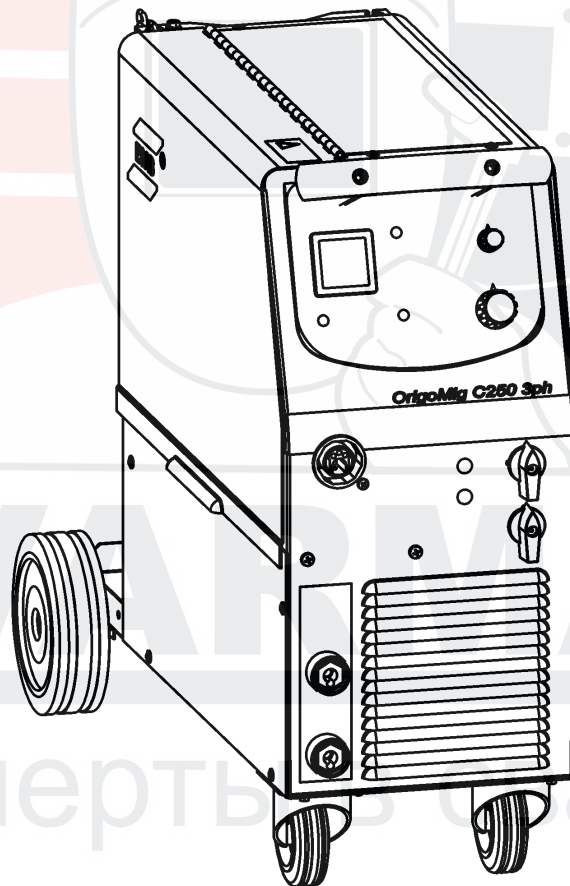




OrigoMig C170 3ph

OrigoMig C200 3ph

OrigoMig C250 3ph



Instruction manual

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SVARMA ru

Эксперты в сварке

1 DIRECTIVE

DECLARATION OF CONFORMITY

ESAB Welding Equipment AB, S-695 81 Laxå, Sweden, gives its unreserved guarantee that welding power source OrigoMig C170 3ph/OrigoMig C200 3ph/OrigoMig C250 3ph from serial number 526, 527, 509, 533 complies with standard IEC/EN 60974-1, in accordance with the requirements of directive (73/23/EEC) and addendum (93/68/EEC) and with standard EN 60974-10 in accordance with the requirements of directive (89/336/EEC) and addendum (93/68/EEC).

Laxå 12-04-2005

Henry Selenius
Vice President
ESAB Welding Equipment AB
695 81 LAXÅ
SWEDEN

Tel: + 46 584 81000

Fax: + 46 584 411924

2 SAFETY

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

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

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



WARNING



ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS' HAZARD DATA.

ELECTRIC SHOCK – Can kill

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

FUMES AND GASES – Can be dangerous to health

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

ARC RAYS – Can injure eyes and burn skin.

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

FIRE HAZARD

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

NOISE – Excessive noise can damage hearing

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

MALFUNCTION – Call for expert assistance in the event of malfunction.

READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.

PROTECT YOURSELF AND OTHERS!



WARNING!

Read and understand the instruction manual before installing or operating.



WARNING!

Do not use the power source for thawing frozen pipes.



This product is solely intended for arc welding.

3 INTRODUCTION

OrigoMig C170 3ph/C200 3ph/C250 3ph are step controlled power sources in a compact design, intended for welding with solid steel, stainless steel or aluminium wire as well as tubular wire with or without shielding gas. The possibility of welding with homogeneous wire/shielding gas and welding with gasless tubular wire is obtained by switching the + and - connections on the switching terminal by the wire feed unit.

ESAB's accessories for the product can be found on page 17.

3.1 Equipment

The power source is supplied with:

- Welding gun
- Return cable with return clamp
- Shelf for gas cylinder
- Instruction manual

4 TECHNICAL DATA

	OrigoMig C170 3ph	OrigoMig C200 3ph	OrigoMig C250 3ph
Voltage	400-415V 3~ 50/60 Hz	400-415V 3~ 50/60 Hz	230/400-415V 3~ 50/60 Hz
Permissible load at 100% duty cycle	100A	120A	150A
60 % duty cycle	130A	150A	190A
35 % duty cycle	170A	200A	250A
Setting range (DC)	30-170A	30-200A	40-280A
Open circuit voltage	15,5-30,6V	16,0-31,8V	15,0-37,0V
Open circuit power	310W	210W	340W
Power factor at max load	0,97	0,97	0,97
Control voltage	42V, 50/60Hz	42V, 50/60Hz	42V, 50/60Hz
Wire feed speed	1,0-17m/min	1,0-17m/min	1,0-17m/min
Burnback time	0,02-0,25s	0,02-0,25s	0,02-0,25s
Spot welding	0,2-2,5s	0,2-2,5s	0,2-2,5s
Welding gun connection	EURO	EURO	EURO
Wire dimension range	0,6-0,8(Fe, SS) 1,0(Al) 0,8(FCW) 0,8-1,0(CuSi)	0,6-1,0(Fe, SS) 1,0(Al) 0,8-1,0(FCW) 0,8-1,0(CuSi)	0,6-1,2(Fe, SS) 1,0-1,2(Al) 0,8-1,2(FCW) 0,8-1,0(CuSi)
Max diameter/weight of wire bobin	300mm/15kg	300mm/15kg	300mm/15kg
Dimensions lwxhxh	860x420x730	860x420x730	860x420x730
Weight	63,5kg	72,5kg	82kg
Operating temperature	-10 ÷ +40°C	-10 ÷ +40°C	-10 ÷ +40°C
Enclosure class	IP 23	IP 23	IP 23
Application classification	S	S	S

Duty cycle

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

Enclosure class

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

Application class

The symbol **S** indicates that the power source is designed for use in areas with increased electrical hazard.

5 INSTALLATION

The installation must be executed by a professional.



WARNING!

