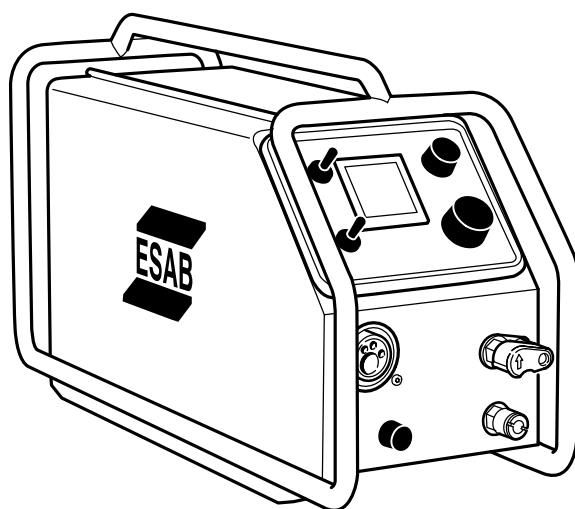


GB



**Origo™ M13y**

**YardFeed 200**



AH 0741

**Instruction manual**



## DECLARATION OF CONFORMITY

According to

The Low Voltage Directive 2006/95/EC, entering into force 16 January 2007

The EMC Directive 2004/108/EC, entering into force 20 July 2007

### Type of equipment

Welding wire feeder

### Type designation

YardFeed 200 with control panel M13y, from serial number 612 xxx xxxx ( 2006 w.12)

YardFeed 200 is a member of the ESAB Origo™ product family

### Brand name or trade mark

ESAB

### Manufacturer or his authorised representatives established within the EEA:

#### Name, address, phone, website:

ESAB AB

Lindholmsallén 9

Box 8004, 402 77 GÖTEBORG, Sweden

Phone: +46 31 509 000, Website: [www.esab.com](http://www.esab.com)

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

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

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

### Additional information:

Restrictive use, Class A equipment, intended for use in locations other than residential.

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

#### Date

2012-06-20

#### Signature

Flavio Santos  
Clarification

#### Position

Global Director  
Standard Equipment

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# 1 SAFETY

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Users of ESAB 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 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 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 equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding and cutting
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 drafts
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 and cutting. Ask for your employer's safety practices which should be based on manufacturers' hazard data.**

**ELECTRIC SHOCK - Can kill**

- Install and earth the 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.**

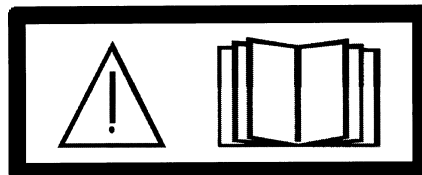
**Read and understand the instruction manual before installing or operating.**

**PROTECT YOURSELF AND OTHERS!**



**CAUTION**

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



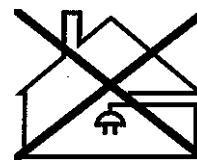
**CAUTION**

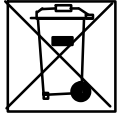
*This product is solely intended for arc welding.*



**CAUTION**

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





**Dispose of electronic equipment at the recycling facility!**

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

As the person responsible for the equipment, it is your responsibility to obtain information on approved collection stations.

For further information contact the nearest ESAB dealer.

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

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## 2 INTRODUCTION

---

The wire feed unit **YardFeed 200** is intended for MIG/MAG welding together with stepped and thyristor-controlled welding power sources.

It comes in different variants, see page [16](#).

The wire feed unit contains a four-wheel drive wire feed mechanism as well as control electronics.

