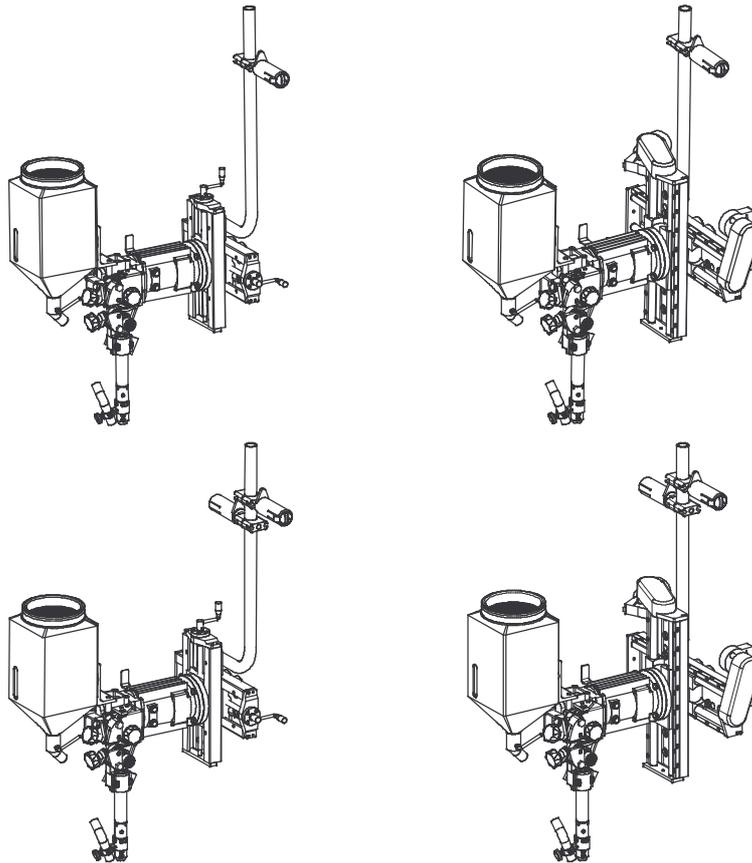




A6 Welding heads

A6SF F1 / A6SF F1 Twin



Instruction manual

ENGLISH 4

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DECLARATION OF CONFORMITY

In accordance with
the LV-Directive 2006/95/EC, the Machinery Directive 2006/42/EC, the EMC Directive 2004/108/EC

Type of equipment

Feeder of welding wire in combination with movable Welding Automats and stationary Welding heads, used with control box PEK

Brand name or trade mark Fabrikatnamn eller varumärke

ESAB

Type designation etc.

A2 Multitrac, A2 Tripletrac, A2 S-series, A6 Mastertrac, A6 Mastertrac Tandem, A6 S- series

Manufacturer or his authorised representative established within the EEA

Name, address, telephone No, telefax No:

ESAB AB, Welding Equipment

Esabvägen, SE-695 81 LAXÅ, Sweden

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

The following harmonised standards in force within the EEA have been used in the design:

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

EN 12100-2, Safety of machinery – Part 2: Technical principles

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

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

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

Date / Datum
Laxå 2009-09-15

Signature / Underskrift

A handwritten signature in dark ink, appearing to read "Kent Eimbrodt", written over a horizontal line.

Kent Eimbrodt
Clarification

Position / Befattning
Global Director
Equipment and Automation

| | |
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1 SAFETY

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

All work must be carried out by trained personnel well-acquainted with the operation of the welding equipment.

Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the welding equipment must be familiar with:
 - its operation
 - location of emergency stops
 - its function
 - relevant safety precautions
 - welding
2. The operator must ensure that:
 - no 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. **Note!** *Do not use safety gloves when replacing wire.*
 - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. Protection against other risks
 - Dust particles of a certain size can be harmful to man. A ventilation system and extractor should therefore be provided to eliminate this risk.
6. 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.

GB



WARNING, RISK OF CRUSHING!

Do not use safety gloves when replacing wire, feed rollers and wire bobbins.



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 MANUFACTURER'S 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 keep fumes and gases 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 ear defenders 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!

2 INTRODUCTION

2.1 General

All the welding heads included in this instruction manual are designed for SAW welding of butt and fillet joints.

They are intended for use in combination with **PEK** and ESAB's welding power source **LAF** or **TAF**.

2.2 Welding Method

Submerged Arc Welding (SAW)

- **Submerged arc Light Duty.**

Submerged arc light duty with a Ø 20 mm connector permits a load up to 800 A (100%).

- **Submerged arc Heavy Duty.**

Submerged-arc heavy duty, with a Ø 35 mm connector, which permits a load of up to 1500 A.

This version can be equipped with feed rollers for single or twin wire welding (twin-arc). A special knurled feed roller is available for flux-cored wire, which guarantees even wire feed without the risk of deformation due to high feed pressure.

2.3 Definitions

| | |
|-------------------------|--|
| SAW welding | The weld bead is protected by a cover of flux during the welding. |
| SAW Light duty | This version permits a load up to 800 A (100%) and welding with a thin wire. |
| SAW Heavy duty | This version permits a load up to 1500 A (100%) and welding with a thick wire. |
| Twin-arc welding | Welding with two wires in one welding head. |

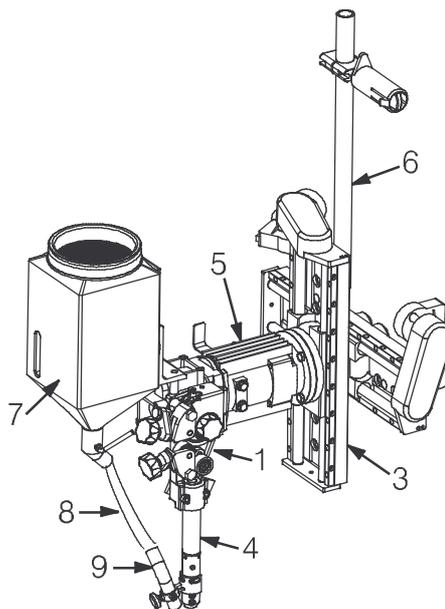
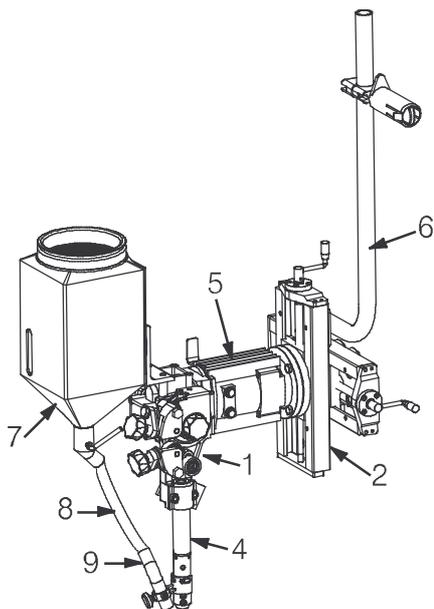


2.4 Technical Data

| | A6SF F1 / A6SF F1 Twin |
|--|-------------------------------|
| Rated load 100% | 1500 A |
| Wire dimensions: | |
| solid single wire | 3,0-6,0 mm |
| flux-cored wire | 3,0-4,0 mm |
| twin wire | 2x2,0-3,0mm |
| Wire feed speed | 0,2-4,0 m/min |
| Brake drum braking torque | 1,5 Nm |
| Max weight, wire | 2x30 kg |
| Flux hopper capacity (Not to be filled with preheated flux) | 10 l |
| Weight (flux and wire excluded) | |
| with hand-operated linear slides | ≈ 58 kg |
| with motor-driven linear slides | ≈ 75 kg |
| Sideways tilt, max. | 25° |
| Setting length of the slide* | |
| hand-operated | 210 mm |
| motor-driven | 300 mm |
| Enclosure class | IP10 |

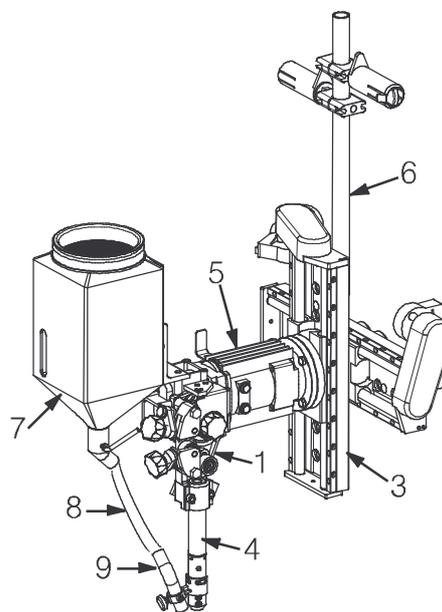
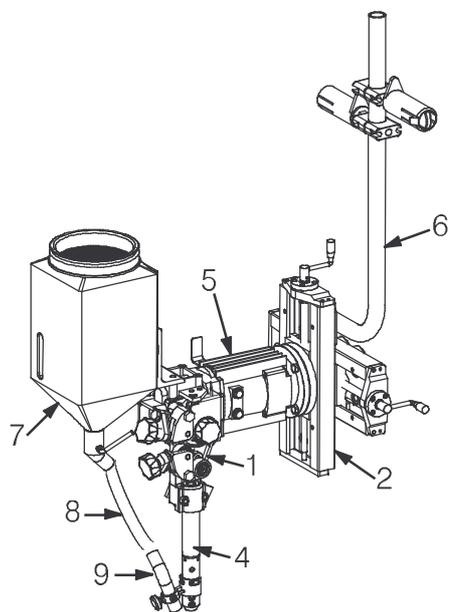
**) NB! Other lengths on request.*

2.5 Main Components A6SF F1



- | | | |
|-------------------------|-----------------------------|----------------|
| 1. Wire feed unit | 4. Contact tube | 7. Flux hopper |
| 2. Slide kit, manual | 5. Motor with gear (A6 VEC) | 8. Flux tube |
| 3. Slide kit, motorised | 6. Carrier for wire drum | 9. Flux nozzle |

2.6 Main Components A6SF F1 Twin



- | | | |
|-------------------------|-----------------------------|----------------|
| 1. Wire feed unit | 4. Connector (Twin) | 7. Flux hopper |
| 2. Slide kit, manual | 5. Motor with gear (A6 VEC) | 8. Flux tube |
| 3. Slide kit, motorised | 6. Carrier for wire drum | 9. Flux nozzle |

See on page 11 for a description of the main components.

2.7 Description of Main Components

2.7.1 Wire Feed Unit

The unit is used for guiding and feeding the welding wire down into the contact tube/connector.

2.7.2 Manual and Motorised Slides

The horizontal and vertical position of the welding head is adjusted by way of linear slides. The angular motion can be freely adjusted using the rotary slide.

For the motorised slide (**A6 Slide**), see instruction manual 0443 394 xxx.

2.7.3 Contact Tube / Connector

Transfers welding current to the wire during welding.

2.7.4 Motor with Gear (A6 VEC)

The motor is used for feeding the welding wire.

For more information regarding the **A6 VEC** see instruction manual 0443 393 xxx.

2.7.5 Carrier for Wire Drum

The carrier is provided with a brake hub on which one the wire drum is to be fitted.

2.7.6 Flux Hopper / Flux Tube / Flux Nozzle

The flux is filled into the flux hopper and is then transferred to the workpiece through the flux tube and the flux nozzle.

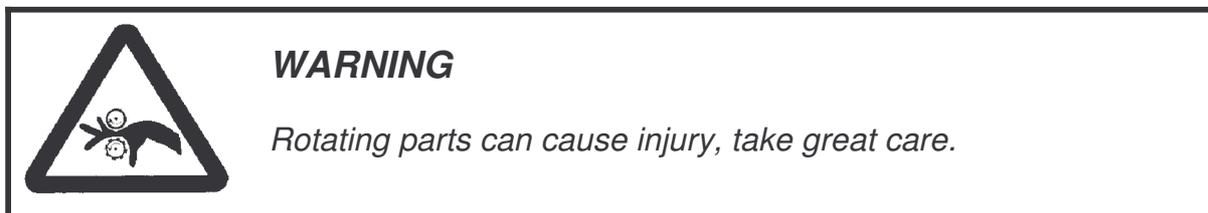
The amount of flux to be dropped down is controlled by way of the flux valve fitted to the flux hopper.

See **Refilling with flux** on page 19.

3 INSTALLATION

3.1 General

The installation must be executed by a professional.



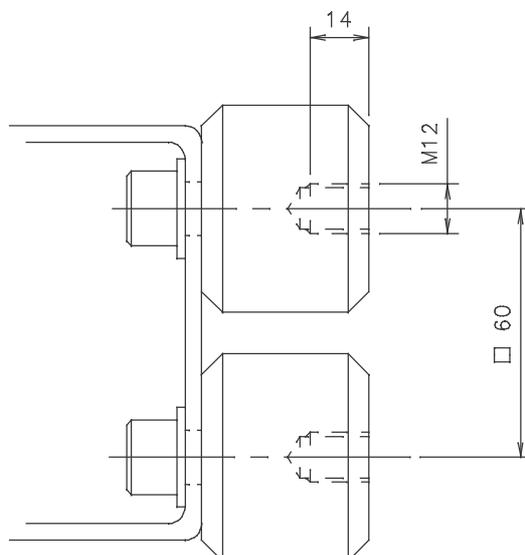
3.2 Mounting

3.2.1 Welding Head

The welding head can be mounted on a beam-travelling carriage or on a welding column and boom unit by way of four M12 screws.

N.B.

Make sure the bolts do not touch the bottom of the insulator, which has a thread depth of 14 mm.



3.2.2 A6 Slide

For mounting/ dismounting of A6 Slide, see instruction manual 0443 394 xxx.

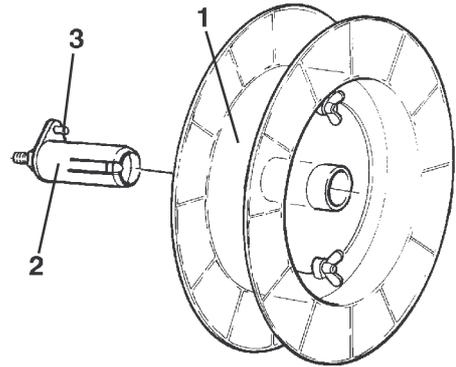
This safety sign is placed on the cover of the vertical slide.



3.2.3 Wire reel (Accessories)

The wire reel (1) is mounted on the brake hub (2).

- Check that the carrier (3) is pointing upwards.



NOTE! The maximum angle for the wire reel is 25°. At extreme angles, wear will occur on the brake hub locking mechanism and the wire reel will slide off the brake hub.



WARNING

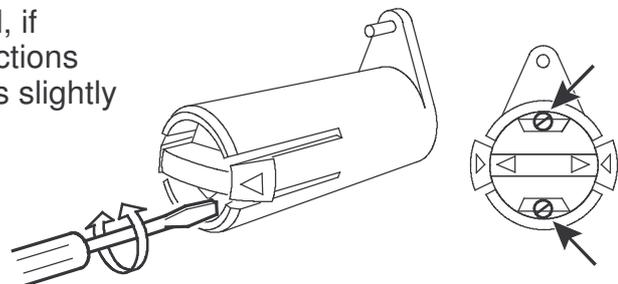
To prevent the reel sliding off the hub:

- Lock the reel in place by turning the red knob as shown on the warning label attached next to the hub.



3.3 Adjusting the Brake Hub

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

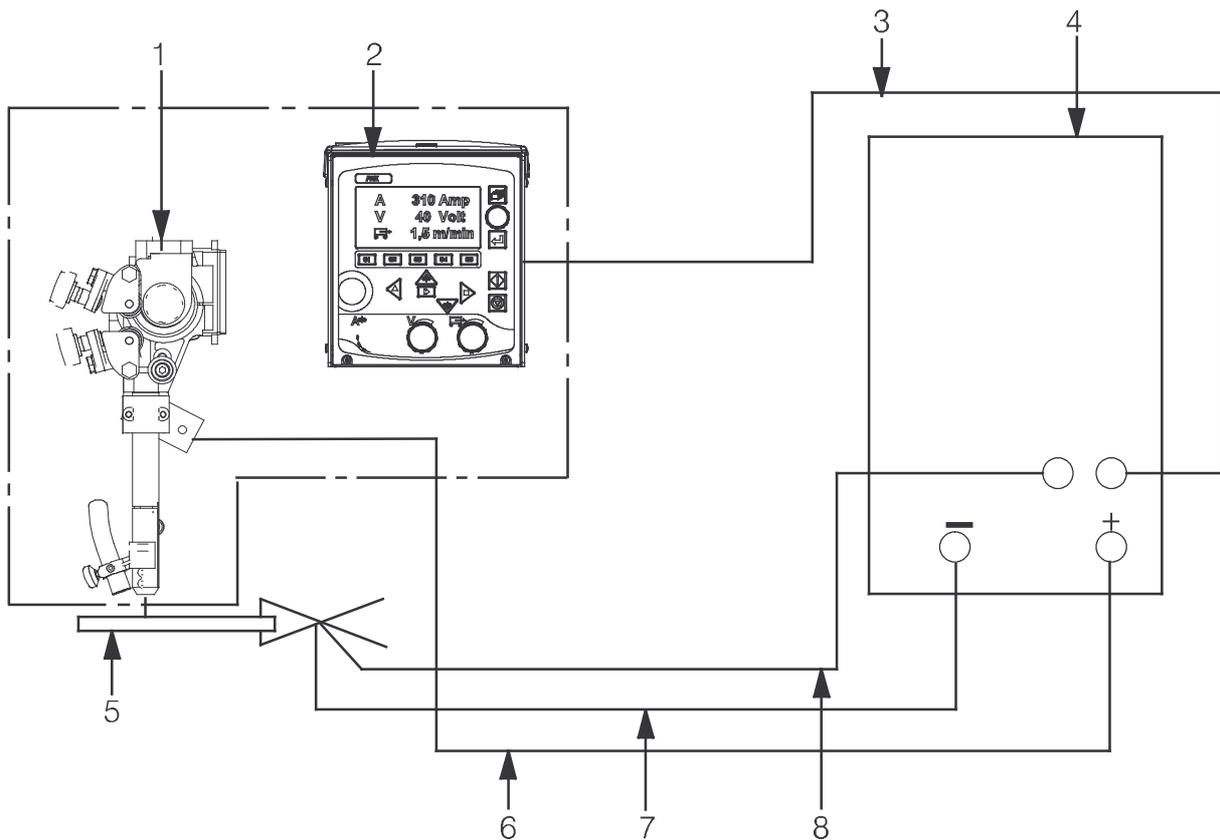
3.4 Connections

3.4.1 General

- **PEK** is to be connected by a qualified person.
See instruction manual 0460 948 xxx, 0460 949 xxx, 0459 839 036.
- For the connection of **A6 GMH**, see instruction manual 0460 671 xxx.
- For the connection of **A6 PAV**, see instruction manual 0460 670 xxx.

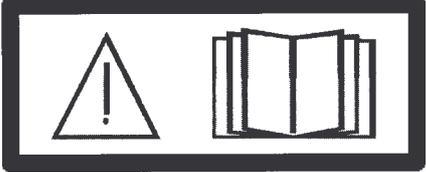
3.4.2 Welding Head A6SF F1 / A6SF F1 Twin

1. Connect the control cable (3) between the welding power source (4) and the (2).
2. Connect the return cable (7) between the welding power source (4) and the work piece (5).
3. Connect the welding cable (6) between the welding power source (4) and the welding head (1).
4. Connect the measuring cable (8) between the welding power source (4) and the work piece (5).



4 OPERATION

4.1 General

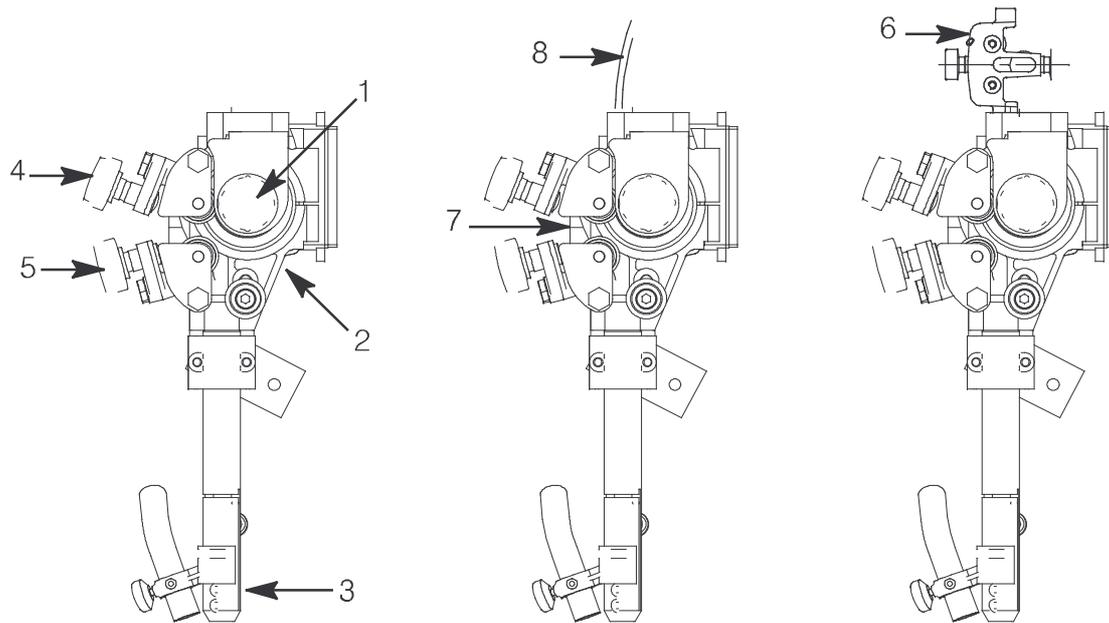
| | |
|---|--|
|  | <p>WARNING: <i>Have you read and understood the safety information ? You must not operate the machine before then !</i></p> |
|---|--|

General safety regulations for the handling of the equipment can be found on page 5. Read through before you start using the equipment!

Return cable

Before welding start, check that the return cable is connected. See page 14.

4.2 Loading the Welding Wire

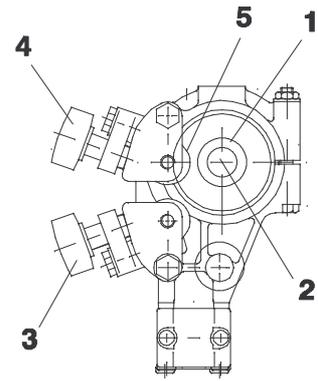


1. Mount the wire drum according to the instructions on page 13.
 2. Check that feed roller (1) and contact jaw or contact tip (3) are of the correct dimension for the selected wire size.
 3. For **A6SF F1 Twin**:
 - Feed the wire through the wire guide (8).
 4. When welding with fine wire:
 - Feed the wire through the fine wire feed unit (6).
Ensure that the straightener is correctly adjusted so that the wire emerges straight out through the contact jaws or contact tip (3).
 5. Pull the end of the wire through the straightener (2).
 - For a wire diameter greater than 2 mm; straighten out 0.5 m of wire and feed it by hand down through the straightener.
 6. Locate the end of the wire in the feed roller (1) groove.
 7. Set the wire tension on the feed roller with the knob (4).
 - **Note!** Do not tension more than is required to achieve an even feed.
 8. Feed the wire forward 30 mm below the contact tip by pressing  on control box **PEK**.
 9. Straighten the wire by adjusting the knob (5).
- **Always** use a guide tube (7) to ensure even feed of fine wire (1.6 - 2.5 mm).

4.3 Changing the Feed Roller

Single wire

- Release the knobs (3) and (4).
- Release the hand wheel (2).
- Change the feed roller (1).
The rollers are marked with their respective wire sizes.



Twin Wire (Twin-arc)

- Change the feed roller (1) with twin grooves in the same way as for single wire.
- **NOTE!** The pressure roller (5) must also be changed. A special curved pressure roller for twin wire replaces the standard pressure roller for single wire.
- Assemble the pressure roller with a special stub shaft (order no. 0146 253 001).

Flux-cored Wire for Knurled Rollers (Accessories)

- Change the feed roller (1) and pressure roller (5) as a pair for the wire size to be used.
NOTE! A special stub shaft is required for the pressure roller (order no. 0212 901 101).
- Tighten the pressure screw (4) with moderate pressure to ensure that the flux-cored wire does not deform.

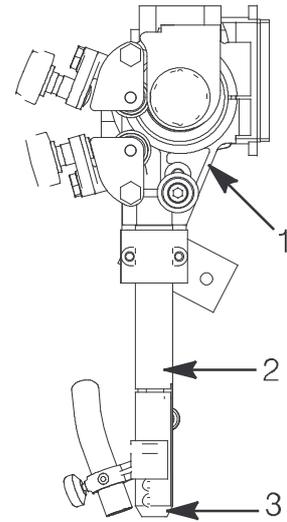
4.4 Contact Equipment for Submerged Arc Welding

4.4.1 For Single Wire 3,0 - 6,0 mm

Use automatic welding machine **A6SF F1** where the following units are included:

- Wire feed unit (1)
- Connector D35 (2)
- Contact jaw (3)

Ensure that good contact is achieved between the contact jaws and the wire.



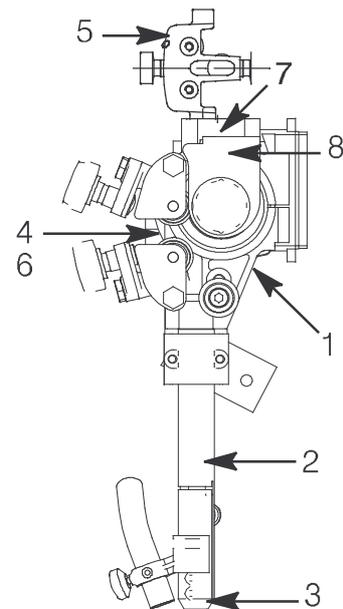
4.4.2 For Twin Wires 2 x 2,0 - 3,0 mm

Use automatic welding machine **A6SF F1 Twin** where the following are included:

- Wire feed unit (1)
- Connector Twin D35 (2)
- Contact jaw (3)

Ensure that good contact is achieved between the contact jaws and the wire.

- Guide tubes (4, 6)



Accessories:

- Fine-wire straightener (5) to be fitted on top of the clamp of the wire feed unit (1).

N.B. When mounting the fine-wire straightener, remove the existing plate (7).

N.B. The protection plate (8) shall not be removed

Adjustment of the Wires for Twin-arc Welding:

- Position the wires in the joint so as to achieve optimal weld quality by rotating the connector. The two wires can be rotated so that they are positioned one after the other along the line of the joint, or in any position up to 90° across the joint, i.e. one wire on each side of the joint.

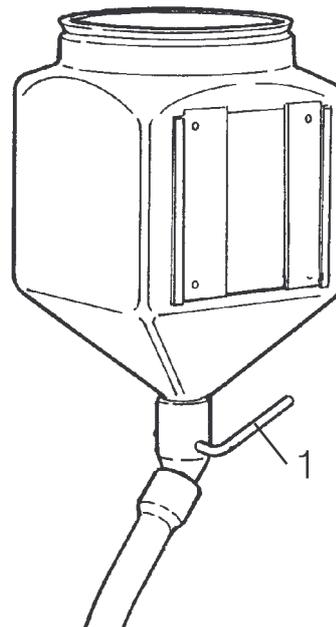
4.5 Refilling with Flux Powder

1. Close the flux valve (1) on the flux hopper.
2. Remove the cyclone on the flux recovery unit, if fitted.
3. Fill with flux powder.

NOTE! The flux powder must be dry.

4. Position the flux tube so that it does not become kinked.
5. Adjust the height of the flux nozzle above the weld so that the correct amount of flux is delivered.

Flux coverage should be sufficient so that penetration of the arc does not occur.



4.6 Conversion of A6SF F1 / A6SF F1 Twin (Submerged Arc Welding) to MIG/MAG welding

For the conversion kit see instruction manual 0456 756 xxx.

4.7 Conversion of A6SF F1 (Submerged Arc Welding) to Twin-arc

For the conversion kit see instruction manual 0456 757 xxx.

5 MAINTENANCE

5.1 General

Note:

All warranty undertakings given by the supplier cease to apply if the customer attempts to rectify any faults on the machine during the warranty period.