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

5.1 Placing

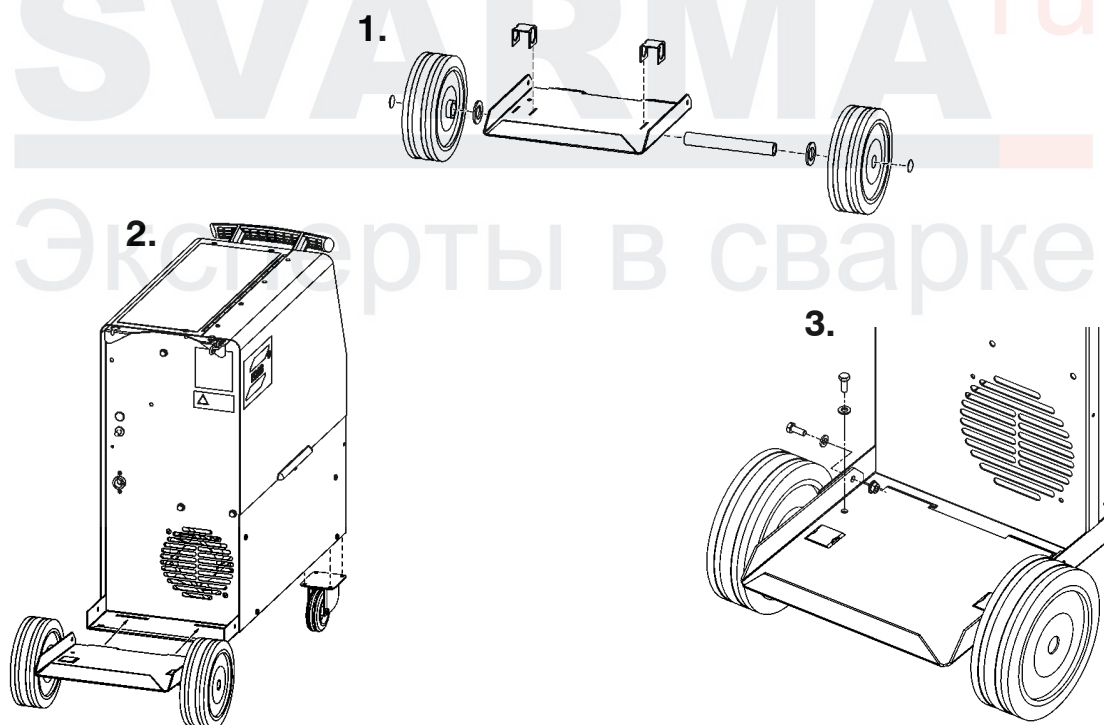
Position the welding power source such way that its cooling air inlets and outlets are not obstructed.

5.2 Assembly of components

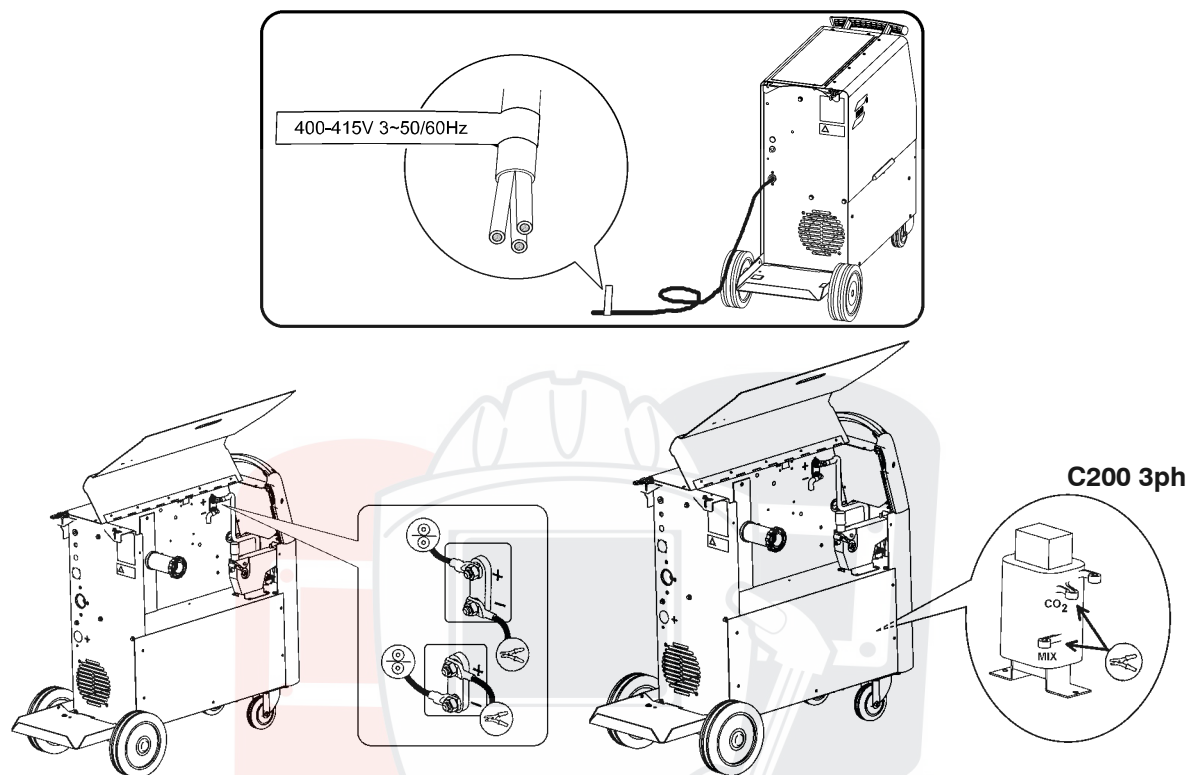


WARNING!

For packing and shipment of the machine the wheels are detached from the unit. Before use attach the wheels according to instruction.



5.3 Electrical installation



5.4 Mains power supply

Check that the unit is connected to the correct mains power supply voltage, and that it is protected by the correct fuse size. A protective earth connection must be made, in accordance with regulations.



	OrigoMig C170 3ph	OrigoMig C200 3ph	OrigoMig C250 3ph
Voltage V	400–415V, 3~ 50/60 Hz	400–415V, 3~ 50/60 Hz	230/400–415V, 3~ 50/60 Hz
Current A at 100% duty cycle	4,0	5,3	12,1/7,0
at 60% duty cycle	6,1	6,8	17,6/10,2
at 35% duty cycle	8,9	10,1	25,3/14,6
Cable area mm²	4 x 1,5	4 x 1,5	4 x 2,5/4 x 1,5
Fuse slow A	10	10	25/16

NB: The mains cable areas and fuse sizes as shown above are in accordance with Swedish regulations. They may not be applicable in other countries: make sure that the cable area and fuse sizes comply with the relevant national regulations.

