a transport handle and / or a transport belt are factory fitted to the machine. If required, the respective transport element can be converted or retrofitted > see 9 chapter.

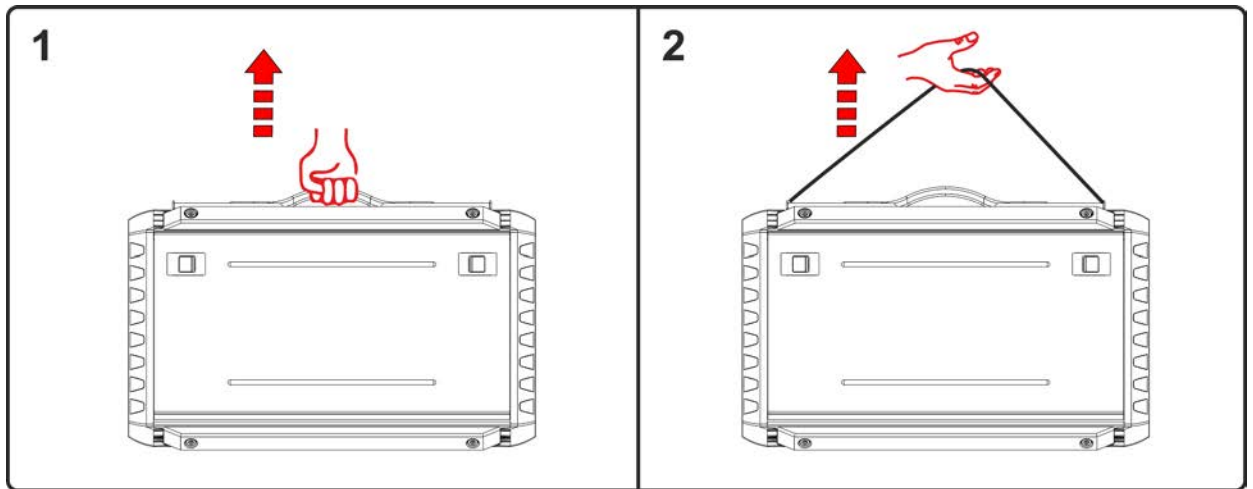


Figure 5-1

The machine can be carried either centrally by the transport handle (1) or with the transport belt (2).

5.1.3 Welding torch cooling system



Insufficient frost protection in the welding torch coolant.

Depending on the ambient conditions, different liquids are used to cool the welding torch > see 5.1.3.1 chapter. Coolant with frost protection (KF 37E or KF 23E) must be checked at regular intervals for sufficient frost protection to prevent damage to the machine or the accessory components.

- The coolant must be checked with the frost protection tester TYP 1 > see 9 chapter for sufficient frost protection.
- Replace coolant with insufficient frost protection if necessary.



Material damage due to unsuitable coolants!

Unsuitable coolant, coolants mixed with other types / liquids or use in an unsuitable temperature range will result in material damage and loss of the manufacturer's warranty!

- Operation without coolant is not permitted! Dry running will destroy the cooling components such as the coolant pump, welding torch and hose packages.
- Only use the coolants described in these instructions for the specified ambient conditions (temperature range) > see 5.1.3.1 chapter.
- Do not mix coolants of different types (including those described in these instructions).
- When changing the coolant, all liquid must be replaced and the cooling system flushed.

Dispose of the coolant in accordance with local regulations and the material safety data sheets.

5.1.3.1 Permitted torch coolant

| Coolant | Temperature range |
|-------------------|--------------------------------------|
| blueCool -10 | -10 °C to +40 °C (14 °F to +104 °F) |
| KF 23E (Standard) | -10 °C to +40 °C (14 °F to +104 °F) |
| KF 37E | -20 °C to +30 °C (-4 °F to +86 °F) |
| blueCool -30 | -30 °C to +40 °C (-22 °F to +104 °F) |

5.1.3.2 Maximal hose package length

All information relates to the total hose package length of the complete welding system and presents exemplary configurations (of components of the EWM product portfolio with standard lengths). A straight kink-free installation is to be ensured, taking into account the max. delivery height.

Pump: Pmax = 3,5 bar (0.35 MPa)

| Power source | Hose package | Wire feeder | miniDrive | Welding torch | Max. |
|--------------|----------------------|-------------|----------------------|-----------------------|----------------|
| Compact | ✗ | ✗ | ✓ (25 m / 82 ft.) | ✓ (5 m / 16 ft.) | 30 m 98 ft. |
| | ✓ (20 m / 65 ft.) | ✓ | ✗ | ✓ ✓ (5 m / 16 ft.) | |
| Decompact | ✓ (25 m / 82 ft.) | ✓ | ✗ | ✓ (5 m / 16 ft.) | |
| | ✓ (15 m / 49 ft.) | ✓ | ✓ (10 m / 32 ft.) | ✓ (5 m / 16 ft.) | |

Pump: Pmax = 4.5 bar (0.45 MPa)

| Power source | Hose package | Wire feeder | miniDrive | Welding torch | Max. |
|--------------|-----------------------|-------------|----------------------|-----------------------|-----------------|
| Compact | ✗ | ✗ | ✓ (25 m / 82 ft.) | ✓ (5 m / 16 ft.) | 30 m 98 ft. |
| | ✓ (30 m / 98 ft.) | ✓ | ✗ | ✓ ✓ (5 m / 16 ft.) | 40 m 131 ft. |
| Decompact | ✓ (40 m / 131 ft.) | ✓ | ✗ | ✓ (5 m / 16 ft.) | 45 m 147 ft. |
| | ✓ (40 m / 131 ft.) | ✓ | ✓ (25 m / 82 ft.) | ✓ (5 m / 16 ft.) | 70 m 229 ft. |

5.2 Intermediate hose package connection

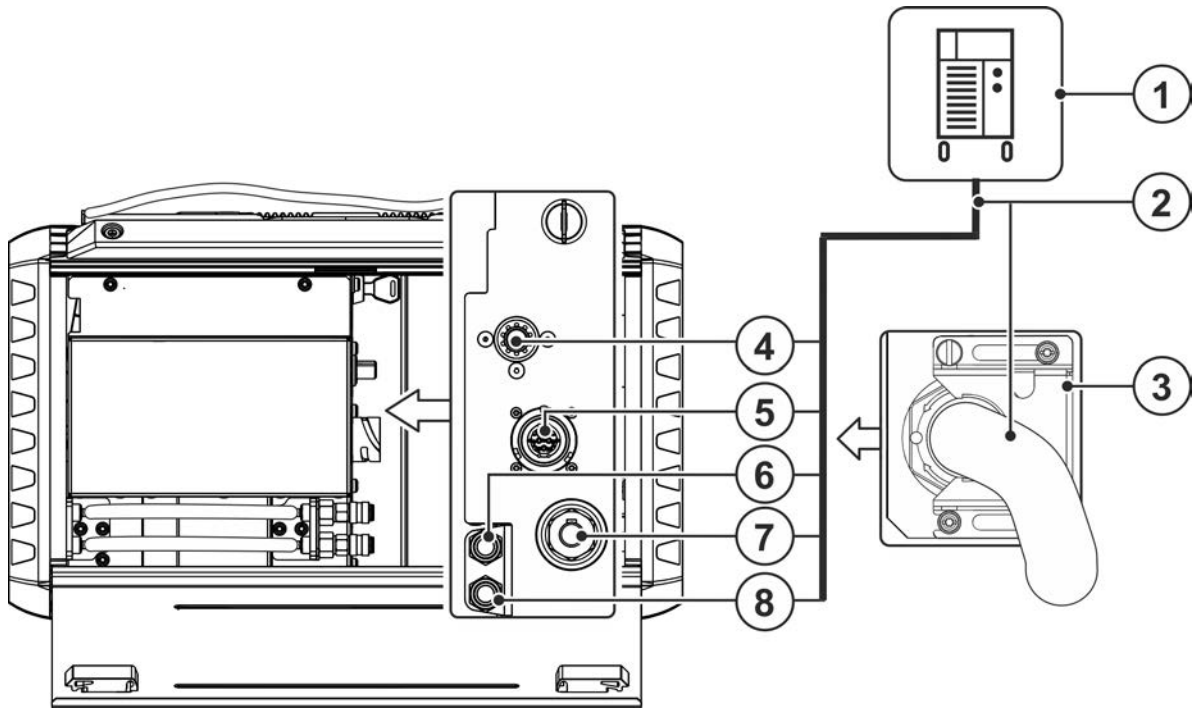


Figure 5-2

| Item | Symbol | Description |
|------|--------|---|
| 1 | | Power source |
| 2 | | Intermediate hose package |
| 3 | | Intermediate hose package strain relief > see 5.2.1 chapter |
| 4 | | Connection thread - G$\frac{1}{4}$" Shielding gas connection (inlet) |
| 5 | | 14-pole connection socket Wire feeder control cable |
| 6 | | Quick connect coupling (red) coolant return |
| 7 | | Power source welding current connector plug Welding current connection between power source and wire feeder |
| 8 | | Quick connect coupling (blue) coolant supply |

- Secure hose package end with the strain relief > see 5.2.1 chapter.
- Push the welding current cable socket onto the “welding current connecting plug” and lock by turning to the right.
- Screw the gas hose connection to the shielding gas connection (inlet) on the machine gas-tight.
- Insert the control cable plug into the connection socket (14-pole) and secure with crown nut (the plug can only be inserted into the connection socket in one position).

Where applicable:

- Lock connecting nipples of the cooling water tubes into the corresponding quick connect couplings: Return line red to quick connect coupling, red (coolant return) and supply line blue to quick connect coupling, blue (coolant supply).

5.2.1 Intermediate hose package strain relief



Property damage due to strain relief not installed or not installed correctly!

The strain relief absorbs tensile forces on cables, plugs and sockets.

If strain reliefs are not installed or not installed correctly, the connector plugs or sockets may be damaged.

- **The attachment must always take place on both sides of the intermediate hose package!**
- **The connections of the hose package must be locked properly!**

5.2.1.1 Locking the strain relief

EWM intermediate hose package

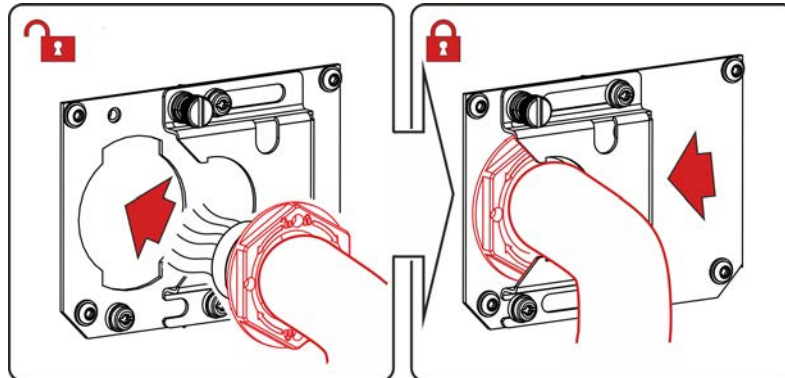


Figure 5-3

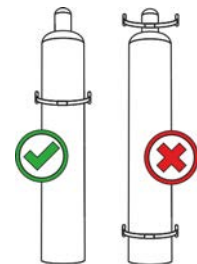
5.2.2 Shielding gas supply (shielding gas cylinder for welding machine)

WARNING



Risk of injury due to improper handling of shielding gas cylinders! Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

- Place shielding gas cylinder into the designated holder and secure with fastening elements (chain/belt)!
- Attach the fastening elements within the upper half of the shielding gas cylinder!
- The fastening elements must tightly enclose the shielding gas cylinder!