NB! Before doing any kind of maintenance work, make sure the mains is disconnected.

For the maintenance of the **PEK**, see the instruction manual 0460 948 xxx, 0460 949 xxx, 0459 839 036.

5.2 Daily

- Keep the moving parts of the welding head clean.
- Make sure contact nozzles, hoses and electric cables are properly connected.
- Make sure all bolted joints are tightened and that the conduit and the feed rollers are not worn or damaged.
- Check the brake hub braking torque. It should not be so low, that the wire reel continues to rotate when wire feed is stopped and it should not be so great that the feed rollers slip. As a guide, the braking torque for a 30 kg wire reel should be 1.5 Nm.
To adjust the braking torque see on page 13.

5.3 Regularly

- Check the wire feed motor brushes once every three months. Replace when they are worn down to 6 mm.
- Examine the slides and lubricate if they bind.
- Inspect the wire guides, drive rollers and contact tip on the wire feed unit. Replace any worn or damaged components, (see spare parts list on page 25).
- Inspect the gas nozzle and clear it regularly of welding spatter.
- Blow the wire conduit clean at regular intervals.
- For trouble-free wire feed the wear parts of the feed mechanism should be cleaned and replaced at regular intervals.
NOTE that too hard pre-tensioning can lead to abnormal wear of the pressure roller, feed roller and wire conduit.

6 FAULT TRACING

6.1 General

Equipment

- Instruction manual for **PEK**, 0460 948 xxx, 0460 949 xxx, 0459 839 036.

Check

- that the power supply is connected for the correct mains supply
- that all three phases are supplying the correct voltage (phase sequence is not important)
- that welding cables and connections are not damaged
- that the controls are correctly set
- that the mains supply is disconnected before starting repairs

6.2 Possible faults

1. Symptom **Current and voltage readings show large fluctuations**

Cause 1.1 Contact jaws or nozzle are worn or wrong size.

Action Replace contact jaws or nozzle.

Cause 1.2 Feed roller pressure is inadequate.

Action Increase pressure on feed rollers.

Cause 1.3 The gas nozzle is choked up.

Action Clear of welding spatter.

2. Symptom **Wire feed is irregular**

Cause 2.1 Pressure on feed rollers incorrectly set.

Action Adjust the pressure.

Cause 2.2 Feed rollers wrong size.

Action Replace feed rollers.

Cause 2.3 Grooves in feed rollers are worn.

Action Replace feed rollers.

3. Symptom **Welding cables overheating**

Cause 3.1 Poor electrical connection.

Action Clean and tighten all electrical connections.

Cause 3.2 Cross-sectional area of welding cables too small.

Action Use cables with a larger cross-section or use parallel cables.

7 ACCESSORIES

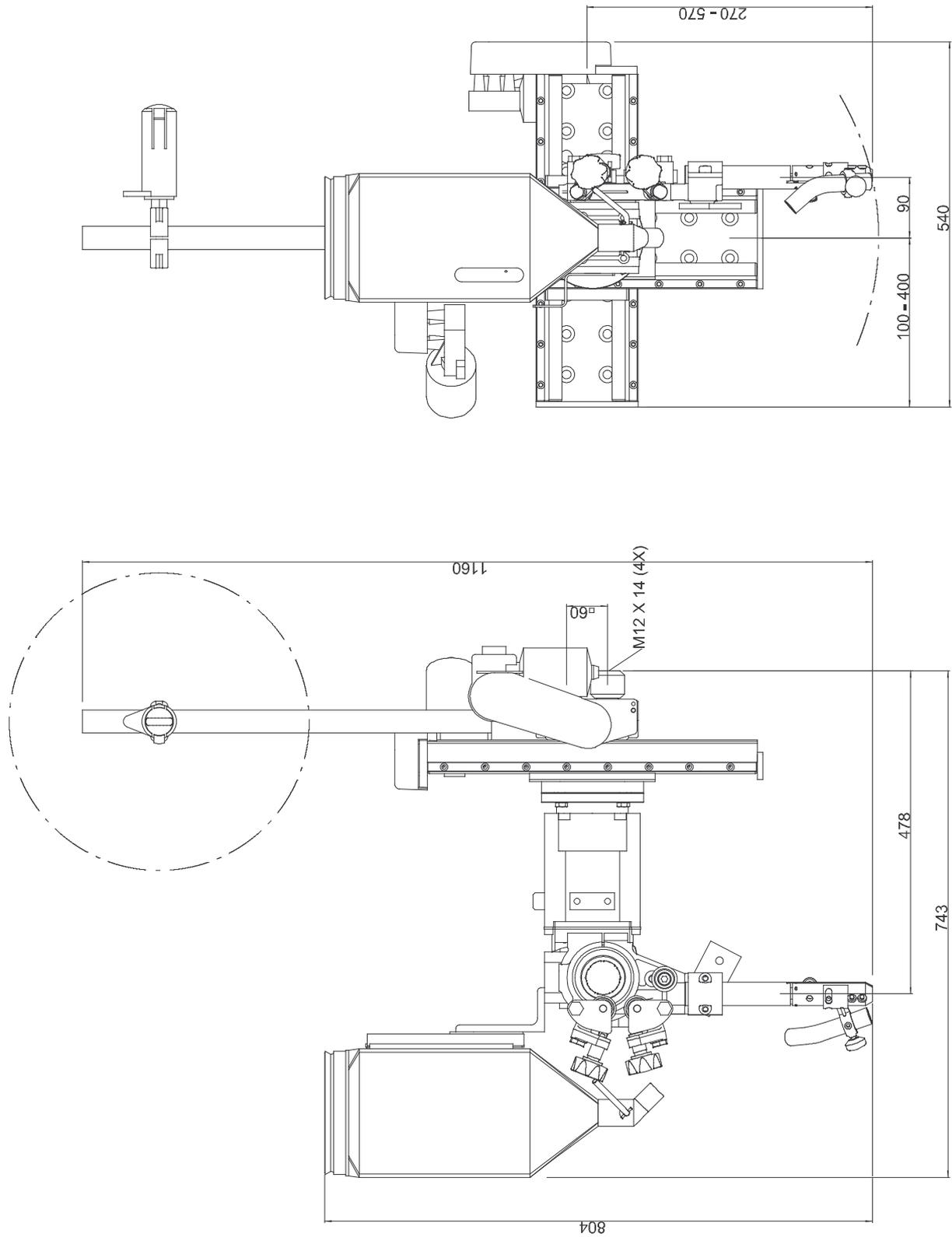
| Denomination | Ordering no. |
|--|---------------------|
| Fine-wire straightener | 0332 565 880 |
| Conversion kit A6SF F1 / A6SF F1 Twin to MIG/MAG welding | 0461 246 880 |
| Conversion kit A6SF F1 to Twin with fine-wire straightener (LD) | 0334 291 888 |
| Conversion kit A6SF F1 to Twin (HD) | 0334 291 889 |
| Pilot lamp | 0153 143 885 |
| Adapter M6/M10 | 0147 333 001 |

8 ORDERING OF SPARE PARTS

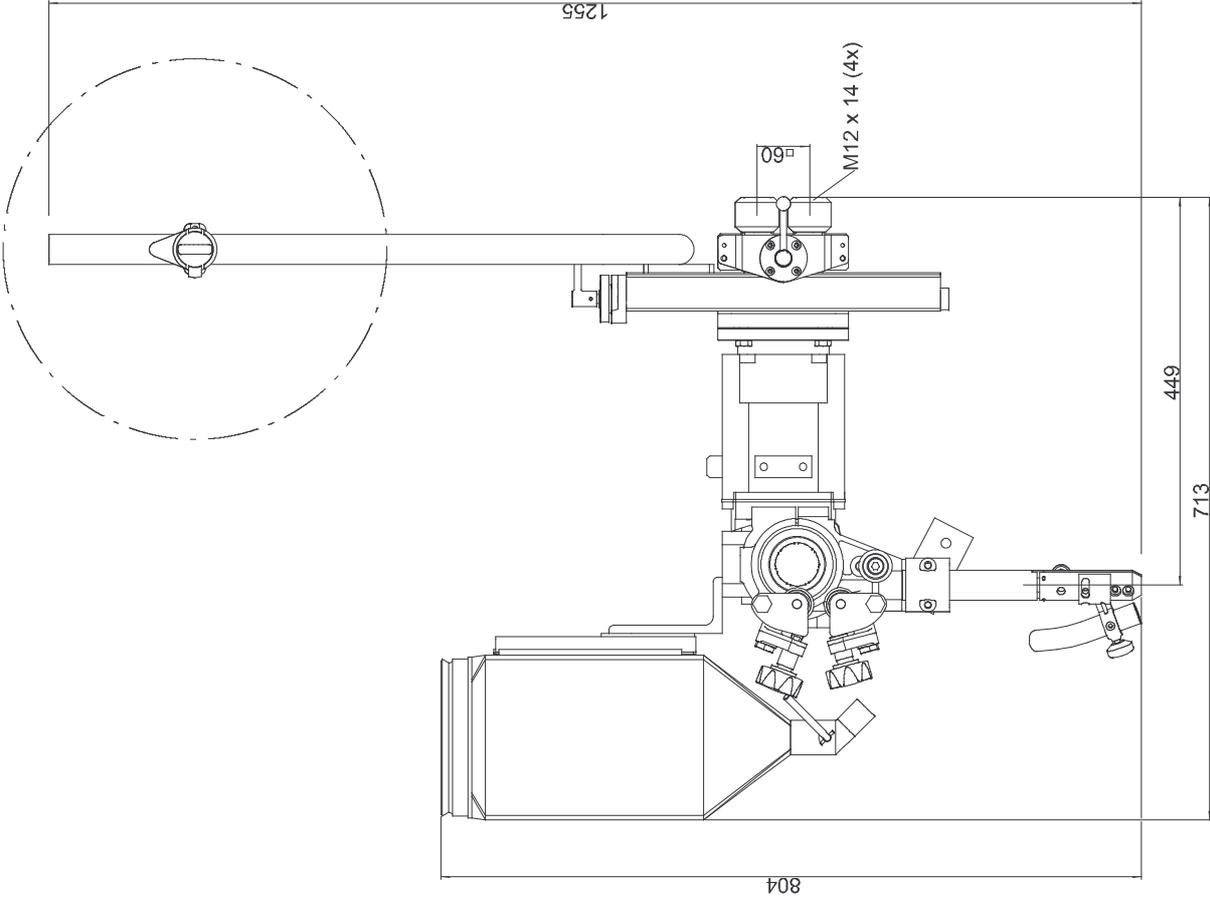
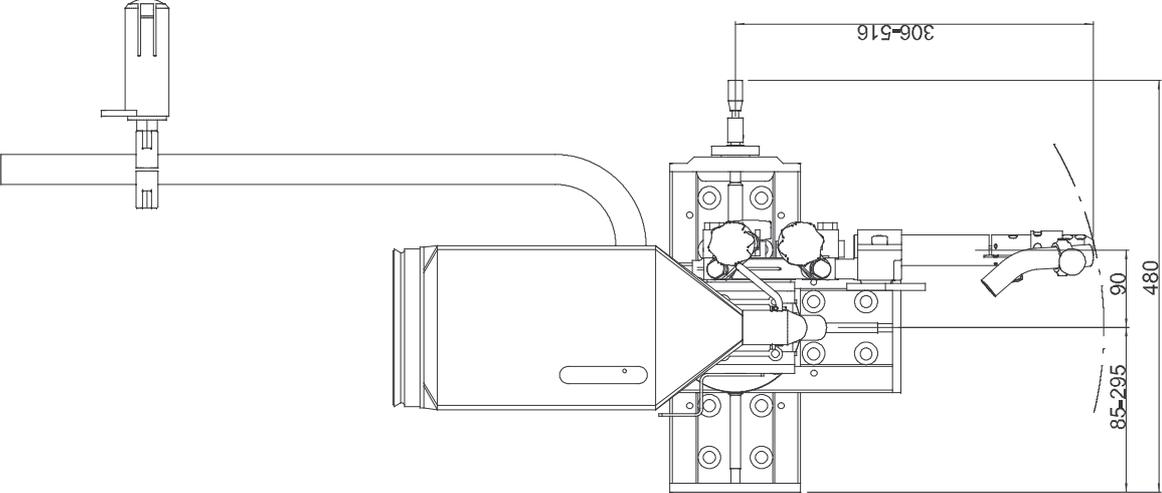
Spare parts are ordered through your nearest ESAB representative, see back cover. When ordering spare parts, please state machine type and number as well as designation and spare part number as shown in the spare parts list on page 25. This will simplify dispatch and ensure you get the right part.

DIMENSION DRAWING

A6 SF with motorised slides

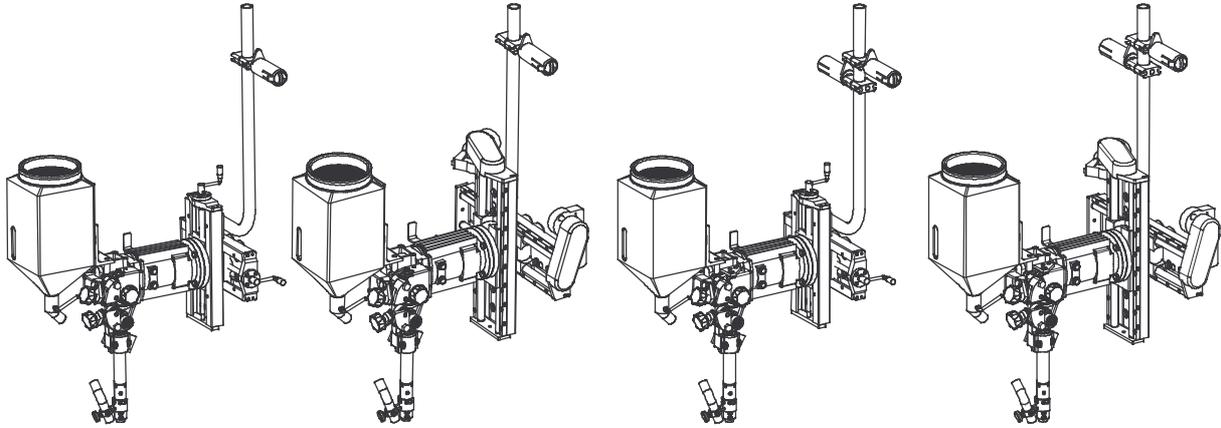


A6 SF with manual slides



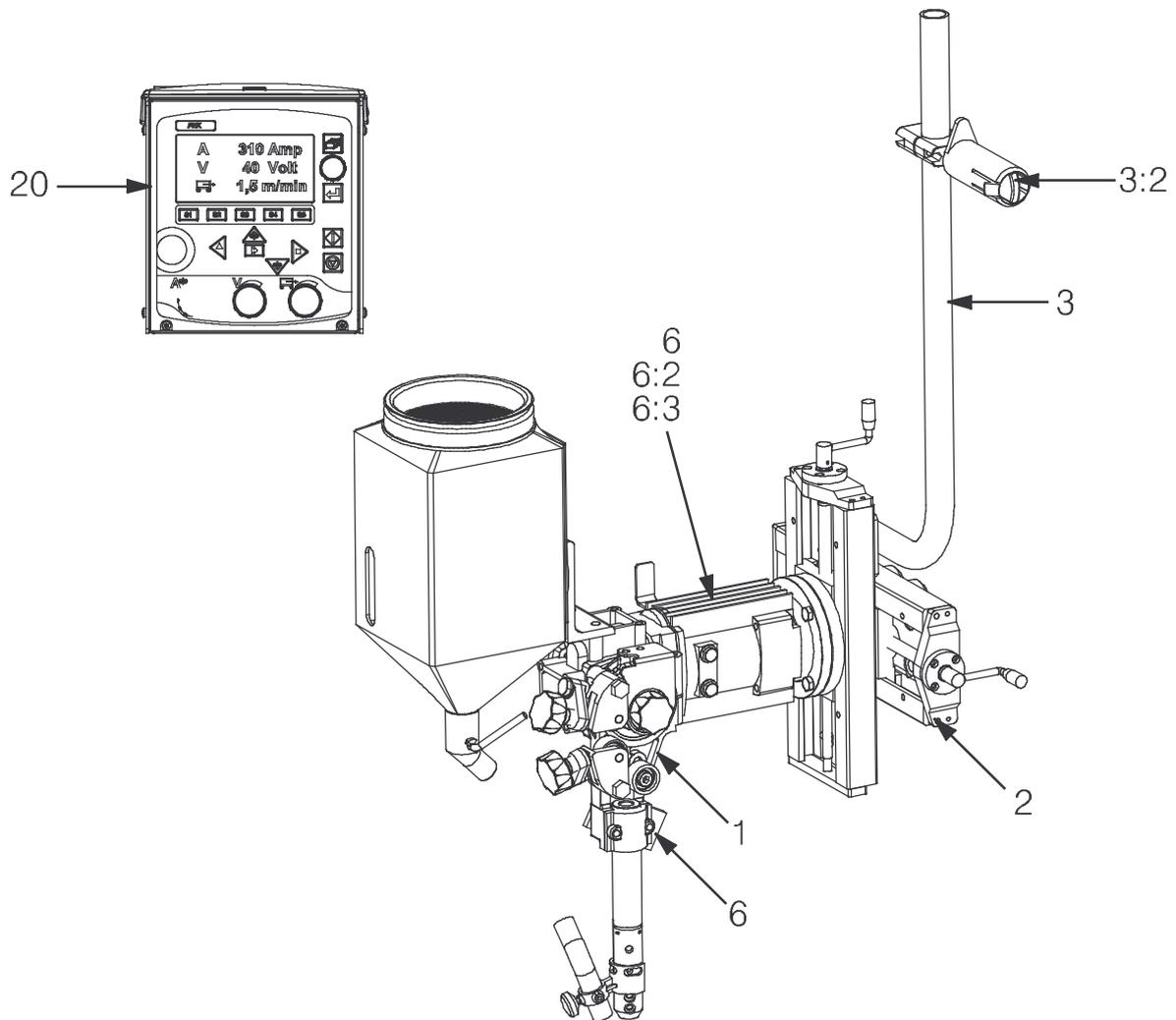
SPARE PARTS LIST

Edition 2009-11-09

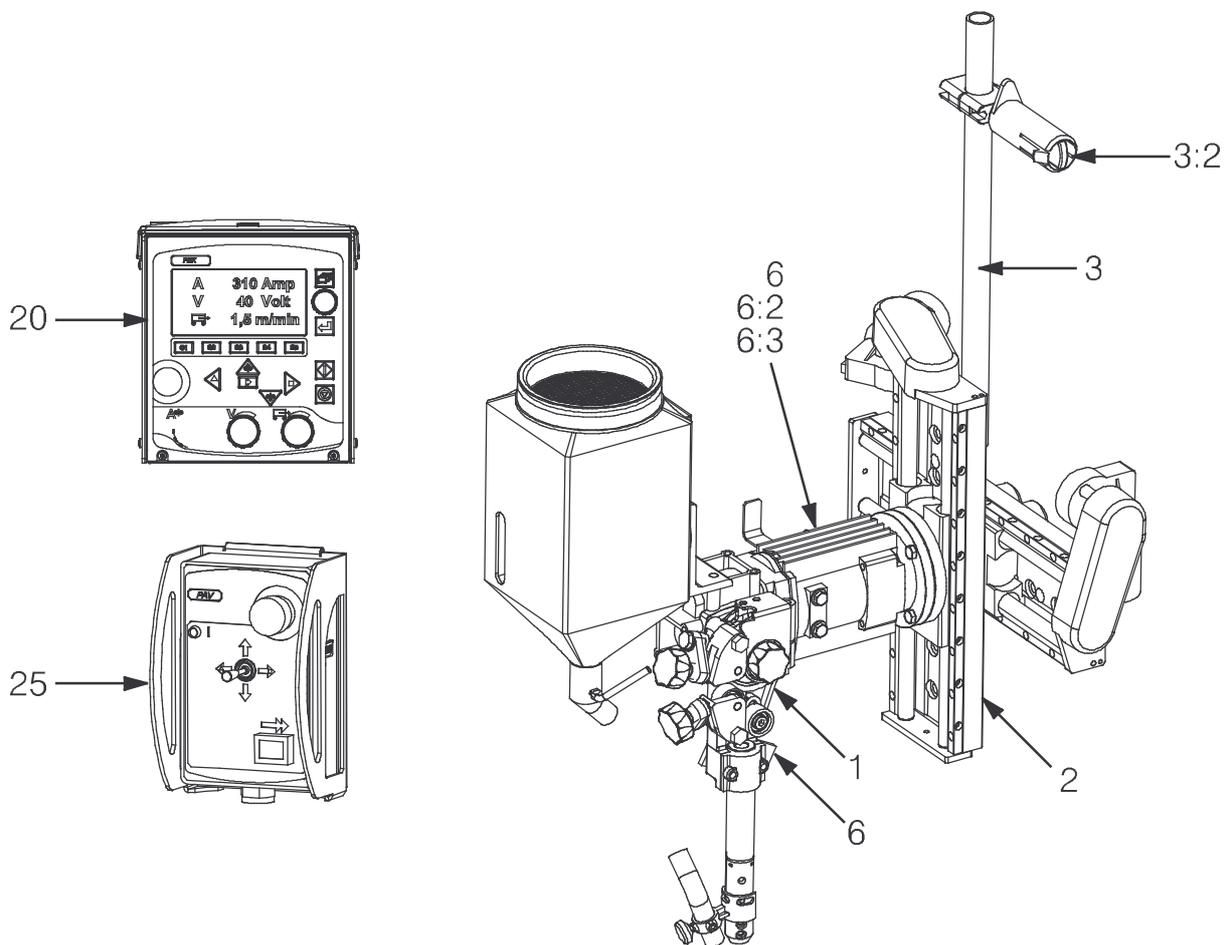


| Ordering no. | Denomination | Notes |
|--------------|--------------|---|
| 0449 270 900 | Welding head | A6 SF F1 SAW (156:1), manual slide, PEK |
| 0449 270 901 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK and A6 PAV |
| 0449 270 902 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK and A6 GMH |
| 0449 270 903 | Welding head | A6 SF F1 SAW (156:1), motorised slide |
| 0449 270 904 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK and A6 PAV |
| 0449 270 905 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK and A6 GMH |
| 0449 270 906 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |
| 0449 270 910 | Welding head | A6 SF F1 SAW (74:1), manual slide, PEK |
| 0449 270 911 | Welding head | A6 SF F1 SAW (74:1), motorised slide, PEK and A6 PAV |
| 0449 270 912 | Welding head | A6 SF F1 SAW (74:1), motorised slide, PEK and A6 GMH |
| 0449 270 913 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |
| 0449 270 914 | Welding head | A6 SF F1 SAW (74:1), motorised slide, PEK and A6 PAV |
| 0449 270 915 | Welding head | A6 SF F1 SAW (74:1), motorised slide, PEK and A6 GMH |
| 0449 270 916 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |
| 0449 271 900 | Welding head | A6 SF F1 SAW, Twin (156:1), manual slide, PEK |
| 0449 271 901 | Welding head | A6 SF F1 SAW, Twin (156:1), motorised slide, PEK and A6 PAV |
| 0449 271 902 | Welding head | A6 SF F1 SAW, Twin (156:1), motorised slide, PEK and A6 GMH |
| 0449 271 903 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |
| 0449 271 904 | Welding head | A6 SF F1 SAW, Twin (156:1), motorised slide, PEK and A6 PAV |
| 0449 271 905 | Welding head | A6 SF F1 SAW, Twin (156:1), motorised slide, PEK and A6 GMH |
| 0449 270 906 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |
| 0449 271 910 | Welding head | A6 SF F1 SAW, Twin (74:1), manual slide, PEK |
| 0449 271 911 | Welding head | A6 SF F1 SAW, Twin (74:1), motorised slide, PEK and A6 PAV |
| 0449 271 912 | Welding head | A6 SF F1 SAW, Twin (74:1), motorised slide, PEK and A6 GMH |
| 0449 271 913 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |
| 0449 271 914 | Welding head | A6 SF F1 SAW, Twin (74:1), motorised slide, PEK and A6 PAV |
| 0449 271 915 | Welding head | A6 SF F1 SAW, Twin (74:1), motorised slide, PEK and A6 GMH |
| 0449 271 916 | Welding head | A6 SF F1 SAW (156:1), motorised slide, PEK |

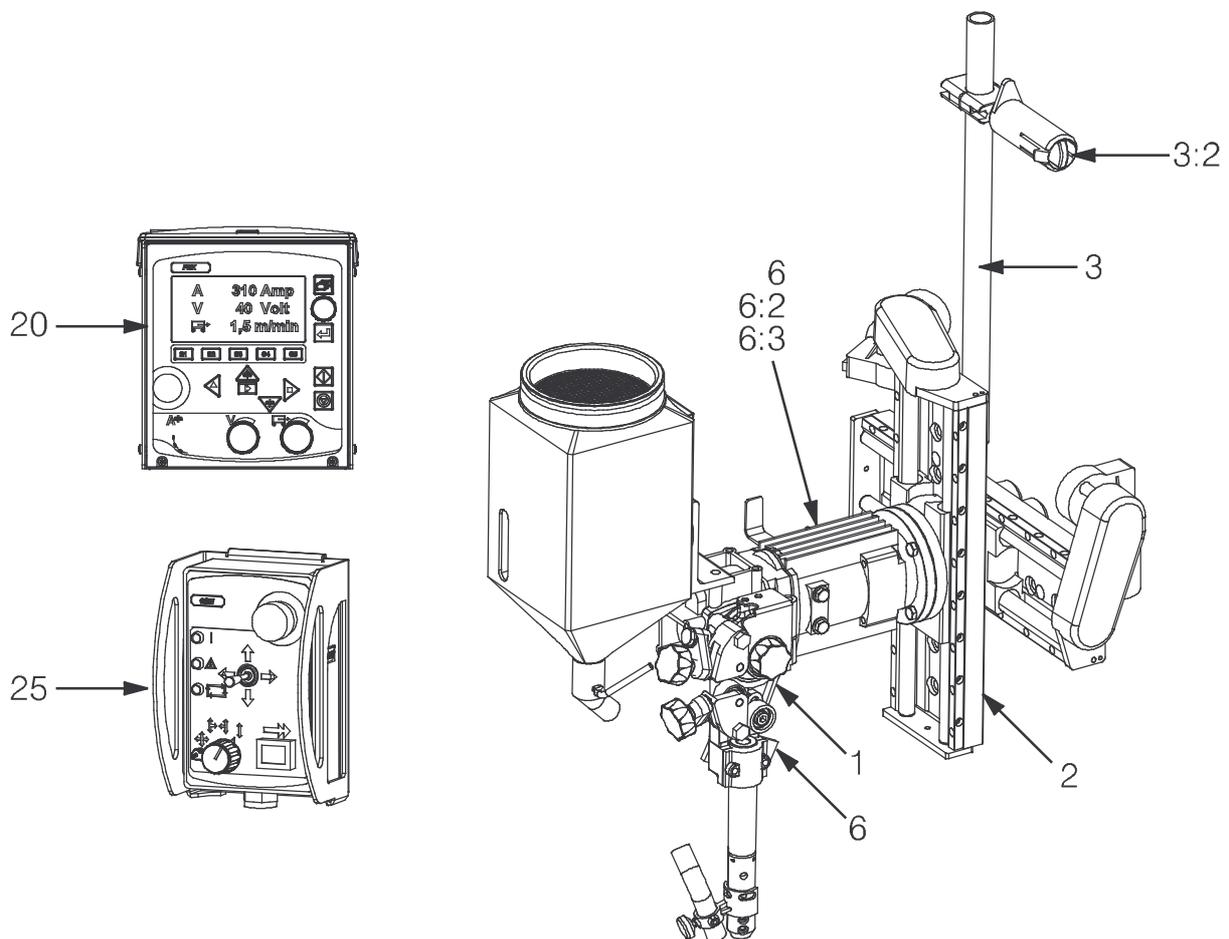
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|----------|-----|-------------------|--------------------------------|-----------------------------|
| | | 0449270900 | Welding head with PEK | A6SF F1, SAW (156:1) |
| 1 | 1 | 0449250880 | Wire feed unit (right mounted) | 156:1 |
| 2 | 1 | 0449252881 | Slide travel kit, manual | 210mm |
| 3 | 1 | 0449255881 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |



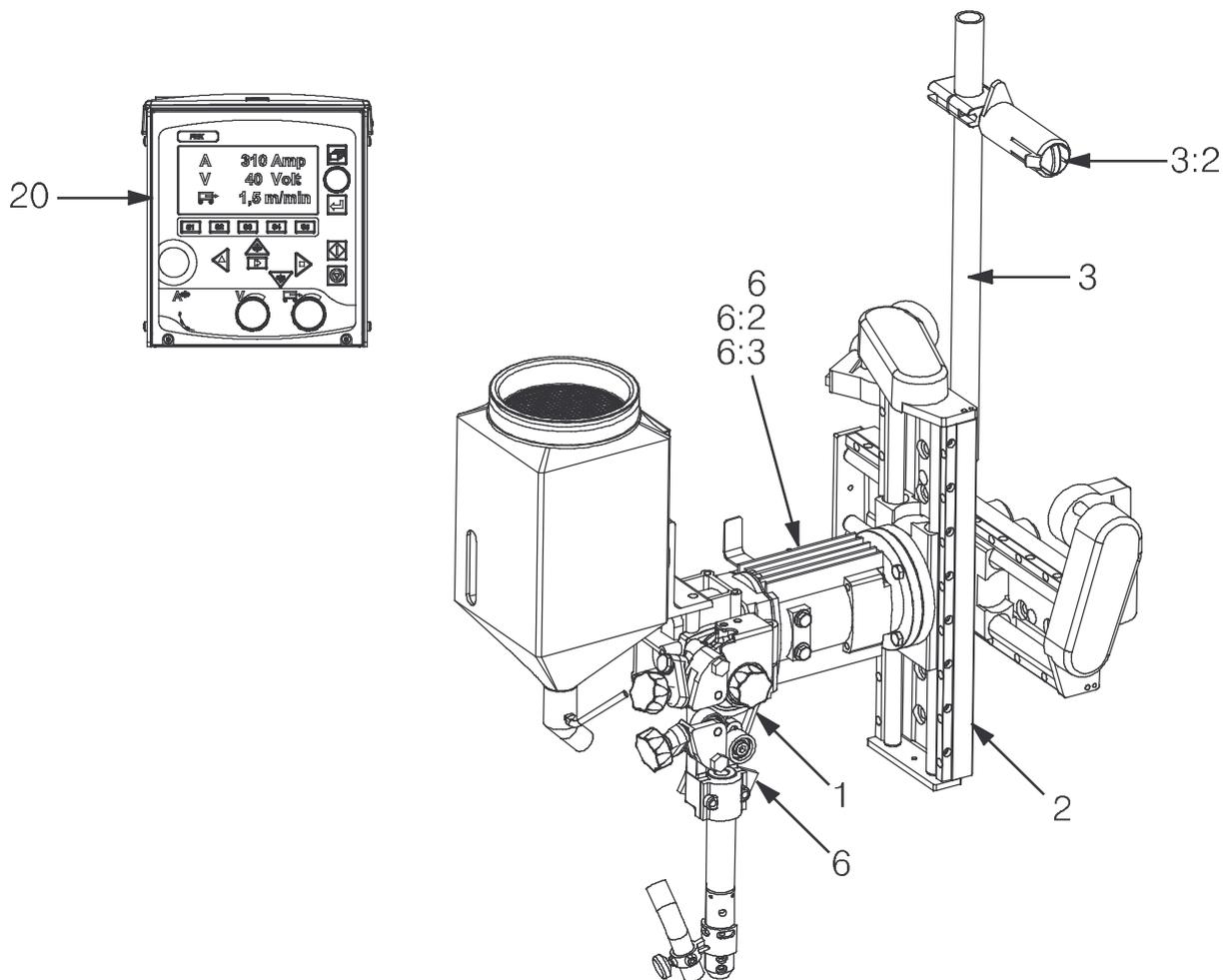
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270901 | Welding head with PAV and PEK | A6SF F1, SAW (156:1) |
| 1 | 1 | 0449250880 | Wire feed unit (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



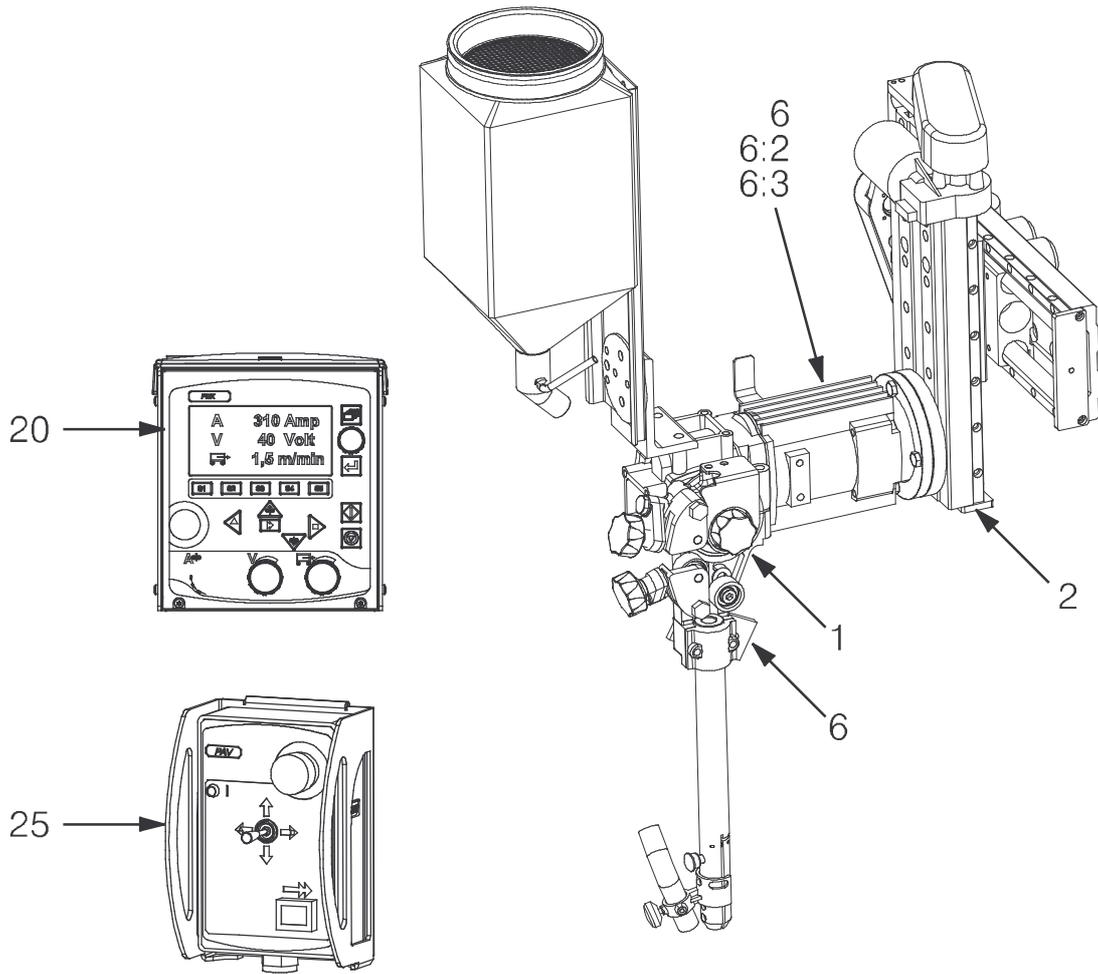
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| | | 0449270902 | Welding head with GMH and PEK | A6SF F1, SAW (156:1) |
| 1 | 1 | 0449250880 | Wire feed unit (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



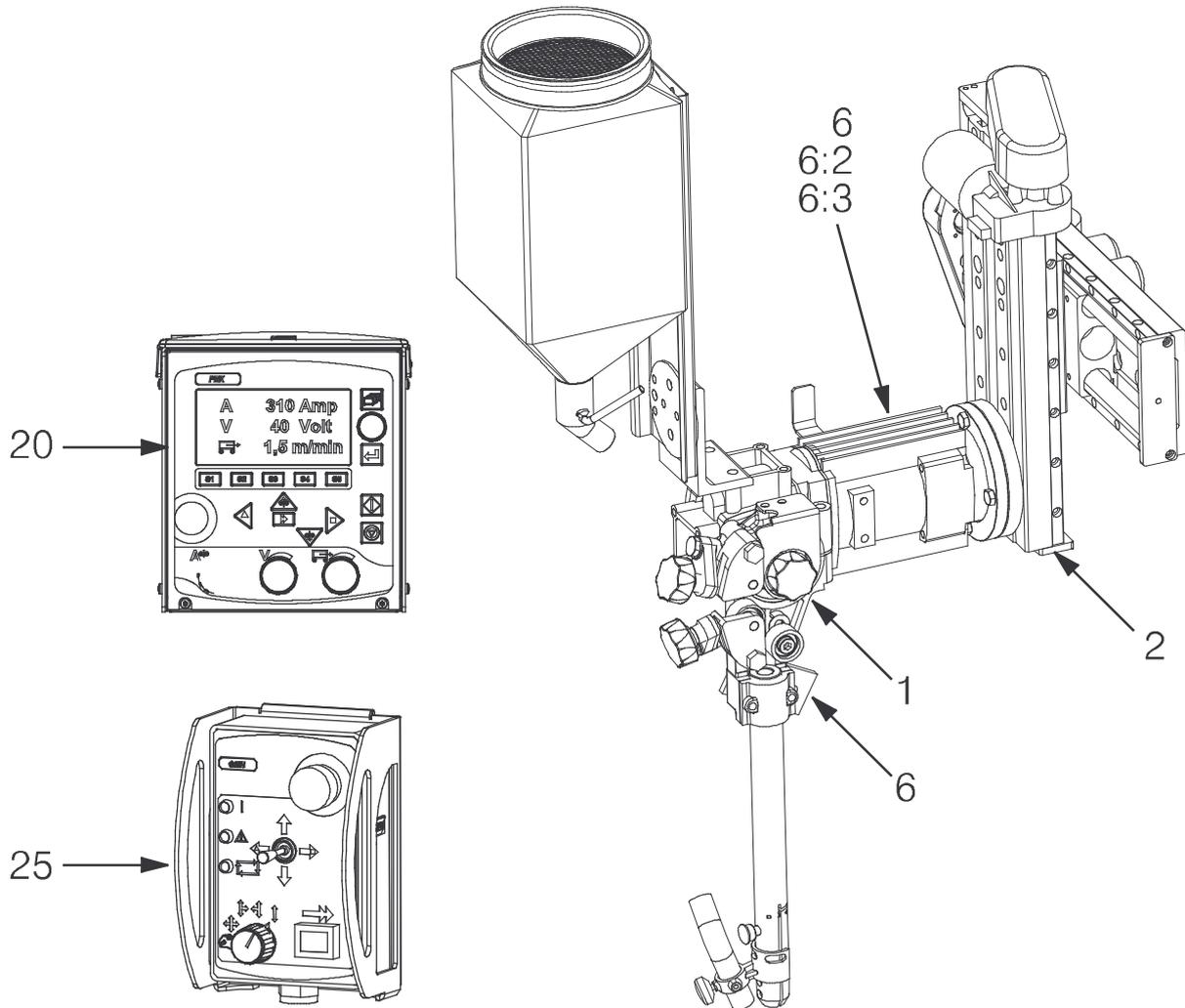
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|----------|-----|-------------------|--------------------------------|-----------------------------|
| | | 0449270903 | Welding head with PEK | A6SF F1, SAW (156:1) |
| 1 | 1 | 0449250880 | Wire feed unit (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, see separate manual |



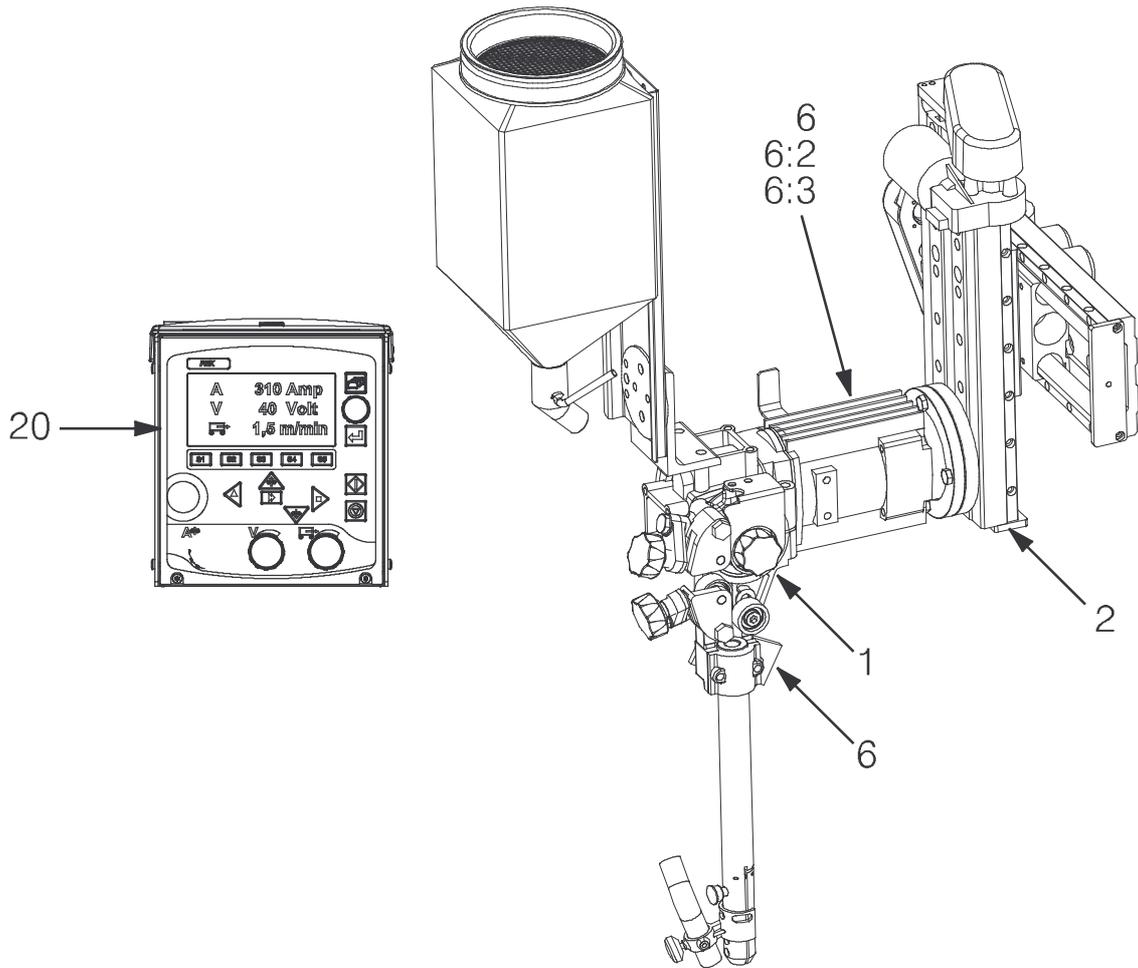
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270904 | Welding head with PAV and PEK | A6SF F1, SAW (156:1) |
| 1 | 1 | 0449250882 | Wire feed unit | 156:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | 5 m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK. See separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |



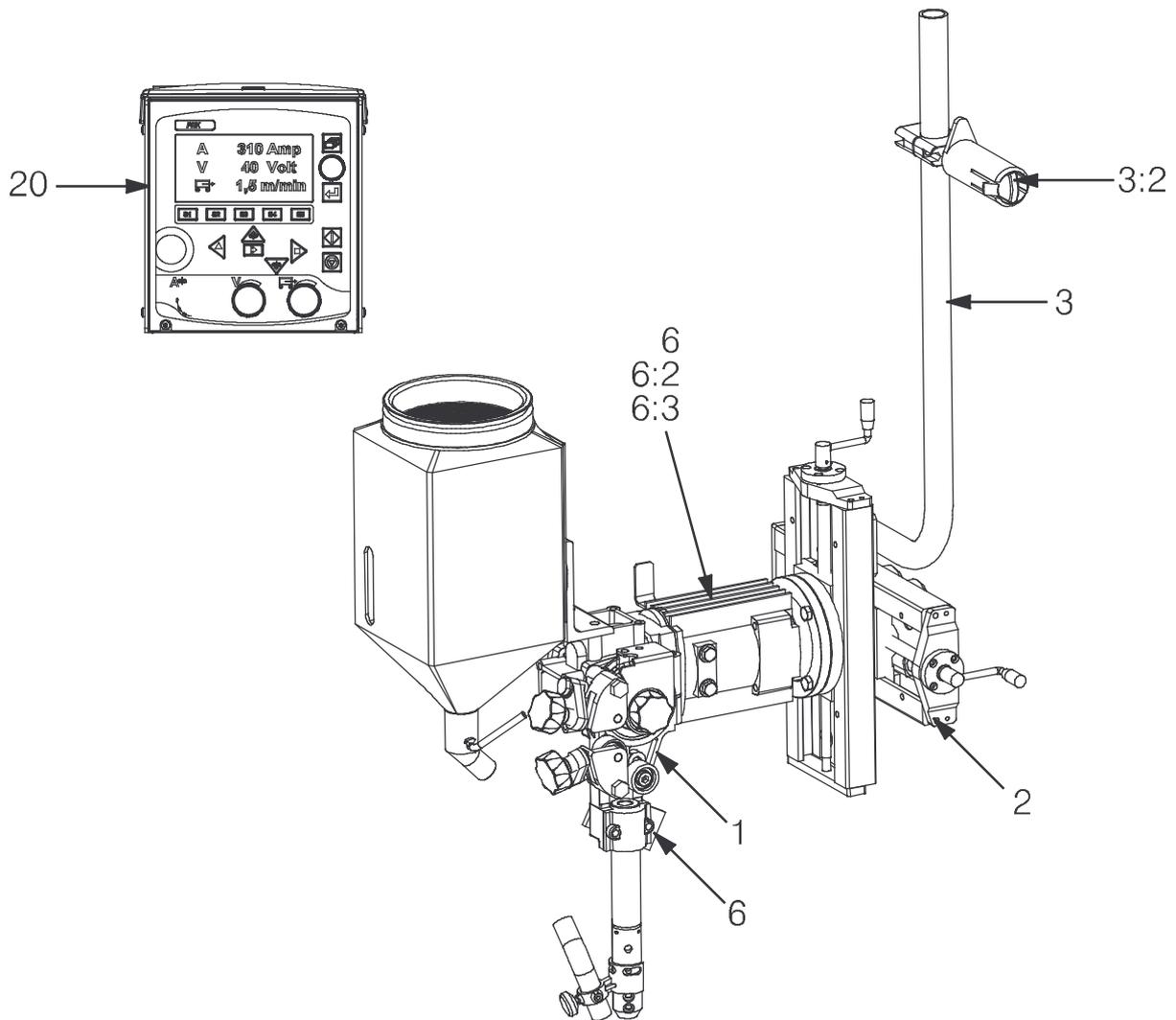
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270905 | Welding head with GMH and PEK | A6SF F1, SAW (156:1) |
| 1 | 1 | 0449250882 | Wire feed unit | 156:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300 mm |
| 6 | 1 | 0449253902 | Cable set | 5 m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK. See separate manual |
| 25 | 1 | 0460884880 | Joint tracking unit | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |



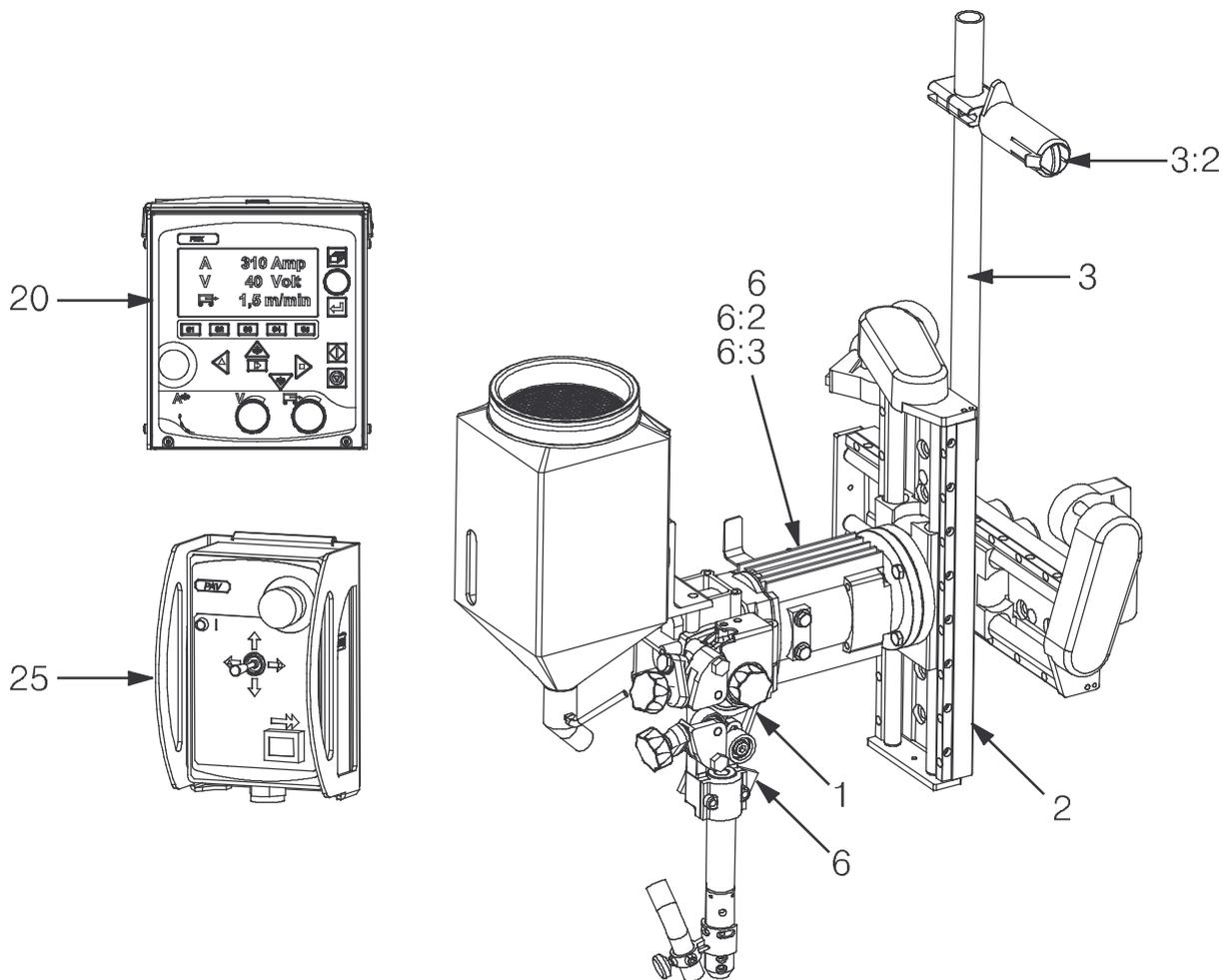
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|--------------|-----------------------------|--------------------------|
| 1 | 1 | 0449270906 | Welding head with PEK | A6SF F1, SAW (156:1) |
| 2 | 1 | 0449250882 | Wire feed unit | 156:1 |
| 6 | 1 | 0449251885 | Slide travel kit, motorised | 300 mm |
| 6 | 1 | 0449253902 | Cable set | 5 m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |



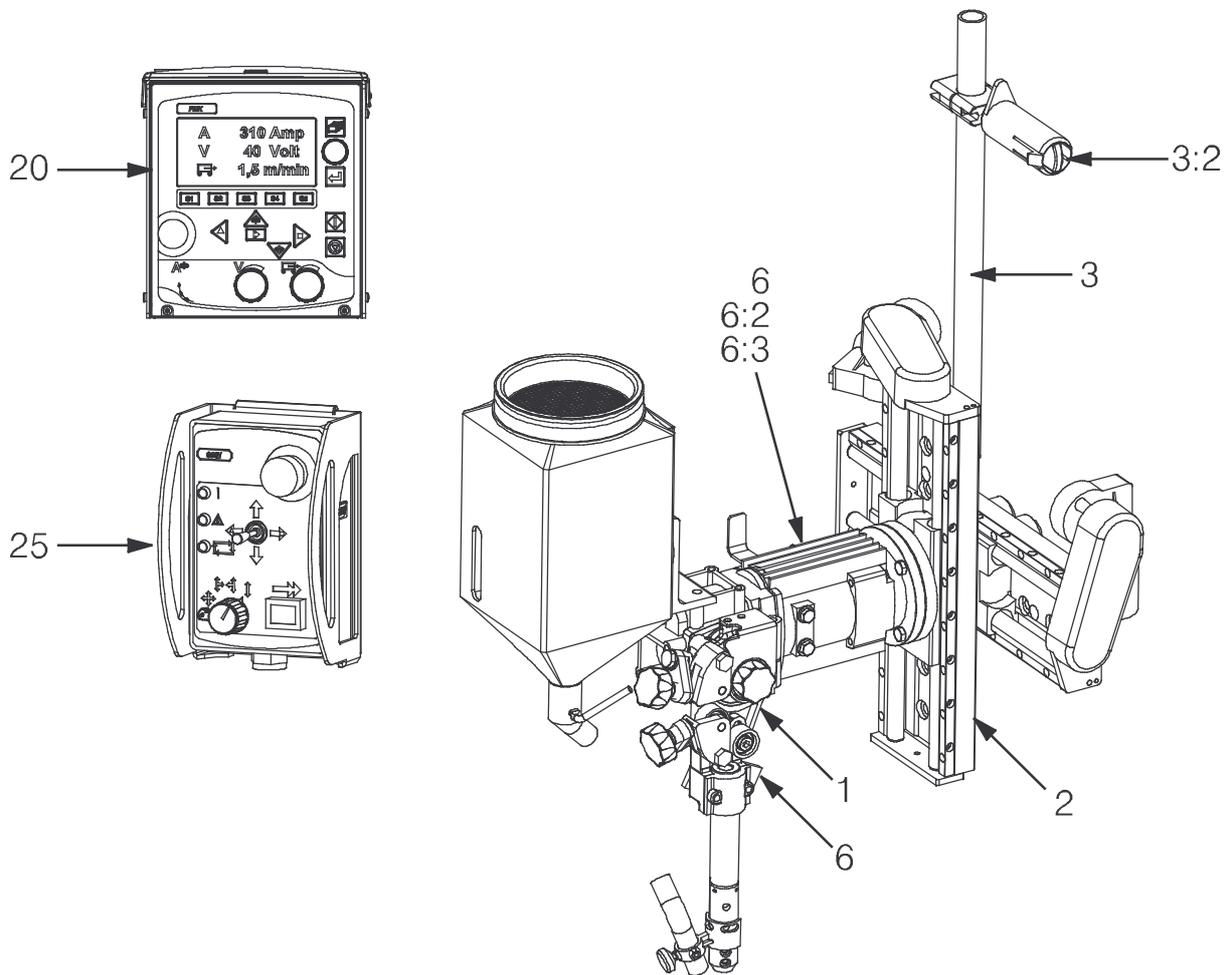
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|----------|-----|-------------------|--------------------------------|----------------------------|
| | | 0449270910 | Welding head with PEK | A6SF F1, SAW (74:1) |
| 1 | 1 | 0449250890 | Wire feed unit (right mounted) | 74:1 |
| 2 | 1 | 0449252881 | Slide travel kit, manual | 210mm |
| 3 | 1 | 0449255881 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |



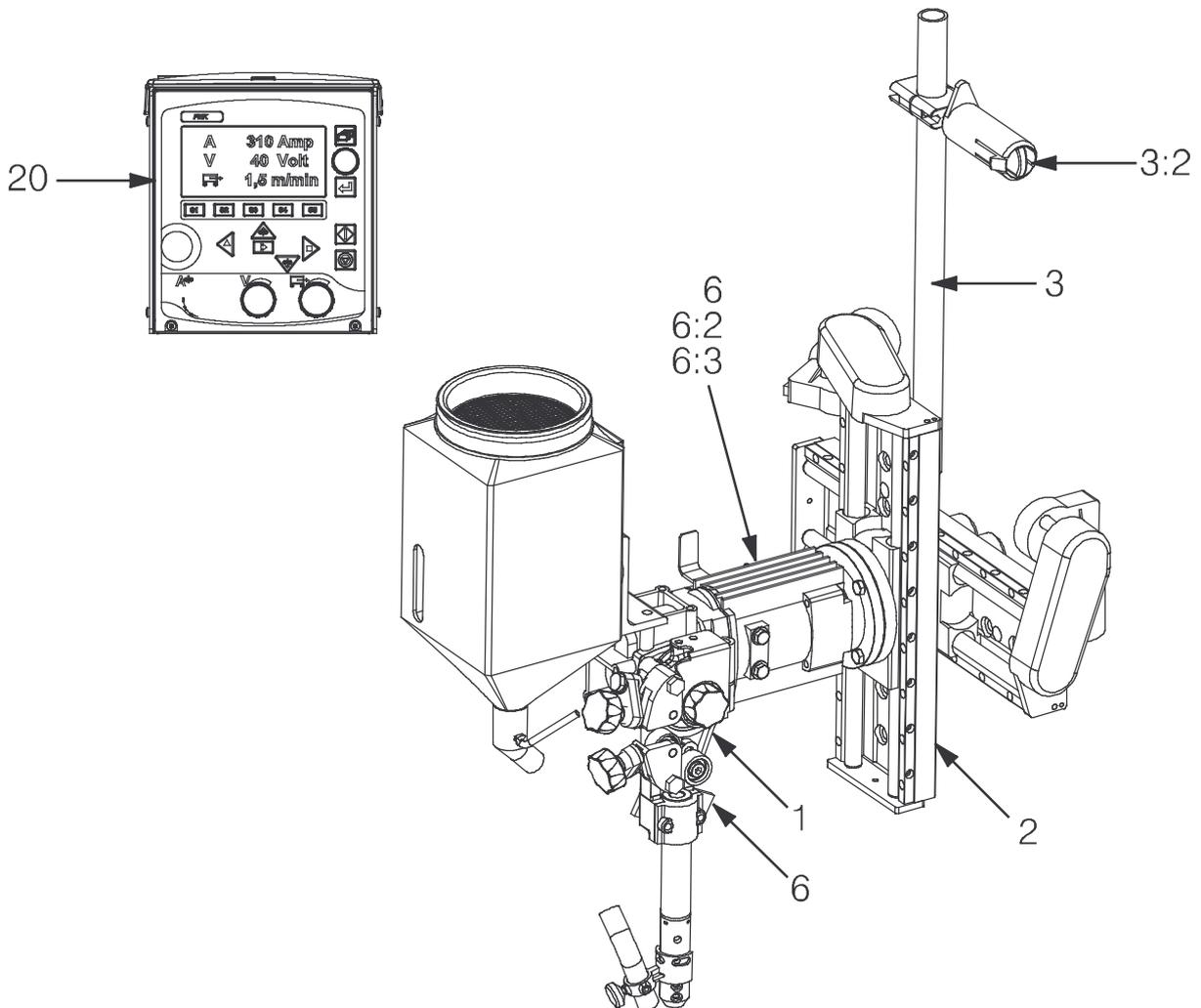
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270911 | Welding head with PAV and PEK | A6SF F1, SAW (74:1) |
| 1 | 1 | 0449250890 | Wire feed unit (right mounted) | 74:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



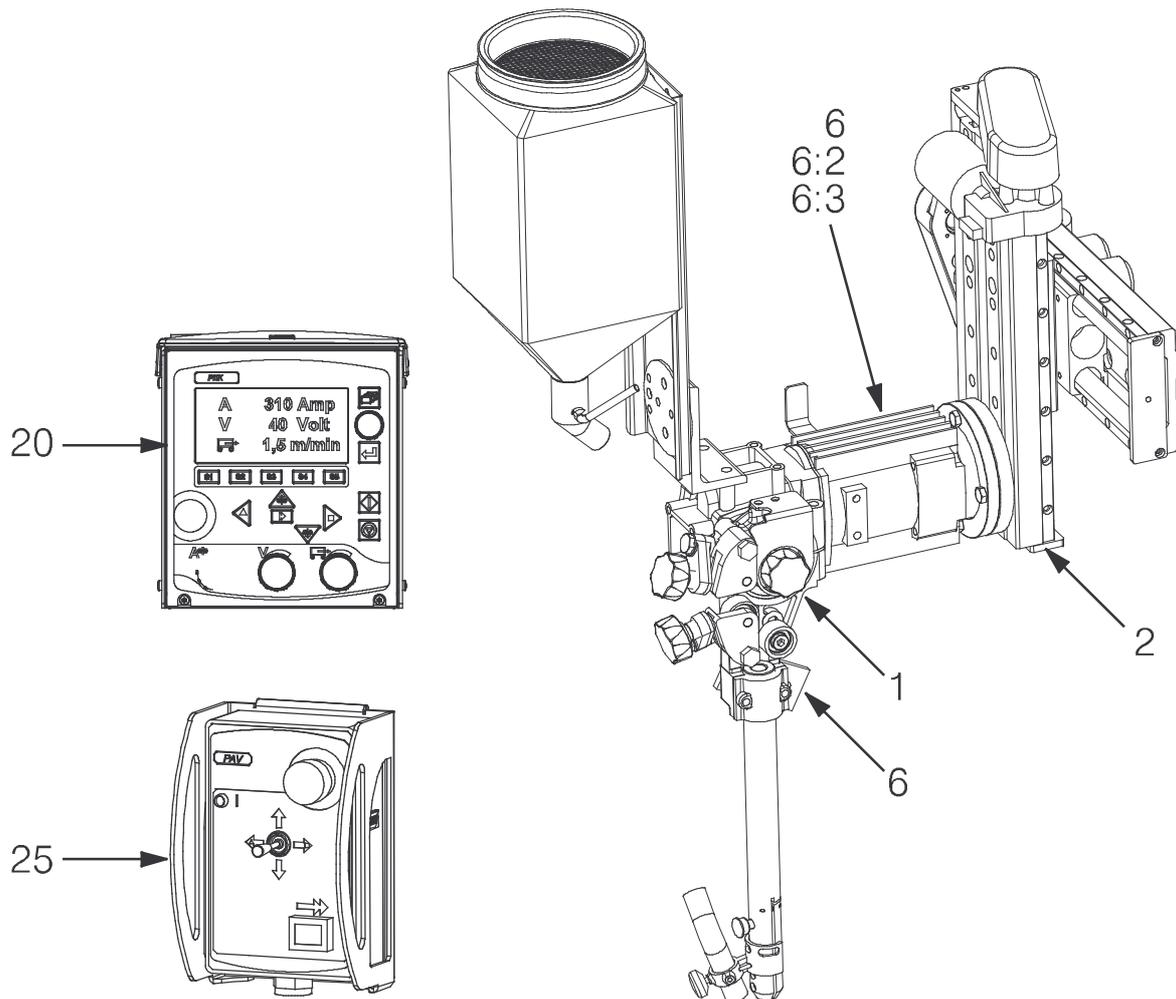
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270912 | Welding head with GMH and PEK | A6SF F1, SAW (74:1) |
| 1 | 1 | 0449250890 | Wire feed unit (right mounted) | 74:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5 m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0416215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



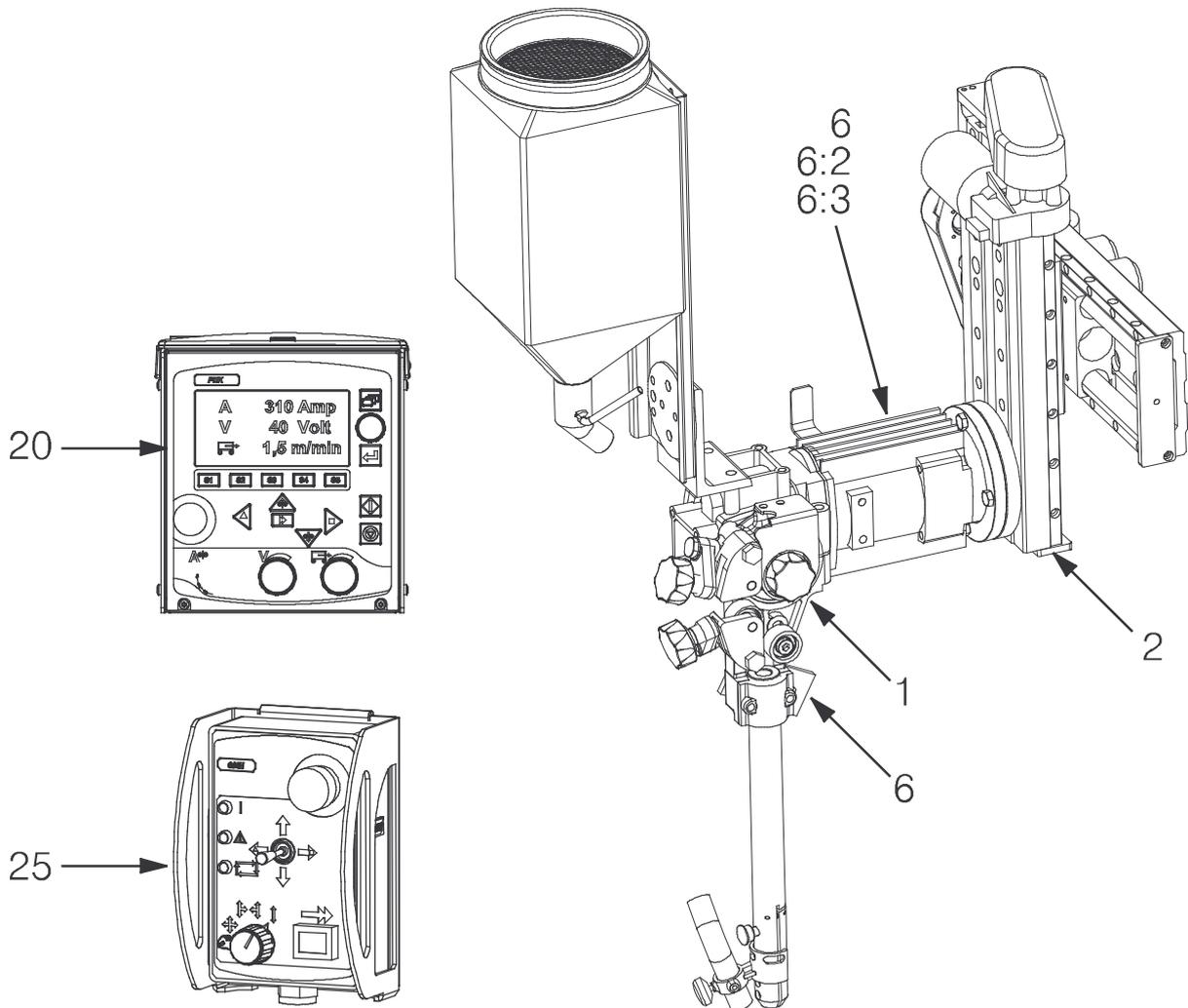
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|----------|-----|-------------------|--------------------------------|----------------------------|
| | | 0449270913 | Welding head with PEK | A6SF F1, SAW (74:1) |
| 1 | 1 | 0449250890 | Wire feed unit (right mounted) | 74:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300 mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5 m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, see separate manual |



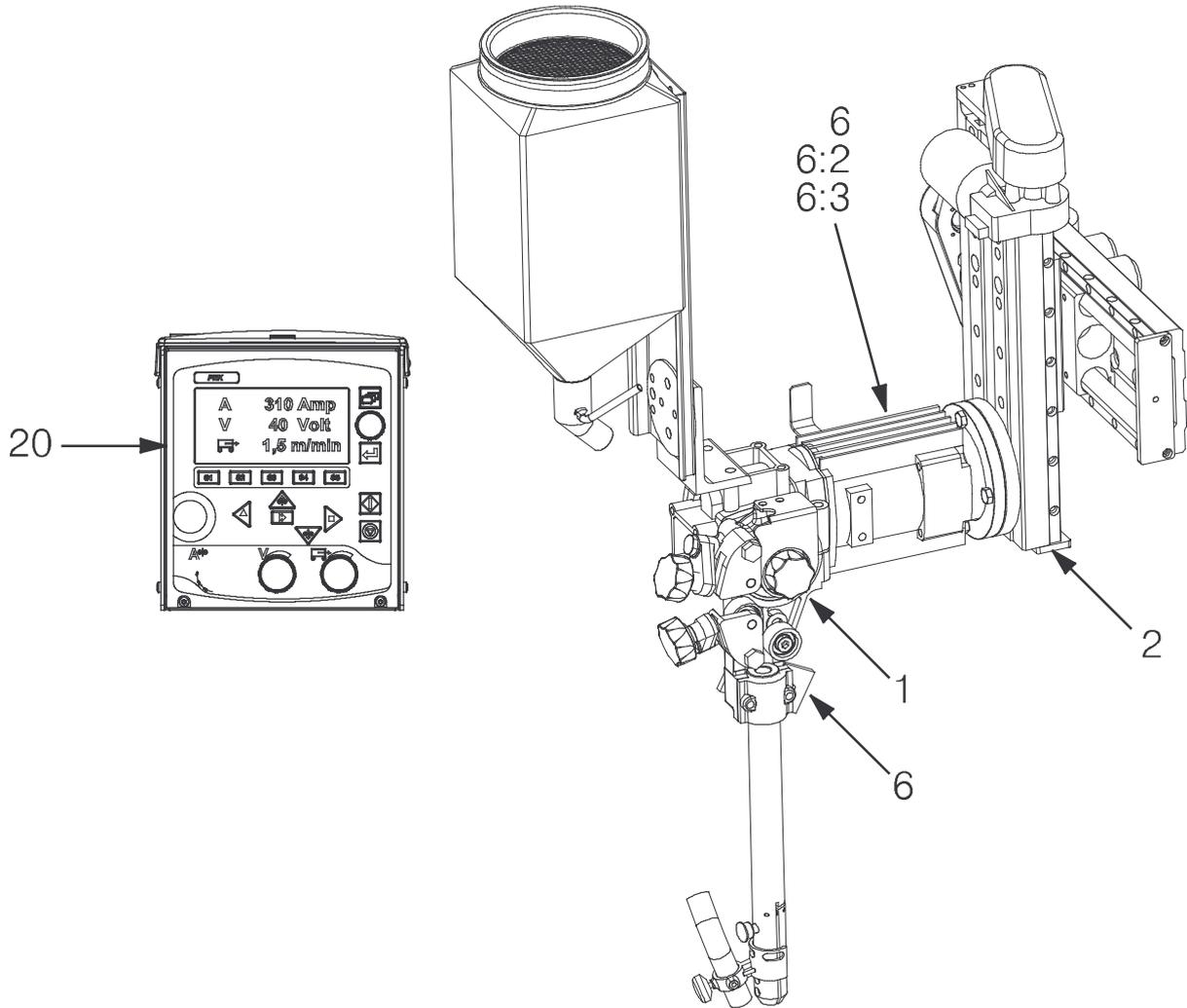
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270914 | Welding head with PAV and PEK | A6SF F1, SAW (74:1) |
| 1 | 1 | 0449250892 | Wire feed unit (Right mounted) | 74:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | 5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK. See separate manual |
| 25 | 1 | 0460697880 | Joint tracking system | A6 PAV, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |



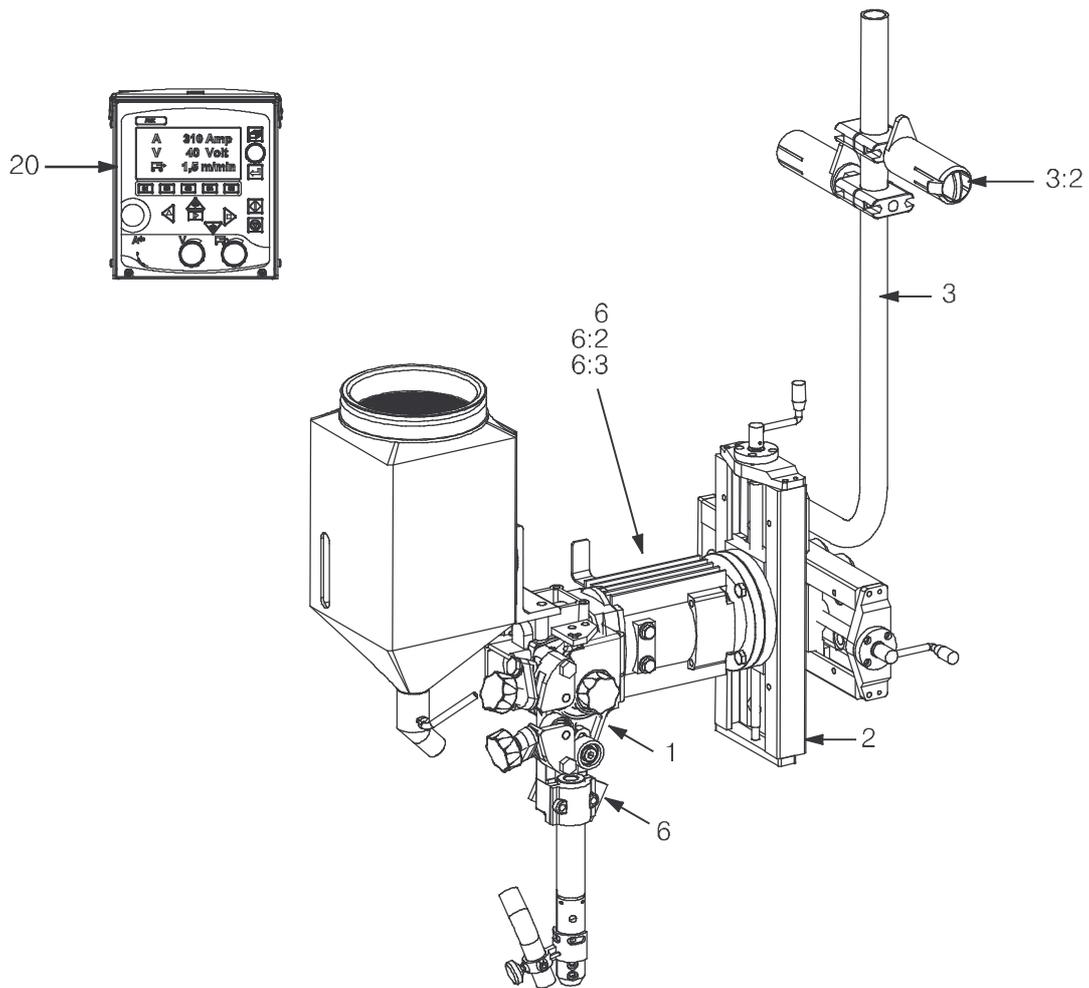
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|----------|-----|-------------------|--------------------------------------|-----------------------------|
| | | 0449270915 | Welding head with GMH and PEK | A6SF, SAW (74:1) |
| 1 | 1 | 0449250892 | Wire feed unit (right mounted) | 74:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | 5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK. See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |



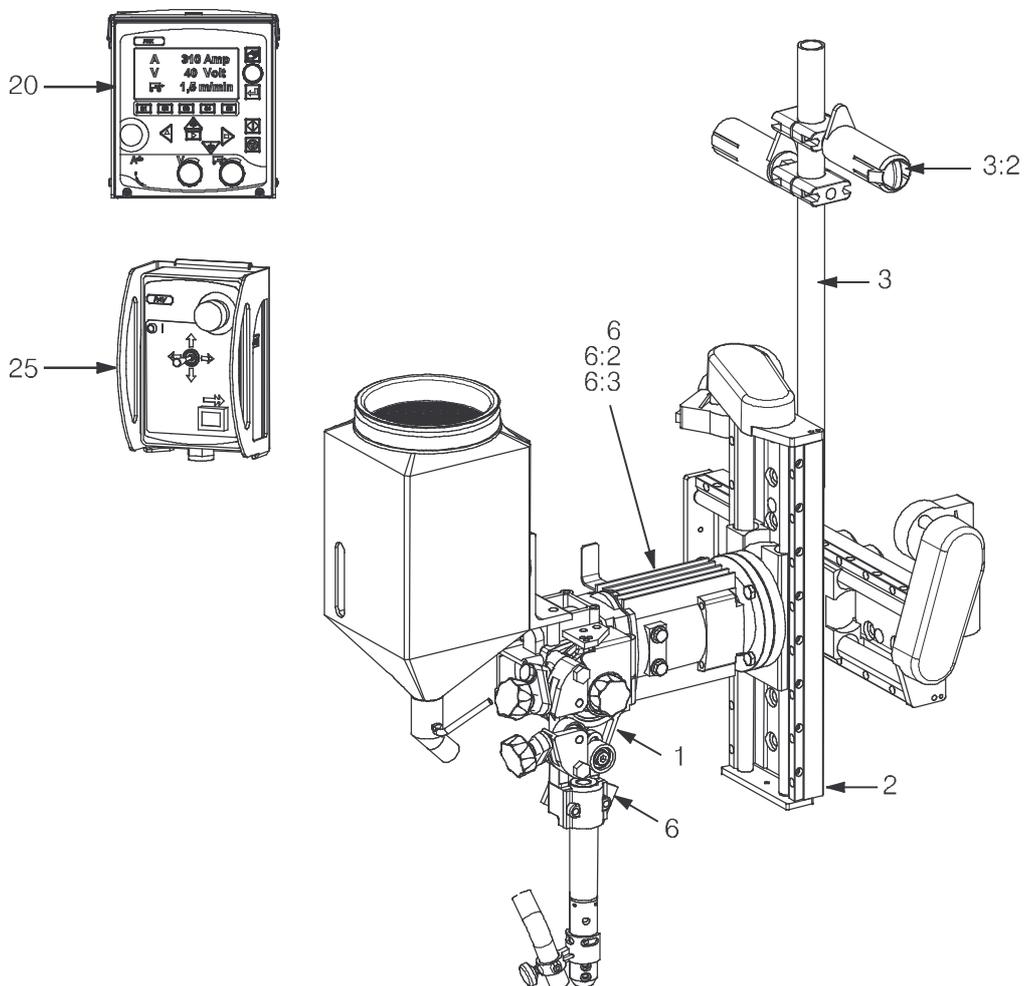
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|----------|-----|-------------------|--------------------------------|----------------------------|
| | | 0449270916 | Welding head with PEK | A6SF F1, SAW (74:1) |
| 1 | 1 | 0449250892 | Wire feed unit (right mounted) | 74:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | 5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |



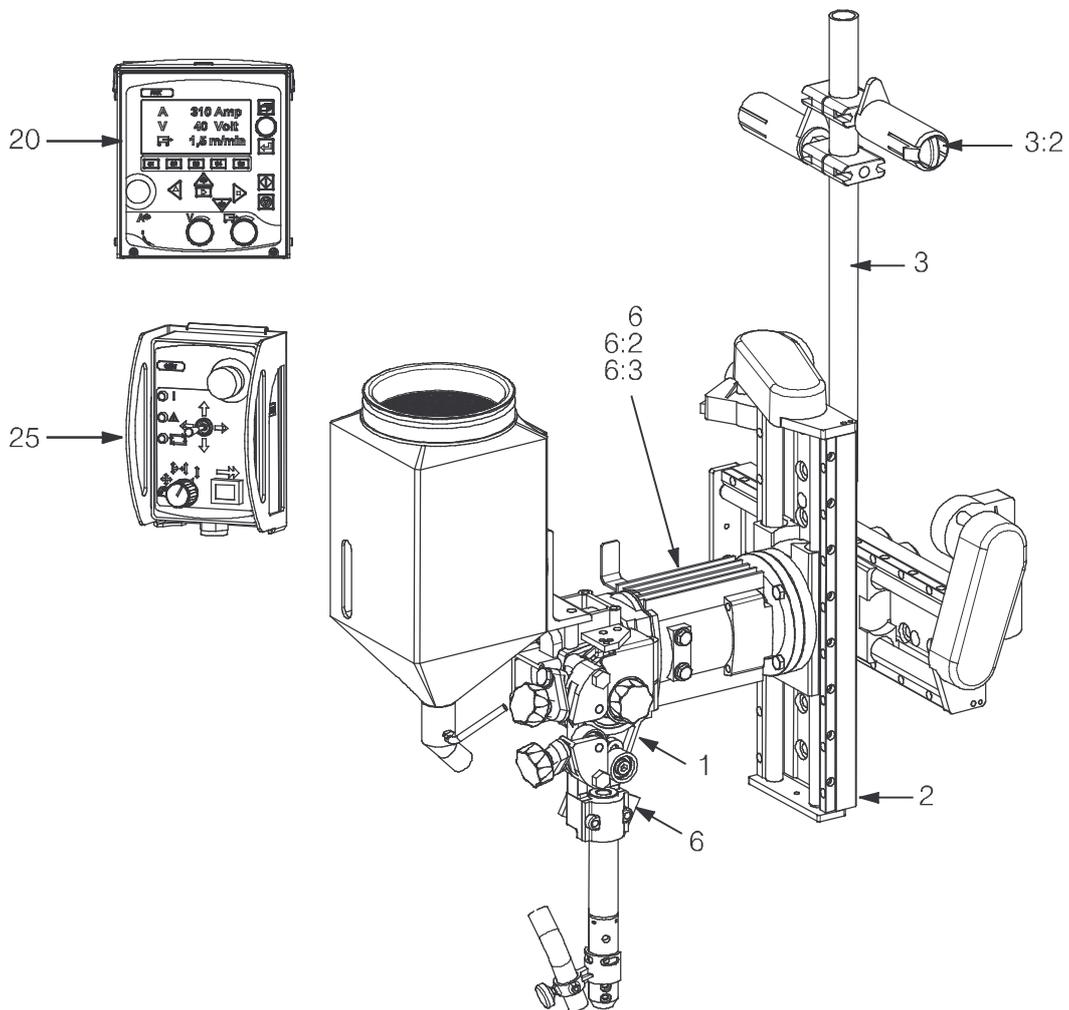
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|----------|-----|-------------------|--------------------------------------|----------------------------------|
| | | 0449271900 | Welding head with PEK | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250881 | Wire feed unit, Twin (right mounted) | 156:1 |
| 2 | 1 | 0449252881 | Slide travel kit, manual | 210mm |
| 3 | 1 | 0449255881 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |



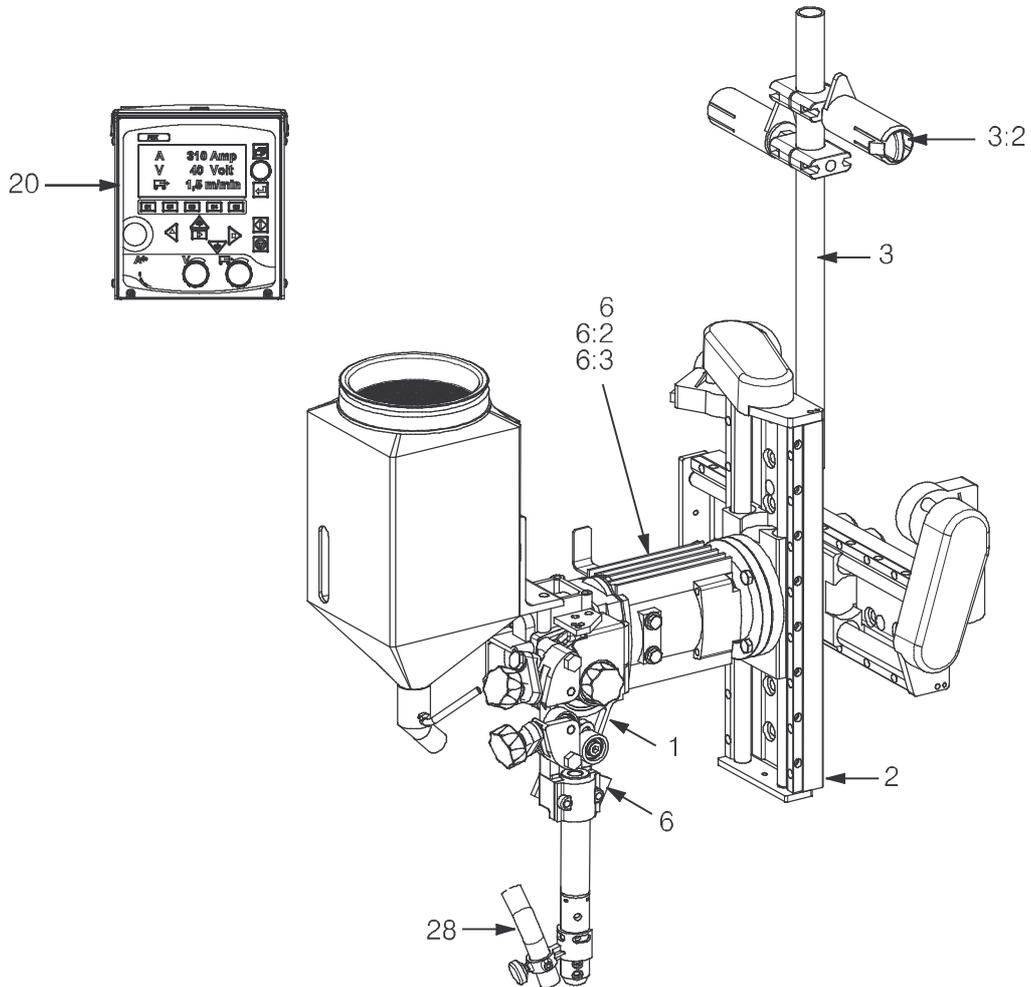
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|----------|-----|-------------------|--------------------------------------|----------------------------------|
| | | 0449271901 | Welding head with PEK and PAV | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250881 | Wire feed unit, Twin (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