6 OPERATION

General safety regulations for the handling of the equipment can be found on page 3. Read through before you start using the equipment!



WARNING!

Rotating parts can cause injury, take great care.

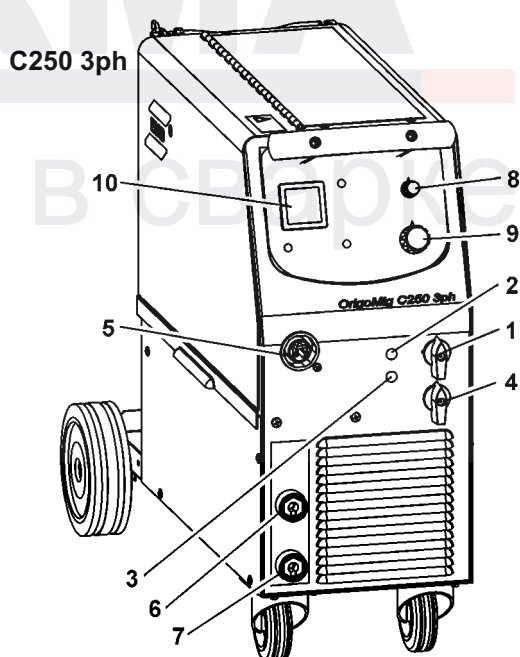
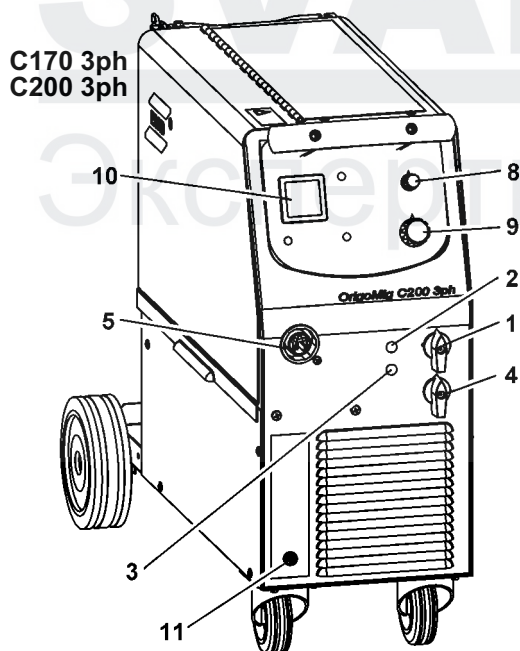


WARNING – TIPPING RISK!

There is a risk of tipping while transportation and operation, if the welding machine leans more than 10°. In that case appropriate securing has to be provided !

6.1 Connection and control devices

- | | | | |
|---|--|----|--|
| 1 | Mains supply switch | 7 | Connection for return cable (-), low inductance |
| 2 | Indicating lamp, power ON/OFF | 8 | Knob for spot welding – ON/OFF and time setting |
| 3 | Orange indicating lamp, overheating | 9 | Knob for wire speed setting |
| 4 | Welding voltage switch | 10 | Digital instrument – V/A (option, see page 17) |
| 5 | EURO – connector for welding gun | 11 | Return cable with return clamp |
| 6 | Connection for return cable (-), high inductance | * | Knob for burn-back time setting (located on control board) |



6.2 Functions explanation

6.2.1 Overheating protection

When the machine is switched on with the mains switch [1], indicating lamp [2] is on and lamp [3] off – the machine is ready to operate. If the internal temperature becomes too high, the welding is interrupted and disabled. This state is indicated by lighting of the orange indicating lamp [3] on the front of the machine. It resets automatically when the temperature has fallen.

7 MAINTENANCE

Regular maintenance is important for safe, reliable operation.

Note!

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

7.1 Inspection and cleaning

Check regularly that the power source is free from dirt.

The power source should be regularly blown clean using dry compressed air at reduced pressure. More frequently in dirty environments. Otherwise the air inlet/outlet may become blocked and cause overheating.

Welding gun

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

The brake hub

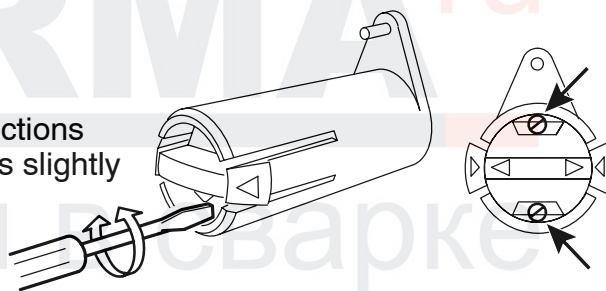
The hub is adjusted when delivered, if readjustment is required, follow the instructions below. Adjust the brake hub so that wire is slightly slack when wire feed stops.

- **Adjusting the braking torque:**

- Turn the red handle to the locked position.
- Insert a screwdriver into the springs in the hub.

Turn the springs clockwise to reduce the braking torque

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



8 FAULT TRACING

Try these recommended checks and inspections before sending for an authorised service technician.