An unhindered shielding gas supply from the shielding gas cylinder to the welding torch is a fundamental requirement for optimum welding results. In addition, a blocked shielding gas supply may result in the welding torch being destroyed.

- **Always re-fit the yellow protective cap when not using the shielding gas connection.**
- **All shielding gas connections must be gas tight.**

5.2.3 Pressure regulator connection

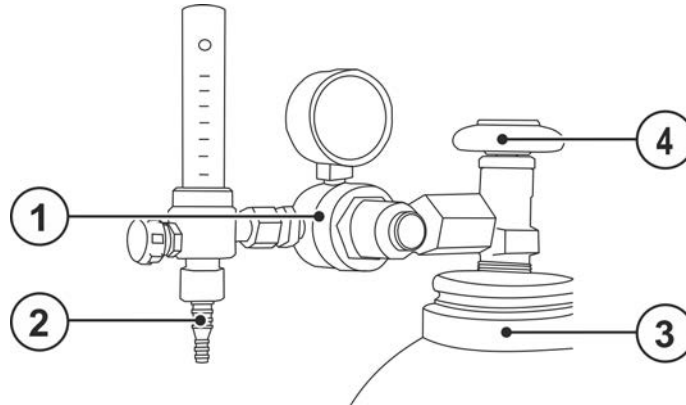


Figure 5-4

| Item | Symbol | Description |
|------|--------|---------------------------------------|
| 1 | | Pressure regulator |
| 2 | | Output side of the pressure regulator |
| 3 | | Shielding gas cylinder |
| 4 | | Cylinder valve |

- Before connecting the pressure regulator to the gas cylinder, open the cylinder valve briefly to blow out any dirt.
- Tighten the pressure regulator screw connection on the gas bottle valve to be gas-tight.
- Screw the gas hose connection to the outlet side of the pressure regulator gas-tight.

5.2.4 Gas test – setting the shielding gas volume

- Slowly open the gas cylinder valve.
- Open the pressure regulator.
- Switch on the power source at the main switch.
- Trigger gas test > see 5.2.4 chapter function (welding voltage and wire feed motor remain switched off – no accidental arc ignition).
- Set the relevant gas quantity for the application on the pressure regulator.

| Welding process | Recommended shielding gas quantity |
|-------------------------|--|
| MAG welding | Wire diameter x 11.5 = l/min |
| MIG brazing | Wire diameter x 11.5 = l/min |
| MIG welding (aluminium) | Wire diameter x 13.5 = l/min (100 % argon) |

Helium-rich gas mixtures require a higher gas volume!

The table below can be used to correct the gas volume calculated where necessary:

| Shielding gas | Factor |
|---------------|--------|
| 75% Ar/25% He | 1.14 |
| 50% Ar/50% He | 1.35 |
| 25% Ar/75% He | 1.75 |
| 100% He | 3.16 |

If the shielding gas setting is too low or too high, this can introduce air to the weld pool and may cause pores to form. Adjust the shielding gas quantity to suit the welding task!

5.2.5 Notes on the installation of welding current leads

- Incorrectly installed welding current leads can cause faults in the arc (flickering).
- Lay the workpiece lead and hose package of power sources without HF igniter (MIG/MAG) for as long and as close as possible in parallel.
- Lay the workpiece lead and hose package of power sources with HF igniter (TIG) for as long as possible in parallel with a distance of 20 cm to avoid HF sparkover.
- Always keep a distance of at least 20 cm to leads of other power sources to avoid interferences
- Always keep leads as short as possible! For optimum welding results max. 30 m (welding lead + intermediate hose package + torch lead).

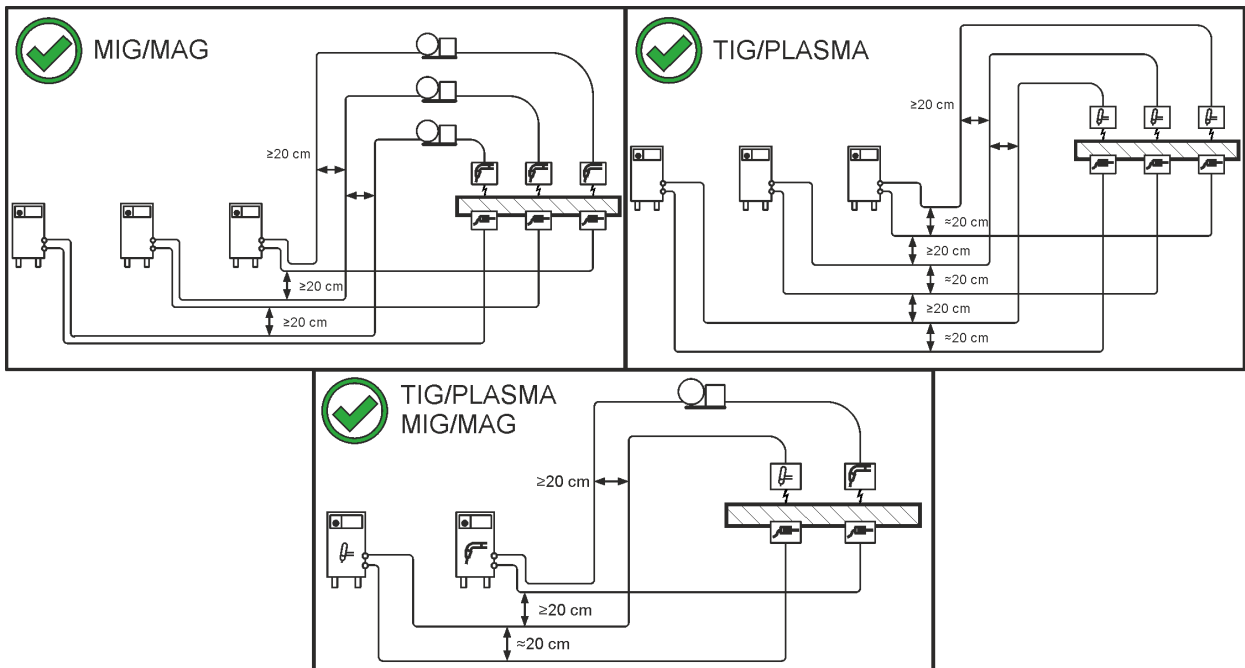


Figure 5-5

- Use an individual welding lead to the workpiece for each welding machine!

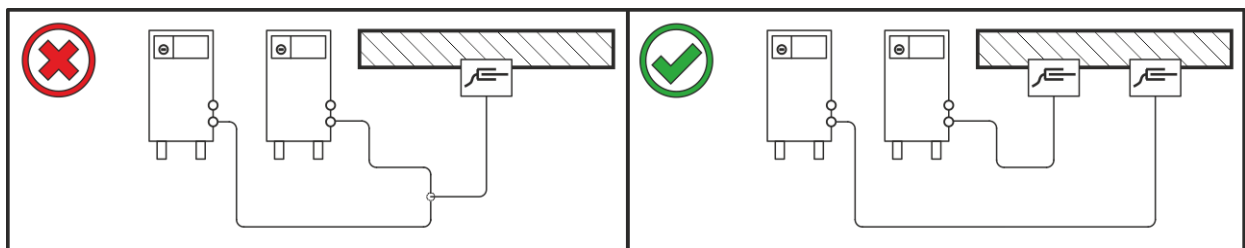


Figure 5-6

- Fully unroll welding current leads, torch hose packages and intermediate hose packages. Avoid loops!
- Always keep leads as short as possible!

Lay any excess cable lengths in meanders.

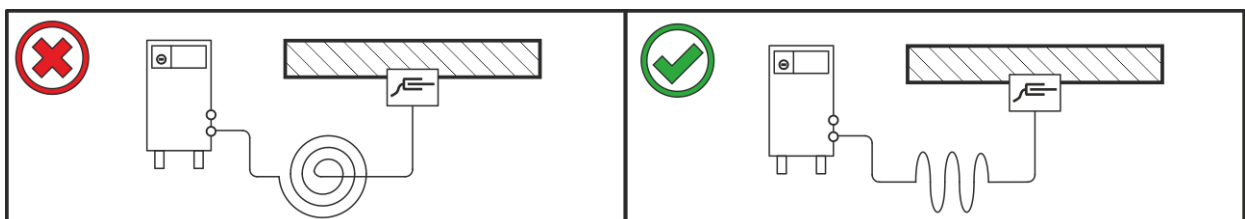


Figure 5-7

5.2.6 Stray welding currents

⚠ WARNING



Risk of injury due to stray welding currents!

Stray welding currents can destroy protective earth conductors, damage machines and electronic devices and cause overheating of components, leading to fire.

- Check that all welding current connections are firmly secured and electrical connections are in perfect condition.
- Set up, attach or suspend all conductive power source components such as casing, transport vehicles and crane frames so they are insulated.
- Do not place any other electronic devices such as drills or angle grinders on the power source, transport vehicle or crane frames unless they are insulated.
- Always put welding torches and electrode holders on an insulated surface when they are not in use.

