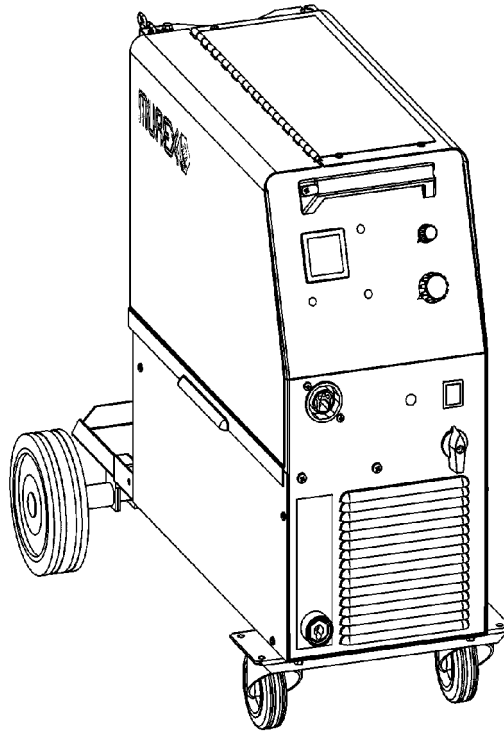


Spare parts list



Valid for serial no. 446/447/448-xxx-xxxx

Ordering number

0349 308 040	Tradesmig 180-1	240V 1~50/60Hz
0349 308 050	Tradesmig 210-1	240V 1~50/60Hz
0349 308 060	Tradesmig 260-1	240V 1~50/60Hz

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

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

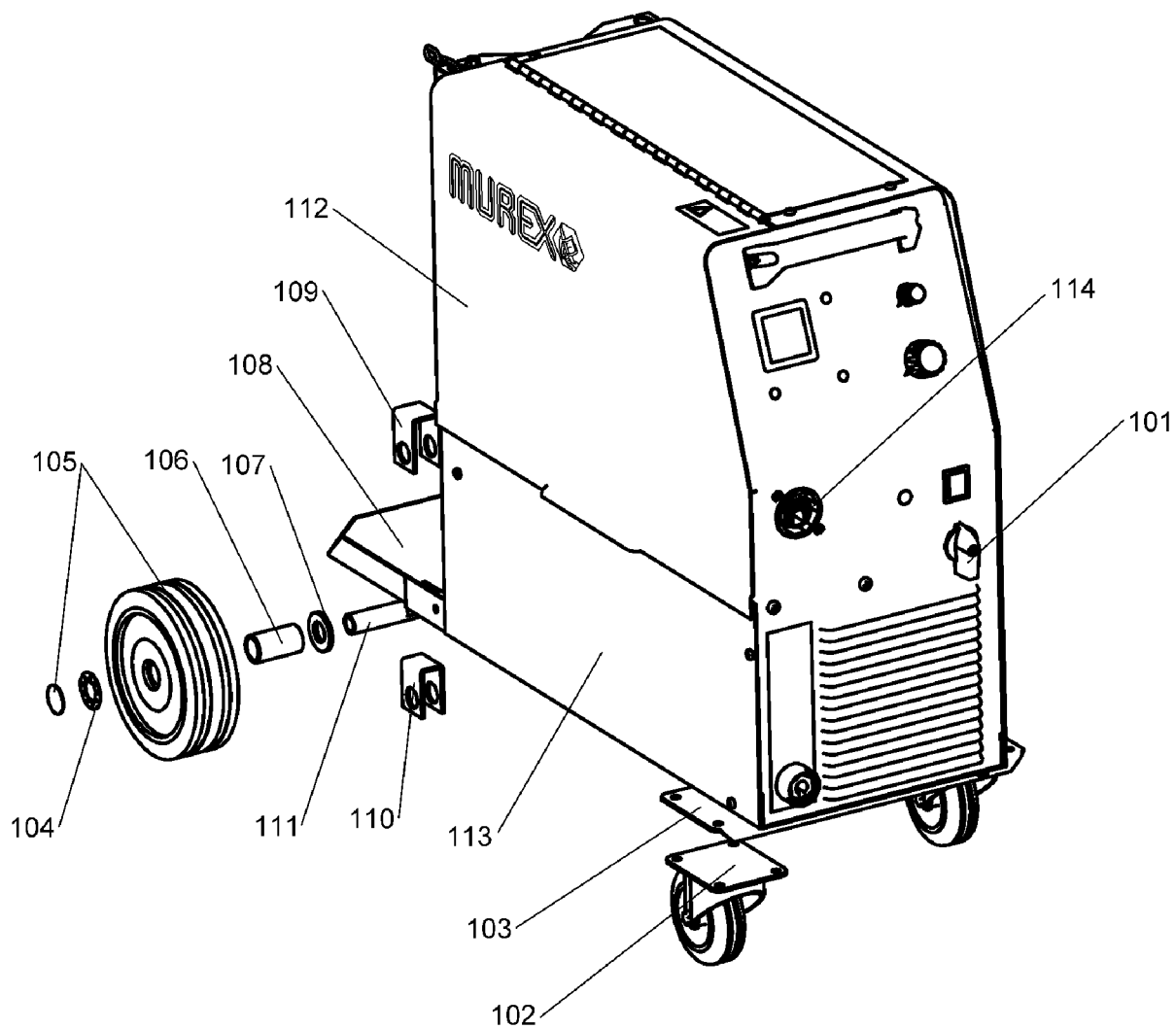
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Tradesmig 180-1/210-1/260-1

(A) = accessory

C = component designation in the circuit diagram

Item	Qty 180-1	Qty 210-1	Qty 260-1	Ordering no.	Denomination	Notes	C
101	1	-	-	0349 304 784	Switch	8 step	QF2
	-	1	-	0349 306 268	Switch	12 step	QF2
	-	-	1	0349 306 269	Switch	12 step	QF2
102	2	2	2	0455 467 001	Link wheel	Ø100	
103	1	1	1	0349 308 225	Bracket		
104	2	2	2	0192 859 126	Locking washer		
105	2	2	2	0455 457 001	Wheel	Ø200	
106	2	2	2	0349 308 228	Sleeve		
107	2	2	2	0349 481 044	Washer	Ø21	
108	1	1	1	0349 308 224	Shelf		
109	2	2	2	0349 308 227	Axle bracket		
110	2	2	2	0349 308 226	Axle bracket		
111	1	1	1	0349 306 773	Axle	Ø20	
112	1	1	1	0349 308 215	Cover cpl.		
113	1	1	1	0349 308 223	Side panel		
114	1	1	1		Wire feed mechanism	See page 16	