**ESAB's accessories for the product can be found on page [20](#).**

### 2.1 Equipment

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

- Instruction manual
- Decal with recommended wear parts
- Gas flow meter

### 3 TECHNICAL DATA

	YardFeed 200
<b>Mains voltage</b>	42 V 50-60 Hz
<b>Power requirement</b>	150 VA
<b>Motor current <math>I_{max}</math></b>	3.5 A
<b>Settings data</b>	
Wire feed speed	1.9 -25.0 m/min
Burnback time	0 -0.5 s
2/4 stroke	2 stroke or 4 stroke
Gas flushing	-
Wire inching	-
<b>Gun connection</b>	EURO
<b>Max. diameter wire bobbin</b>	200 mm
<b>Wire dimension</b>	
Fe	0.6 - 1.2 mm
Ss	0.6 - 1.2 mm
Al	1.0 - 1.2 mm
Cored wire	0.8 - 1.2 mm
<b>Weight</b>	11.3 kg
<b>Dimensions (l x w x h)</b>	593 x 210 x 302 mm
<b>Operating temperature</b>	-10 to +40° C
<b>Shielding gas</b>	All types intended for MIG/MAG welding
max pressure	0.5 MPa ( 5 bar)
<b>Type of cooling</b>	50% water / 50% monoethylenglycol
max pressure	0.5 MPa ( 5 bar)
<b>Maximum permissible load at</b>	
60% duty cycle	365 A
<b>Enclosure class</b>	IP23

#### Duty cycle

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

#### Enclosure class


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

## 4 INSTALLATION

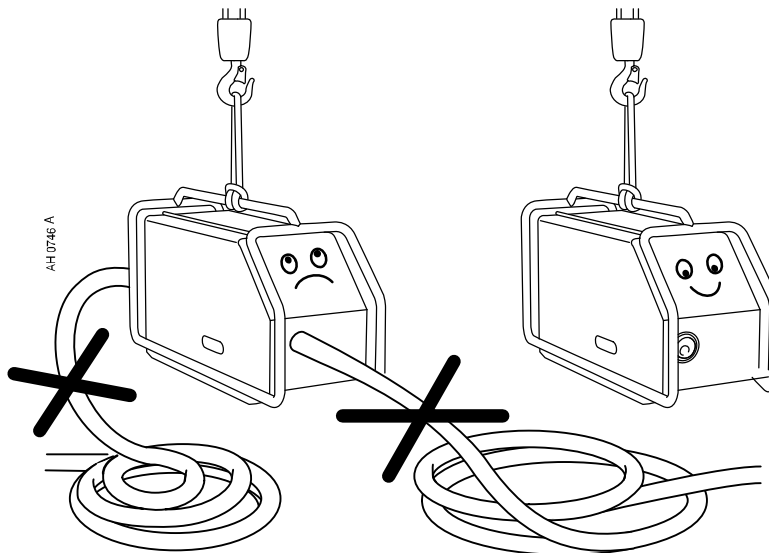
*The installation must be carried out by a professional.*



### WARNING

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

### 4.1 Lifting instructions



## 5 OPERATION

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



### WARNING

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



### WARNING

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



### WARNING

*Risk of crushing when replacing the wire bobbin!  
Do not use safety gloves when inserting the welding wire between the feed rollers.*



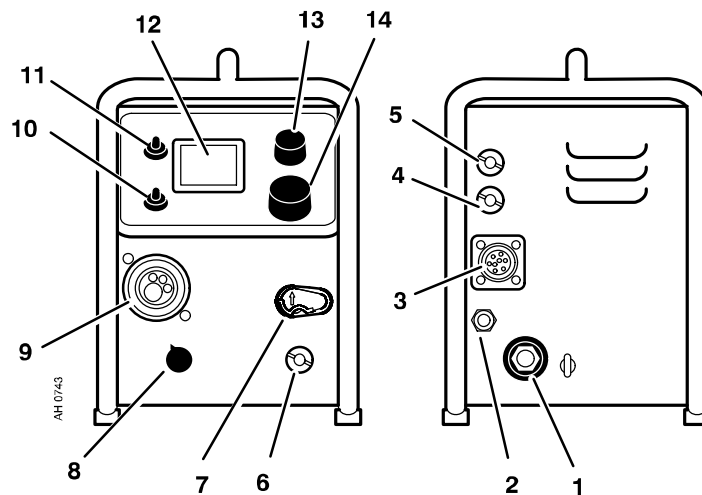
## 5.1 Connections and control devices

- |   |                                                               |    |                                               |
|---|---------------------------------------------------------------|----|-----------------------------------------------|
| 1 | Connection for welding current from power source, (OKC)       | 8  | Safety contact switch                         |
| 2 | Connection for shielding gas                                  | 9  | Connection for welding gun                    |
| 3 | Connection for control cable from power source                | 10 | Toggle switch for gas flushing / wire inching |
| 4 | Connection RED, for coolant to power source (cooling unit)    | 11 | Toggle switch for 2 stroke/ 4 stroke          |
| 5 | Connection BLUE, for coolant from power source (cooling unit) | 12 | Display                                       |
| 6 | Connection RED, for coolant from welding gun                  | 13 | Knob for setting the voltage**                |
| 7 | Connection BLUE, with ELP* for coolant to the welding gun     | 14 | Knob for setting wire feed speed              |

Note! Display (digital instrument) and coolant connections only available on certain models.