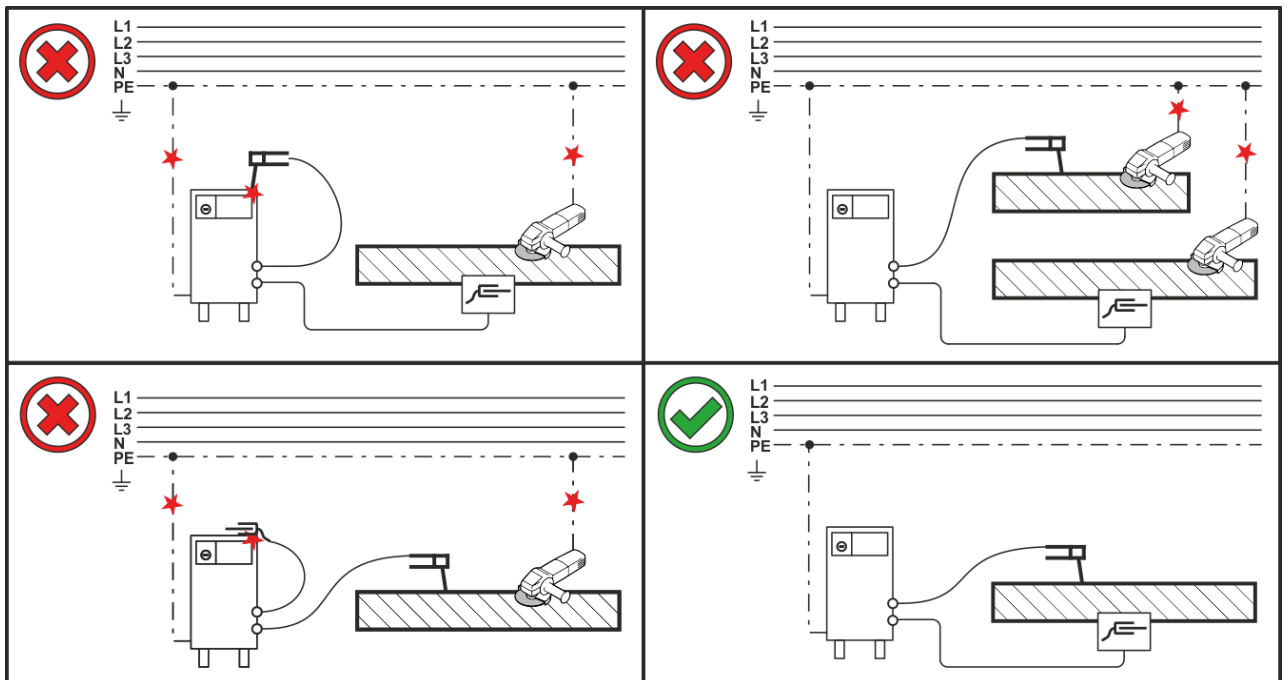


Figure 5-8

5.3 MIG/MAG welding

5.3.1 Welding torch connection



Equipment damage due to improperly connected coolant pipes!

If the coolant pipes are not properly connected or a gas-cooled welding torch is used, the coolant circuit is interrupted and equipment damage can occur.

- **Connect all coolant pipes correctly!**
- **Completely unroll the hose package and the torch hose package!**
- **Observe maximal hose package length > see 5.1.3.2 chapter.**
- **When using a gas-cooled welding torch, use a hose bridge to establish the coolant circuit > see 9 chapter.**

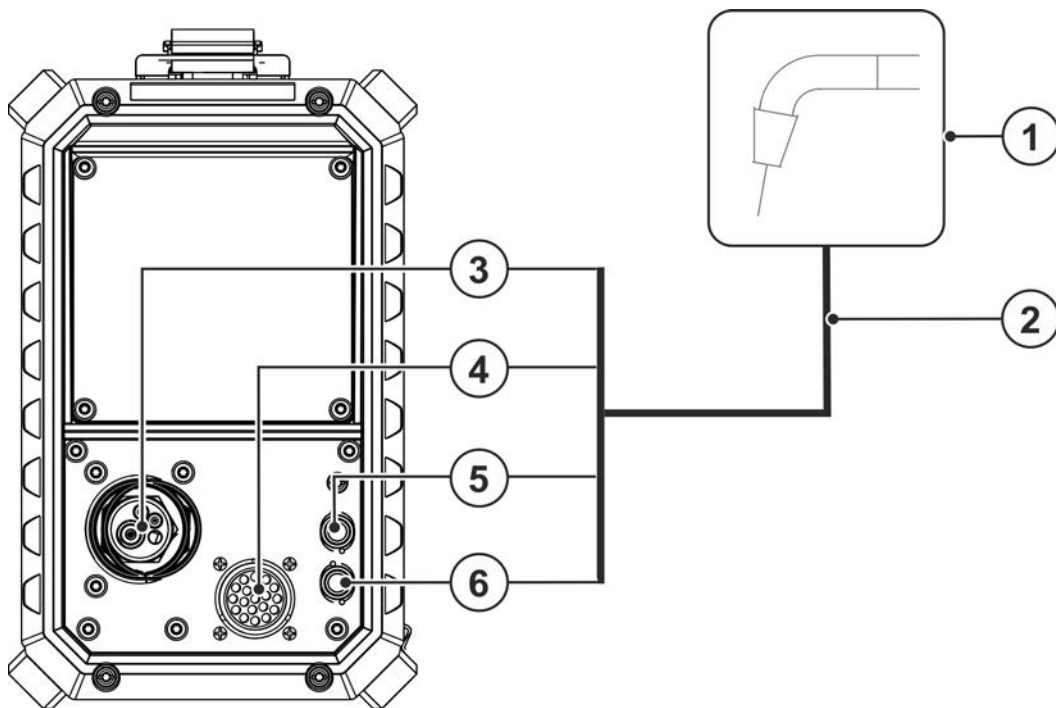


Figure 5-9

| Item | Symbol | Description |
|------|--------|--|
| 1 | | Welding torch |
| 2 | | Welding torch hose package |
| 3 | | Welding torch connection (Euro torch connector) Welding current, shielding gas and torch trigger integrated |
| 4 | | 19-pole connection socket (analogue) For connecting analogue accessory components (remote control, welding torch control lead, etc.) |
| 5 | | Quick connect coupling (red) coolant return |
| 6 | | Quick connect coupling (blue) coolant supply |

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the welding torch control cable into the 19-pole connection socket and lock (MIG/MAG torches with additional control cables only).

Where applicable:

- Lock connecting nipples of the cooling water tubes into the corresponding quick connect couplings: Return line red to quick connect coupling, red (coolant return) and supply line blue to quick connect coupling, blue (coolant supply).

5.4 Assemble the wire guide

The Euro torch connector is factory-fitted with a guide tube for welding torches with steel liner. Conversion is necessary if a welding torch with a steel liner is used!

- Operate welding torches with a liner > with a guide tube!
- Operate welding torches with a steel liner > with a capillary tube!

Depending on the wire electrode diameter or type, either a steel liner or liner with the correct inner diameter must be inserted in the torch!

Recommendation:

- Use a steel liner when welding hard, unalloyed wire electrodes (steel).
- Use a chrome nickel liner when welding hard, high-alloy wire electrodes (CrNi).
- Use a plastic or teflon liner when welding or brazing soft wire electrodes, high-alloy wire electrodes or aluminium materials.

Preparation for connecting welding torches with a spiral guide:

- Check that the capillary tube is correctly positioned in relation to the central connector!

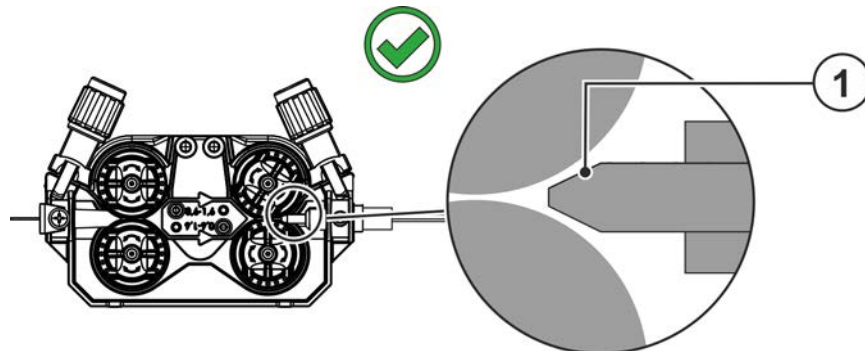


Figure 5-10

Preparation for connecting welding torches with a liner:

- Push forward the capillary tube on the wire feed side in the direction of the Euro torch connector and remove it there.
- Insert the liner guide tube from the Euro torch connector side.
- Carefully insert the welding torch connector with as yet too long a liner into the Euro torch connector and secure with a crown nut.
- Cut off the liner with a liner cutter > see 9 chapter just before the wire feed roller.
- Loosen the welding torch connector and remove.
- Carefully chamfer the cut off end of the liner with a liner sharpener > see 9 chapter and sharpen.

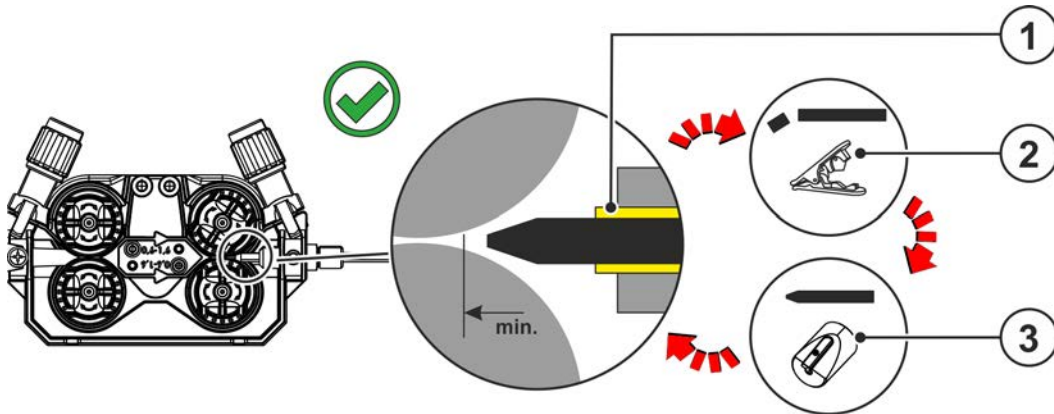


Figure 5-11

5.4.1 Wire feed

⚠ CAUTION



Risk of injury due to moving parts!

The wire feeders are equipped with moving parts, which can trap hands, hair, clothing or tools and thus injure persons!

- Do not reach into rotating or moving parts or drive components!
- Keep casing covers or protective caps closed during operation!



Risk of injury due to welding wire escaping in an unpredictable manner!

Welding wire can be conveyed at very high speeds and, if conveyed incorrectly, may escape in an uncontrolled manner and injure persons!

- Before mains connection, set up the complete wire guide system from the wire spool to the welding torch!
- Check wire guide at regular intervals!
- Keep all casing covers or protective caps closed during operation!

5.4.1.1 Inserting the wire spool

⚠ CAUTION



Risk of injury due to incorrectly secured wire spool.

If the wire spool is not secured properly, it may come loose from the wire spool support and fall to the ground, causing damage to the machine and injuries.

- Make sure to correctly fasten the wire spool to the wire spool support.
- Before you start working, always check the wire spool is securely fastened.

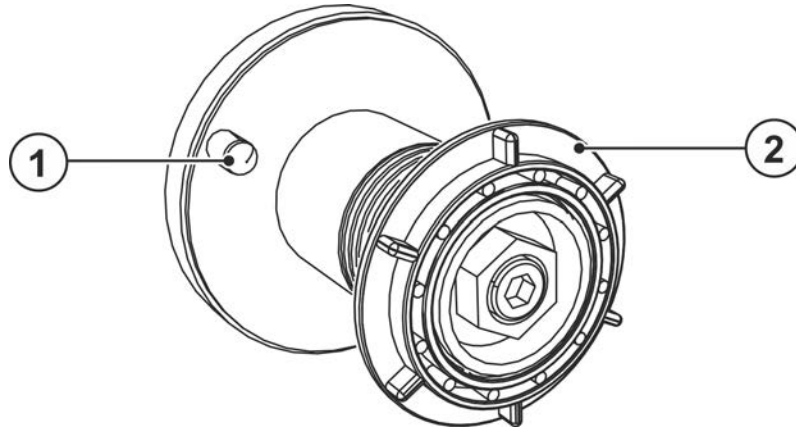


Figure 5-12

| Item | Symbol | Description |
|------|--------|---|
| 1 | | Carrier pin For fixing the wire spool |
| 2 | | Knurled nut For fixing the wire spool |

- Unlock and open protective flap.
- Loosen knurled nut from spool holder.
- Fix welding wire reel onto the spool holder so that the carrier pin locks into the spool bore.
- Fasten wire spool using knurled nut.