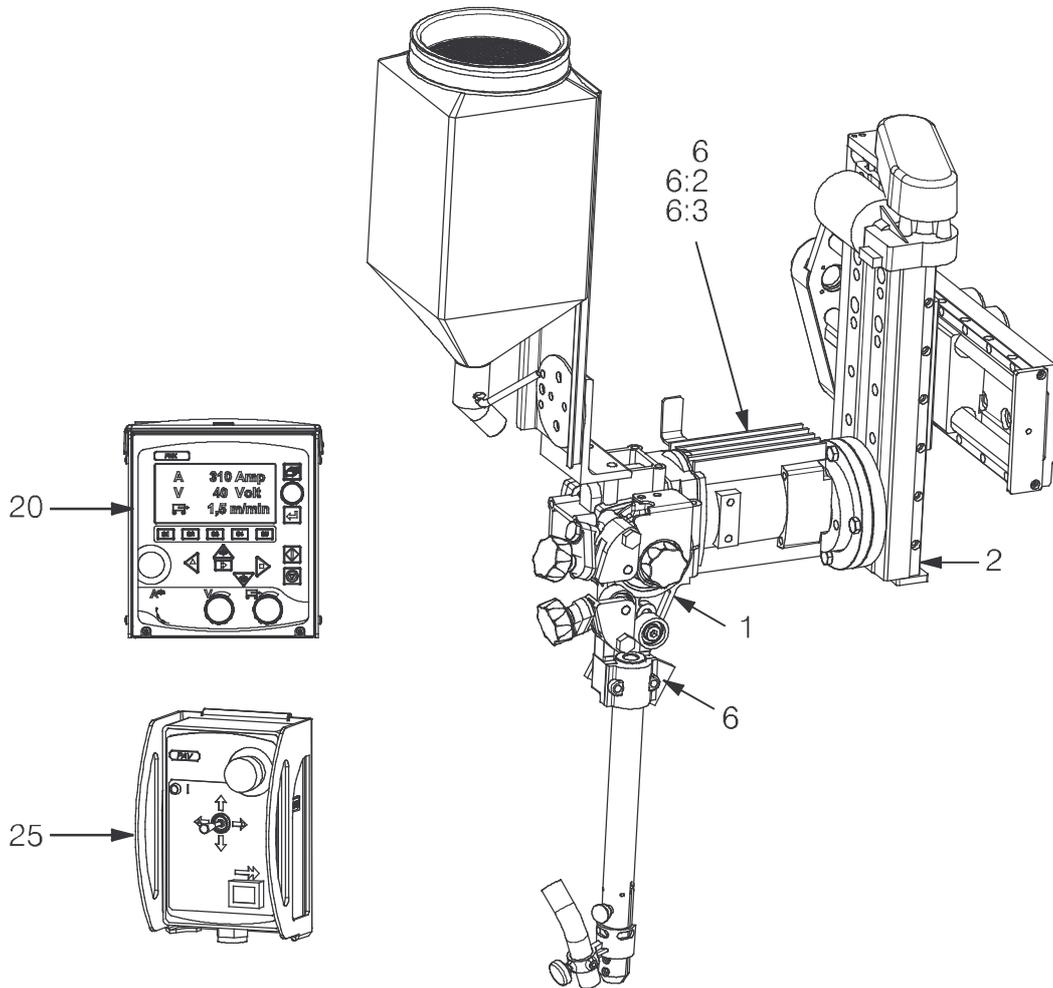
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| | | 0449271902 | Welding head with PEK and GMH | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250881 | Wire feed unit, Twin (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



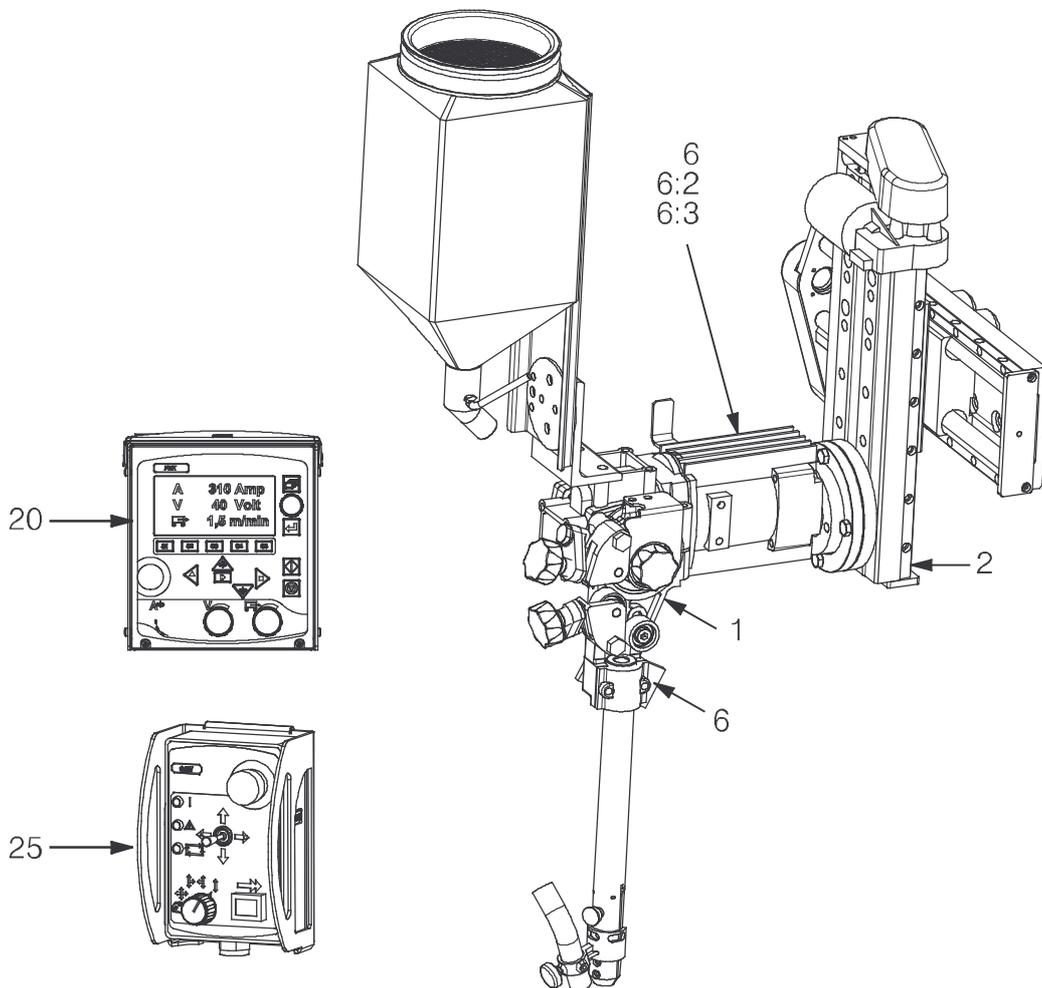
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| | | 0449271903 | Welding head with PEK | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250881 | Wire feed unit, Twin (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300 mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l = 5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 28 | | 0443383001 | Flux hose | d32/25 |



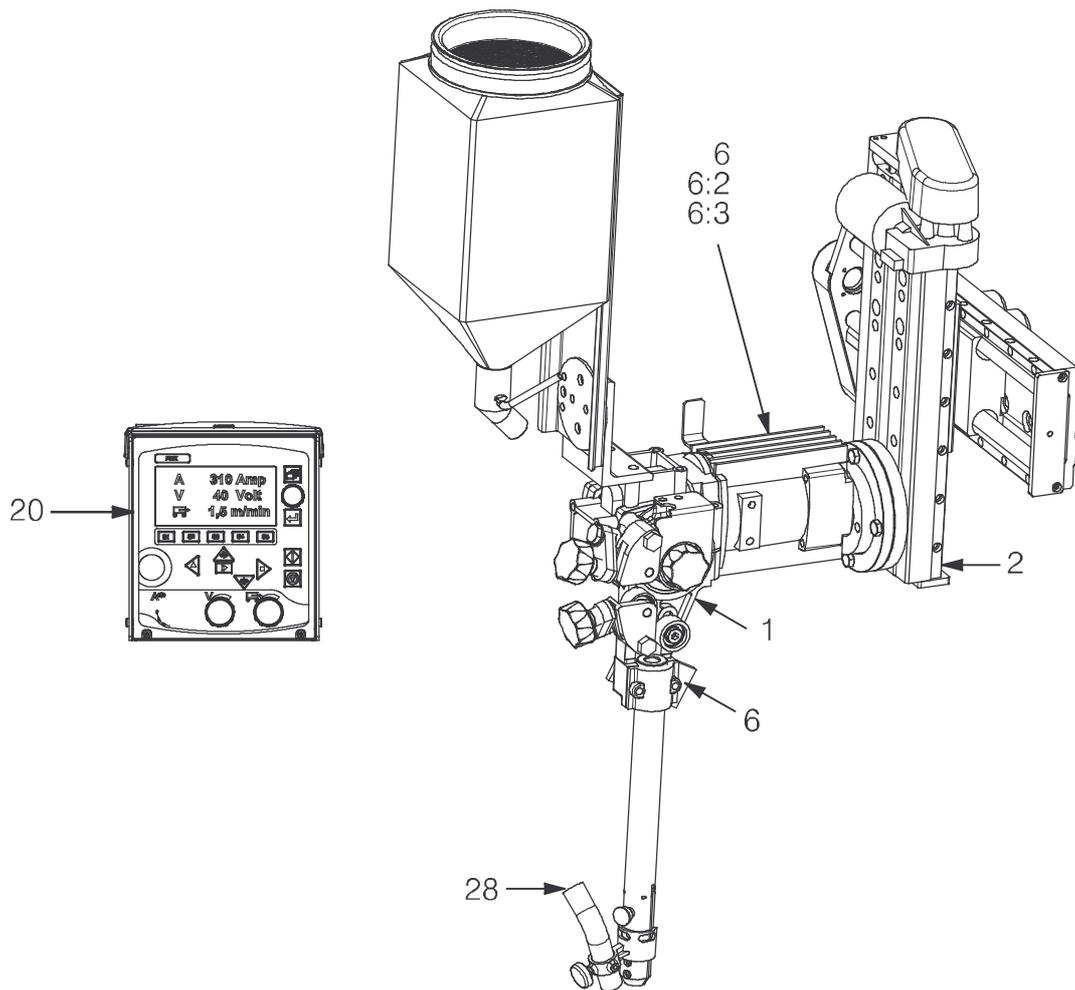
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| | | 0449271904 | Welding head with PEK and PAV | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250883 | Wire feed unit, Twin | 156:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | l= 5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, see separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV, see separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



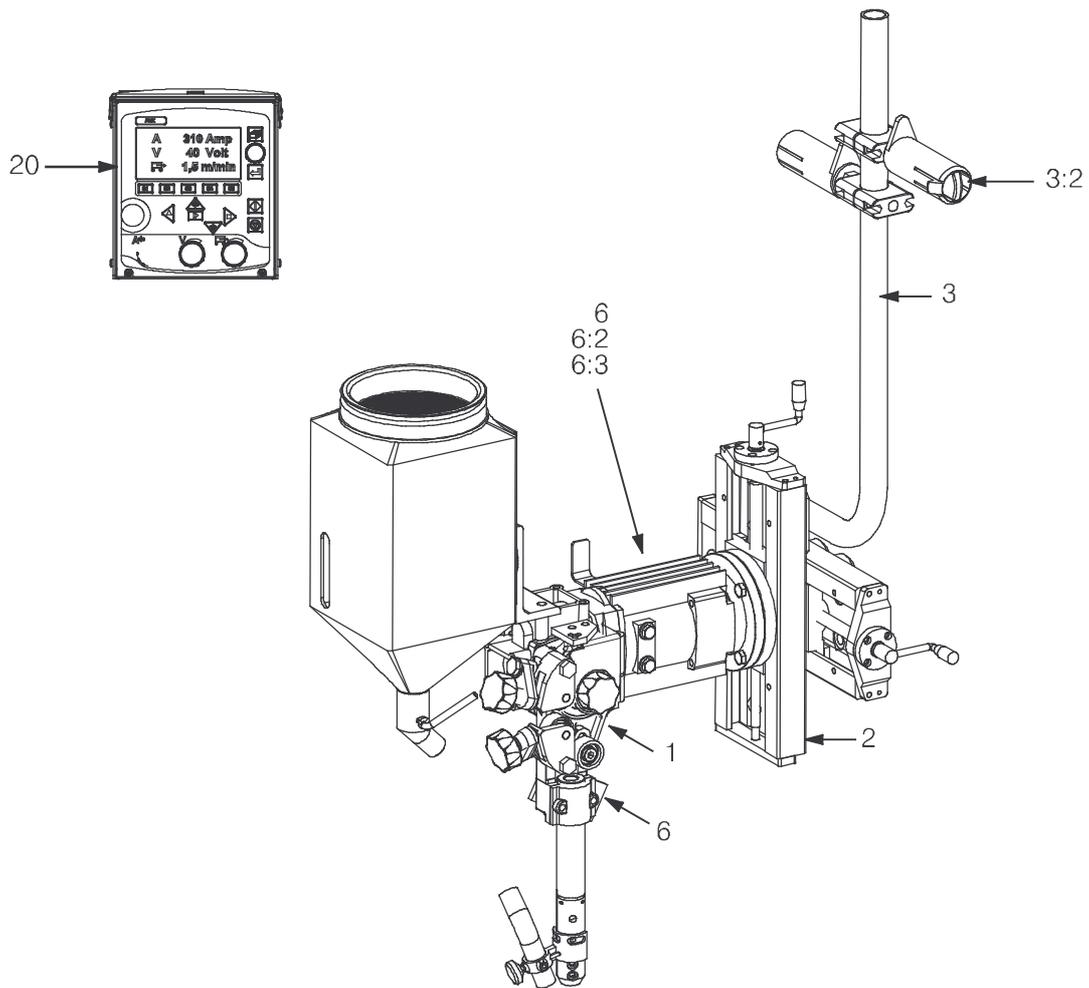
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|----------|-----|-------------------|--------------------------------------|----------------------------------|
| | | 0449271905 | Welding head with PEK and GMH | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250883 | Wire feed unit, Twin (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



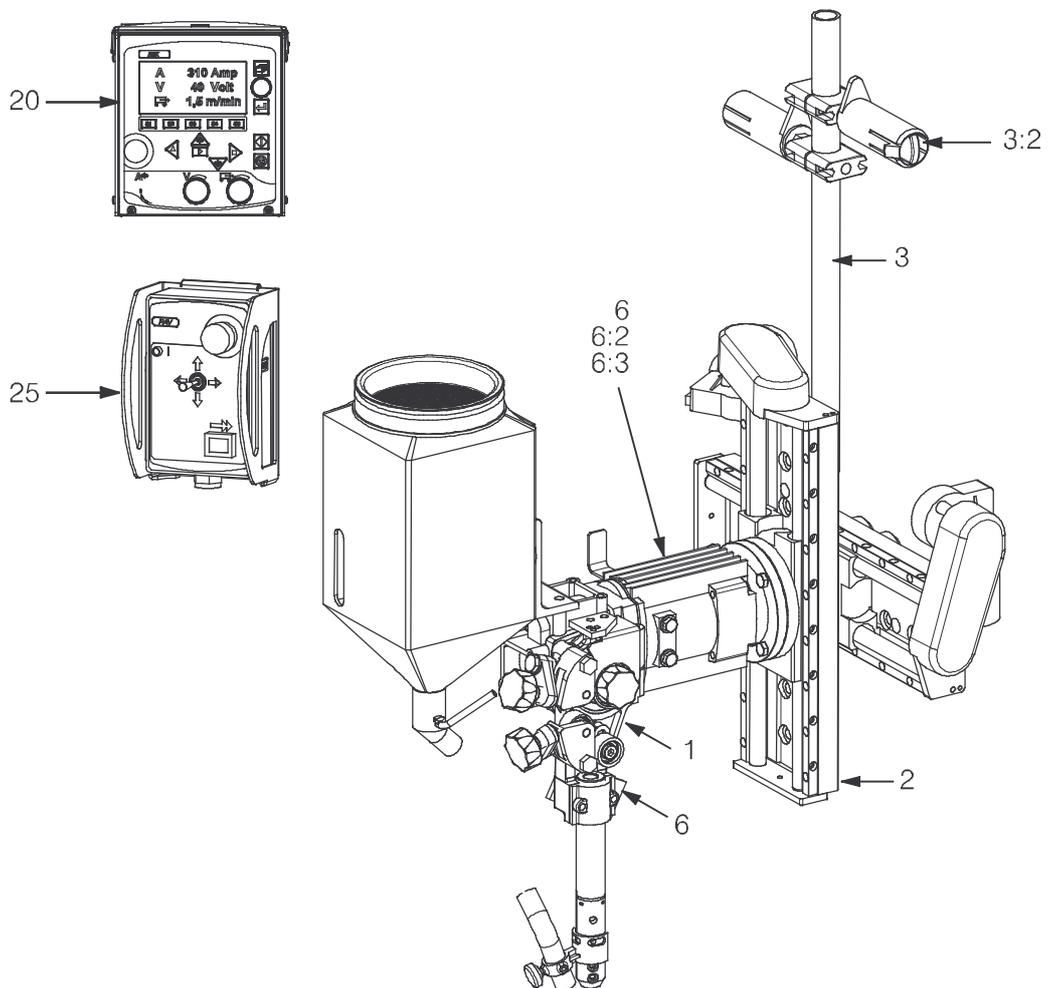
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|----------|-----|-------------------|--------------------------------------|----------------------------------|
| | | 0449271906 | Welding head with PEK | A6SF F1 Twin, SAW (156:1) |
| 1 | 1 | 0449250881 | Wire feed unit, Twin (right mounted) | 156:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 28 | | 0443383001 | Flux hose | d32/25 |



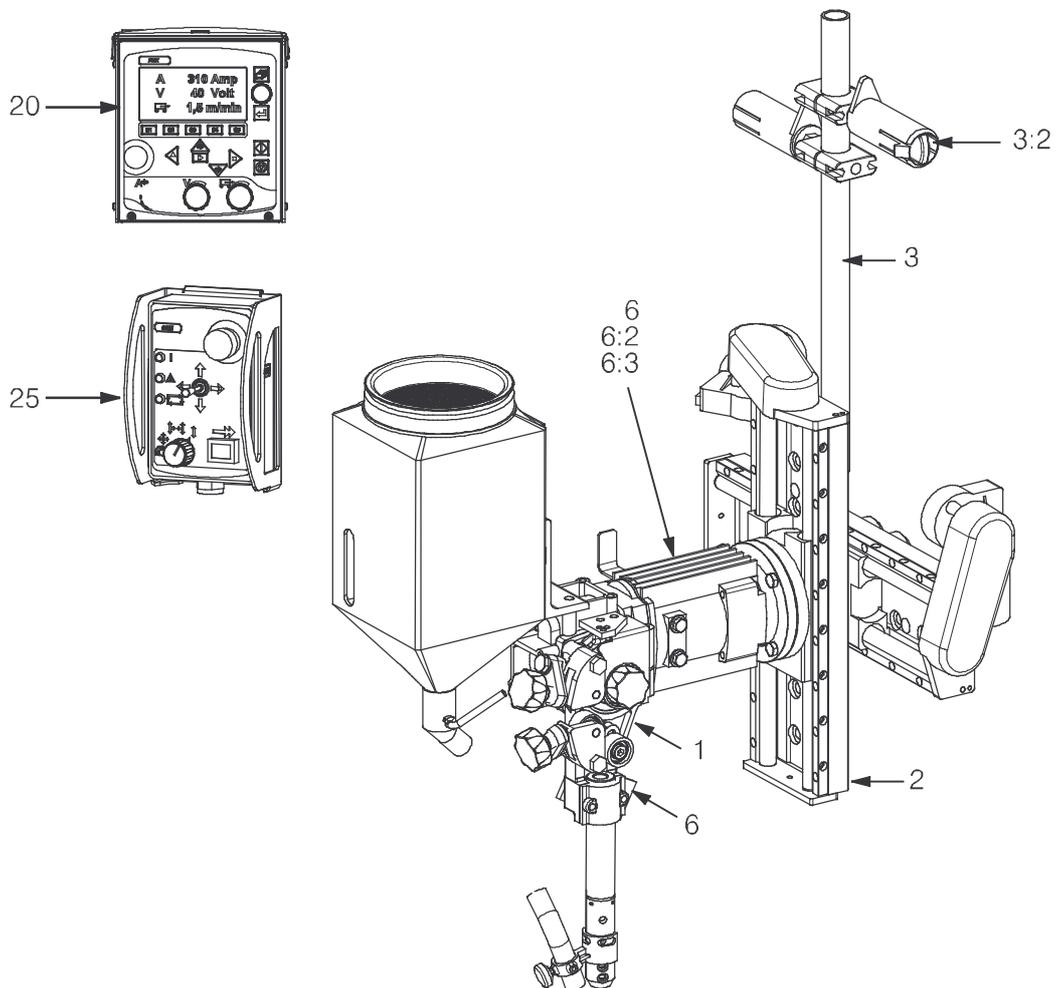
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------------------------|---------------------------------|
| | | 0449271910 | Welding head with PEK | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250891 | Wire feed unit, Twin (right mounted) | 74:1 |
| 2 | 1 | 0449252881 | Slide travel kit, manual | 210mm |
| 3 | 1 | 0449255881 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |



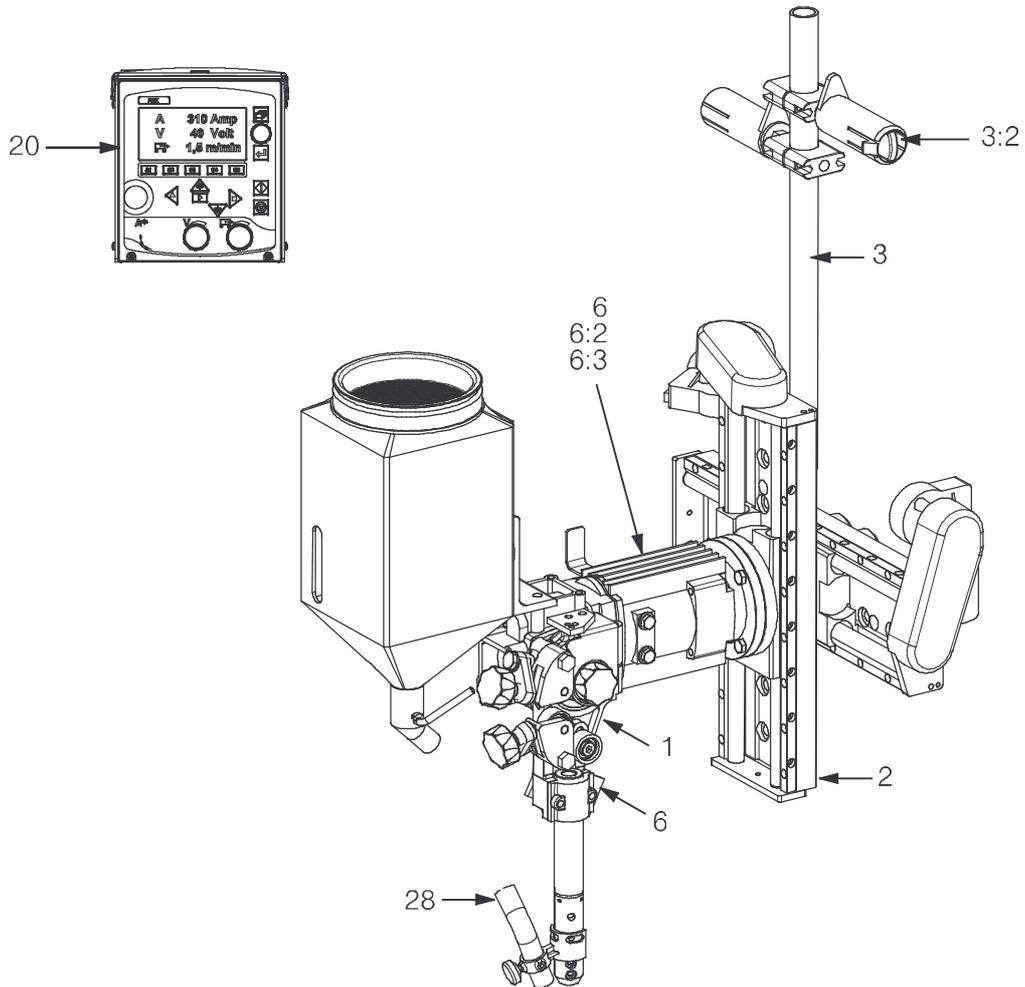
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------------------------|---------------------------------|
| | | 0449271911 | Welding head with PEK and PAV | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250891 | Wire feed unit, Twin (right mounted) | 74:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



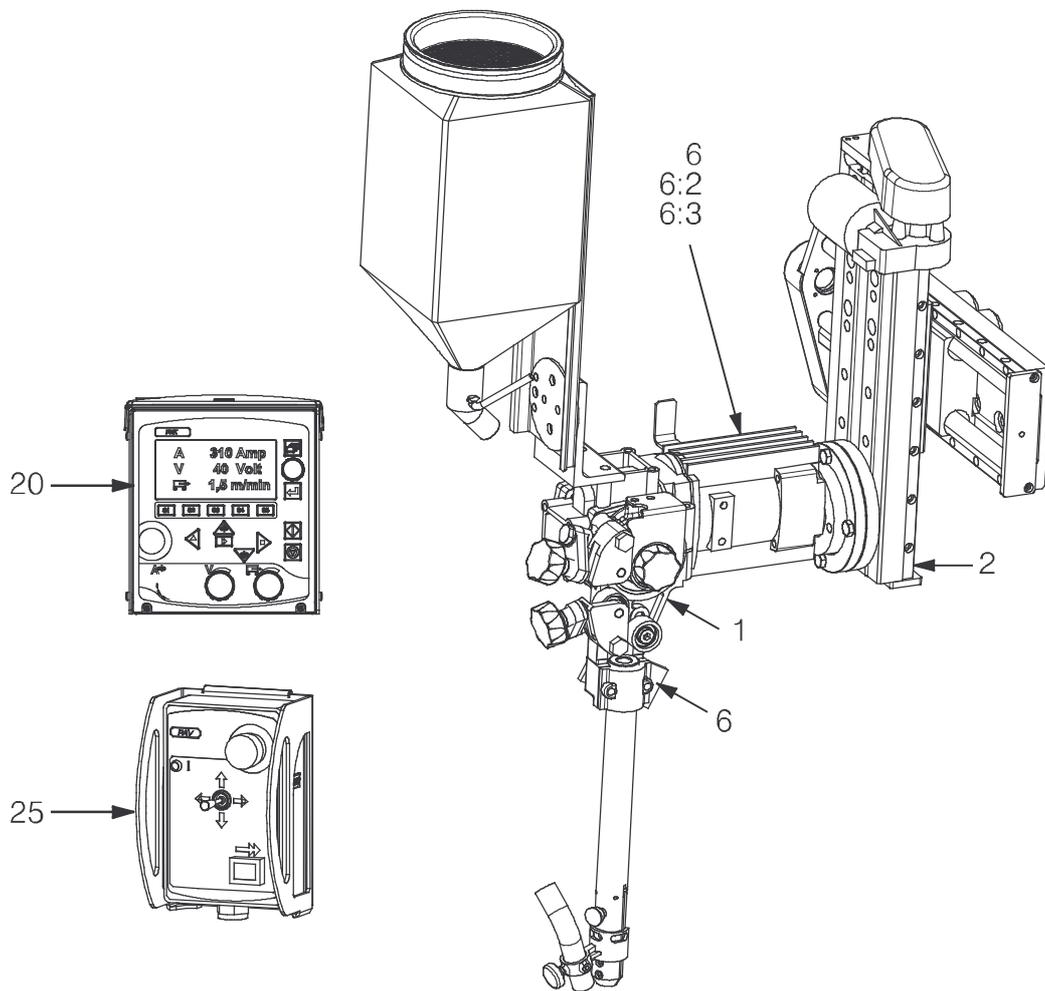
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------------------------|---------------------------------|
| | | 0449271912 | Welding head with PEK and GMH | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250891 | Wire feed unit, Twin (right mounted) | 74:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