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

\*\* Voltage regulation from the wire feed unit does not function with step regulated power sources.



## 5.2 Function explanations

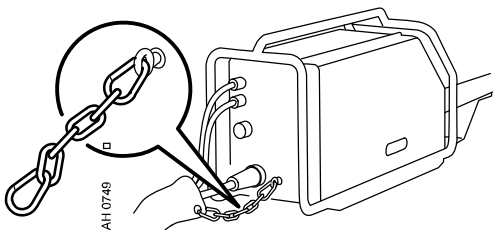
### Water connection

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

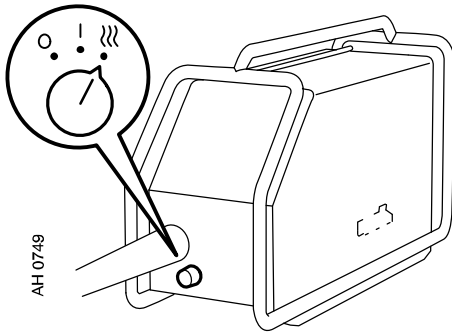
Detection only works with power sources that are equipped with ELP.

### Strain relief

Hook the strain relief onto the hook on the rear side of the feeder unit and the connection cable.



### Safety contact switch



0 Welding OFF

1 Welding ON



- Heat ON (accessory) and welding OFF  
The bobbin area is heated so that the welding wire is not damp when welding .

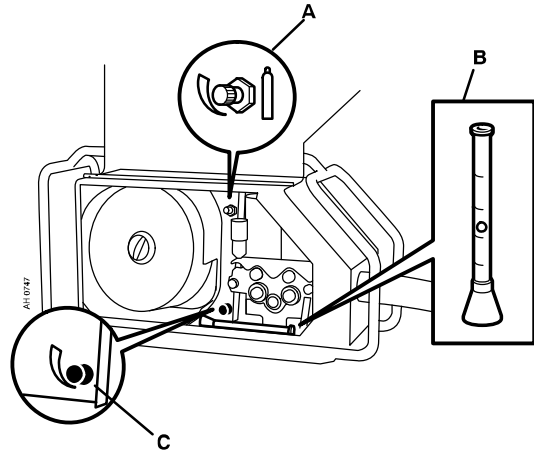
### Gasflow control and burnback time

A = Controlling gas flow.

B = Gas flow meter

C = Setting burnback time.

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



### Gas flushing

Gas flushing is used when measuring the gas flow or to flush any air or moisture from the gas hoses before welding starts. Gas flushing occurs for as long as the toggle switch is held depressed and occurs without voltage or wire feed starting.



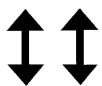
### Wire inching

Wire inching is used when one needs to feed wire without welding voltage being applied. The wire is fed as long as the toggle switch is depressed.



**2 stroke**

With **2-stroke** gasflow starts when the welding gun trigger switch is pressed. The welding process then starts. Releasing the trigger switch stops welding entirely and starts burn back time (if selected).



**4 stroke**

With **4 stroke**, the gas flow starts when the welding gun trigger switch is pressed in and the wire feed starts when it is released. The welding process continues until the switch is pressed in again, the wire feed and burn back time (if selected) stops when the switch is released.

## V Voltage

Higher voltage increases the arc length and produces a hotter, wider arc.