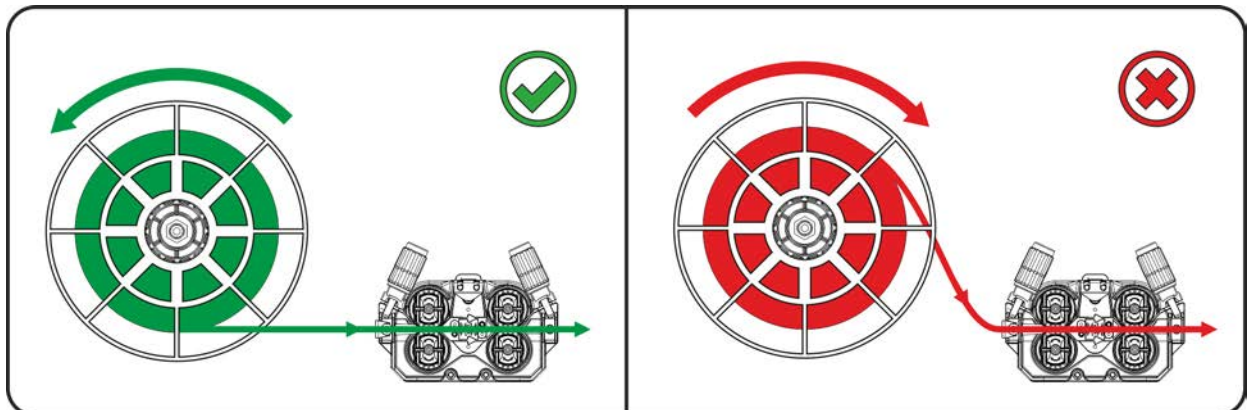


Figure 5-13

Observe the unwinding direction of the wire spool.

5.4.1.2 Changing the wire feed rollers

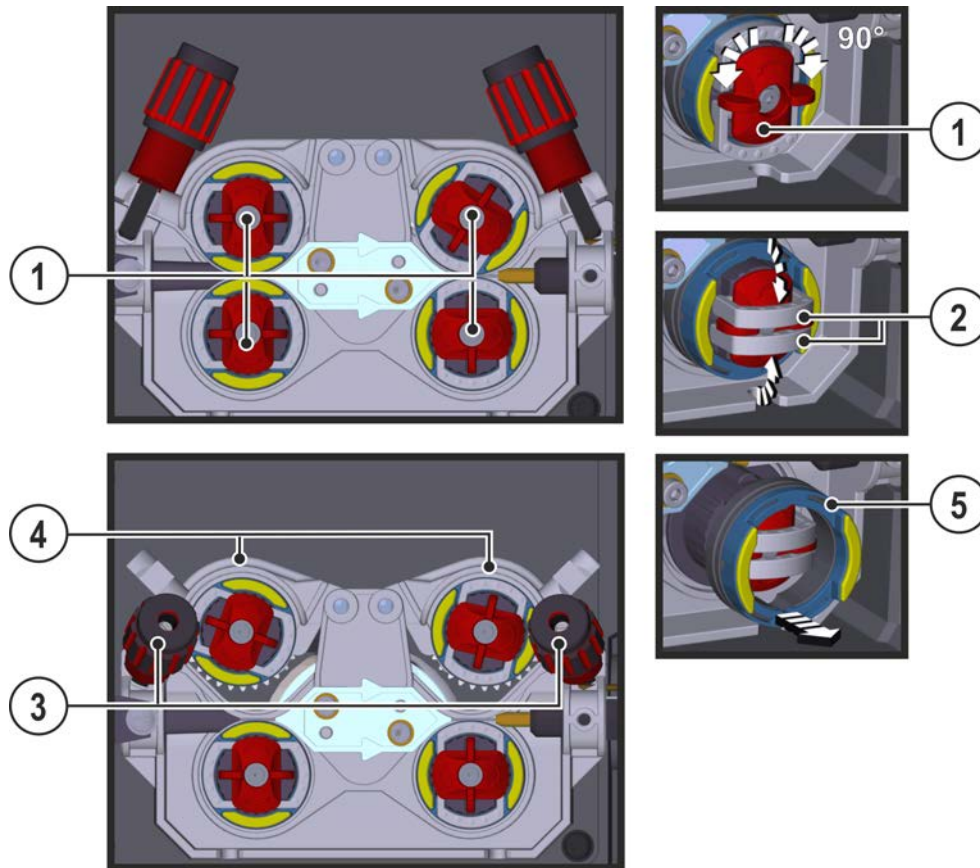


Figure 5-14

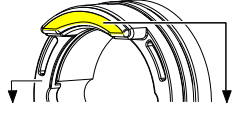
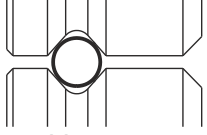
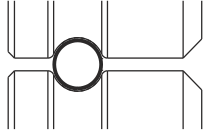
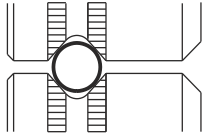
| Item | Symbol | Description |
|------|--------|--|
| 1 | | Tommy The tommy is used to secure the closure brackets of the wire feed rollers. |
| 2 | | Closure bracket The closure brackets are used to secure the wire feed rollers. |
| 3 | | Feed roll tensioner Fixing the clamping unit and setting the pressure. |
| 4 | | Clamping unit |
| 5 | | Wire feed roller see the Wire feed roller overview table |

- Rotate the tommy by 90° clockwise or anti-clockwise (tommy locks into place).
- Fold the closure brackets outwards by 90°.
- Unfasten pressure units and fold out (clamping units and pressure rollers will automatically flip upwards).
- Remove the wire feed rollers from the roller support.
- Select new wire feed rollers according to the Wire feed roller overview table and reassemble the wire feed mechanism in reverse order.

Unsatisfactory welding results due to faulty wire feeding!

The wire feed rolls must be suitable for the diameter of the wire and the material. The wire feed rolls are colour-coded to facilitate distinction (see the Wire feed roll overview table). When working with a wire diameter of > 1.6 mm the drive has to be converted for the wire feed kit ON WF 2,0-3,2MM EFEEED > see 10 chapter.

Wire feed roll overview table:

| Material | Diameter | | Colour code |  | | Groove form |
|-------------------------------------|----------|-------------|-------------|--|--------|--|
| | Ø mm | Ø inch | | | | |
| Steel Stainless steel Brazing | 0.6 | .024 | monochrome | light pink | - |  V-groove |
| | 0.8 | .031 | | white | | |
| | 0.8 | .031 | bicolour | white | blue | |
| | 0.9 | .035 | | | | |
| | 1.0 | .039 | | | | |
| | 1.0 | .039 | | blue | red | |
| | 1.2 | .047 | | | | |
| | 1.4 | .055 | monochrome | green | - | |
| | 1.6 | .063 | | black | | |
| | 2.0 | .079 | | grey | | |
| 2.4 | .094 | brown | | | | |
| 2.8 | .110 | light green | | | | |
| 3.2 | .126 | purple | | | | |
| Aluminium | 0.8 | .031 | bicolour | white | yellow |  U-groove |
| | 0.9 | .035 | | blue | | |
| | 1.0 | .039 | | | | |
| | 1.2 | .047 | | red | | |
| | 1.6 | .063 | | black | | |
| | 2.0 | .079 | | grey | | |
| | 2.4 | .094 | | brown | | |
| | 2.8 | .110 | | light green | | |
| | 3.2 | .126 | | purple | | |
| Flux cored wire | 0.8 | .031 | bicolour | white | orange |  V-groove, knurled |
| | 0.9 | .035 | | blue | | |
| | 1.0 | .039 | | | | |
| | 1.2 | .047 | | red | | |
| | 1.4 | .055 | | green | | |
| | 1.6 | .063 | | black | | |
| | 2.0 | .079 | | grey | | |
| | 2.4 | .094 | | brown | | |

5.4.1.3 Inching the wire electrode

⚠ CAUTION



Risk of injury due to welding wire escaping from the welding torch!
 The welding wire can escape from the welding torch at high speed and cause bodily injury including injuries to the face and eyes!

- Never direct the welding torch towards your own body or towards other persons!



Incorrect contact pressure will cause extensive wear of the wire feed rollers!

- With the adjusting nuts of the pressure units set the contact pressure so that the wire electrode is conveyed but will still slip through if the wire spool jams.
- Set the contact pressure of the front rollers (in wire feed direction) to a higher value!

The inching speed is infinitely adjustable by simultaneously pressing the wire inching push-button and turning the wire speed rotary knob. The left display shows the wire feed speed selected, the right display shows the current motor current of the wire feed mechanism. Depending on the design of the device, the wire feed mechanism may be reversed!

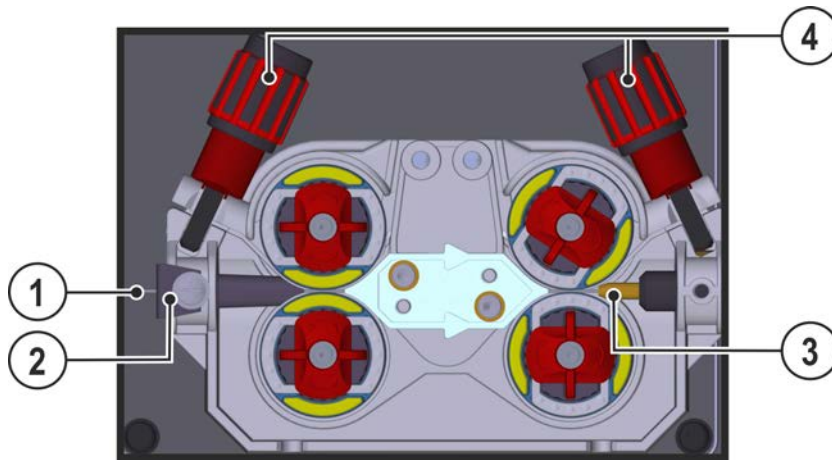


Figure 5-15

| Item | Symbol | Description |
|------|--------|------------------|
| 1 | | Welding wire |
| 2 | | Wire feed nipple |
| 3 | | Guide tube |
| 4 | | Adjusting nut |

- Extend and lay out the torch hose package.
- Carefully unwind the welding wire from the wire spool and insert through the wire feed nipples up to the wire feed rollers.
- Press the inching push-button (the drive catches the welding wire and automatically guides it to the welding torch outlet) > see 4.2 chapter.

A prerequisite for the automatic inching process is the correct preparation of the wire guide, especially in the capillary and wire guide tube area > see 5.3.1 chapter.