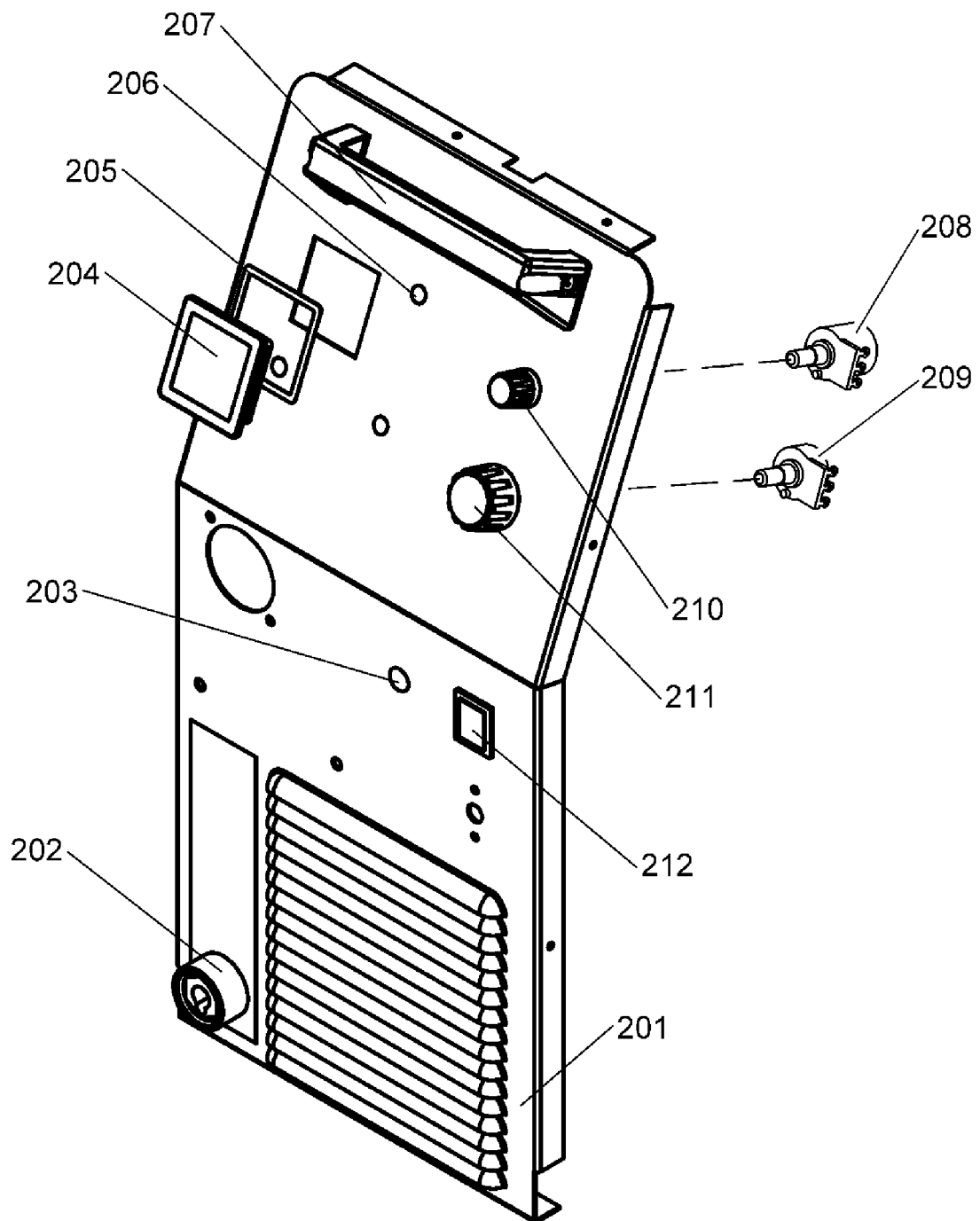


Tradesmig 180-1/210-1/260-1

(A) = accessory

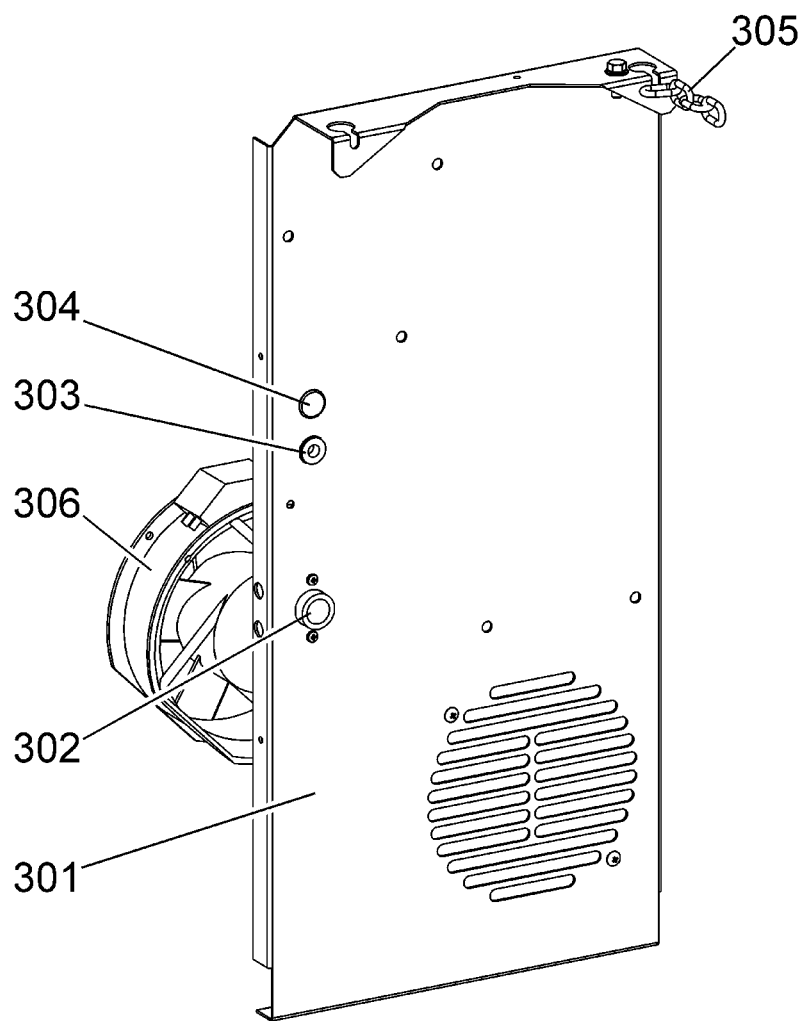
C = component designation in the circuit diagram