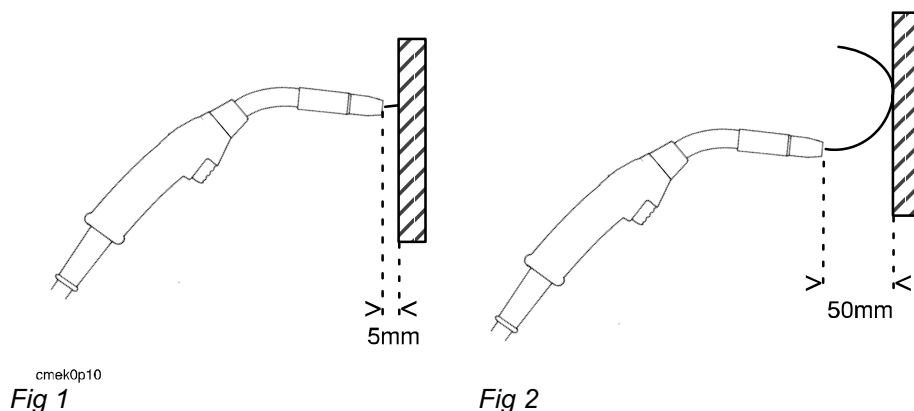
**NOTE!** Voltage regulation from the wire feed unit does not function with step regulated power sources.

## Wire feed speed

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

### 5.3 Wire feed pressure

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



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

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

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

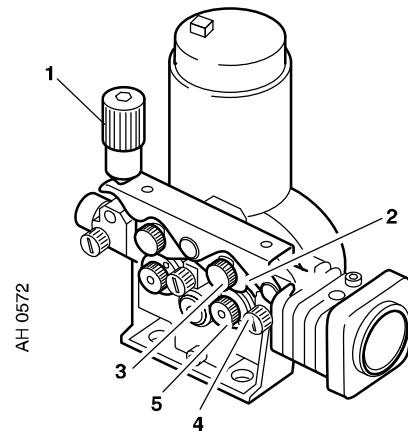
### 5.4 Replacing and inserting wire

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

## 5.5 Changing feed rollers

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

During installation, repeat the above in reverse order.



### Choice of track in the feed rollers

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

## 6 MAINTENANCE

*Regular maintenance is important for safe, reliable operation.*



### CAUTION

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

## 6.1 Inspection and cleaning

### Wire feed unit

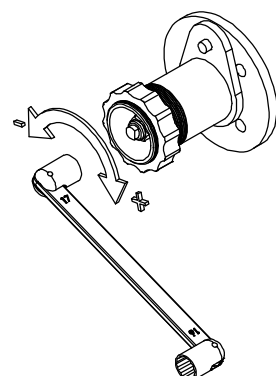
Check regularly that the wire feed unit is not clogged with dirt.

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

### The brake hub

The hub is adjusted when delivered.

- Adjust the brake hub so that wire is slightly slack when wire feed stops.



**Welding gun**

- The welding gun's wear parts should be cleaned and replaced at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean regularly and clean the contact tip.