- The contact pressure has to be adjusted separately for each side (wire inlet/outlet) at the feed roll tensioner setting nuts depending on the welding consumable used. A table with the setting values can be found on a sticker near the wire drive.

Version 1: left hand mounting

Version 2: right hand mounting

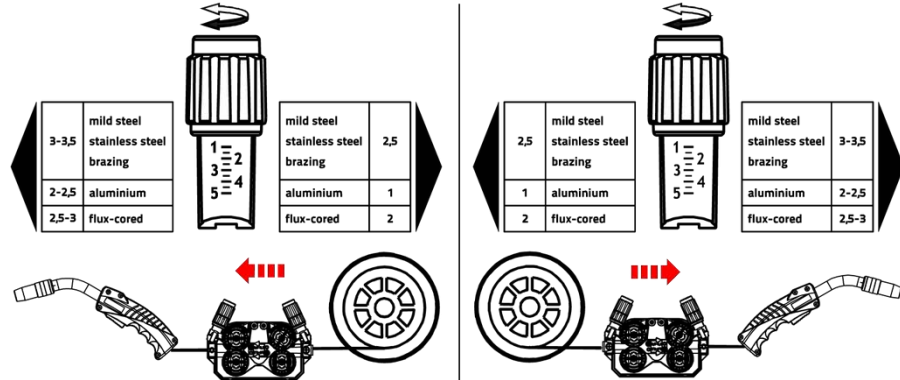


Figure 5-16

Automatic inching stop

Touch the welding torch against the workpiece during inching. Inching of the welding wire will stop as soon it touches the workpiece.

5.4.1.4 Spool brake setting

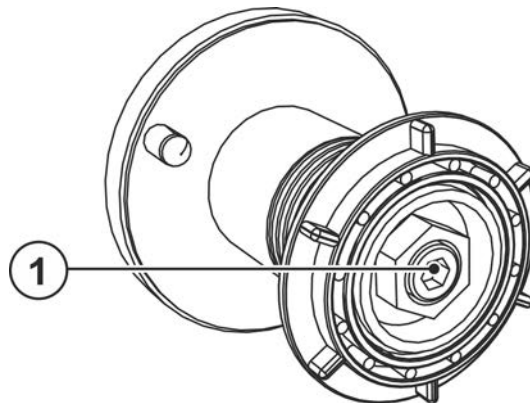


Figure 5-17

| Item | Symbol | Description |
|------|--------|--|
| 1 | | Allen screw Securing the wire spool retainer and adjustment of the spool brake |

- Tighten the Allen screw (8 mm) in the clockwise direction to increase the braking effect.

Tighten the spool brake until the wire spool no longer turns when the wire feed motor stops but without it jamming during operation!

5.5 TIG welding

5.5.1 Welding torch connection

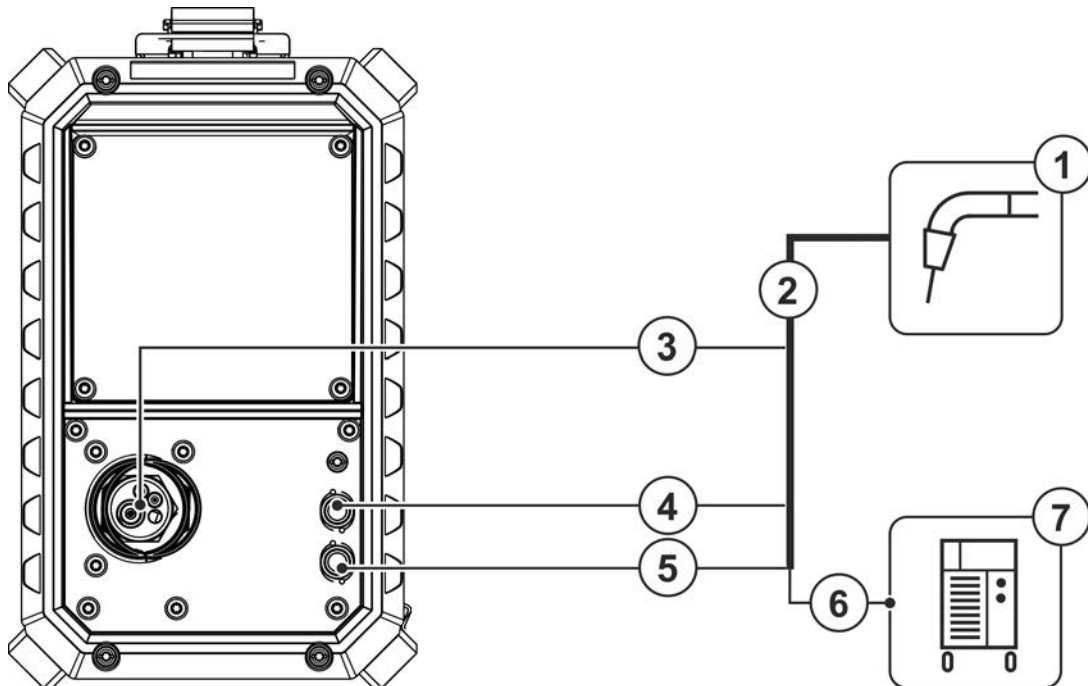


Figure 5-18

| Item | Symbol | Description |
|------|--------|--|
| 1 | | Welding torch |
| 2 | | Welding torch hose package |
| 3 | | Welding torch connection (Euro or Dinse torch connector) Welding current, shielding gas and torch trigger integrated |
| 4 | | Quick connect coupling (red) coolant return |
| 5 | | Quick connect coupling (blue) coolant supply |
| 6 | | "-" welding current connection socket • TIG welding: Welding current connection for welding torch |
| 7 | | Power source |

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the welding current plug of the combi welding torch into the (-) welding current connection socket and lock into place by turning to the right (only in case of a separate welding current connection).

Where applicable:

- Lock connecting nipples of the cooling water tubes into the corresponding quick connect couplings: Return line red to quick connect coupling, red (coolant return) and supply line blue to quick connect coupling, blue (coolant supply).

5.5.2 Welding task selection

For selection of the welding task and for general operation see the relevant Control operating instructions.

5.6 MMA welding or gouging

⚠ CAUTION



Risk from electrical current!

If welding is carried out alternately using different methods and if a welding torch and an electrode holder remain connected to the machine, the open-circuit/welding voltage is applied simultaneously on all cables.

- The torch and the electrode holder should therefore always be placed on an insulated surface before starting work and during breaks.

5.6.1 Connection of electrode holder or gouging torch

The device configuration shown may differ in case of an additional ex works options or retrofitting options > see 9 chapter.

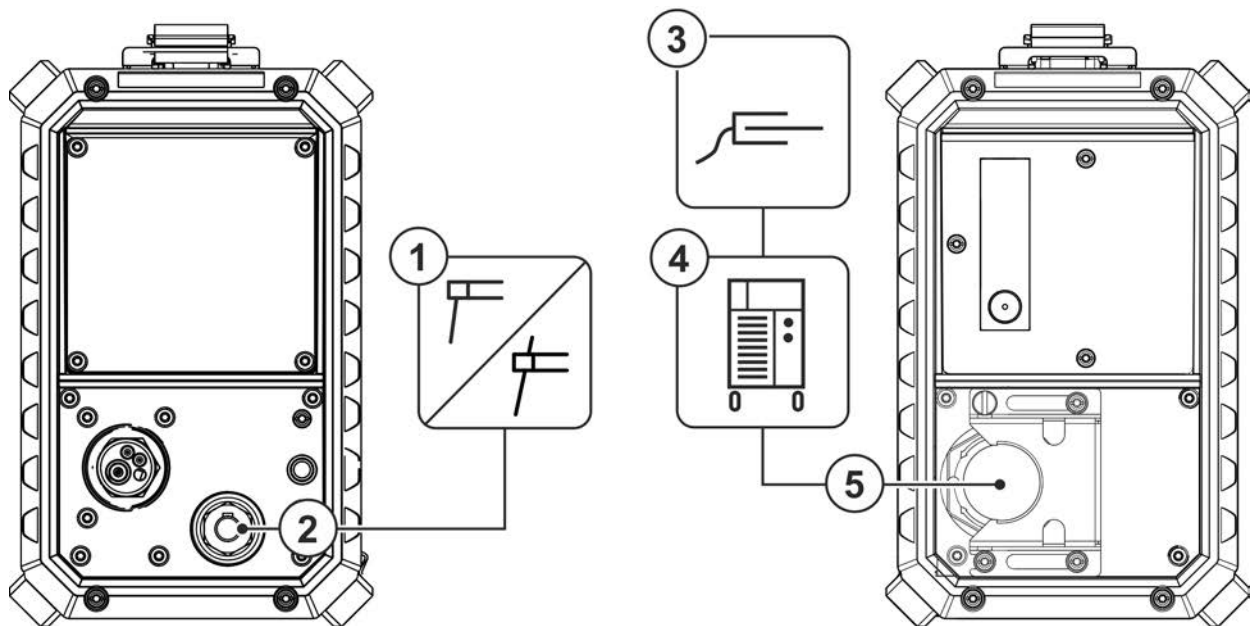


Figure 5-19

| Item | Symbol | Description |
|------|--------|--|
| 1 | | Electrode holder or gouging torch |
| 2 | | Connection socket for welding current - optional Welding current potential of the torch connector for MMA welding or gouging |
| 3 | | Workpiece |
| 4 | | Power source |
| 5 | | Intermediate hose package |

- Insert the electrode holder plug into the welding current connection socket (wire feeder) and lock in place by turning to the right.
- Insert the workpiece lead plug into the "-" welding current connection socket (welding machine) and lock in place by turning to the right.

5.6.2 Welding task selection

For selection of the welding task and for general operation see the relevant Control operating instructions.

5.7 Remote control

The remote controls are operated on the 19-pole remote control connection socket (analogue).

5.8 Access control

To protect against unauthorised or unintentional adjustment of the welding parameters on the machine, the control input can be locked with the aid of a key switch.

In key switch position 1 all functions and parameters can be set without restriction.

In key switch position 0 the following functions and parameters cannot be changed:

- No adjustment of the operating point (welding performance) in programs 1–15.
- No change of welding or operating mode in programs 1–15.
- The welding parameters can be displayed but not changed in the control's function sequence.
- No welding task switching (JOB block operation P16 possible).
- No change of special parameters (except P10). Restart required.

5.9 Interfaces for automation

WARNING



Do not carry out any unauthorised repairs or modifications!

To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!

The warranty becomes null and void in the event of unauthorised interference.

- Appoint only skilled persons for repair work (trained service personnel)!



Accessory components and the power source itself can be damaged by incorrect connection!