Type of fault	Actions
No arc	<ul style="list-style-type: none"> • Check that the mains power supply switch is turned on. • Check that the welding current supply and return cables are correctly connected. • Check that correct current value is set.
Welding current is interrupted during welding	<ul style="list-style-type: none"> • Check whether the thermal overload trip has operated (indicated by the orange lamp on the front). • Check the main power supply fuses.
Thermal overload trips operate frequently	<ul style="list-style-type: none"> • Check to see whether the air inlets/outlets are clogged. • Make sure that you are not exceeding the rated data for the power source (i.e. that the unit is not being overloaded).
Poor welding performance	<ul style="list-style-type: none"> • Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check that the correct welding wires are being used. • Check the main power supply fuses. • Check the wire feed unit – if proper rolls are applied and properly set the pressure of the wire feeder’s pressure rollers

9 ORDERING OF SPARE PARTS

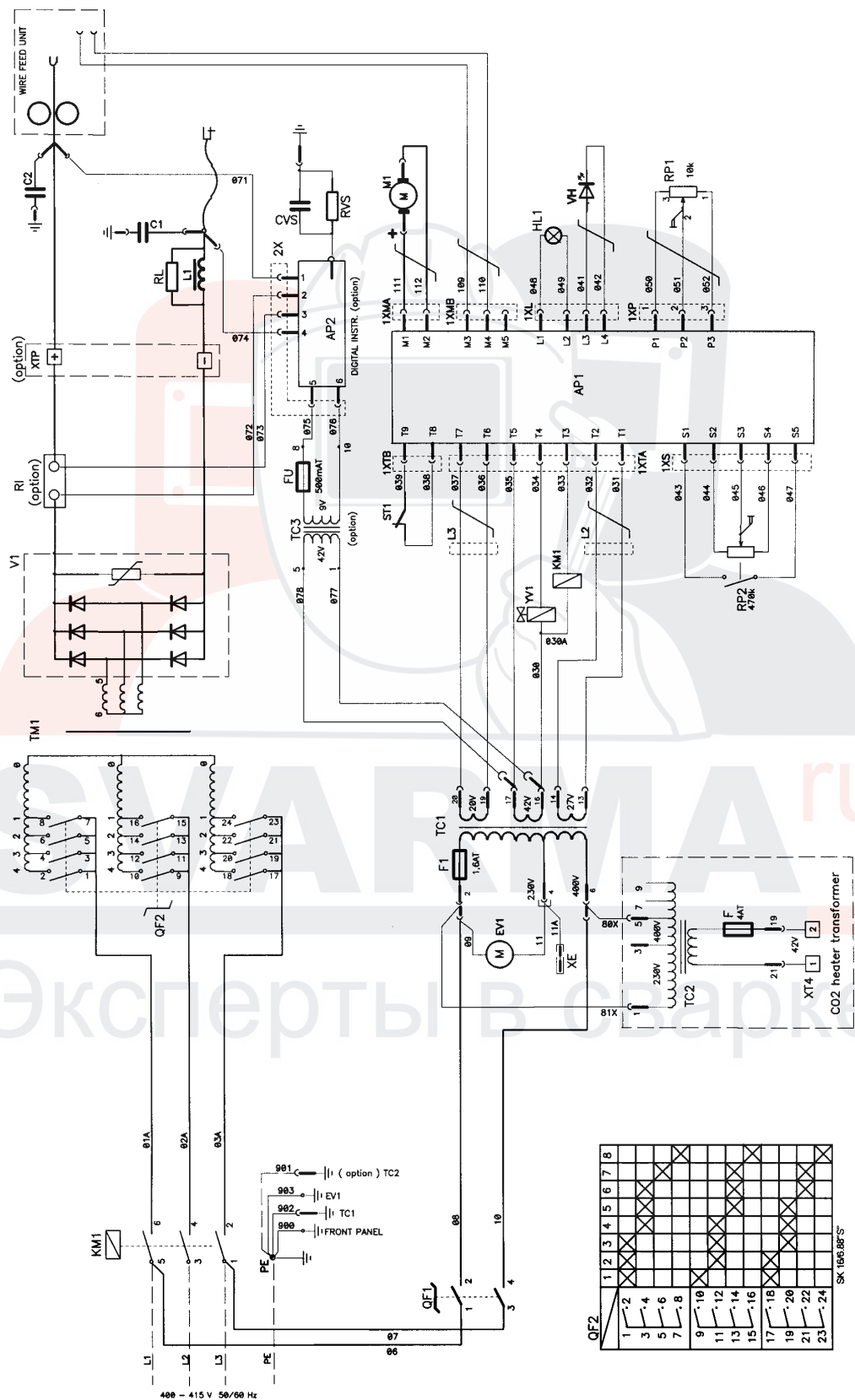
OrigoMig C170 3ph/C200 3ph/C250 3ph is designed and tested in accordance with the international and European standards IEC/EN 60974–1 and EN 60974–10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