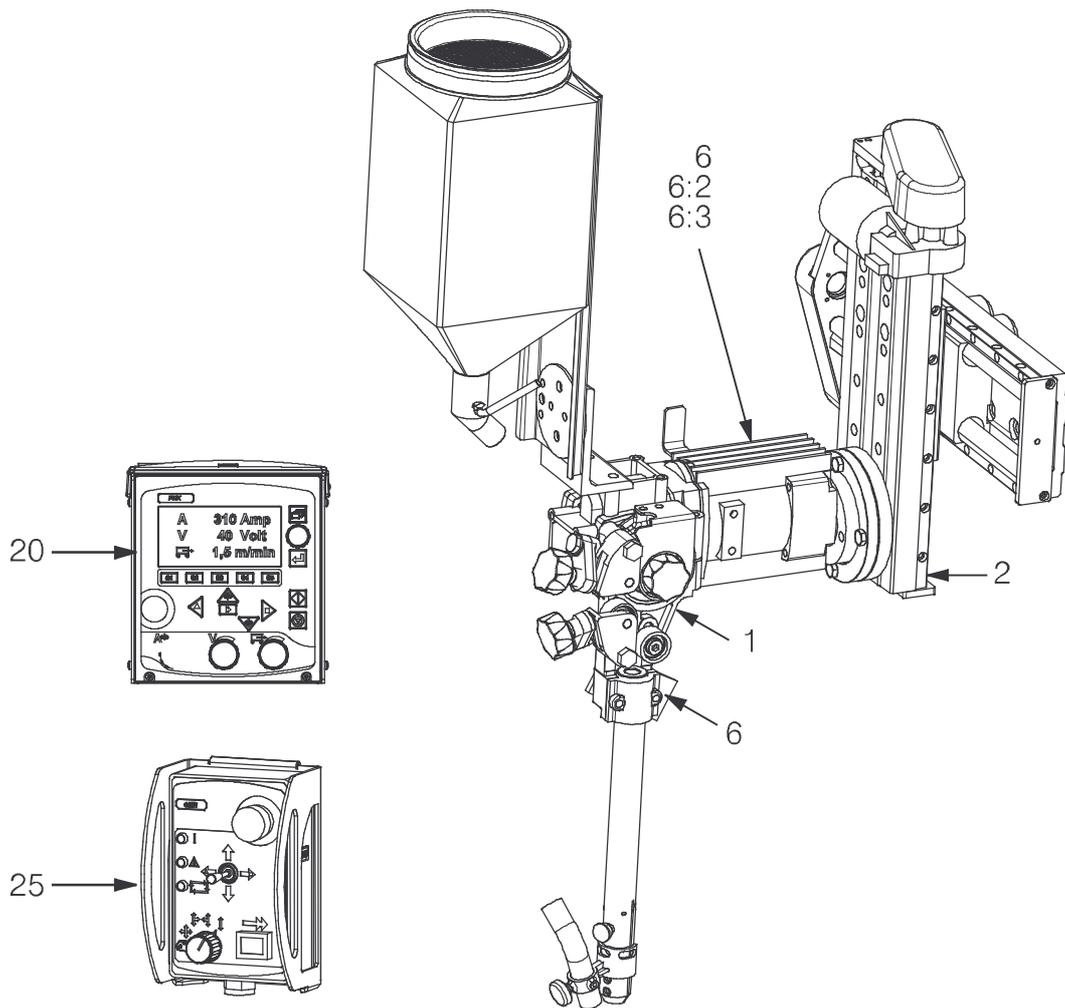
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------------------------|---------------------------------|
| | | 0449271913 | Welding head with PEK | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250891 | Wire feed unit, Twin (right mounted) | 74:1 |
| 2 | 1 | 0449251884 | Slide travel kit, motorised | 300mm |
| 3 | 1 | 0449255880 | Bobbin holder complete | |
| 3:2 | 1 | 0146967880 | Brake hub | |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 28 | | 0443383001 | Flux hose | d32/25 |



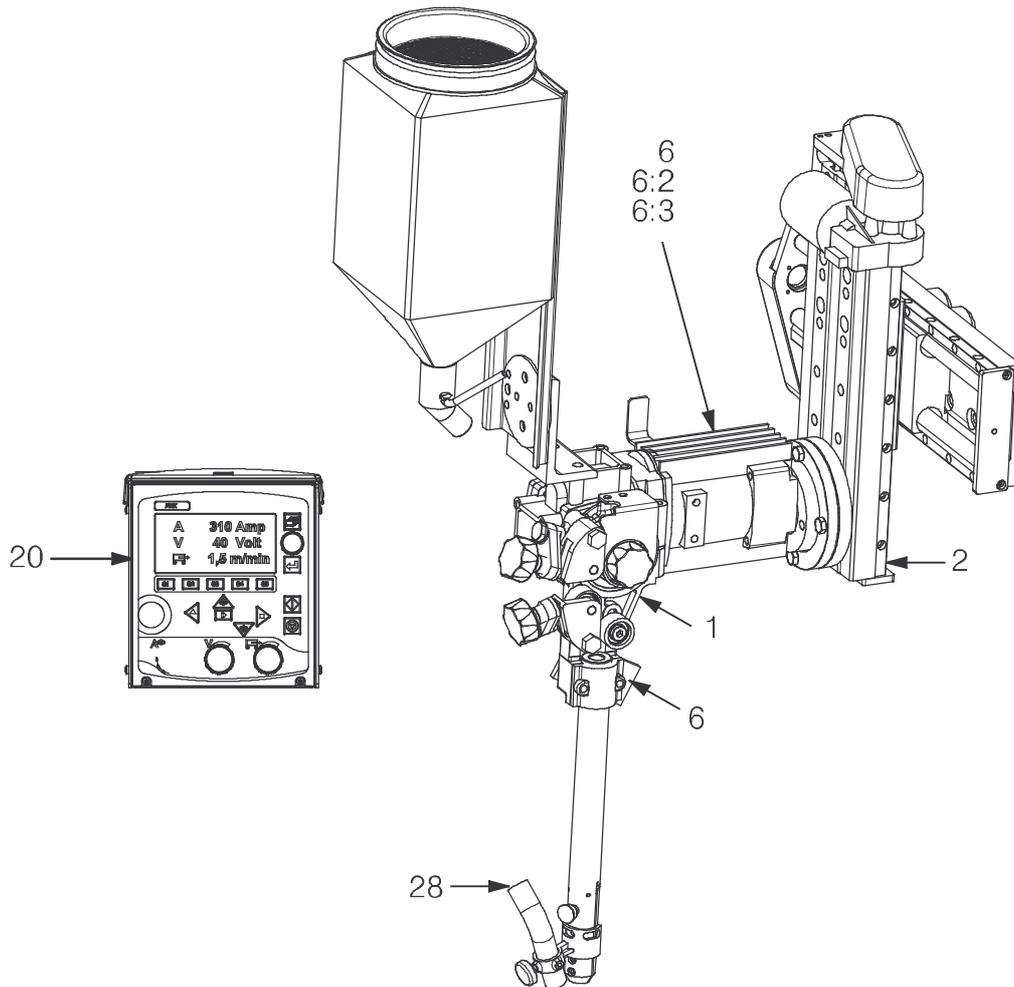
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------------------------|---------------------------------|
| | | 0449271914 | Welding head with PEK and PAV | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250893 | Wire feed unit, Twin | 74:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | l= 5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, see separate manual |
| 25 | 1 | 0460697880 | Joint tracking unit | A6 PAV, see separate manual |
| 26 | 1 | 0461215880 | cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



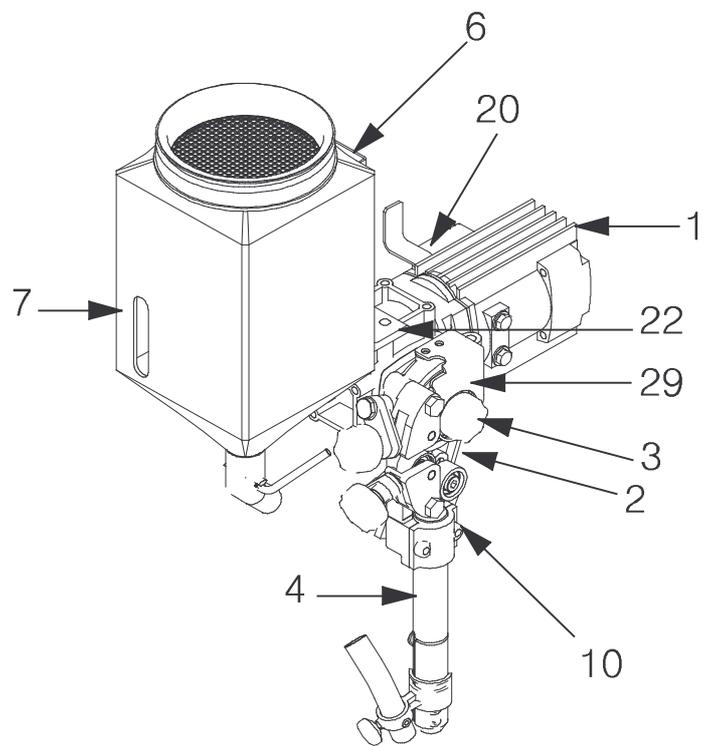
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------------------------|---------------------------------|
| | | 0449271915 | Welding head with PEK and GMH | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250893 | Wire feed unit, Twin | 74:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 25 | 1 | 0460884880 | Joint tracking system | A6 GMH, See separate manual |
| 26 | 1 | 0461215880 | Cable set | |
| 26:5 | 2 | 0417310888 | Motor cable | 5 m |



| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|------------------------------|---------------------------------|
| | | 0449271916 | Welding head with PEK | A6SF F1 Twin, SAW (74:1) |
| 1 | 1 | 0449250893 | Wire feed unit, Twin | 74:1 |
| 2 | 1 | 0449251885 | Slide travel kit, motorised | 300mm |
| 6 | 1 | 0449253902 | Cable set | l=5m |
| 6:2 | 1 | 0460907881 | Motor cable | 5 m |
| 6:3 | 1 | 0461239884 | Arc welding cable | 5 m |
| 20 | 1 | 0460504880 | Control box | PEK, See separate manual |
| 28 | | 0443383001 | Flux hose | d32/25 |

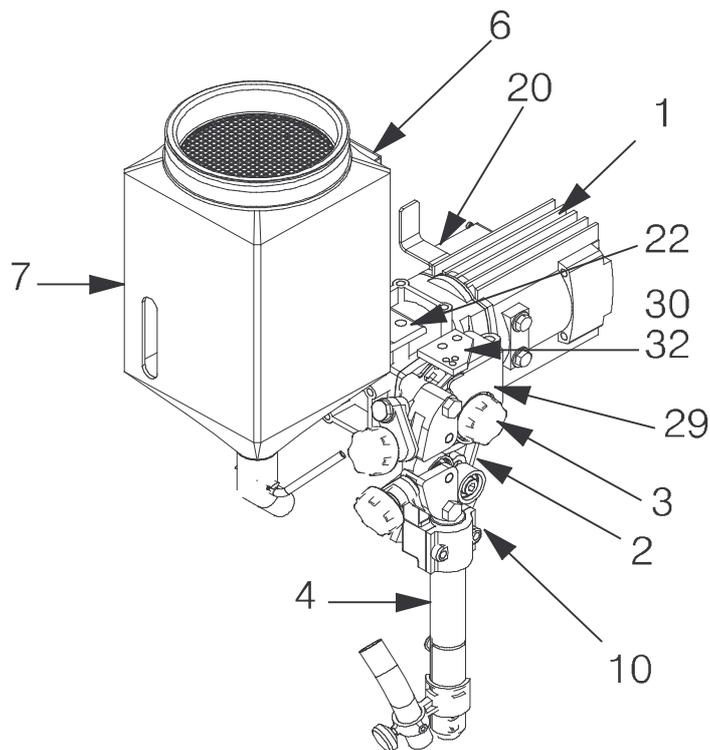


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---------------------------------------|-------------------------------------|
| | | 0449250880 | Wire feed unit (Right mounted) | SAW (156:1), Single |
| 1 | 1 | 0145063906 | Motor with gear | A6 VEC (156:1), see separate manual |
| 2 | 1 | 0147639880 | Wire straightener (right mounted) | D35 |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290882 | Contact equipment | D35/ L275 |
| 6 | 1 | 0148487880 | Bracket for flux hopper | |
| 7 | 1 | 0147649881 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection plate | |

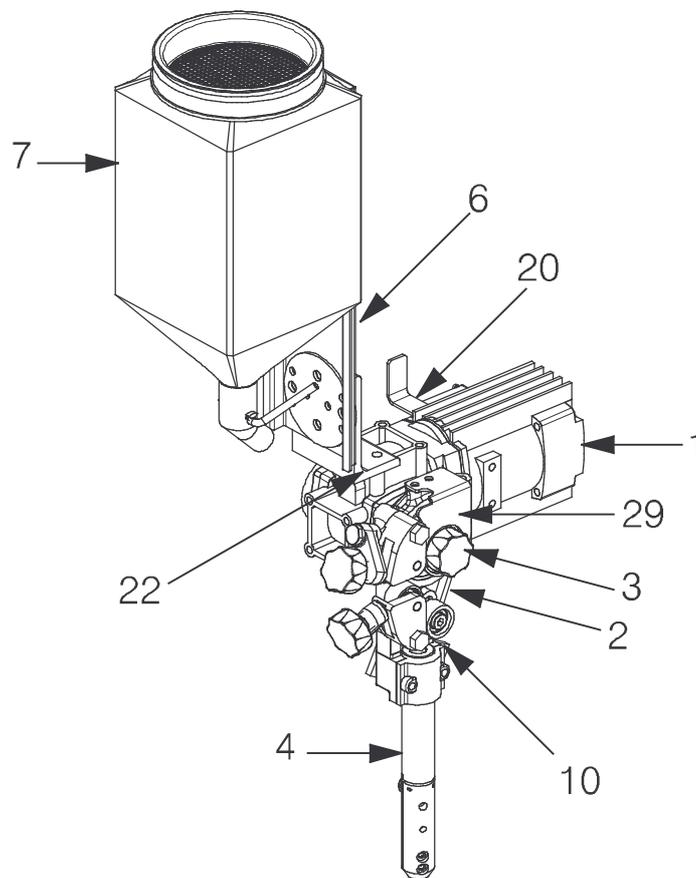


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---------------------------------------|-------------------------------------|
| | | 0449250881 | Wire feed unit (Right mounted) | SAW (156:1), Twin |
| 1 | 1 | 0145063906 | Motor with gear | A6 VEC (156:1), see separate manual |
| 2 | 1 | 0147639887 | Wire straightener (right mounted) | D35, Twin |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290882 | Contact equipment | D35/ L275 |
| 6 | 1 | 0148487880 | Bracket for flux hopper | |
| 7 | 1 | 0147649881 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection plate | |
| 30 | 1 | 0155300001 | Plate | |
| 32 | 2 | 0156800002 | Wire liner | D 8/4 |
| 35* | 1 | 0146967880 | Brake hub | |
| 36* | 2 | 0154734001 | Brake hub clamp | |

* Not shown in the picture

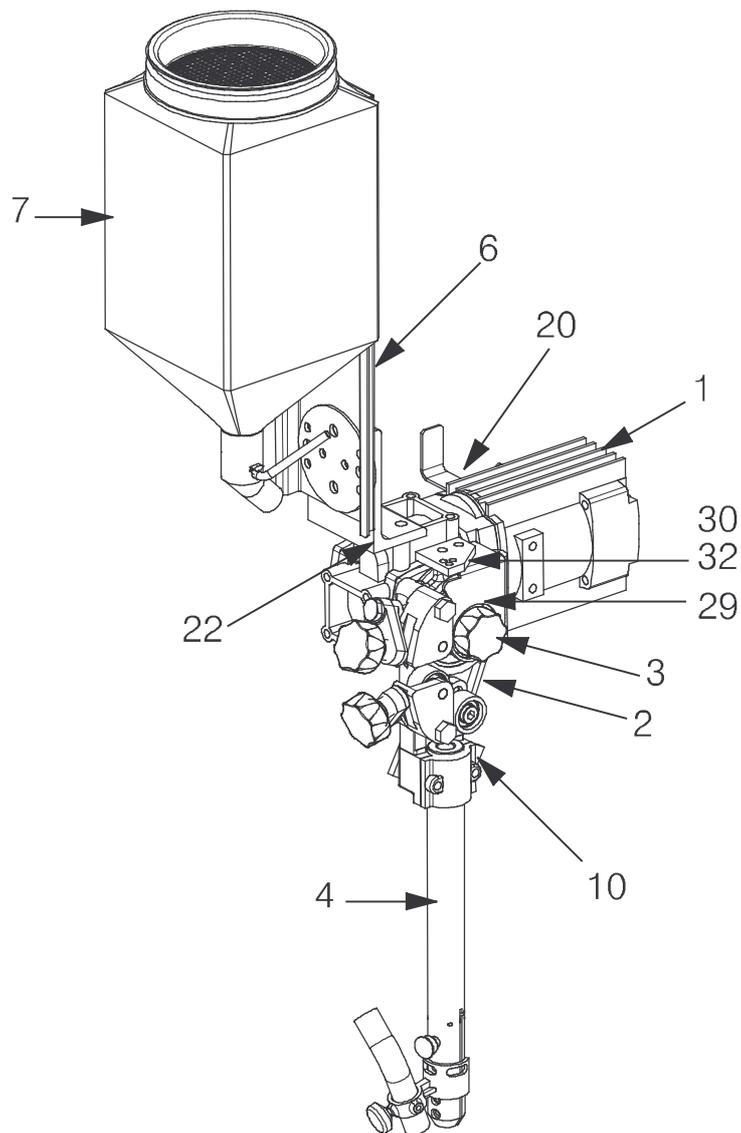


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-----------------------------------|-------------------------------------|
| | | 0449250882 | Wire feed unit | SAW (156:1) CaB |
| 1 | 1 | 0145063906 | Motor with gear | A6 VEC (156:1), see separate manual |
| 2 | 1 | 0147639880 | Wire straightener (right mounted) | D35 |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290884 | Contact equipment single wire | D35/1400 |
| 6 | 1 | 0148487881 | Bracket for flux hopper | |
| 7 | 1 | 0147649882 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection right | |

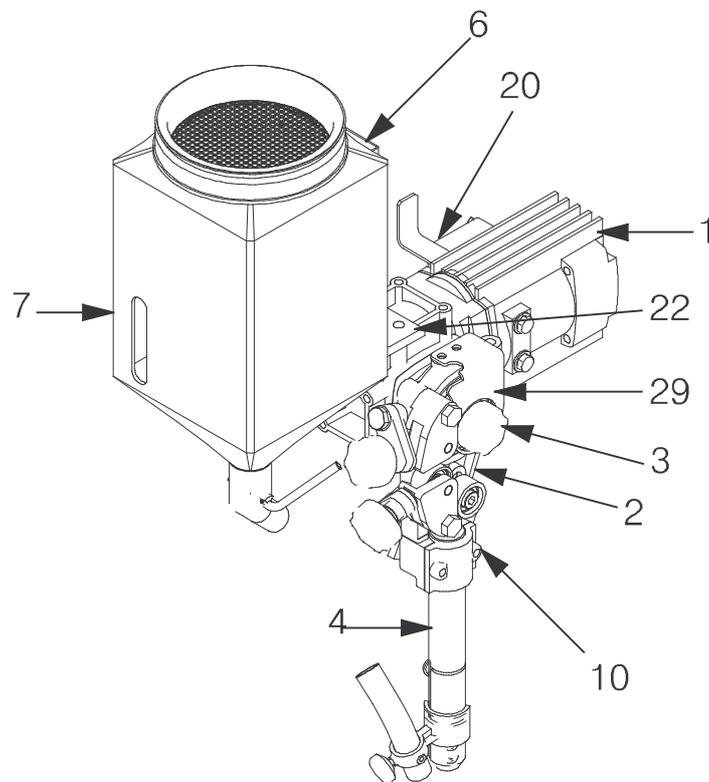


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-----------------------------------|-------------------------------------|
| | | 0449250883 | Wire feed unit | SAW (156:1) CaB |
| 1 | 1 | 0145063906 | Motor with gear | A6 VEC (156:1), see separate manual |
| 2 | 1 | 0147639880 | Wire straightener (right mounted) | D35 |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290884 | Contact equipment single wire | D35/1400 |
| 6 | 1 | 0148487881 | Bracket for flux hopper | |
| 7 | 1 | 0147649882 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection plate | |
| 30 | 1 | 0155300001 | Plate | |
| 32 | 2 | 0156800002 | Wire liner | D8/4 |
| 35* | 1 | 0146967880 | Brake hub | |
| 36* | 2 | 0154734001 | Brake hub clamp | |

* Not shown in the picture

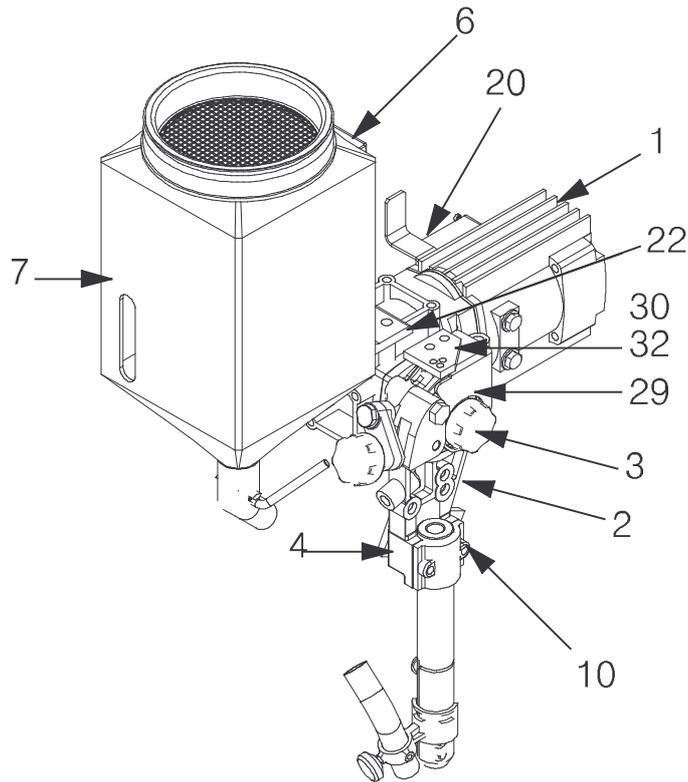


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---------------------------------------|------------------------------------|
| | | 0449250890 | Wire feed unit (Right mounted) | SAW (74:1), Single |
| 1 | 1 | 0145063907 | Motor with gear | A6 VEC (74:1), see separate manual |
| 2 | 1 | 0147639880 | Wire straightener (right mounted) | D35 |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290882 | Contact equipment | D35/ L275 |
| 6 | 1 | 0148487880 | Bracket for flux hopper | |
| 7 | 1 | 0147649881 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection plate | |

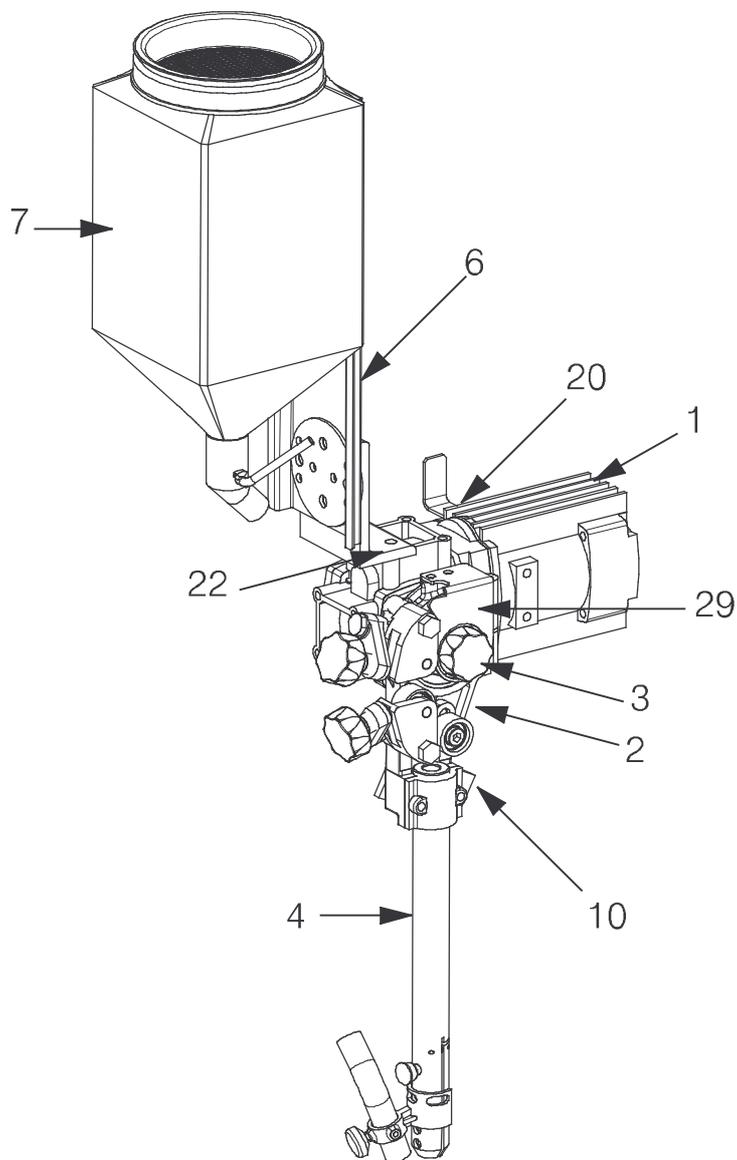


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---------------------------------------|------------------------------------|
| | | 0449250891 | Wire feed unit (Right mounted) | SAW (74:1), Twin |
| 1 | 1 | 0145063907 | Motor with gear | A6 VEC (74:1), see separate manual |
| 2 | 1 | 0147639891 | Wire straightener (right mounted) | D35, Twin |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290882 | Contact equipment | D35/ L275 |
| 6 | 1 | 0148487880 | Bracket for flux hopper | |
| 7 | 1 | 0147649881 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection plate | |
| 30 | 1 | 0155300001 | Plate | |
| 32 | 2 | 0156800002 | Wire liner | D8/4 |
| 35* | 1 | 0146967880 | Brake hub | |
| 36* | 2 | 0154734001 | Brake hub clamp | |
| 40* | 1 | 0145787880 | Fine wire straightener for Twin wire | |
| 42* | 1 | 0334278881 | Guide tube insert for fine wire | |