- ***Only insert and lock accessory components into the relevant connection socket when the machine is switched off.***
- ***Comprehensive descriptions can be found in the operating instructions for the relevant accessory components.***
- ***Accessory components are detected automatically after the power source is switched on.***

5.9.1 Remote control connection socket, 19-pole

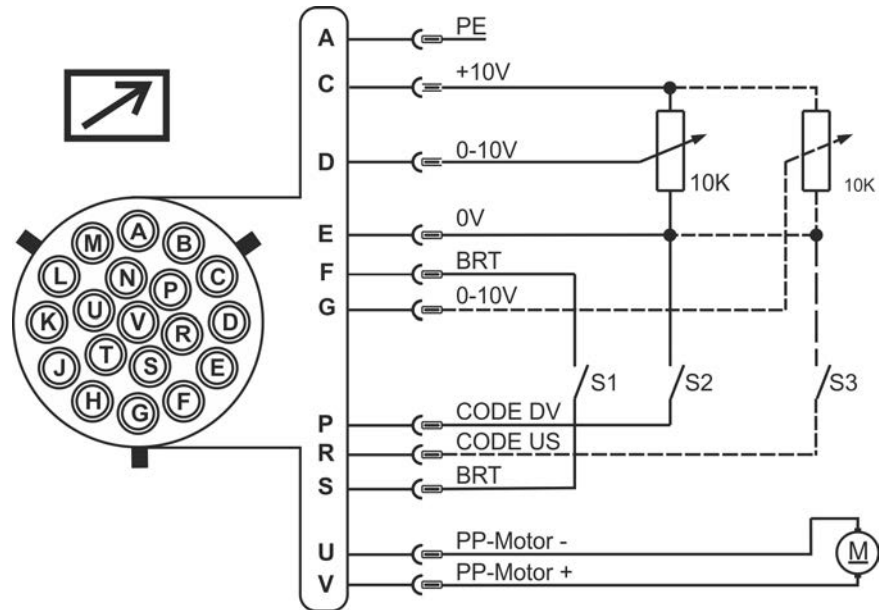


Figure 5-20

| Pin | Signal form | Short description |
|-----|-------------|---|
| A | Output | Connection for PE cable screen |
| C | Output | Reference voltage for potentiometer 10 V (max. 10 mA) |
| D | Input | Control voltage specification (0 V–10 V) – wire feed speed |
| E | Output | Reference potential (0 V) |
| F/S | Input | Welding power start/stop (S1) |
| G | Input | Control voltage specification (0 V–10 V) – arc length correction |
| P | Input | Activation of control voltage specification for wire feed speed (S2) For activation, put signal to reference potential 0 V (pin E) |
| R | Input | Activation of control voltage specification for arc length correction (S3) For activation, put signal to reference potential 0 V (pin E) |
| U/V | Output | Supply voltage push/pull welding torch |

6 Maintenance, care and disposal

6.1 General

DANGER



Risk of injury due to electrical voltage after switching off!

Working on an open machine can lead to fatal injuries!

Capacitors are loaded with electrical voltage during operation. Voltage remains present for up to four minutes after the mains plug is removed.

1. Switch off machine.
2. Remove the mains plug.
3. Wait for at least 4 minutes until the capacitors have discharged!

WARNING



Incorrect maintenance, testing and repair!

Maintenance, testing and repair of the machine may only be carried out by skilled and qualified personnel. A qualified person is one who, because of his or her training, knowledge and experience, is able to recognise the dangers that can occur while testing welding power sources as well as possible subsequent damage, and who is able to implement the required safety procedures.

Observe the maintenance instructions > see 6.2 chapter.

- In the event that the provisions of one of the below-stated tests are not met, the machine must not be operated again until it has been repaired and a new test has been carried out!

Repair and maintenance work may only be performed by qualified authorised personnel; otherwise the right to claim under warranty is void. In all service matters, always consult the dealer who supplied the machine. Return deliveries of defective equipment subject to warranty may only be made through your dealer. When replacing parts, use only original spare parts. When ordering spare parts, please quote the machine type, serial number and item number of the machine, as well as the type designation and item number of the spare part.

Under the specified ambient conditions and normal working conditions this machine is essentially maintenance-free and requires just a minimum of care.

Contamination of the machine may impair service life and duty cycle. The cleaning intervals depend on the ambient conditions and the resulting contamination of the machine. The minimum interval is every six months.

6.1.1 Cleaning

- Clean the outer surfaces with a moist cloth (no aggressive cleaning agents).
- Purge the machine venting channel and cooling fins (if present) with oil- and water-free compressed air. Compressed air may overspeed and destroy the machine fans. Never direct the compressed air directly at the machine fans. Mechanically block the fans, if required.
- Check the coolant for contaminants and replace, if necessary.

6.1.2 Dirt filter

When using a dirt filter, the cooling air throughput is reduced and the duty cycle of the machine is reduced as a result. The duty cycle decreases with the increasing contamination of the filter. The dirt filter must be removed at regular intervals and cleaned by blowing out with compressed air (depending on the level of soiling).

6.2 Maintenance work, intervals

6.2.1 Daily maintenance tasks

Visual inspection

- Mains supply lead and its strain relief
- Gas cylinder securing elements
- Check hose package and power connections for exterior damage and replace or have repaired by specialist staff as necessary!
- Gas tubes and their switching equipment (solenoid valve)
- Check that all connections and wearing parts are hand-tight and tighten if necessary.
- Check correct mounting of the wire spool.
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Other, general condition

Functional test

- Operating, message, safety and adjustment devices (Functional test)
- Welding current cables (check that they are fitted correctly and secured)
- Gas tubes and their switching equipment (solenoid valve)
- Gas cylinder securing elements
- Check correct mounting of the wire spool.
- Check that all screw and plug connections and replaceable parts are secured correctly, tighten if necessary.
- Remove any spatter.
- Clean the wire feed rollers on a regular basis (depending on the degree of soiling).

6.2.2 Monthly maintenance tasks

Visual inspection

- Casing damage (front, rear and side walls)
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Check coolant tubes and their connections for impurities

Functional test

- Selector switches, command devices, emergency stop devices, voltage reducing devices, message and control lamps
- Check wire guide elements (wire feed roll holder, wire feed nipple, wire guide tube) for tight fit. Recommendation for replacing the wire feed roll holder (eFeed) after 2000 hours of operation, see replacement parts).
- Check coolant tubes and their connections for impurities
- Check and clean the welding torch. Deposits in the torch can cause short circuits and have a negative impact on the welding result, ultimately causing damage to the torch.

6.2.3 Annual test (inspection and testing during operation)

A periodic test according to IEC 60974-4 "Periodic inspection and test" has to be carried out. In addition to the regulations on testing given here, the relevant local laws and regulations must also be observed.

For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

6.3 Disposing of equipment



Proper disposal!

The machine contains valuable raw materials, which should be recycled, and electronic components, which must be disposed of.

- **Do not dispose of in household waste!**
- **Observe the local regulations regarding disposal!**
- According to European provisions (Directive 2012/19/EU on Waste of Electrical and Electronic Equipment), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.
This machine has to be disposed of, or recycled, in accordance with the waste separation systems in use.
- According to German law (law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment (ElektroG)), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.
- Information about returning used equipment or about collections can be obtained from the respective municipal administration office.
- In addition to this, returns are also possible throughout Europe via EWM sales partners.


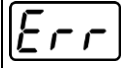
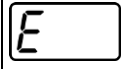
7 Rectifying faults

All products are subject to rigorous production checks and final checks. If, despite this, something fails to work at any time, please check the product using the following flowchart. If none of the fault rectification procedures described leads to the correct functioning of the product, please inform your authorised dealer.

7.1 Error messages (power source)

The possible error numbers displayed depend on the machine series and version!

Depending on the options of the machine display, a fault is shown as follows:

| Display type - machine control | Display |
|--------------------------------|---|
| Graphic display |  |
| two 7-segment displays |  |
| one 7-segment display |  |

The possible cause of the fault is signalled by a corresponding fault number (see table). In the case of an error, the power unit shuts down.

- Document machine errors and inform service staff as necessary.
- If multiple errors occur, these are displayed in succession.
- Document machine warning and inform service personnel, if required.
- If there are several errors in a control system, the error with the lowest error number (Err) is displayed. If this error is corrected, the next higher error number appears. This process is repeated until all errors have been resolved.

Reset error (category legend)



^A The error message disappears when the error is eliminated.

^B The error message can be reset by pressing a push-button ◀.

All other error messages can only be reset by switching the machine off and on again.

| Error (category) | Possible cause | Remedy |
|-----------------------------------|---------------------------------------|---|
| 3 ^{A, B} Tacho error | Wire feed unit interference | Check connections (connections, pipes). |
| | Permanent overload of the wire drive. | Do not place the liner in tight radii. Check liner for smooth movement. |
| 4 ^A Excess temperature | Power source overheated | Allow the switched on machine to cool down. |
| | Fan blocked, dirty or defective. | Check fan and clean or replace. |
| | Air inlet or outlet blocked. | Check air inlet and outlet. |
| 5 Mains overvoltage | Mains voltage too high | Check the mains voltages and compare with the power source connection voltages. |
| 6 Mains undervoltage | Mains voltage too low | |

| Error (category) | Possible cause | Remedy |
|---|---|---|
| 7 ^B Low coolant level | low flow rate | Fill coolant. |
| | | Check coolant flow - remove kinks in hose package. |
| | | Adjust flow threshold. ^[1] ^[3] |
| | | Clean water block. |
| | Pump does not turn | Turn the pump shaft. |
| | Air in the coolant circuit | Vent coolant circuit. |
| | Hose package not completely filled with coolant. | Switch the machine off and on again > pump running > filling process. |
| Operation with gas-cooled welding torch. | Deactivate torch cooling. | |
| | Connecting coolant feed and return to hose bridges. | |
| Failure of automatic circuit-breaker ^[2] | Reset automatic circuit-breaker. | |
| 8 ^{A, B} Shielding gas error | No shielding gas | Check shielding gas supply. |
| | Pre-pressure too low. | Remove kinks in the hose package (nominal value: 4-6 bar pre-pressure). |
| 9 Overvoltage on secondary | Overvoltage at output: Inverter error | Request service. |
| 10 Earth fault (PE error) | Connection between welding wire and machine casing | Remove electrical connection. |
| 11 ^{A, B} Fast shut-down | Removing the logical signal "robot ready" during the process. | Eliminate errors on the higher-level control. |
| 16 ^A General pilot arc | Emergency stop circuit error | Check emergency stop circuit. |
| | Temperature error | See description of error 4. |
| | Short circuit on welding torch | Check welding torch. |
| | Request service | |
| 17 ^B Cold wire error | See description of error 3. | See description of error 3. |
| 18 ^B Plasma gas error | Low gas level | See description of error 8. |
| 19 ^B Shielding gas error | Low gas level | See description of error 8. |
| 20 ^B Low coolant level | see description of error 7. | See description of error 7. |
| 22 ^A Excess coolant temperature ^[1] | Coolant overheated ^[3] | Allow the switched on machine to cool down. |
| | Fan blocked, dirty or defective. | Check fan and clean or replace. |
| | Air inlet or outlet blocked. | Check air inlet and outlet. |
| 23 ^A Excess temperature of the HF choke | External XF ignition unit overheated | Allow the switched on machine to cool down. |
| 24 ^B Pilot arc ignition error | Pilot arc cannot ignite. | Check welding torch equipment. |
| 25 ^B Forming gas error | Low gas level | See description of error 8. |
| 26 ^A Excess pilot arc module temperature | Pilot arc module overheated | See description of error 4. |
| 32 Error I>0 ^[1] | Current recording faulty | Request service. |