Item	Qty 180-1	Qty 210-1	Qty 250-1	Ordering no.	Denomination	Notes	C
201	1	-	-	0349 308 121	Front plate		
	-	1	-	0349 308 099	Front plate		
	-	-	1	0349 308 145	Front plate		
202	-	-	1	0160 362 881	Current terminal		
203	1	1	1	0369 733 005	Signal lamp	orange	VH
204	1	1	1	0455 172 001	Glass		
205	1	1	1	0455 174 001	Seal		
206	3	3	3	0455 226 004	Spacer		
207	1	1	1	0469 437 002	Handle		
208	1	1	-	0349 305 837	Potentiometer cpl.		RP2
	-	-	1	0349 305 973	Potentiometer cpl.		RP2
209	1	1	-	0349 305 836	Potentiometer cpl.		RP1
	-	-	1	0349 305 972	Potentiometer cpl.		RP1
210	1	1	1	0349 302 093	Knob		
211	1	1	1	0191 510 104	Knob		
212	1	1	1	0349 306 518	Switch		QF1 LF1



Tradesmig 180-1/210-1/260-1**(A) = accessory****C = component designation in the circuit diagram**

Item	Qty 180-1	Qty 210-1	Qty 260-1	Ordering no.	Denomination	Notes	C
301	1	1	1	0349 305 670	Rear plate		
302	1	1	1	0349 305 481	Gland with lock		
303	1	1	1	0192 041 119	Grommet	Ø16	
304	1	1	1		Blind plug	Ø13	
305	1	1	1	0321 173 001	Securing chain		
306	1	1	1	0349 483 510	Fan		EV1

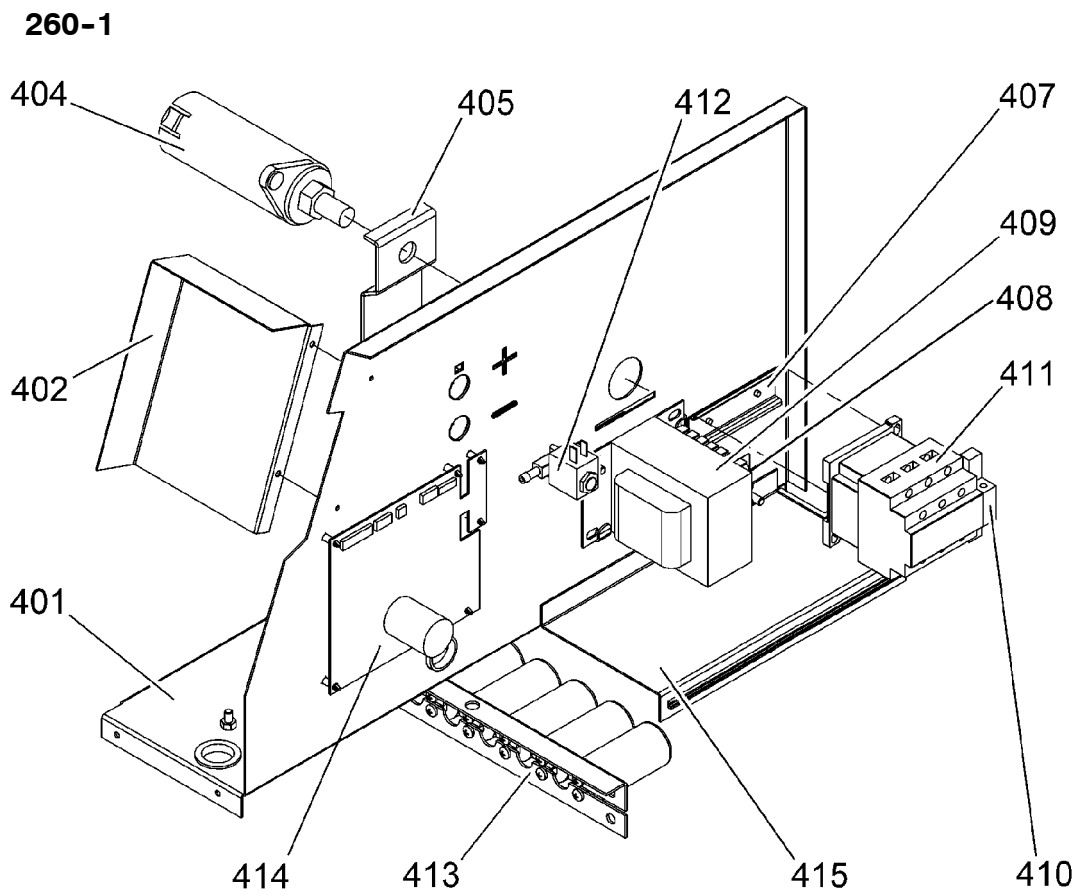
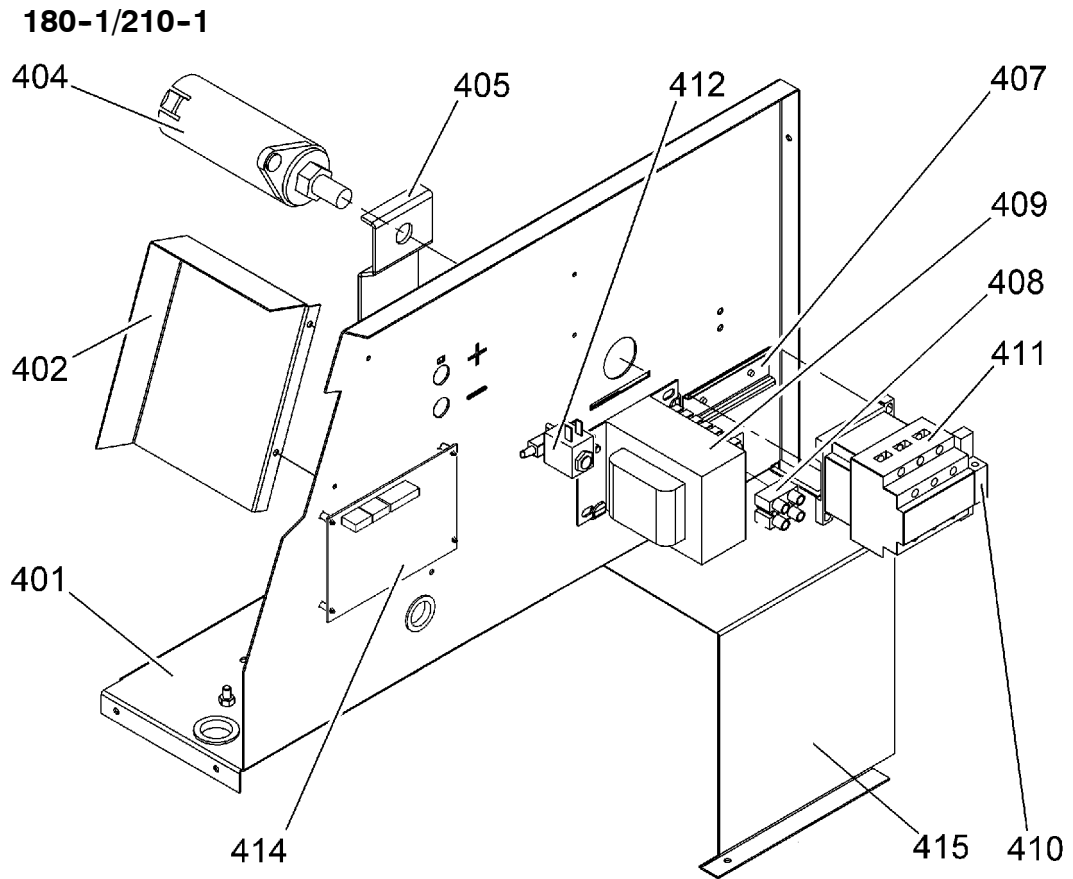