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

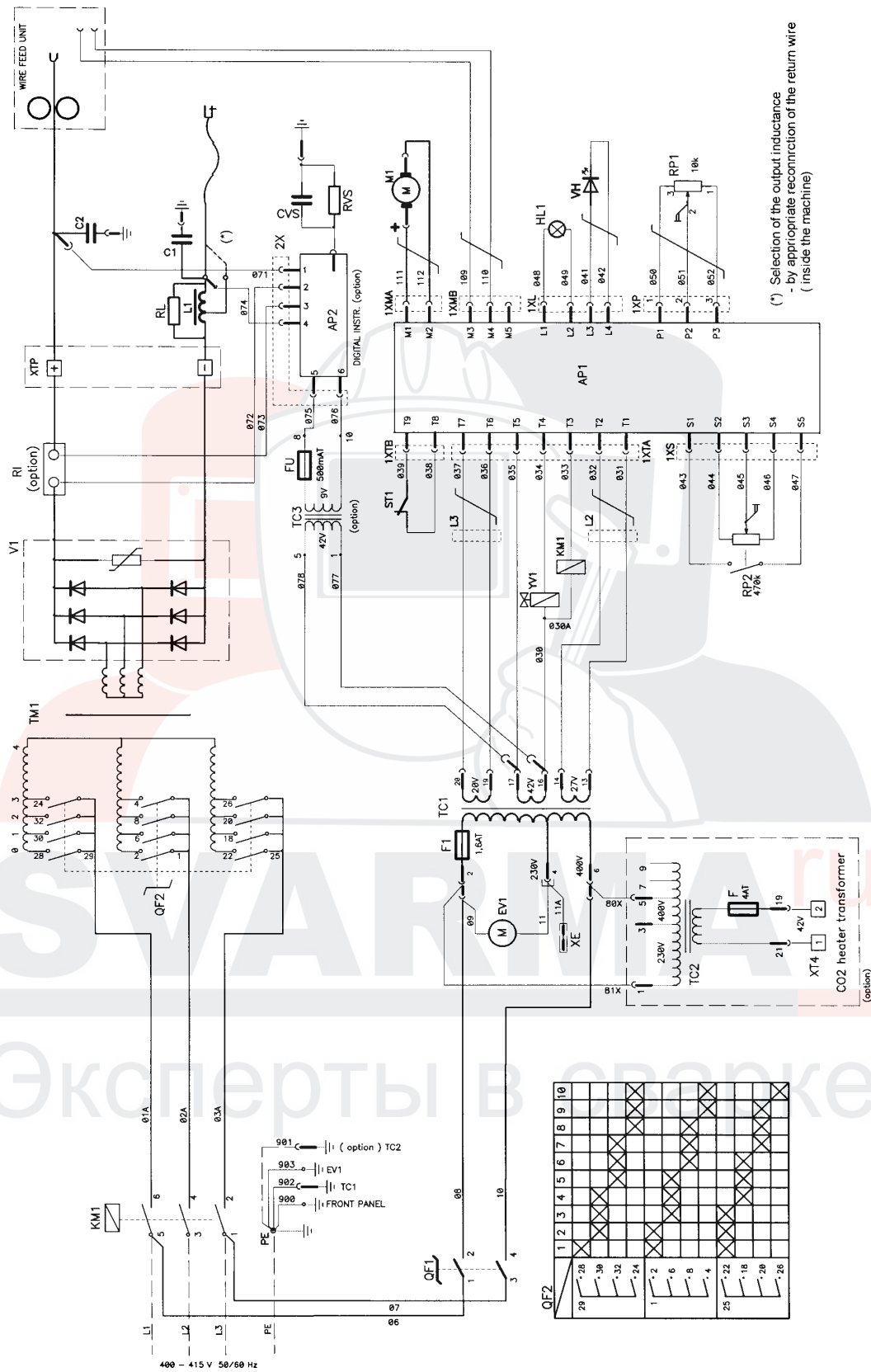
Эксперты в сварке

Diagram

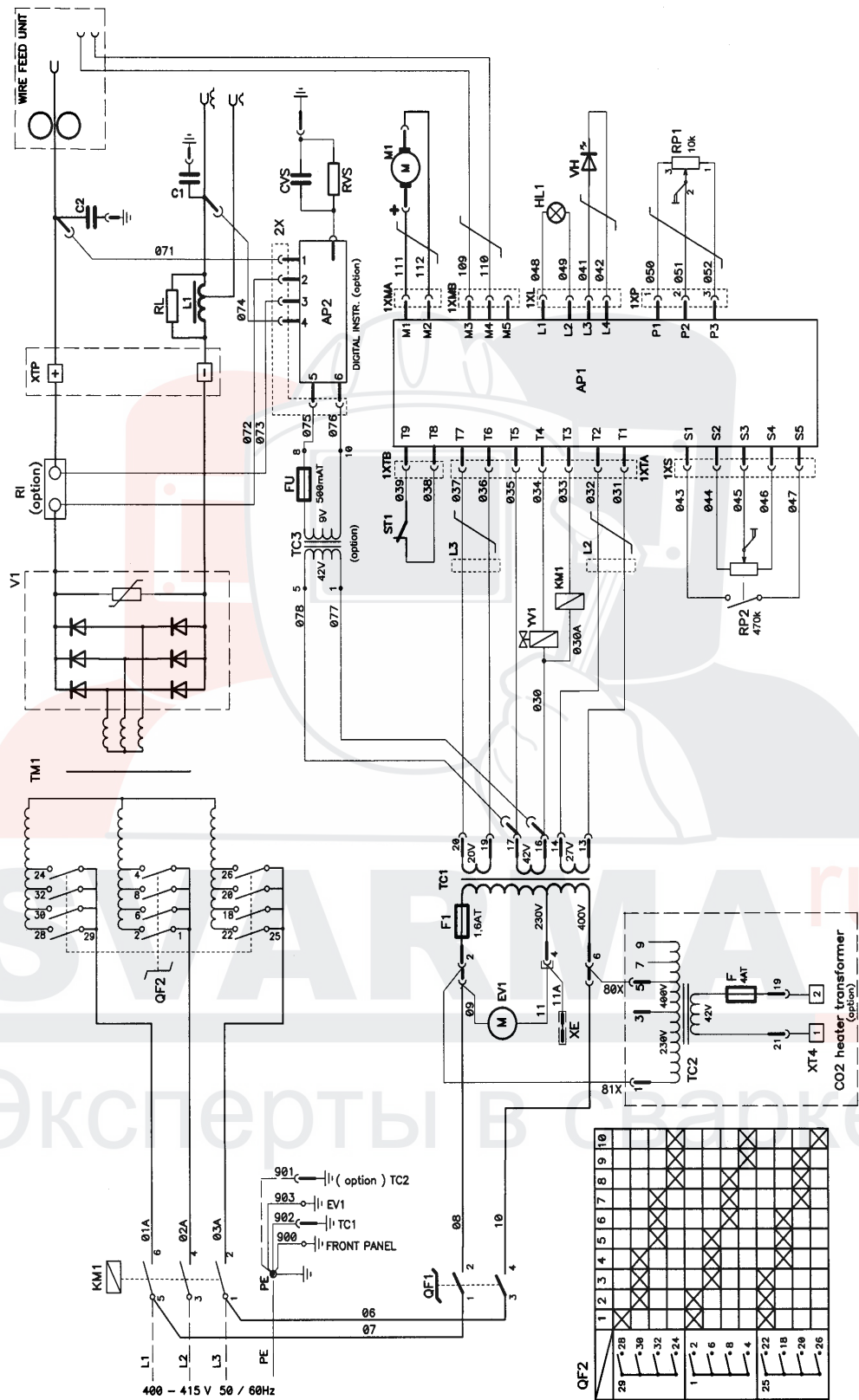
OrigoMig C170 3ph, 400-415V



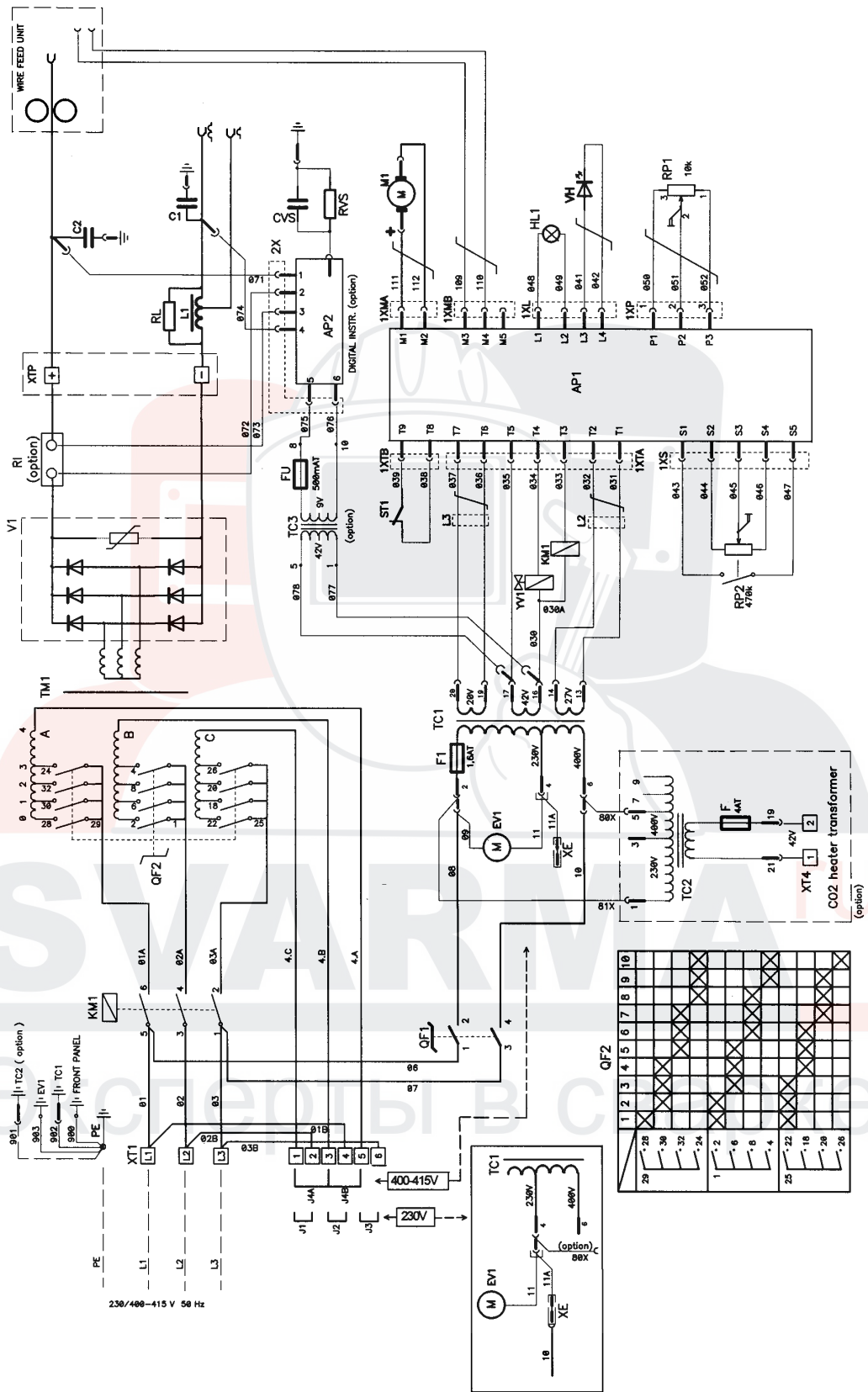
OrigoMig C200 3ph, 400-415V



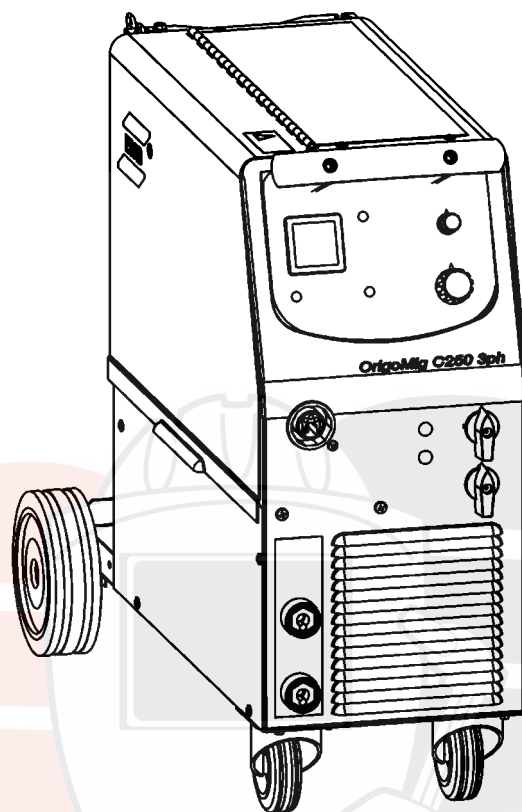
OrigoMig C250 3ph, 400-415V



OrigoMig C250 3ph, 230/400-415V



OrigoMig C170 3ph/C200 3ph/C250 3ph



Valid for serial no. 526, 527, 509, 533-XXX-XXXX

Ordering numbers

0349 308 670	OrigoMig C170 3ph	400-415V 3~50/60Hz
0349 308 290	OrigoMig C200 3ph	400-415V 3~50/60Hz
0349 307 840	OrigoMig C250 3ph	400-415V 3~50/60Hz
0349 309 090	OrigoMig C250 3ph	230/400-415V 3~50/60Hz