| Error (category) | Possible cause | Remedy |
|---|---|--|
| 33 Error UIST ^[1] | Voltage recording faulty | Eliminate short circuit in welding circuit. |
| | | remove external sensor voltage. |
| | | Request service. |
| 34 Electronics error | A/D-channel error | Switch the machine off and on again. |
| | | Request service. |
| 35 Electronics error | Slope error | Switch the machine off and on again. |
| | | Request service. |
| 36  -Error |  -Conditions violated. | Switch the machine off and on again. |
| | | Request service. |
| 37 Electronics error | Temperature error | Allow the switched on machine to cool down. |
| 38 Error IIST ^[1] | Short circuit in welding circuit before welding. | Eliminate short circuit in welding circuit. |
| | | Request service. |
| 39 Electronics error | Secondary overvoltage | Switch the machine off and on again. |
| | | Request service. |
| 40 Electronics error | I>0 error | Request service. |
| 47 ^B Bluetooth error | - | Observe accompanying documentation for Bluetooth function. |
| 48 ^B Ignition error | no ignition at process start (automated machines). | Check wire feeding |
| | | Check load cable connections in welding current circuit. |
| | | clean corroded surfaces on work-piece before welding if necessary. |
| 49 ^B Arc interruption | An arc interruption occurred during welding with an automated system. | Check wire feeding. |
| | | Adjust welding speed. |
| 50 ^B Program number | Internal error | Request service. |
| 51 ^A Emergency stop | The emergency stop circuit of the power source has been activated. | Disable the activation of the emergency stop circuit (release protective circuit). |
| 52 No wire feeder | After switching on the automated system, no wire feeder (DV) was detected. | Check or connect the control lines of the wire feeders; |
| | | Check the identification number of the automated wire feeder (for 1DV: number 1, for 2DV: each a wire feeder with number 1 and a wire feeder with number 2). |
| 53 ^B No wire feeder 2 | Wire feeder 2 not detected. | Check control cable connections. |
| 54 VRD error | Open circuit voltage reduction error. | if necessary, disconnect external machine from the welding circuit. |
| | | Request service. |
| 55 ^B Excess wire feeder current | Excess current detected on wire feed mechanism. | Do not place the liner in tight radii. |
| | | Check liner for smooth movement. |

| Error (category) | Possible cause | Remedy |
|------------------------------------|---|--|
| 56 Mains phase failure | One phase of the mains voltage has failed. | Check mains connection, mains plug and mains fuses. |
| 57 ^B Slave tacho error | Wire feeder fault (slave drive). | Check connectors, cables, connections. |
| | Permanent overload of the wire drive (slave drive). | Do not place the liner in tight radii. Check liner for smooth movement. |
| 58 ^B Short circuit | Check welding circuit for short circuit. | Check welding current circuit. |
| | | Place welding torch on an insulated surface. |
| 59 Incompatible machine | A machine connected to the system is not compatible. | Disconnect incompatible machine from system. |
| 60 Incompatible software | A machine's software is not compatible. | Request service. |
| 61 Welding monitor | The actual value of a welding parameter is outside the specified tolerance field. | Observe tolerance fields. |
| | | Adjust welding parameters. |
| 62 System component ^[1] | System component not found. | Request service. |
| 63 Mains voltage error | Operating and mains voltage are incompatible | Check or adjust operating and mains voltage |


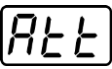
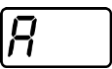
^[1] only for XQ. machine series

^[2] not for XQ. machine series

^[3] See technical data for values and other switching thresholds > see 8 chapter.

7.2 Warnings

Depending on the display options of the machine display, a warning message is displayed as follows:

| Display type - machine control | Display |
|--------------------------------|---|
| Graphic display |  |
| two 7-segment displays |  |
| one 7-segment display |  |

The cause of the warning is indicated by a corresponding warning number (see table).

- In case of multiple warnings, these are displayed in sequence.
- Document machine warning and inform service personnel, if required.

| Warning | Possible cause / remedy |
|---------------------------------|---|
| 1 Excess temperature | A shutdown is imminent due to excess temperature. |
| 2 Half-wave failures | Check process parameters. |
| 3 Welding torch cooling warning | Check coolant level and top up if necessary. |
| 4 Shielding gas | Check shielding gas supply. |
| 5 Coolant flow | Check min. flow rate. ^[2] |
| 6 Wire reserve | Only a small amount of wire is left on the spool. |
| 7 CAN-bus failure | Wire feeder not connected, automatic circuit-breaker of wire feed motor (reset the tripped automatic circuit-breaker by actuating). |

| Warning | | Possible cause / remedy |
|---------|--|--|
| 8 | Welding circuit | The welding circuit inductance is too high for the selected welding task. |
| 9 | WF configuration | Check WF configuration. |
| 10 | Partial inverter | One of several partial inverters is not supplying welding current. |
| 11 | Excess temperature, coolant ^[1] | Check temperature and switching thresholds. ^[2] |
| 12 | Welding monitor | The actual value of a welding parameter is outside the specified tolerance field. |
| 13 | Contact error | The resistance in the welding circuit is too high. Check earth connection. |
| 14 | Adjustment error | Switch the machine off and on. If the error persists, notify Service. |
| 15 | Mains fuse | The power limit of the mains fuse is reached and the welding power is reduced. Check the fuse setting. |
| 16 | Protective gas warning | Check the gas supply. |
| 17 | Plasma gas warning | Check the gas supply. |
| 18 | Forming gas warning | Check the gas supply. |
| 19 | Gas warning 4 | reserved |
| 20 | Coolant temperature warning | Check coolant level and top up if necessary. |
| 21 | Excess temperature 2 | reserved |
| 22 | Excess temperature 3 | reserved |
| 23 | Excess temperature 4 | reserved |
| 24 | Coolant flow warning | Check coolant supply. Check coolant level and top up if necessary. Check flow and switching thresholds. ^[2] |
| 25 | Flow 2 | reserved |
| 26 | Flow 3 | reserved |
| 27 | Flow 4 | reserved |
| 28 | Wire stock warning | Check wire feeding. |
| 29 | Low wire 2 | reserved |
| 30 | Low wire 3 | reserved |
| 31 | Low wire 4 | reserved |
| 32 | Tacho error | Fault of wire feeder - permanent overload of the wire drive. |
| 33 | Wire feed motor excess current | Excess current detected on wire feed motor. |
| 34 | JOB unknown | JOB selection was not performed because the JOB number is unknown. |
| 35 | Wire feed motor slave excess current | Excess current detected on wire feed motor slave (push/push system or intermediate drive). |
| 36 | Slave tacho error | Fault of wire feeder - permanent overload of the wire drive (push/push system or intermediate drive). |
| 37 | FST-bus failure | Wire feeder not connected (reset by actuating the automatic cutout of the wire feed motor). |
| 38 | Incomplete component information | Check XNET component management. |
| 39 | Halfwave failure | Check supply voltage. |

[1] only for XQ machine series

[2] See technical data for values and other switching thresholds > see 8 chapter.

7.3 Checklist for rectifying faults

The correct machine equipment for the material and process gas in use is a fundamental requirement for perfect operation!

| Legend | Symbol | Description |
|--------|--------|-------------|
| | ↯ | Fault/Cause |
| | ✘ | Remedy |

Functional errors

- ↯ Mains fuse triggers - unsuitable mains fuse
 - ✘ Set up recommended mains fuse > see 8 chapter.
- ↯ Machine does not start up after switching on (device fan and possibly coolant pump have no function).
 - ✘ Connect the control cable of the wire feeder.
- ↯ All machine control signal lights are illuminated after switching on
- ↯ No machine control signal light is illuminated after switching on
- ↯ No welding power
 - ✘ Phase failure > check mains connection (fuses)
- ↯ Machine restarts continuously
- ↯ Wire feeder without function
- ↯ System does not start up
 - ✘ Make control lead connections and check that they are fitted correctly.
- ↯ Loose welding current connections
 - ✘ Tighten power connections on the torch and/or on the workpiece
 - ✘ Properly fasten the contact tip and contact tip holder.

Collective interference signal light illuminates

- ↯ Excess temperature, welding machine
 - ✘ Allow the machine to cool down whilst still switched on
- ↯ Welding current monitoring device triggered (stray welding currents flowing across the protective earth). The error must be reset by switching the machine off and on again.
 - ✘ Welding wire is touching electrically conductive casing parts (check wire guide, has the welding wire sprung off the wire spool?).
 - ✘ Check for a correct mounting of the welding lead. Fit the feeder clamp of the welding lead as close as possible to the arc.

Excess temperature signal light illuminates

- ↯ Excess temperature, welding machine
 - ✘ Allow the machine to cool down whilst still switched on

Coolant error/no coolant flowing

- ↯ Insufficient coolant flow
 - ✘ Check coolant level and refill if necessary
- ↯ Air in the coolant circuit
 - ✘ Vent coolant circuit > see 7.4 chapter

Wire feed problems

- ✓ Wire feed roll holder is worn (wire feed rolls must be firmly seated on their holders and must not have any play)
 - ✘ Replace wire feed roll holder (092-002960-E0000) > see 10.1.4 chapter
- ✓ Contact tip blocked
 - ✘ Clean and, if necessary, replace.
- ✓ Setting the spool brake > see 5.4.1.4 chapter
 - ✘ Check settings and correct if necessary
- ✓ Setting pressure units > see 5.4.1.3 chapter
 - ✘ Check settings and correct if necessary
- ✓ Worn wire rolls
 - ✘ Check and replace if necessary
- ✓ Wire feed motor without supply voltage (automatic cutout triggered by overloading)
 - ✘ Reset triggered fuse (rear of the power source) by pressing the key button
- ✓ Kinked hose packages
 - ✘ Extend and lay out the torch hose package
- ✓ Wire guide core or spiral is dirty or worn
 - ✘ Clean core or spiral; replace kinked or worn cores

7.4 Vent coolant circuit

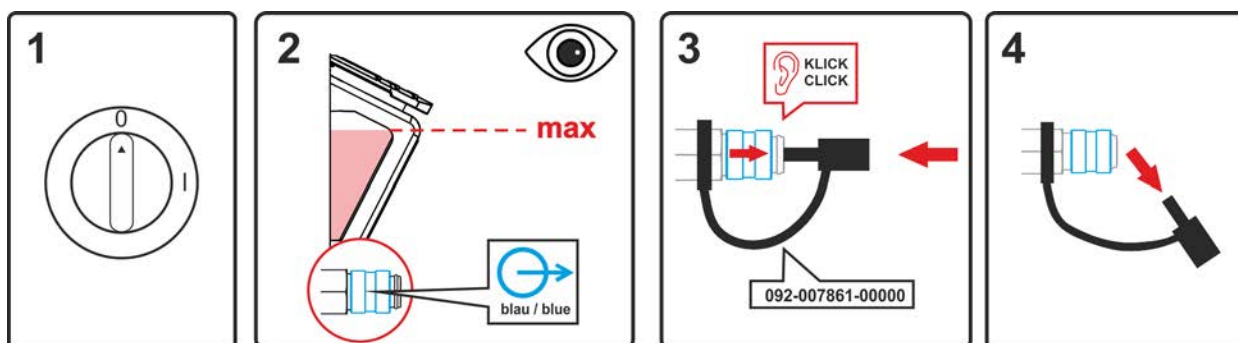


Figure 7-1

- Switch off the machine and fill the coolant tank to the maximum level.
- Unlock the quick-connect coupling with a suitable tool (connection open).