Tradesmig 180-1/210-1/260-1

(A) = accessory

C = component designation in the circuit diagram

Item	Qty 180-1	Qty 210-1	Qty 260-1	Ordering no.	Denomination	Notes	C
401	1	1	1	0349 305 642	Intermediate plate		
402	1	1	1	0349 305 966	Shield		
404	1	1	1	0146 967 881	Brake hub		
405	1	1	1	0349 306 762	Support		
407	1	1	1	0349 302 421	Bracket		
408	1	1	1	0162 781 011	Terminal		XTM
409	1	1	-	0349 310 250	Transformer		TC1
	-	-	1	0455 637 001	Transformer		TC1
410	1	1	1	0349 484 367	Contact block		KM1
411	1	1	-	0349 305 975	Contactactor		KM1
	-	-	1	0349 306 792	Contactactor		KM1
412	1	1	1	0349 483 648	Gas valve		YV1
413	-	-	1	0349 306 204	Capacitor cpl.	Incl. in item 502 (0349 307 946)	C0
414	1	1	-	0349 306 301	Circuit board		AP1
	-	-	1	0487 288 881	Circuit board		AP1
415	1	1	-	0349 305 967	Shield		
	-	-	1	0349 306 246	Shield		



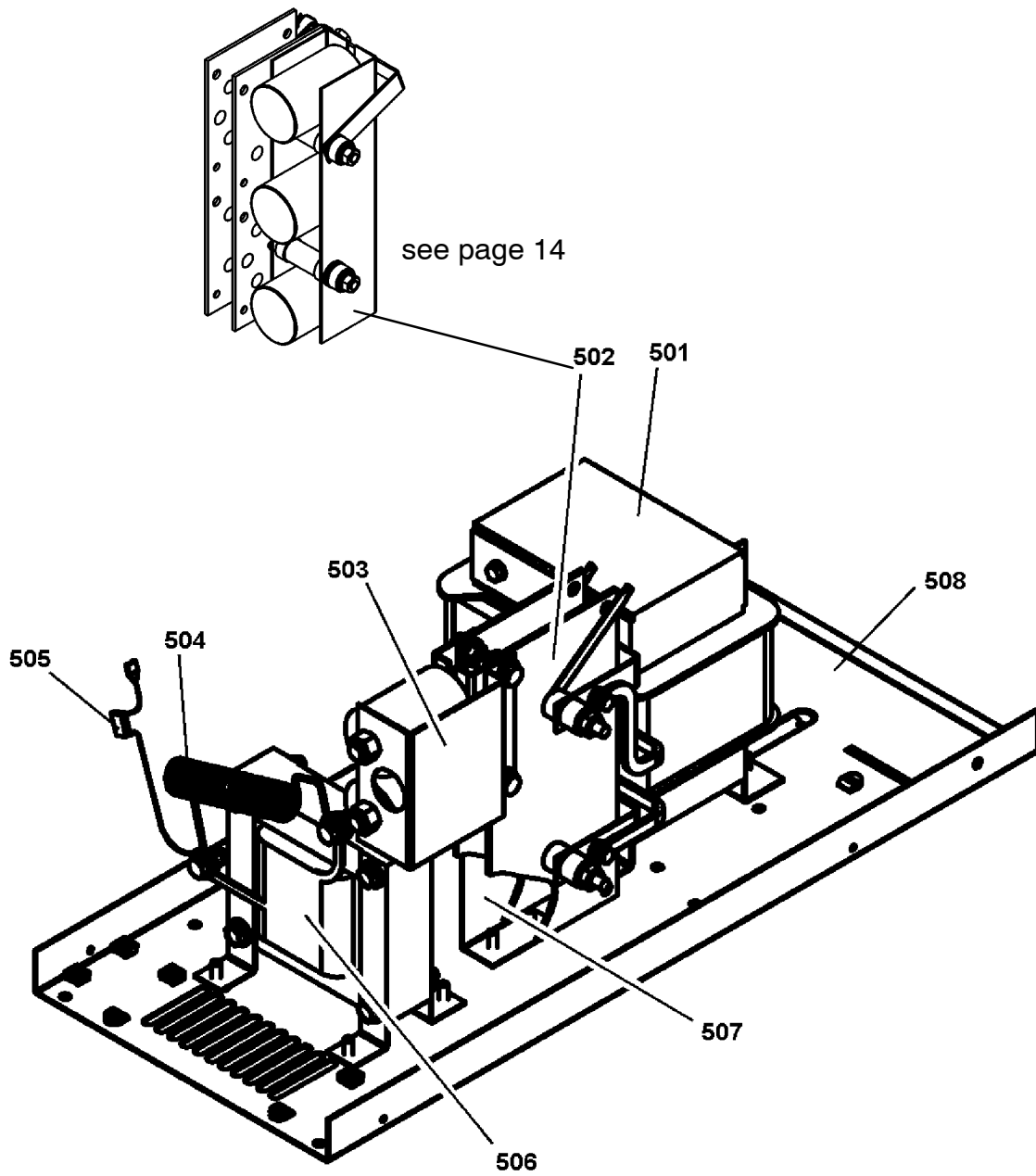
Tradesmig 180-1/210-1/260-1

(A) = accessory

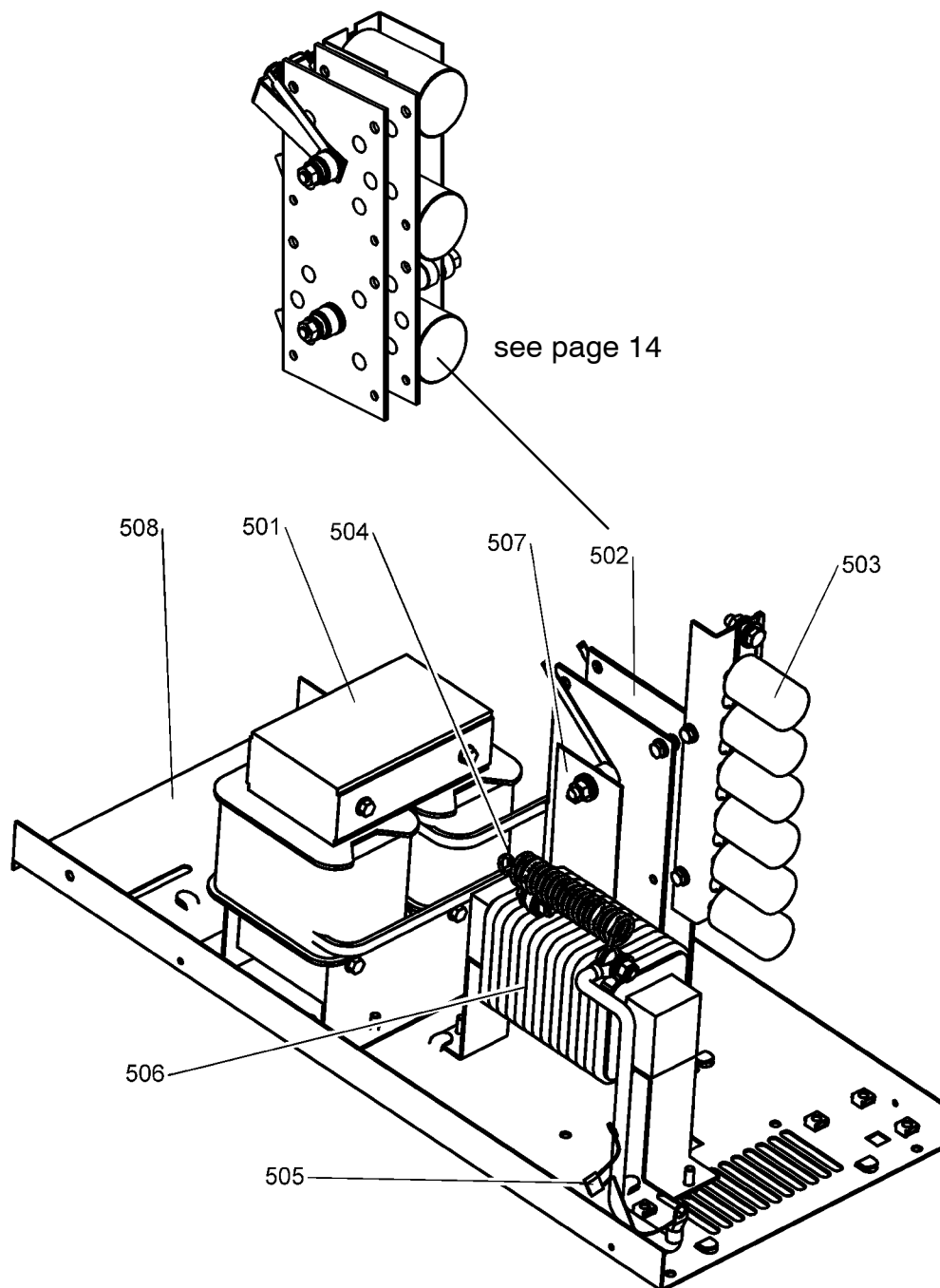
C = component designation in the circuit diagram

Item	Qty 180-1	Qty 210-1	Qty 260-1	Ordering no.	Denomination	Notes	C