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**7 ORDERING SPARE PARTS**

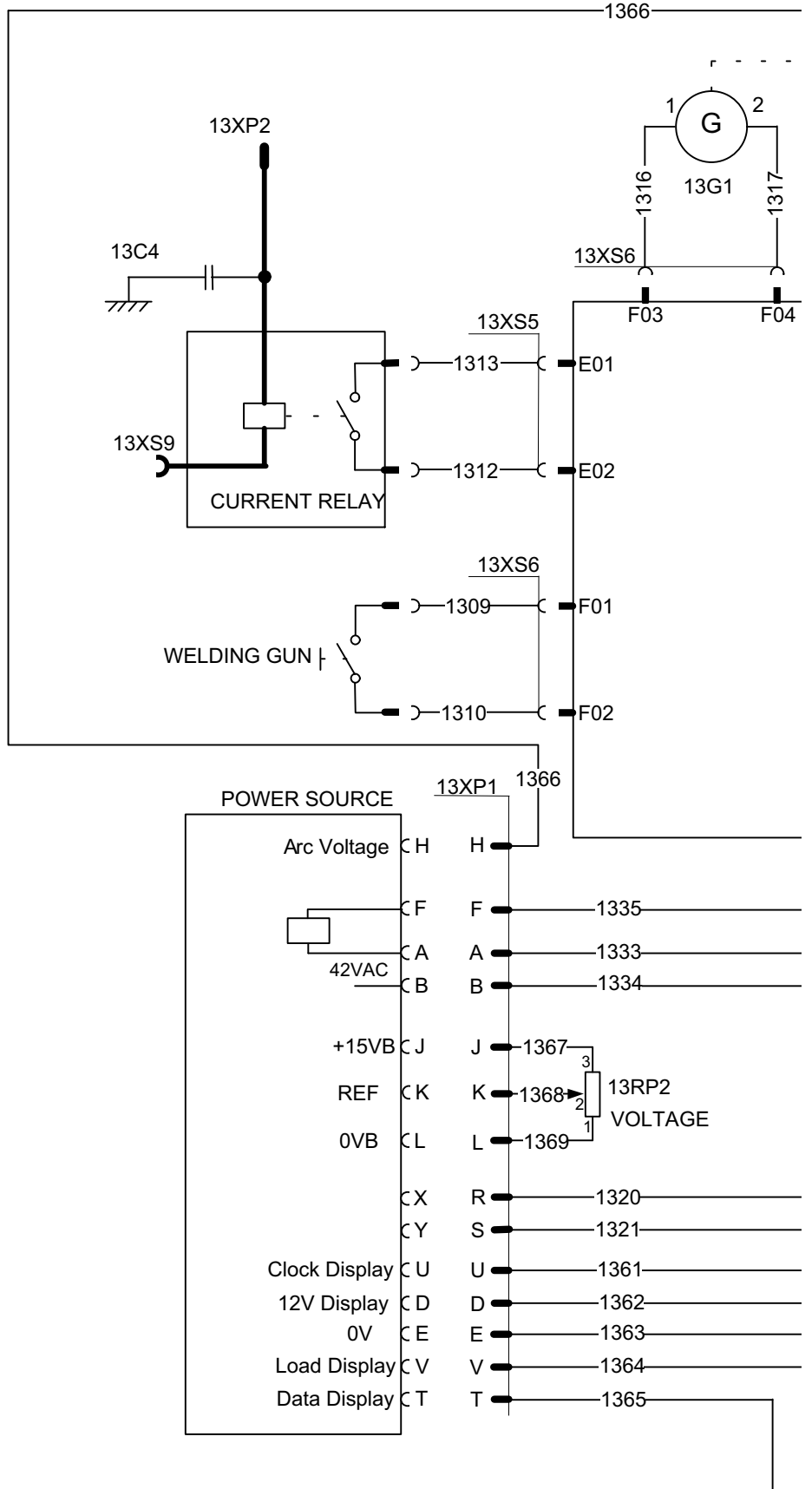
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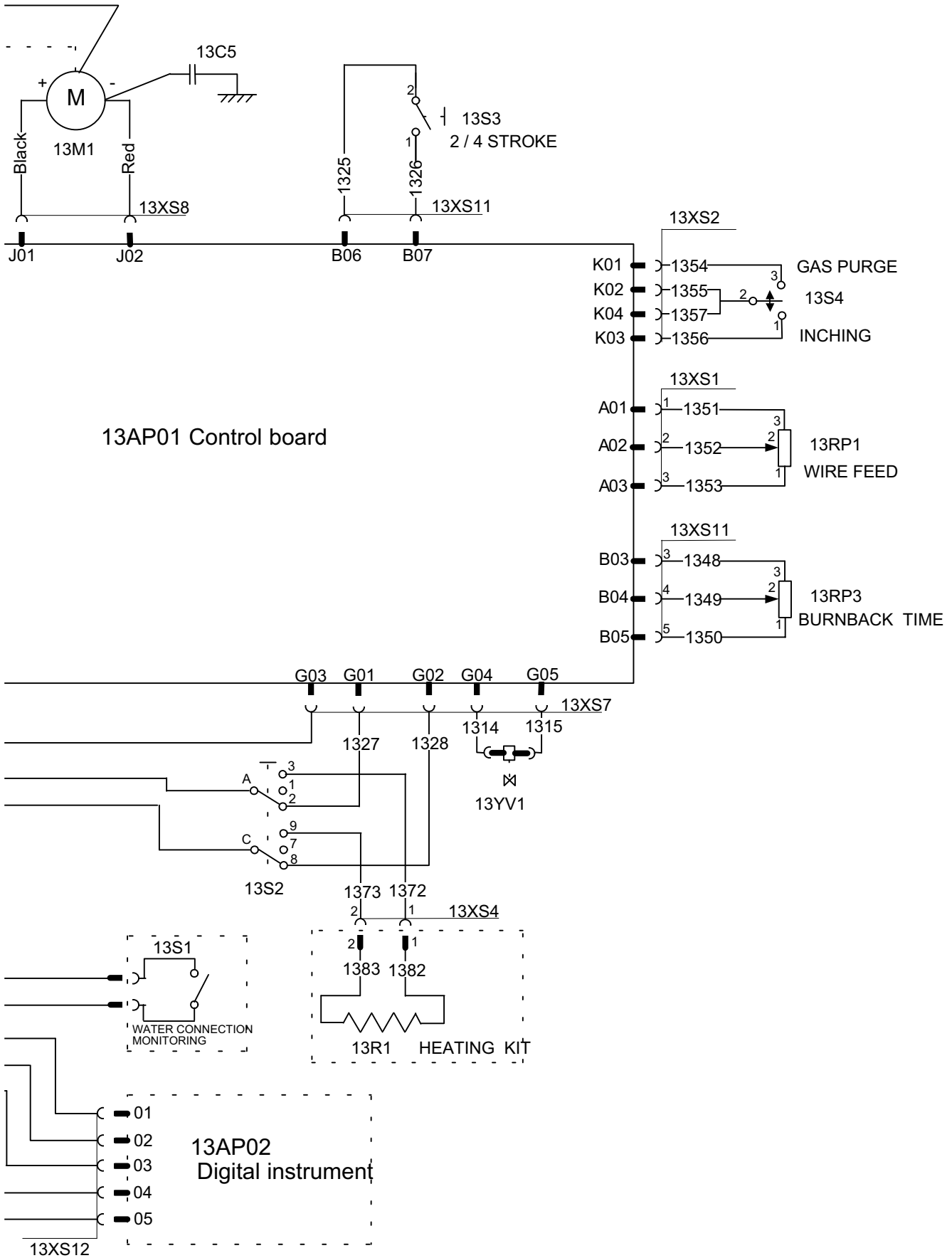
**YardFeed 200 is designed and tested in accordance with the international and European standards EN 60974-5 and EN 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.**