* Not shown in the picture

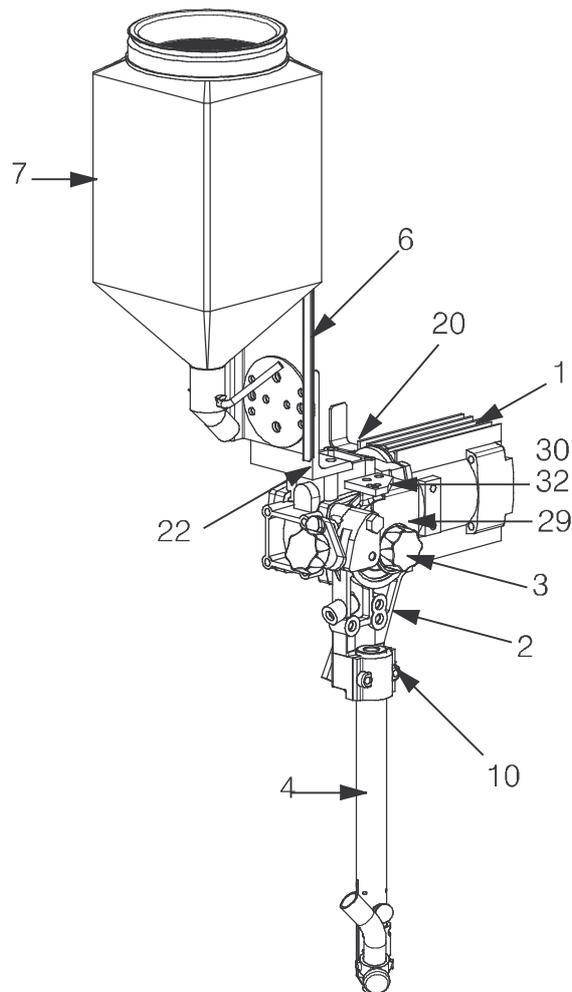


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---------------------------------------|------------------------------------|
| | | 0449250892 | Wire feed unit (Right mounted) | SAW (74:1), Single |
| 1 | 1 | 0145063907 | Motor with gear | A6 VEC (74:1), see separate manual |
| 2 | 1 | 0147639880 | Wire straightener (right mounted) | D35 |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290884 | Contact equipment | D35/ L275 |
| 6 | 1 | 0148487881 | Bracket for flux hopper | |
| 7 | 1 | 0147649882 | Flux hopper | 10 l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 29 | 1 | 0449528001 | Protection right | |

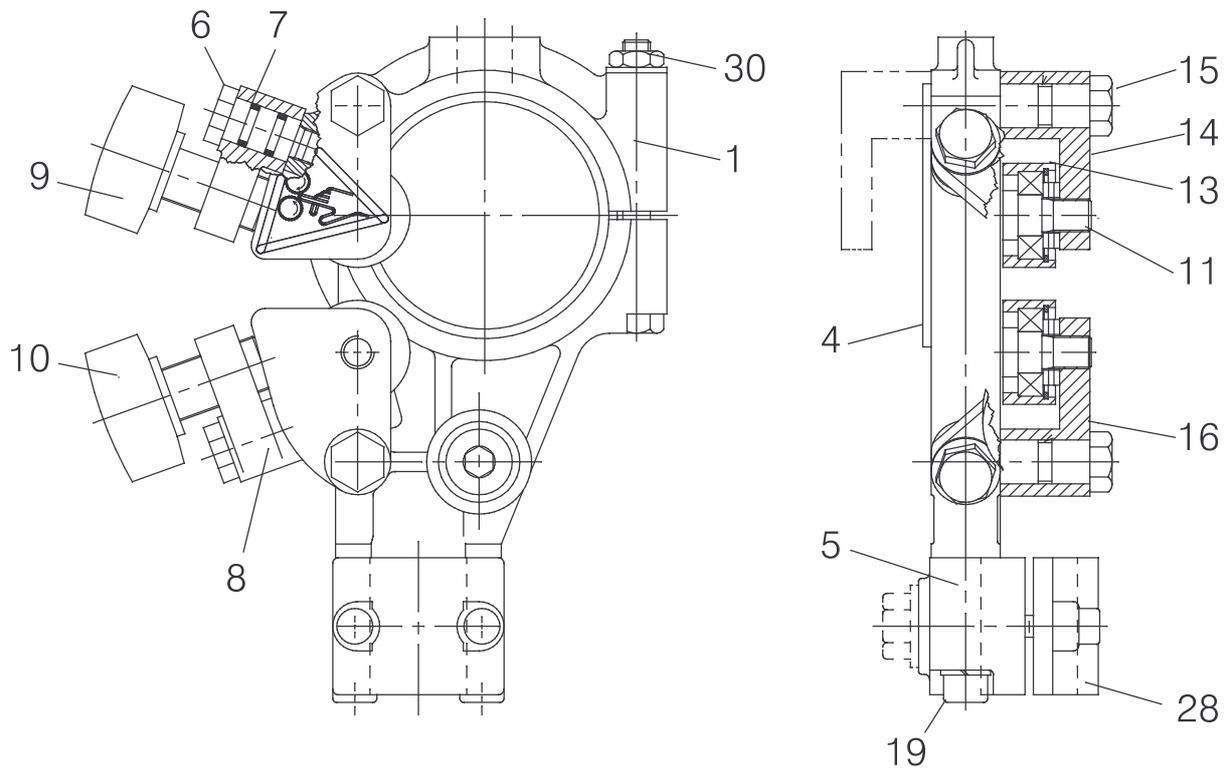


| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-----------------------------------|------------------------------------|
| | | 0449250893 | Wire feed unit | SAW TWIN (74:1) CaB |
| 1 | 1 | 0145063907 | Motor with gear | A6 VEC (74:1), see separate manual |
| 2 | 1 | 0147639891 | Wire straightener (right mounted) | D35 twin (74:1) |
| 3 | 1 | 0218810183 | Insulated hand wheel | |
| 4 | 1 | 0334290884 | Contact equipment | D35/L400 A6 with contact bars |
| 6 | 1 | 0148487881 | Bracket for fluxhopper | |
| 7 | 1 | 0147649882 | Flux hopper | 10l |
| 10 | 1 | 0457713001 | Bar | |
| 20 | 1 | 0449498880 | Junction box complete | |
| 22 | 1 | 0334294001 | Attachment | |
| 30 | 1 | 0155300001 | Plate | |
| 32 | 2 | 0156800002 | Wire liner | d8/4 |
| 35* | 1 | 0146967880 | Brake hub heavy duty | |
| 36* | 2 | 0154734001 | Brake hub clamp | |
| 40* | 1 | 0145787880 | Wire straightener for Twin wire | |
| 42* | 1 | 0334278881 | Guide tube insert for fine wire | |

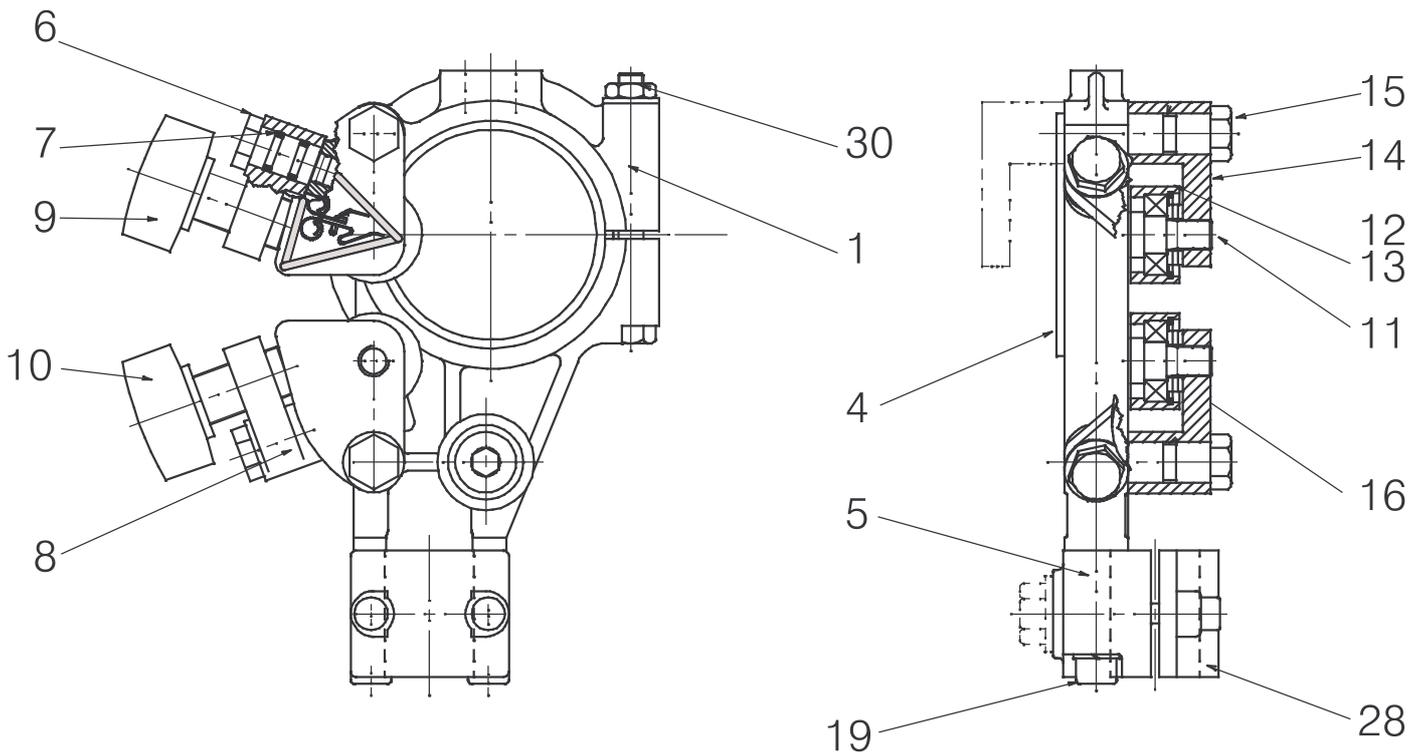
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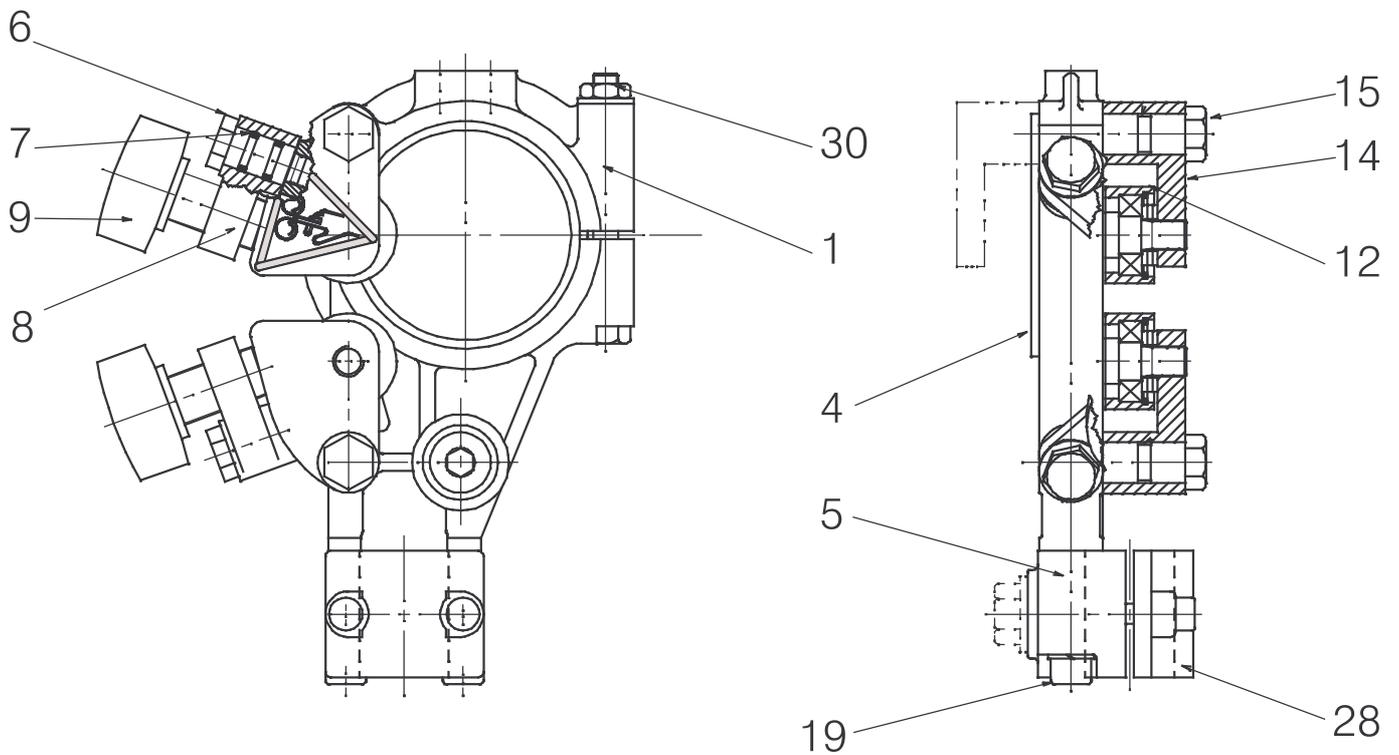
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---|------------|
| | | 0147639880 | Wire straightener(right mounted) | |
| 1 | 1 | 0156449001 | Clamp | |
| 4 | 1 | 0215503601 | Insulating sleeve | |
| 5 | 1 | 0156530001 | Clamp half | D35 |
| 6 | 2 | 0212900001 | Spacer screw | |
| 7 | 4 | 0215201209 | Sealing, O-ring | D11.3x2.4 |
| 8 | 2 | 0218400801 | Pressure roller arm | |
| 9 | 1 | 0218810181 | Handwheel, insulated | |
| 10 | 1 | 0218810182 | Handwheel, insulated | |
| 11 | 3 | 0332408001 | Stub shaft | |
| 13 | 3 | 0153148880 | Pressure roller | |
| 14 | 1 | 0415498001 | Pressure roller, upper | |
| 15 | 2 | 0212902601 | Spacer screw | |
| 16 | 1 | 0415499001 | Pressure roller, lower | |
| 19 | 2 | 0219501013 | Spring washer | D18.1/10.2 |
| 28 | 1 | 0156531001 | Clamp half | D35 |
| 30 | 1 | 0212 601110 | Nut | M10 |



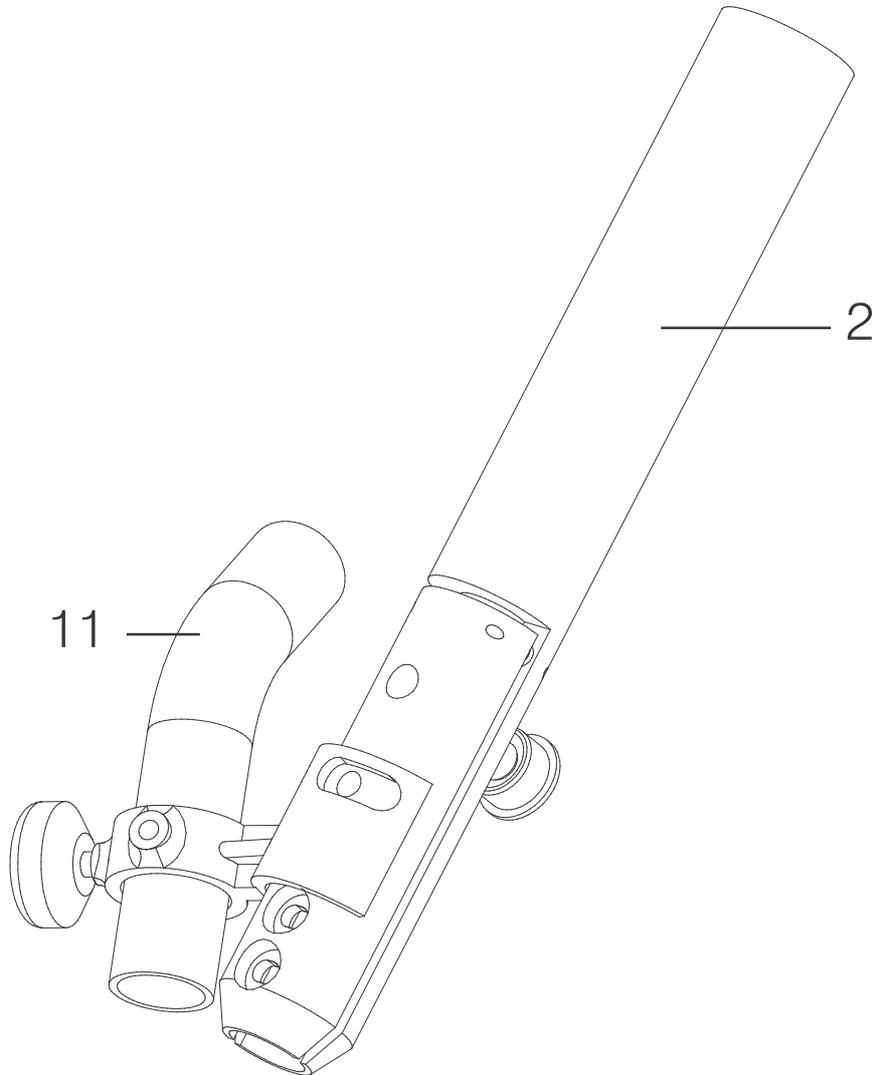
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--|--------------------|
| | | 0147639887 | Wire Wire straightener(right mounted) | A6 D35 TWIN |
| 1 | 1 | 0156449001 | Clamp | |
| 4 | 1 | 0215503601 | Insulating sleeve | |
| 5 | 1 | 0156530001 | Clamp half | |
| 6 | 2 | 0212900001 | Spacer screw | |
| 7 | 4 | 0215201209 | O-ring | 11,3x2,4 |
| 8 | 2 | 0218400801 | Pressure roller arm | |
| 9 | 1 | 0218810181 | Handwheel | |
| 10 | 1 | 0218810182 | Handwheel | |
| 11 | 2 | 0332408001 | Stub shaft | |
| 12 | 1 | 0218524580 | Pressure roller twin | |
| 13 | 2 | 0153148880 | Roller | |
| 14 | 1 | 0415498001 | Thrust roller carrier | |
| 15 | 2 | 0212902601 | Spacer screw | a6 |
| 16 | 1 | 0415499001 | Thrust roller carrier | |
| 19 | 2 | 0219501013 | Spring washer | d18,1/10,2 |
| 28 | 1 | 0156531001 | Clamp half | |
| 30 | 1 | 0212 601 110 | Nut | M10 |



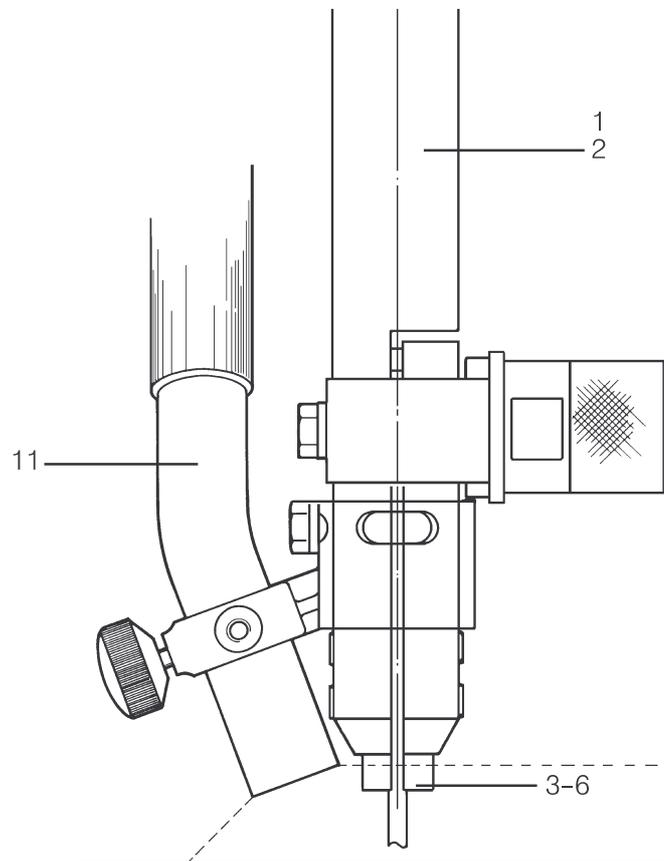
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---|---------------------------|
| | | 0147639891 | Wire straightener(right mounted) | A6 D35 TWIN (74:1) |
| 1 | 1 | 0156449001 | Clamp | |
| 4 | 1 | 0215503601 | Insulating sleeve | |
| 5 | 1 | 0156530001 | Clamp half | D35 |
| 6 | 1 | 0212900001 | Spacer screw | |
| 7 | 2 | 0215201209 | Sealing, O-ring | D11,3x2,4 |
| 8 | 1 | 0218400801 | Pressure roller arm | |
| 9 | 1 | 0218810181 | Handwheel, insulated | |
| 12 | 1 | 0218524580 | Pressure roller twin | |
| 14 | 1 | 0415498001 | Pressure roller, upper | |
| 15 | 1 | 0212902601 | Spacer screw | |
| 19 | 2 | 0219501013 | Spring washer | D18,1/10,2 |
| 28 | 1 | 0156531001 | Clamp half | |
| 30 | 1 | 0212601110 | Nut | M10 |



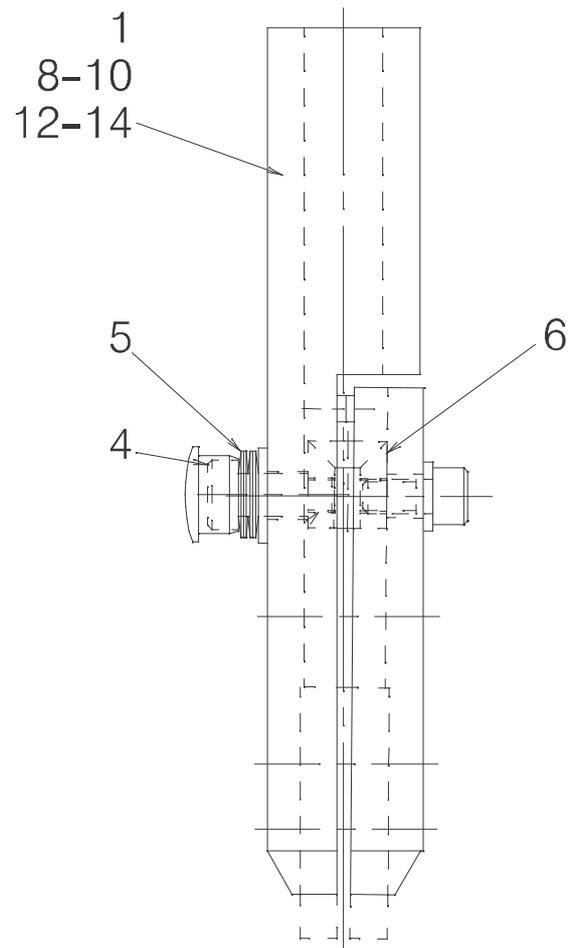
| Item | Qty | Orderingno. | Denomination | Remarks |
|------|-----|-------------------|--------------------------------------|------------|
| | | 0334290882 | Contact equipment single wire | D35 |
| 2 | 1 | 0417959881 | Contact jaw tube | L=275 |
| 11 | 1 | 0153299880 | Flux nozzle complete | |



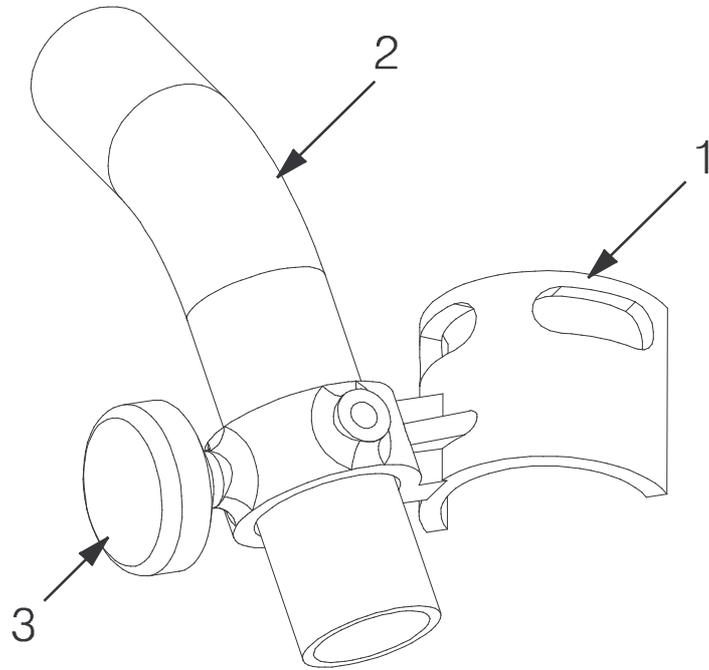
| Item | Qty | Orderingno. | Denomination | Remarks |
|------|-----|-------------------|--------------------------------------|-------------|
| | | 0334290884 | Contact equipment single wire | D35 |
| 1 | 1 | 0417959882 | Contact jaw tube | L=400 |
| 3 | 1 | 0265900880 | Contact jaw | ø 3, L=58mm |
| 4 | 1 | 0265900882 | Contact jaw | ø 4, L=58mm |
| 5 | 1 | 0265900883 | Contact jaw | ø 5, L=58mm |
| 6 | 1 | 0265900884 | Contact jaw | ø 6 |
| 7 | 1 | 0218510298 | Feed roller | ø 3 |
| 8 | 1 | 0218510286 | Feed roller | ø 4 |
| 9 | 1 | 0218510287 | Feed roller | ø 5 |
| 10 | 1 | 0218510288 | Feed roller | ø 6 |
| 11 | 1 | 0153299880 | Flux nozzle complete | |



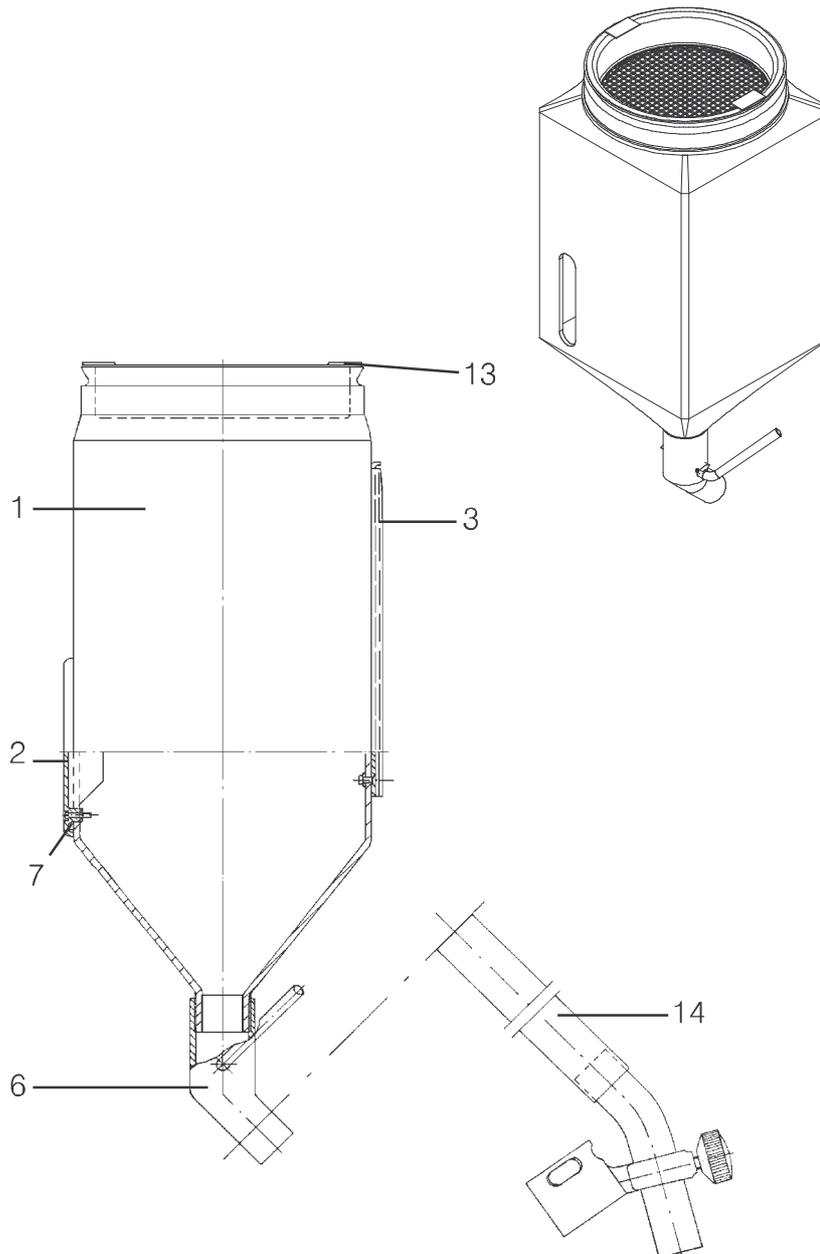
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-------------------------|-------------------|
| | | 0417959881 | Contact jaw tube | L = 275 mm |
| 4 | 1 | 0443372001 | Fitting bolt | |
| 5 | 4 | 0219504307 | Cup spring | d20/10.2, T=1.1 |
| 6 | 1 | 0417979001 | Ring | |
| 8 | 1 | 0443344881 | Contact tube | L = 275 mm |
| | | 0417959882 | Contact jaw tube | L = 400 mm |
| 4 | 1 | 0443372001 | Fitting bolt | |
| 5 | 4 | 0219504307 | Cup spring | d20/10.2, T=1.1 |
| 6 | 1 | 0417979001 | Ring | |
| 9 | 1 | 0443344882 | Contact tube | L = 400 mm |