501	1	-	-	0349 305 987	Transformer		TM1
	1	-	-	0349 305 915	Transformer with switch		TM1
	-	1	-	0349 305 684	Transformer		TM1
	-	1	-	0349 305 637	Transformer with switch		TM1
	-	-	1	0349 305 993	Transformer		TM1
	-	-	1	0349 305 991	Transformer with switch		TM1
502	1	1	-	0469 662 880	Rectifier brigde	Up to S/N 446-643-0275 (180-1) Up to S/N 447-630-0127 (210-1)	V1
	1	1	-	0349 307 945	Rectifier brigde		V1
	-	-	1	0349 306 841	Rectifier brigde	Up to S/N 448-648-0427	V1
	-	-	1	0349 307 946	Rectifier brigde		V1
503	1	-	-	0349 306 697	Capacitor cpl.	Up to S/N 446-643-0275. From S/N 446-643-0276 incl. in item 502 (0349 307 945)	C0
	-	1	-	0349 307 614	Capacitor cpl.	Up to S/N 447-630-0127. From S/N 447-630-0128 incl. in item 502 (0349 307 945)	C0
504	1	1	1	0349 306 637	Resistor		RL
505	1	1	1	0349 302 352	Capacitor		C1
506	1	-	-	0349 306 488	Inductor		L1
	-	1	-	0349 306 094	Inductor		L1
	-	-	1	0349 305 417	Inductor		L1
507	1	1	-	0349 305 639	Bracket		
	-	-	1	0349 307 453	Bracket		
508	1	1	-	0349 305 633	Bottom plate		
	-	-	1	0349 306 843	Bottom plate		