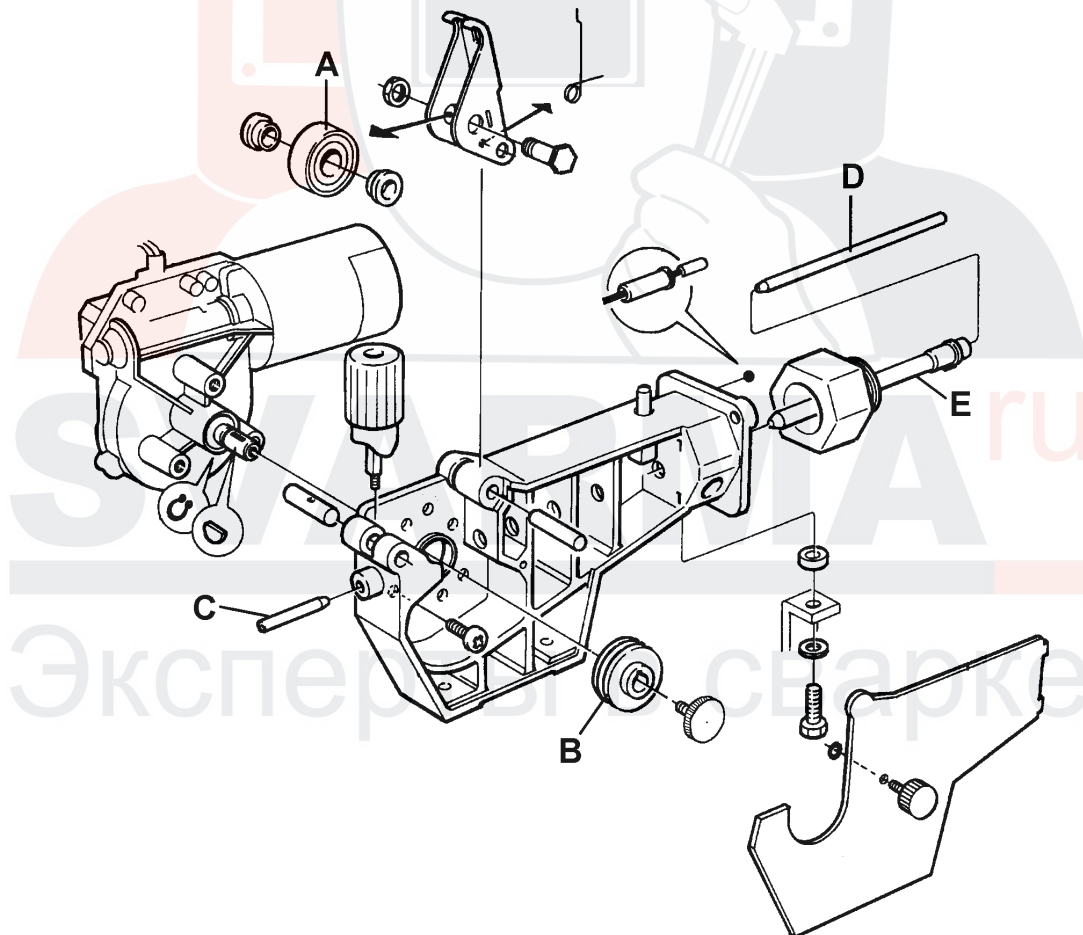
Эксперты в сварке

Wear components

(W. F. Mechanism 0455 890 890)

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.

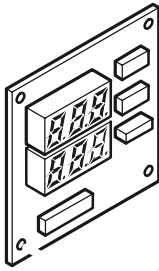
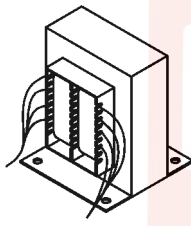
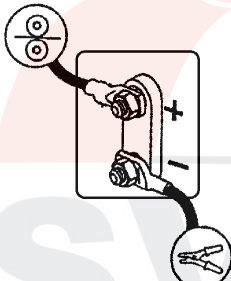
The rollers are marked with wire dimension in mm, some are also marked with inch.



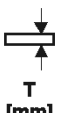














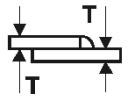
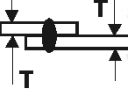
Welding with aluminium wires.

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.

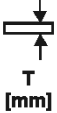














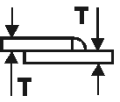
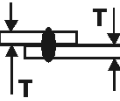
Accessories

	<p>Digital meter 0349 302 598</p>
	<p>Transformer kit for CO₂ heater 0349 302 250</p>
	<p>Polarity change KIT 0349 309 310</p>

SWARMA ru
Эксперты в сварке

OrigoMig C170 3ph	 T [mm]	 d [mm]	Fe Ar + 18% CO ₂			Fe CO ₂			SS Ar + 2% CO ₂		AlMg5 Ar 100%		tubular gasless wire (TUBROD OK.14.16) REVERSE POLARITY					
																		
			1-10	1-10	t	1-10	1-10	t	1-10	1-10	1-10	1-10	1-10	1-10	t			
	0,6	0,6	3,1	2		2,8	3		3	2						2,5	1	
		0,8	2,5	2		3	3		2,5	2								
	0,8	0,6	3,6	3		4	4		4	3							3	2
		0,8	3	3		3	4		3	3								
	1,0	0,6	5	4		5	5		5,5	4								
		0,8	3,5	4		3,5	5		4	4							3,5	3
		1,0									4	1						
	1,5	0,6	5,5	5		5,5	6		8	5								
		0,8	4,5	5		4	6		6	5							4,5	4
		1,0									5,5	2						
	2,0	0,6	6,5	6		7	7		10	6								
		0,8	5,5	6		4,5	7		8	6							6	5
1,0										6	3							
2,5	0,6	8,5	7		8,5	8		10	8									
	0,8	7	7		5,5	8		8,5	7							8	6	
	1,0									7,5	4							
3,0	0,8	8	8		6	8		7	8							10	7	
	1,0									8,5	6							
	0,6	0,6	3,6	3	7	5	5	6								3	2	7
		0,8	3	3	6	3,5	5	6										
	0,8	0,6	6,5	6	6	7	7	7										
		0,8	4,5	5	6	4	6	7								4,5	4	8
	1,0	0,6	8,5	7	8	8,5	8	8										
		0,8	7	7	6	4,5	7	10								8	6	7
	1,5	0,6	8,5	7	10	8,5	8	10										
		0,8	8	8	9			10										

GIN:0349 309 306

OrigoMig C200 3ph	 T [mm]	 d [mm]	Fe Ar + 18% CO ₂			Fe CO ₂			SS Ar + 2% CO ₂		AlMg5 Ar 100%		tubular gasless wire (TUBROD OK.14.16) REVERSE POLARITY					
																		