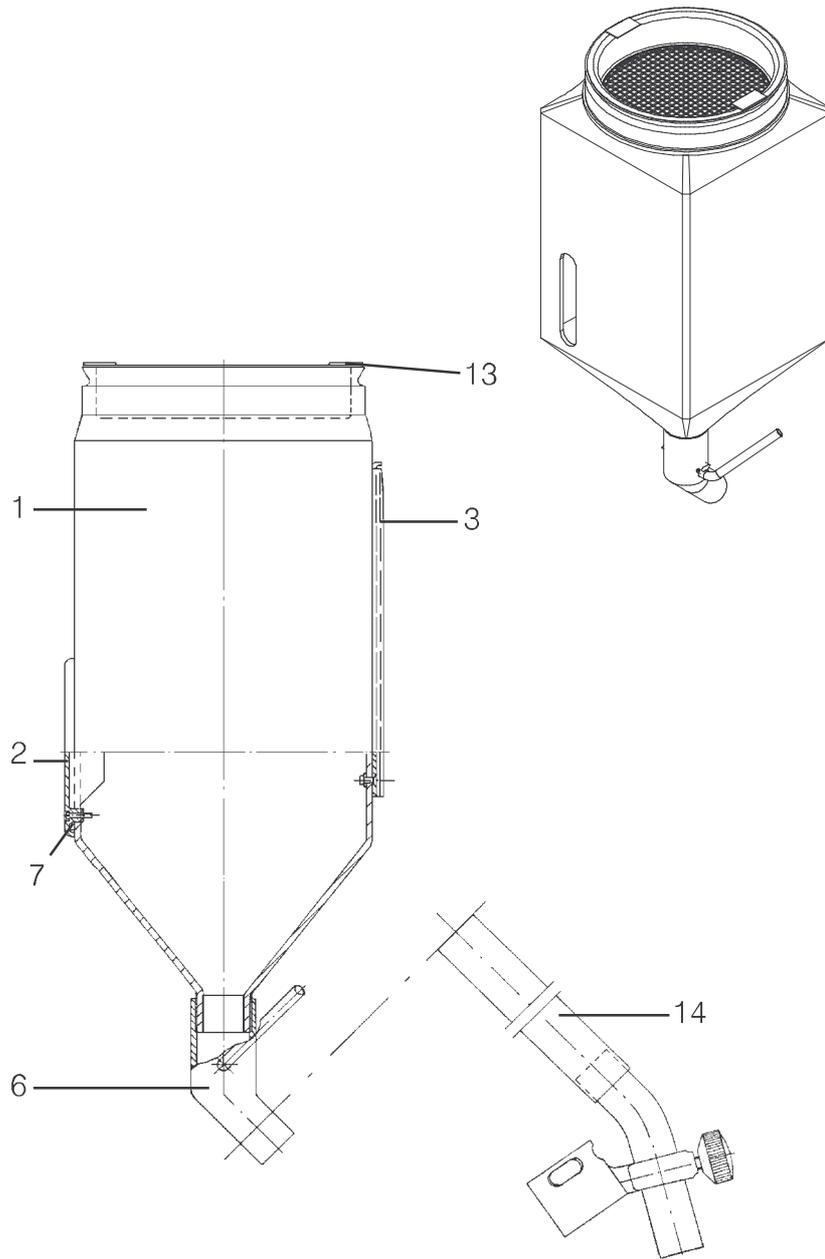
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-----------------------------|-------|
| | | 0153299880 | Flux nozzle complete | |
| 1 | 1 | 0153290002 | Holder for flux pipe | |
| 2 | 1 | 0153296001 | Flux pipe, bent | |
| 3 | 1 | 0153425001 | Wheel | |



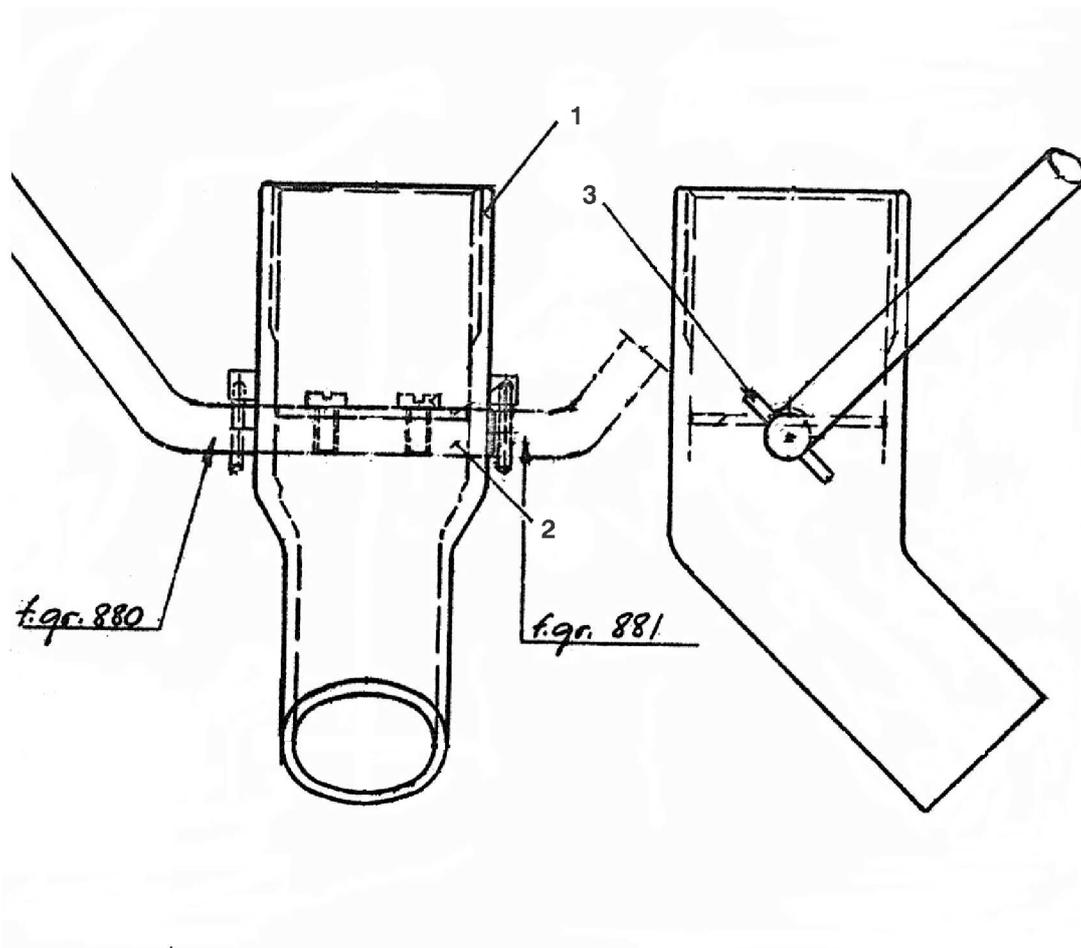
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-------------------------|------------|
| | | 0147649881 | Flux Hopper | 10l |
| 1 | 1 | 0154007001 | Flux hopper | |
| 2 | 1 | 0148837001 | Window (a6 flux hopper) | |
| 3 | 1 | 0147645001 | Mounting | |
| 6 | 1 | 0153347880 | Flux valve | |
| 7 | 1 | 0215201232 | Sealing, O-ring | 69,2x5,7 |
| 13 | 1 | 0020301780 | Flux strainer | |
| 14 | 1 | 0443383002 | Flux hose | L=500 |



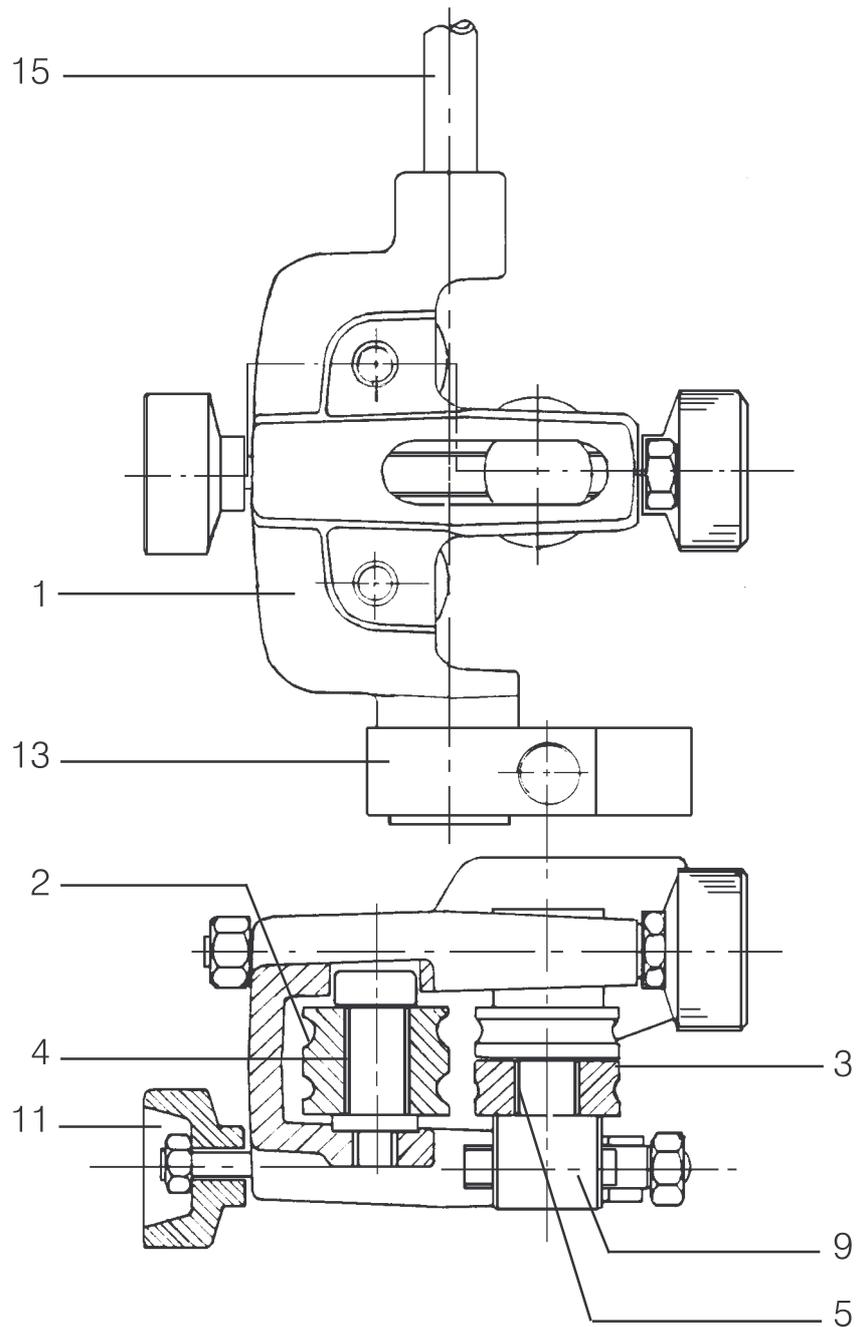
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--------------------|------------|
| | | 0147649882 | Flux Hopper | 10l |
| 1 | 1 | 0154007002 | Flux hopper | |
| 3 | 1 | 0147645001 | Mounting | |
| 6 | 1 | 0153347880 | Flux valve | |
| 13 | 1 | 0020301780 | Flux strainer | |
| 14 | 1 | 0443383002 | Flux hose | L=500 |



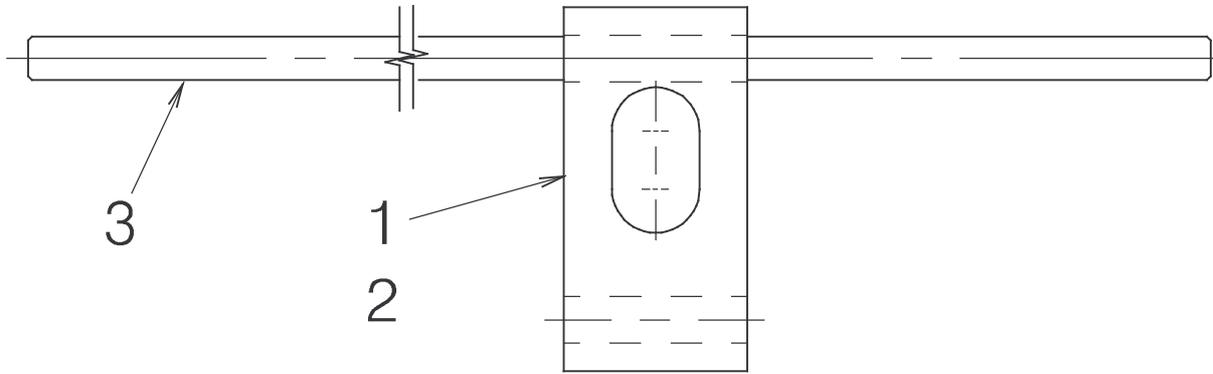
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-------------------|--------|
| | | 0153347880 | Flux valve | |
| 1 | 1 | 0153348001 | Outlet | |
| 2 | 1 | 0153349001 | Shaft | |
| 3 | 1 | 0211102938 | Roll pin | d 3x20 |



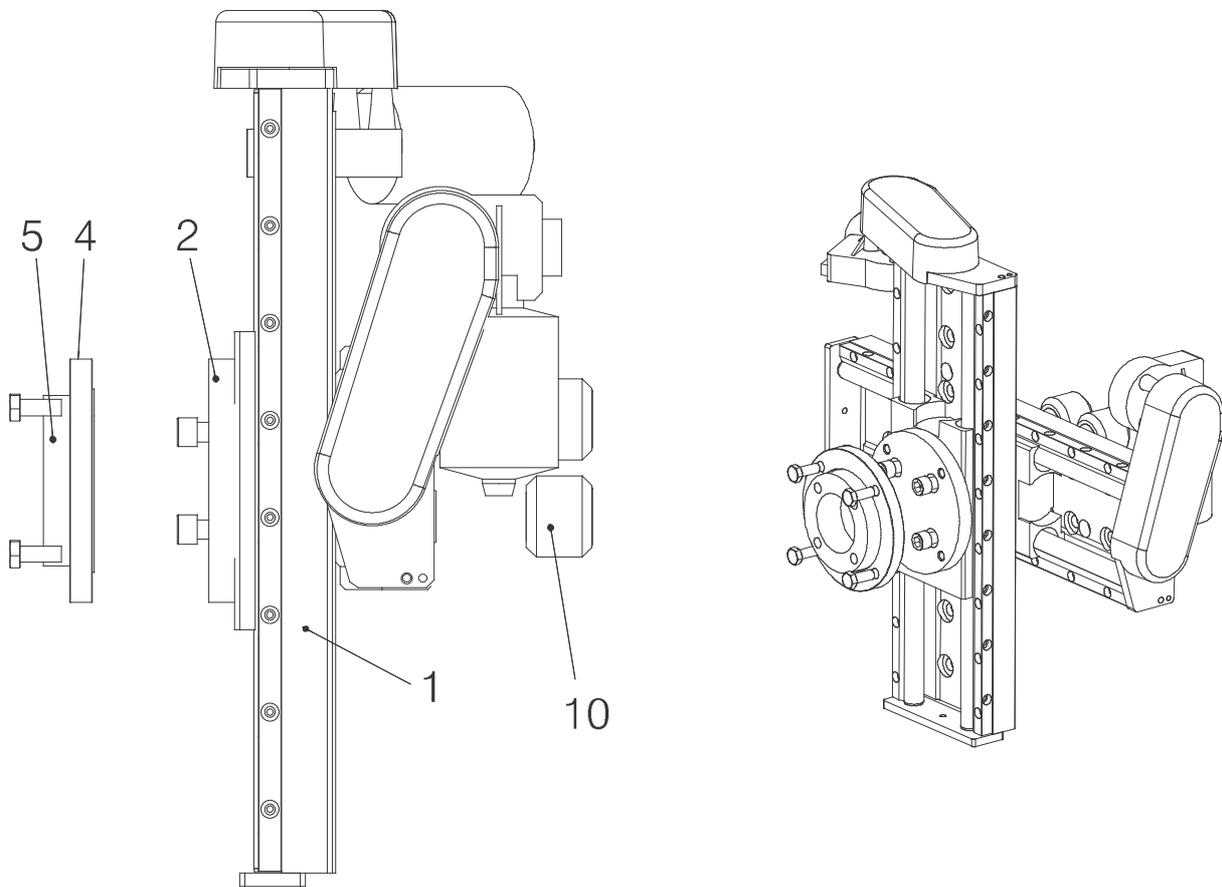
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---|--------|
| | | 0145787880 | Fine wire straightener for twin wire | |
| 1 | 1 | 0145788001 | Case | |
| 2 | 2 | 0145789001 | Roller | |
| 3 | 2 | 0145790001 | Roller | |
| 4 | 2 | 0145791001 | Searing bushing | |
| 5 | 2 | 0190240103 | Bearing bushing | D12/10 |
| 9 | 2 | 0145793001 | Runner | |
| 11 | 2 | 0145794001 | Knob | |
| 13 | 1 | 0145795001 | Link | |
| 15 | | 0151287001 | Hose | |



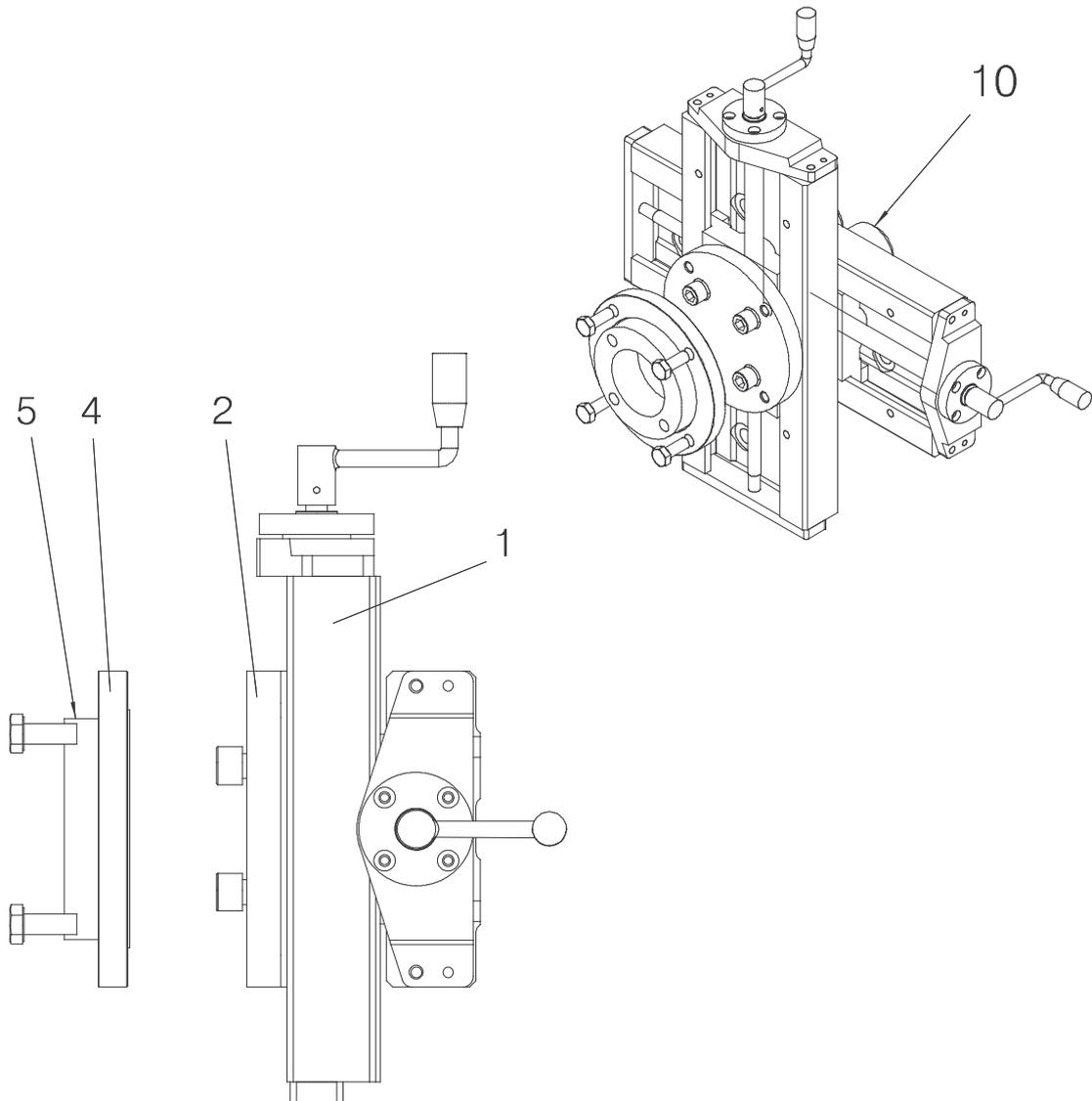
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|--|----------|
| | | 0334278881 | Guide tube insert for fine wire | |
| 2 | 1 | 0218518201 | Clamp | |
| 3 | 2 | 0415032001 | Guide tube | L=358 mm |



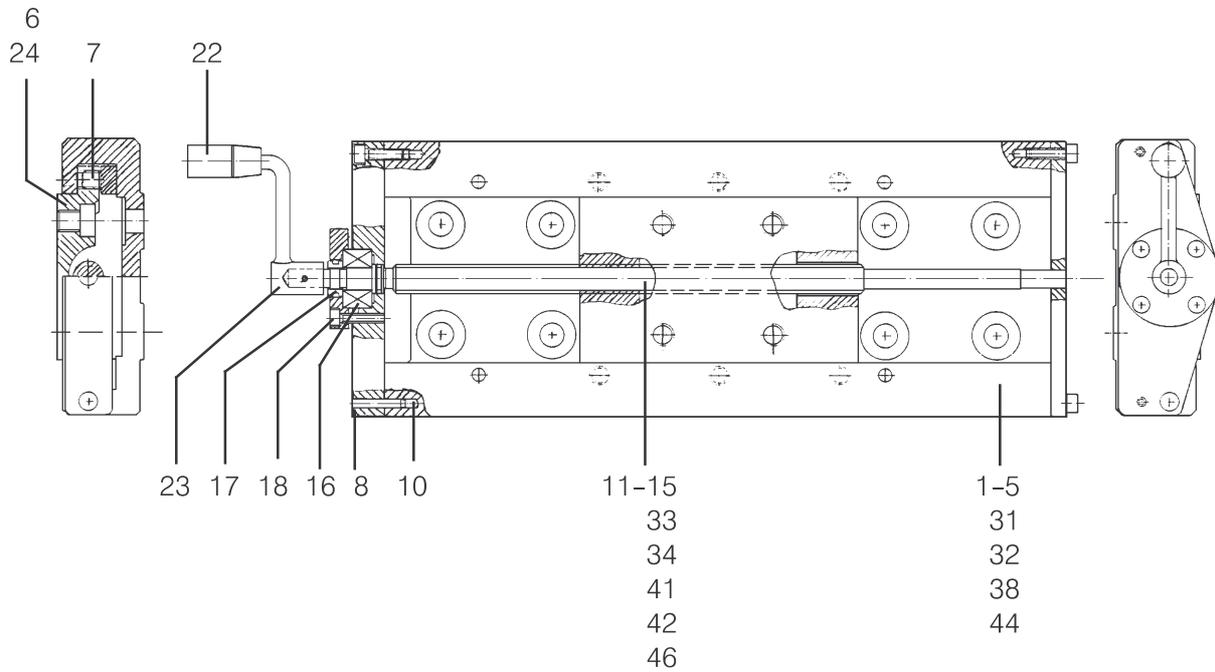
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-------------------------------------|---------------|
| 1 | 2 | 0449251884 | Slide travel kit motorised | 300 mm |
| | | 0334333884 | Motorised slide | li = 300 |
| 30 | 1 | 0449251999 | Common parts motorised slide | |
| 1 | 2 | 0449251885 | Slide travel kit motorised | 300 mm |
| | | 0334333884 | Motorised slide | li = 300 |
| 30 | 1 | 0449251999 | Common parts motorised slide | |
| 2 | 1 | 0449251999 | Common parts motorised slide | A6 |
| | | 0334171001 | Plate | |
| 4 | 1 | 0334170001 | Clamping ring | |
| 5 | 1 | 0334172001 | Gear bracket | |
| 10 | 4 | 0278300180 | Insulator | |



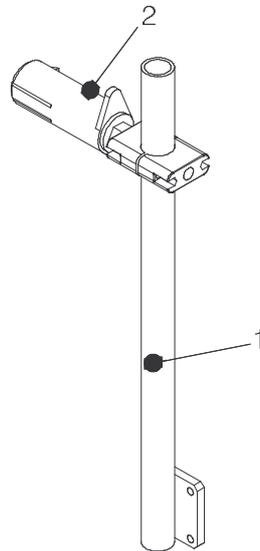
| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|---------------------------------|---------------|
| | | 0449252881 | Slide travel kit, manual | 210 mm |
| 1 | 2 | 0154465881 | Slide manual | L=210 |
| 2 | 1 | 0334171001 | Plate | |
| 4 | 1 | 0334170001 | Clamping ring | |
| 5 | 1 | 0334172001 | Gear bracket | |
| 10 | 4 | 0278300180 | Insulator | 2000 V |



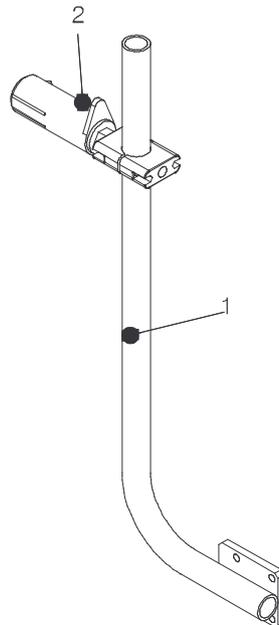
| Item | Qty | Orderingno. | Denomination | Remarks |
|------|-----|-------------------|---------------------------------|----------|
| | | 0154465881 | Slide, manually operated | |
| 2 | 1 | 0154464002 | Slide frame | |
| 6 | 1 | 0154463880 | Carriage with slide rails | |
| 7 | 6 | 0190509485 | Stop screw | M10x10 |
| 8 | 1 | 0154458001 | End piece | |
| 10 | 2 | 0211102957 | Roll pin | D5x20 |
| 12 | 1 | 0154461002 | Lead screw | |
| 16 | 1 | 0190531201 | Ball bearing | SKF 3201 |
| 17 | 1 | 0154456001 | Lock nut | |
| 18 | 1 | 0154457001 | Ball bearing cap | |
| 22 | 1 | 0334537001 | Handle crank | |
| 23 | 1 | 0211102938 | Roll pin | D3x20 |



| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-------------------------------|-------|
| | | 0449255880 | Bobbin holder complete | |
| 1 | 1 | 0334318880 | Bobbin holder straight | |
| 2 | 1 | 0146967880 | Brake hub | |



| Item no. | Qty | Ordering no. | Denomination | Notes |
|----------|-----|-------------------|-------------------------------|-------|
| | | 0449255881 | Bobbin holder complete | |
| 1 | 1 | 0443510880 | Bobbin holder bent | |
| 2 | 1 | 0146967880 | Brake hub | |



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