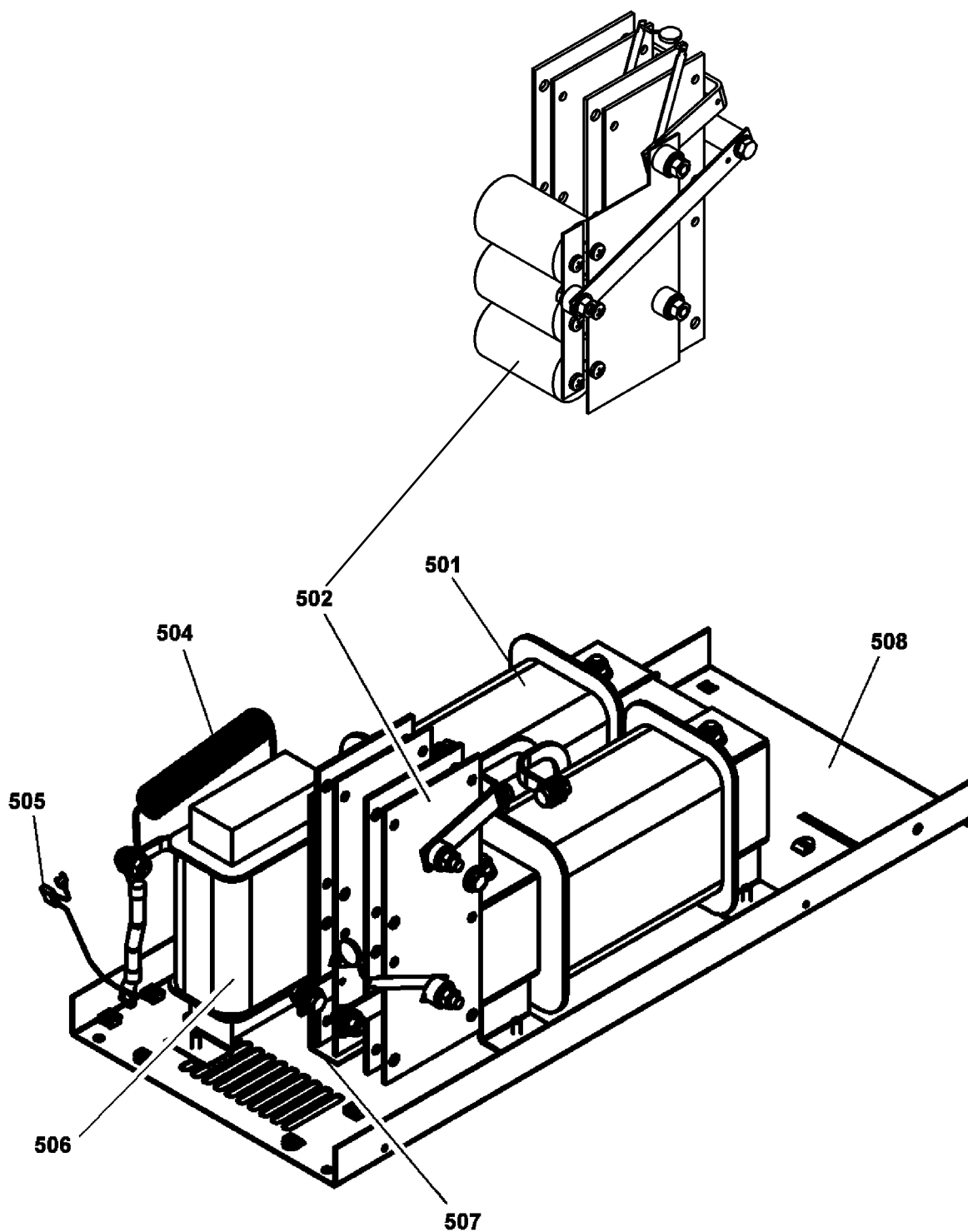
180-1



210-1

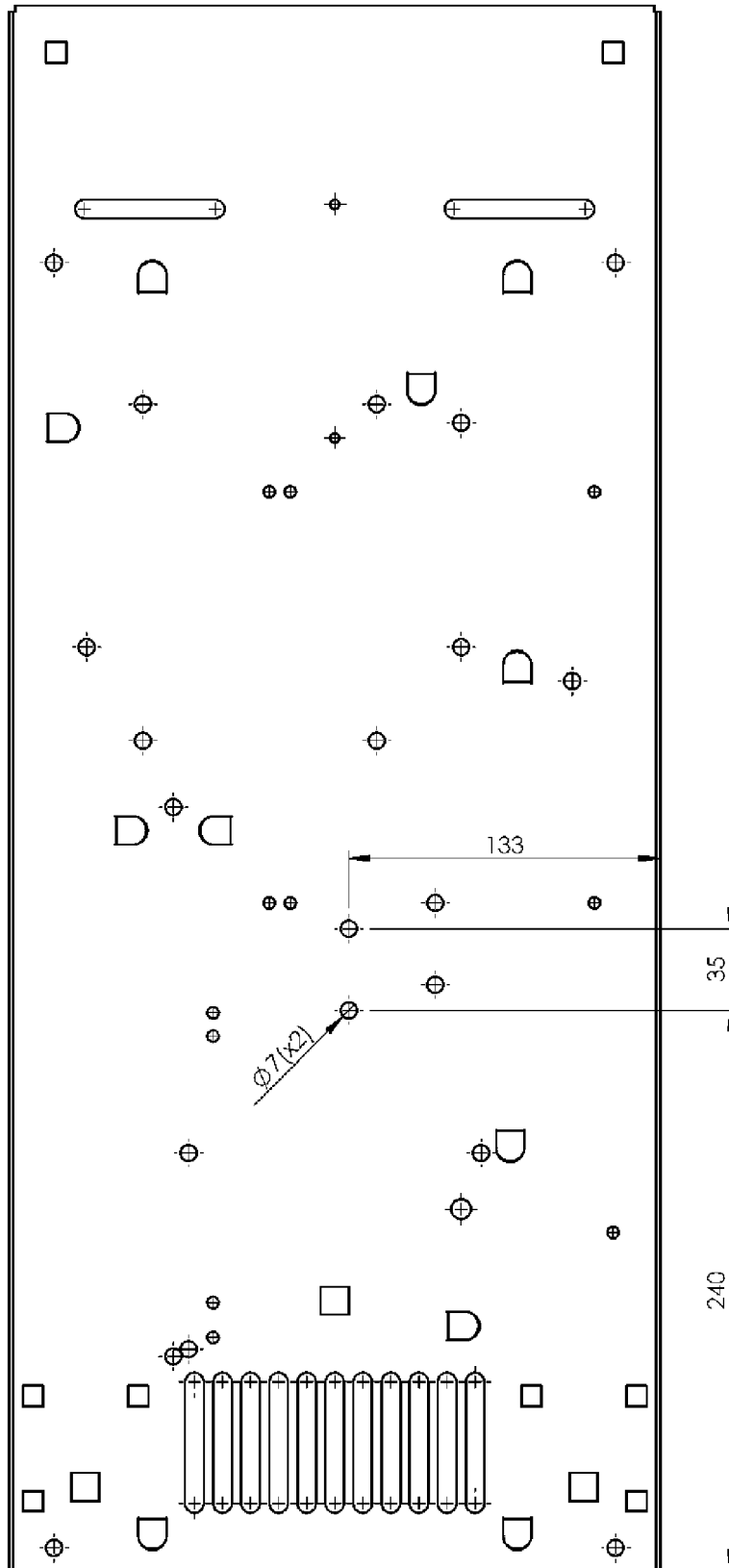


260-1



Tradesmig 180-1/210-1/260-1

If rectifier bridge Item 502 is to be mounted on 180-1 (up to number 446-643-0275), or on 210-1 (up to number 447-630-0127), additional holes must be drilled in bottom plate according to drawing.