			1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10	1-10		
	0,6	0,6	3	1		2,5	4		3	3								
		0,8	2	3		2	4						2	1				
	0,8	0,6	4	4		3	5		4	4								
		0,8	3	4		2,5	5		3	3			2,5	2				
		1,0	2	4		2	5		2,5	3			2	2				
	1,0	0,6	5	5		4,5	6		5,5	5								
		0,8	4	5		3	6		3,5	4			2,6	3				
		1,0	3	5		2,5	6		3	4	4	1	2	3				
	1,5	0,6	5,5	6		5	7		7,5	6								
		0,8	4,5	6		3,5	7		4,5	5			3	4				
		1,0	3	6		3	7		3	5	4,5	2	2,5	5				
	2,0	0,6	7	7		7,5	8		10	7								
		0,8	5,5	7		4	8		5,5	6			3,2	5				
		1,0	3,5	7		3,5	8		4	6	5	3	3,5	6				
	2,5	0,6	9	8		9,5	9		10	10								
		0,8	6,5	8		5	9		6	7			4	7				
		1,0	4	8		4	9		4,5	7	6,5	5	4,5	7				
	3,0	0,8	7	9		6	10		7,5	8			5	8				
		1,0	5	9		5	10		5,5	8	6	8	5,5	9				
	4,0	0,8	8	10		6,5	10		6	10			6	10				
1,0		5,5	10		5,5	10		5	10	7	9	7,5	10					
	0,6	0,6	5	5	6	3	5	8										
		0,8	4	5	6	2,5	5	7					3	4	7			
		1,0	3	5	5	2	5	7					3,5	4	7			
	0,8	0,6	5,5	6	8	5	7	8										
		0,8	4,5	6	6	4	7	7					3	5	8			
		1,0	3	6	6	2,5	6	8					3,5	6	8			
	1,0	0,6	7	7	8	9,5	9	8										
		0,8	5,5	7	6	4	8	8					5	8	10			
		1,0	3,5	7	6	3	7	8					5,5	9	6			
	1,5	0,8	7	9	7	6	10	9										
		1,0	5	9	5	5,5	10	7					7,5	10	7			

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OrigoMig C250 3ph	T [mm]	d [mm]	Fe Ar + 18% CO ₂				Fe CO ₂				SS Ar + 2% CO ₂			AlMg5 Ar 100%			tubular gasless wire (TUBROD OK.14.16) REVERSE POLARITY			
													High (H)			High (H)			H	
			1-10	1-10	L	1-10	1-10	1-10	L	1-10	1-10	1-10	Low (L)	1-10	1-10	Low (L)	1-10	1-10	L	1-10

	0,6	0,6	3	2	L	3	4	H	5	4	L								
		0,8	2,5	2	L	2,5	3	L	4	4	L					3	1	L	
	0,8	0,6	4,5	3	L	4	5	H	6	5	L								
		0,8	3,5	3	H	3	4	L	5	5	L					3,5	2	L	
		1,0	3	3	L	3,5	5	L	3,5	4	L					2	2	L	
	1,0	0,6	4,5	4	H	5	6	H	7,5	6	H								
		0,8	4	4	H	3	5	H	6,5	6	H					3,5	3	L	
		1,0	3,5	4	L	4	6	L	4	4	L	4,5	2	H	2,5	3	L		
		1,2	2	4	H	2,5	6	L	3	4	L	4	2	H	2	3	L		
	1,5	0,6	6	5	H	5,5	7	H	10	7	H								
		0,8	4,5	5	H	3,5	6	H	7,5	7	L					4,5	4	L	
		1,0	4	5	H	4,5	7	L	5	5	L	5	3	H	2,5	4	L		
		1,2	3	5	H	3	7	H	4	5	L	5	3	H	2	4	L		
	2,0	0,6	7,5	6	H	10	8	H											
		0,8	5,5	6	H	4	7	H	8	8	L					6,5	5	L	
		1,0	4,5	6	H	4,5	8	H	5,5	6	H	6,5	4	H	3	5	L		
		1,2	3,5	6	H	3,2	7	H	5	6	L	5,5	4	H	2,5	5	L		
	3,0	0,8	7	7	H	5,5	8	H	10	9	L					8	6	L	
		1,0	5	7	H	6,5	9	H	6,5	7	H	7	5	H	3,5	6	L		
		1,2	4	7	H	3,5	8	H	5,5	7	L	6	5	H	3	6	L		
	4,0	0,8	8,5	8	H	6,5	9	H								9,5	7	L	
		1,0	6,5	8	H	8	10	H	5,5	8	L	7	7	L	5	8	L		
		1,2	5	8	H	4	9	H	5	8	L	6	7	L	4	8	L		
	5,0	0,8	7,5	9	L	9	10	H								10	8	L	
1,0		6,5	9	H	8,5	10	H	7	9	L	8,5	8	L	7,5	9	L			
1,2		5,5	9	H	6	9	L	5,5	9	L	7	8	L	5	9	L			
6,0	0,8	8	10	L															
	1,0	6,5	10	L	8	10	L	8,5	10	L	10	9	L	10	10	L			
	1,2	5,5	10	L	6,5	10	L	6,5	10	L	8,5	9	L	8	10	L			

	0,6	0,6	6	5	H	7	5	6	H	7									
		0,8	3,5	4	H	6	4	5	H	6					4	4	L	6	
		1,0	3	3	H	6	3	4	H	6					2,5	3	L	7	
		1,2	2,5	4	H	5	2,5	6	L	5					2	4	L	6	
	0,8	0,6	6,5	6	H	7	5,5	7	H	9									
		0,8	4,5	5	H	6	4	6	H	7						7	6	L	6
		1,0	4	5	H	6	3,5	5	H	6						3	4	L	8
		1,2	3,5	5	H	5	3	7	H	5						2,5	5	L	6
	1,0	0,6	8,5	8	H	7	9,5	8	H	8									
		0,8	7	7	H	6	5,5	8	H	8						9,5	8	L	6
		1,0	4,5	6	H	6	4,5	7	H	6						4,5	6	L	8
		1,2	3,5	6	H	5	4	8	H	5						3	6	L	7
	1,5	0,8	10	9	H	7	10	10	H	7									
		1,0	6	8	H	6	6,5	9	H	6						8	8	L	8
		1,2	4	7	H	6	5,5	9	L	5						5	9	L	7

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