To vent the cooling system always use the blue coolant connection, which is located as deep as possible inside the system (close to the coolant tank)!

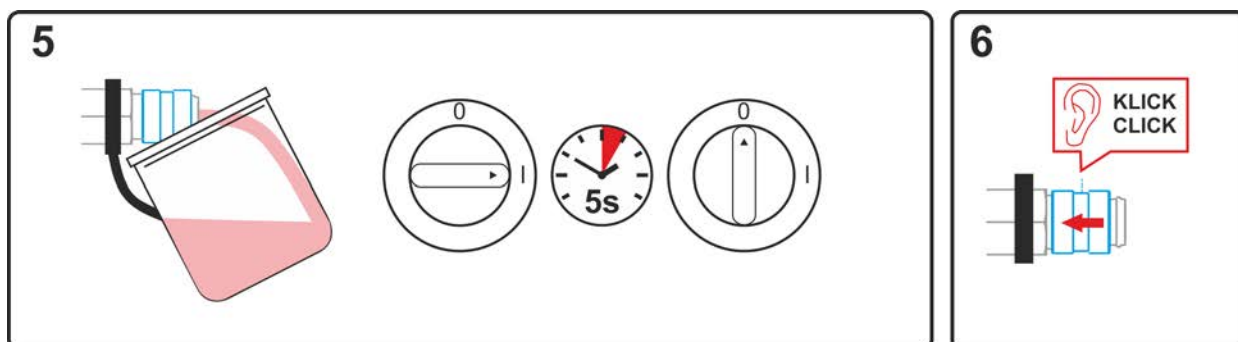


Figure 7-2

- Position a suitable collection container for collecting the escaping coolant at the quick-connect coupling and switch on the machine for approx. 5s.
- Lock the quick-connect coupling by pushing back the locking ring.

8 Technical data

Performance specifications and guarantee only in connection with original spare and replacement parts!

8.1 Drive XQ IC 200

| | |
|---|---|
| Supply voltage (from the welding machine) | 42 VAC |
| Duty cycle DC at 40° C ^[1] | |
| 40 % | 500 A |
| 100 % | 360 A |
| Wire feed speed | 0,5 m/min to 25 m/min |
| Factory-installed roll equipment | 1,0-1,2 mm (for steel wire) |
| Drive | 4 rollers (37 mm) |
| Wire spool diameter | Standardised wire spools up to 200 mm |
| Welding torch connection | Euro torch connector |
| protection classification | IP 23 |
| Ambient temperature ^[2] | -25 °C to +40 °C |
| EMC class | A |
| Safety marking | CE / ENEC |
| Standards used | See declaration of conformity (appliance documents) |
| Dimensions (l x b x h) | 1150 x 678 x 972 mm 45.3 x 26.7 x 38.3 inch |
| Weight | 10,5 kg 23.1 lb. |

^[1] Load cycle: 10 min. (60 % DC \triangleq 6 min. welding, 4 min. pause)

^[2] Ambient temperature dependent on coolant! Observe coolant temperature range!

9 Accessories

Performance-dependent accessories like torches, workpiece leads, electrode holders or intermediate hose packages are available from your authorised dealer.

9.1 General accessories

| Type | Designation | Item no. |
|--|-----------------------------------|------------------|
| DM 842 Ar/CO ₂ 230bar 30l D | Pressure regulator with manometer | 394-002910-00030 |
| HOSE BRIDGE UNI | Tube bridge | 092-007843-00000 |
| DSP | Sharpener for liner | 094-010427-00000 |
| Cutter | Hose cutter | 094-016585-00000 |

9.1.1 Welding torch cooling system

| Type | Designation | Item no. |
|-----------------|-------------|------------------|
| HOSE BRIDGE UNI | Tube bridge | 092-007843-00000 |

9.1.1.1 Coolant - type blueCool

| Type | Designation | Item no. |
|-------------------|------------------------------------|------------------|
| blueCool -10 5 l | Coolant up to -10 °C (14 °F), 5 l | 094-024141-00005 |
| blueCool -10 25 l | Coolant up to -10 °C (14 °F), 25 l | 094-024141-00025 |
| blueCool -30 5 l | Coolant up to -30 °C (22 °F), 5 l | 094-024142-00005 |
| blueCool -30 25 l | Coolant up to -30 °C (22 °F), 25 l | 094-024142-00025 |
| FSP blueCool | Frost protection tester | 094-026477-00000 |

9.1.1.2 Coolant - type KF

| Type | Designation | Item no. |
|------------|-----------------------------------|------------------|
| KF 23E-5 | Coolant up to -10 °C (14 °F), 5 l | 094-000530-00005 |
| KF 23E-200 | Coolant (-10 °C), 200 litres | 094-000530-00001 |
| KF 37E-5 | Coolant up to -20 °C (4 °F), 5 l | 094-006256-00005 |
| KF 37E-200 | Coolant (-20 °C), 200 l | 094-006256-00001 |
| TYP1 | Frost protection tester | 094-014499-00000 |

9.2 19-pole remote control

| Type | Designation | Item no. |
|---------------|---|------------------|
| R10 19POL | Remote control | 090-008087-00000 |
| RG10 19POL 5M | Remote control to set the wire speed and welding voltage correction | 090-008108-00000 |
| R20 19POL | Program changeover remote control | 090-008263-00000 |

9.2.1 Connection cables

| Type | Designation | Item no. |
|----------------|--------------------------------------|------------------|
| RA5 19POL 5M | Remote control e.g. connection cable | 092-001470-00005 |
| RA10 19POL 10m | Remote control e.g. connection cable | 092-001470-00010 |
| RA20 19POL 20m | Remote control e.g. connection cable | 092-001470-00020 |

9.2.2 Extension cable

| Type | Designation | Item no. |
|------------------|-----------------|------------------|
| RV5M19 19POLE 5M | Extension cable | 092-000857-00000 |
| RV5M19 19POL 10M | Extension cable | 092-000857-00010 |
| RV5M19 19POL 15M | Extension cable | 092-000857-00015 |
| RV5M19 19POL 20M | Extension cable | 092-000857-00020 |

9.3 Options

| Type | Designation | Item no. |
|-------------------------------------|--|------------------|
| ON PDM LP-XQ-S D12 | Transparent protective screen for the wire feed controls | 092-004179-00000 |
| ON Cool W D12 | Retrofitting option: Water cooling for the wire feeder | 092-004180-00000 |
| ON FLOWMETER | Option analogue gas flow control with gas flow meter | 092-003374-00000 |
| ON Handle/ON TG D12 | Retrofitting option: Carrying handle and carrying strap | 092-004182-00000 |
| ON WAK 200C/300C | Wheel assembly kit for drive 200C/300C | 092-002550-00000 |
| ON PS Trolley 55-5 / 55-6 drive D12 | Pivot support | 092-004184-00000 |

10 Replaceable parts

Performance specifications and guarantee only in connection with original spare and replacement parts!

10.1 Wire feed rollers

10.1.1 Wire feed rollers for steel wire

| Type | Designation | Item no. |
|--|---|------------------|
| FE 4R 0.6 MM/0.023 INCH LIGHT PINK | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00006 |
| FE 4R 0.8-1.0MM / 0.03-0.04 INCH BLUE/WHITE | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00009 |
| FE 4R 1.0-1.2MM / 0.04-0.045 INCH BLUE/RED | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00011 |
| FE 4R 1.4 MM/0.052 INCH GREEN | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00014 |
| FE 4R 1.6 MM/0.06 INCH BLACK | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00016 |
| FE 4R 2.0 MM/0.08 INCH GREY | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00020 |
| FE 4R 2.4 MM/0.095 INCH BROWN | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00024 |
| FE 4R 2.8 MM/0.11 INCH LIGHT GREEN | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00028 |
| FE 4R 3.2 MM/0.12 INCH VIOLET | Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing | 092-002770-00032 |

10.1.2 Wire feed rollers for aluminium wire

| Type | Designation | Item no. |
|---|--------------------------------------|------------------|
| AL 4R 0.8 MM/0.03 INCH WHITE/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00008 |
| AL 4R 1.0 MM/0.04 INCH BLUE/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00010 |
| AL 4R 1.2 MM/0.045 INCH RED/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00012 |
| AL 4R 1.6 MM/0.06 INCH BLACK/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00016 |
| AL 4R 2.0 MM/0.08 INCH GREY/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00020 |
| AL 4R 2.4 MM/0.095 INCH BROWN/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00024 |
| AL 4R 2.8 MM/0.110 INCH LIGHT GREEN/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00028 |
| AL 4R 3.2 MM/0.125 INCH VIOLET/YELLOW | Drive roll set, 37 mm, for aluminium | 092-002771-00032 |

10.1.3 Wire feed rollers for cored wire

| Type | Designation | Item no. |
|---|--|------------------|
| FUEL 4R 0.8 MM/0.03 INCH WHITE/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00008 |
| FUEL 4R 1.0 MM/0.04 INCH BLUE/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00010 |
| FUEL 4R 1.2 MM/0.045 INCH RED/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00012 |
| FUEL 4R 1.4 MM/0.052 INCH GREEN/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00014 |
| FUEL 4R 1.6 MM/0.06 INCH BLACK/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00016 |
| FUEL 4R 2.0 MM/0.08 INCH GREY/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00020 |
| FUEL 4R 2.4 MM/0.095 INCH BROWN/ORANGE | Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire | 092-002848-00024 |

10.1.4 Wire guide

| Type | Designation | Item no. |
|-----------------------------|---|------------------|
| DV X | Wire feed roll mount set | 092-002960-E0000 |
| SET DRAHTFUERUNG | Wire guide set | 092-002774-00000 |
| ON WF 2,0-3,2mm eFeed | Retrofitting option, wire guide for 2.0–3.2 mm wires, eFeed drive | 092-019404-00000 |
| SET IG 4x4 1.6mm BL | Inlet guide set | 092-002780-00000 |
| GUIDE TUBE L105 | Guide tube | 094-006051-00000 |
| CAPTUB L=107 mm; Ø ≤ 1,6 mm | Capillary tube | 094-006634-00000 |
| CAPTUB L=105 mm; Ø ≤ 2,4 mm | Capillary tube | 094-021470-00000 |

11 Appendix

11.1 Searching for a dealer

Sales & service partners
www.ewm-group.com/en/specialist-dealers



"More than 400 EWM sales partners worldwide"