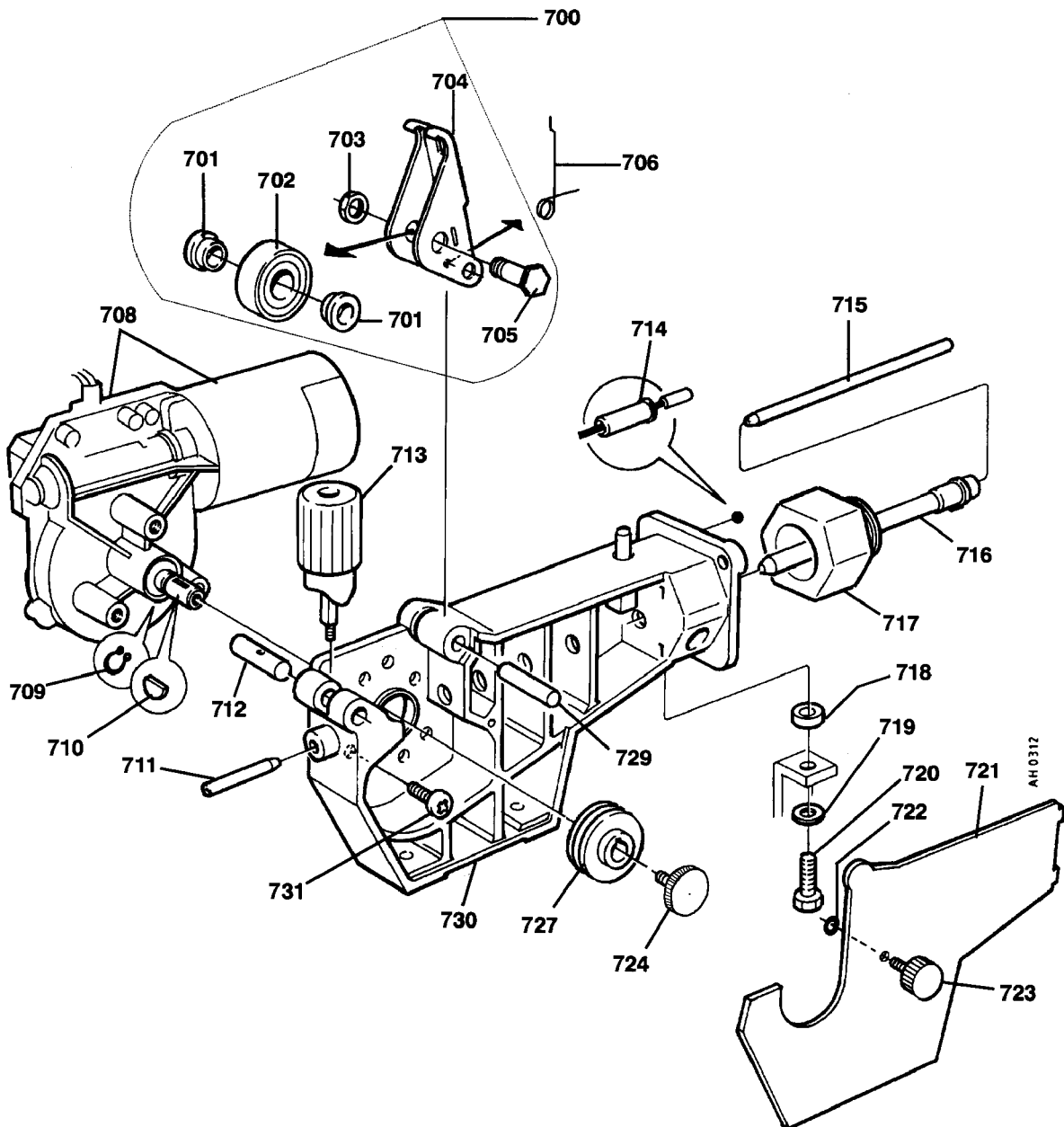
Tradesmig 180-1/210-1/260-1

(A) = accessory
C = component designation in the circuit diagram

Item	Qty 180-1 210-1	Qty 260-1	Ordering no.	Denomination	Notes	C
-	1	-	0455 890 890	Wire feed mechanism	Complete, contains items 701 - 731	
-	-	1	0455 890 882	Wire feed mechanism	Complete, contains items 701 - 731	
700	1	1	0367 529 001	Pressure arm	Complete, contains items 701 - 705	
701	2	2	0455 906 001	Spacer sleeve		
702	1	1	0455 907 001	Pressure roller		
	1	1	0466 262 001	Pressure roller	Knurled	
703	1	1		Nut	SGA D8	
704	1	1		Holder		
705	1	1		Shaft		
706	1	1	0455 896 001	Spring		
708	1	-	0469 397 001	Drive unit		M1
	-	1	0466 489 001	Drive unit		M1
709	1	1	0215 701 007	Locking washer	Included in item 708	
710	1	1	0191 496 114	Key	Included in item 708	
711	1	1	0466 074 001	Inlet nozzle		
712	1	1	0367 528 001	Pin bolt		
713	1	1	0368 749 880	Pressure transducer		
714	2	2	0368 750 001	Insulating sleeve		
715a	1	1	0455 894 001	Insert tube	Plastic, must be used together with item 716a. For welding with Al wire.	
715b	1	1	0455 889 001	Insert tube	Steel, must be used together with item 716b.	
716a	1	1	0455 885 001	Outlet nozzle	Must be used together with item 715a. For welding with Al wire.	
716b	1	1	0455 886 001	Outlet nozzle	Must be used together with item 715b.	
717	1	1	0455 882 001	Current sleeve		
718	1	1	0455 883 001	Spacer sleeve	Ø 16/8.2x0.9	
719	1	1		Washer	Ø 16/8.4x1.5	
720	1	1		Screw	M8x20	
721	1	1	0455 881 001	Protection plate		
722	1	1	0215 201 202	O-ring		
723	1	1		Screw	M5x12	
724	1	1	0349 308 502	Screw	M4x10	
727	1	1	0367 556 001	Feed roller	Ø 0.6-0.8mm Fe, Ss, cored wire.	
	1	1	0367 556 002	Feed roller	Ø 0.8-1.0mm Fe, Ss, cored wire.	
	1	1	0367 556 003	Feed roller	Ø 1.0-1.2mm Fe, Ss, cored wire.	
	1	1	0367 556 004	Feed roller	Ø 1.0-1.2mm Al wire.	
729	1	1	0455 893 001	Shaft		

Tradesmig 180-1/210-1/260-1

Item	Qty 180-1 210-1	Qty 260-1	Ordering no.	Denomination	Notes	C
730	1	1	0455 884 001	Gear housing		
731	3	3		Screw	M6x16	

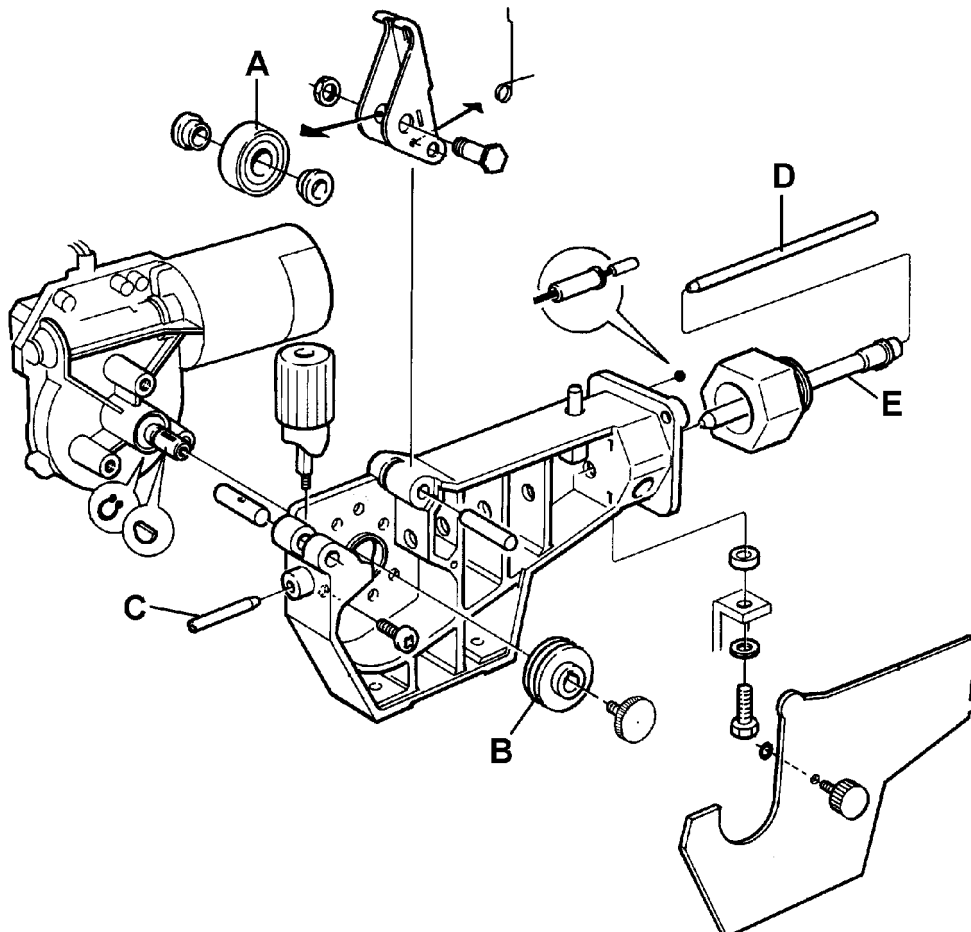


Wear components

(W. F. Mechanism 0455 890 890 / 0455 890 882)

Item	Denomination	Ordering no.	Notes
A	Pressure roller	0455 907 001	
B	Feed roller	0367 556 001	Ø 0.6-0.8mm Fe, Ss, cored wire.
		0367 556 002	Ø 0.8-1.0mm Fe, Ss, cored wire.
		0367 556 003	Ø 1.0-1.2mm Fe, Ss, cored wire.
		0367 556 004	Ø 1.0-1.2mm Al wire.
C	Inlet nozzle	0466 074 001	
D	Insert tube	0455 894 001	Plastic, must be used together with item 0455 885 001, for welding with Al wire.
		0455 889 001	Steel, must be used together with item 0455 886 001.
E	Outlet nozzle	0455 885 001	Must be used together with item 0455 894 001, for welding with Al wire.
		0455 886 001	Must be used together with item 0455 889 001.

The rollers are marked with wire dimension in mm, some are also marked with inch.



Welding with aluminium wires.

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