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

# Diagram

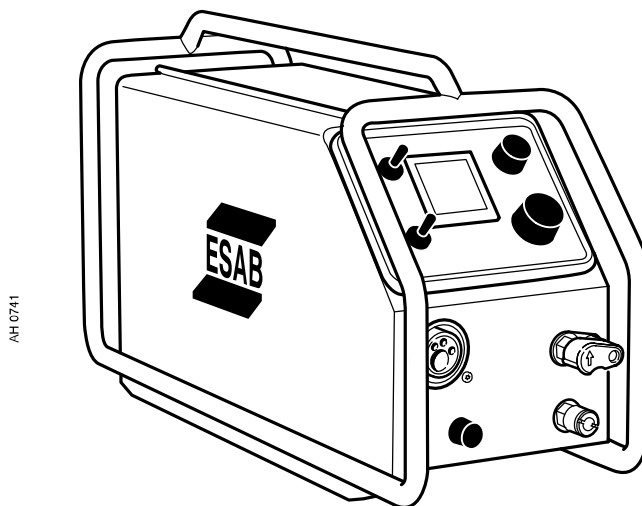
## YardFeed 200





## YardFeed 200

### Order number



Ordering no.	Denomination	Type
0459 906 881	Wire feed unit	Origo™ YardFeed 200 with control panel M13Y
0459 906 882	Wire feed unit	Origo™ YardFeed 200 with digital instrument and control panel M13Y
0459 906 891	Wire feed unit	Origo™ YardFeed 200 with water cooling and control panel M13Y
0459 906 892	Wire feed unit	Origo™ YardFeed 200 with water cooling, digital instrument and control panel M13Y
0459 839 005	Spare parts list	Origo™ YardFeed 200

Instruction manuals and the spare parts list are available on the Internet at [www.esab.com](http://www.esab.com)





## YardFeed 200

### Wear parts

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HI 1	0455 072 002 0456 615 001	Intermediate nozzle Intermediate nozzle	Fe, Ss & cored Al	
HI 2	0469 837 880 0469 837 881	Outlet nozzle Outlet nozzle	Fe, Ss & cored Al	Ø 2.0 mm steel for 0.6-1.2 mm Ø 2.0 mm plastic for 0.8-1.2 mm
HI 3	0191 496 114	Key		
HI 4	0215 701 007	Locking washer		
HI 5a	0459 440 001	Motor gear euro		

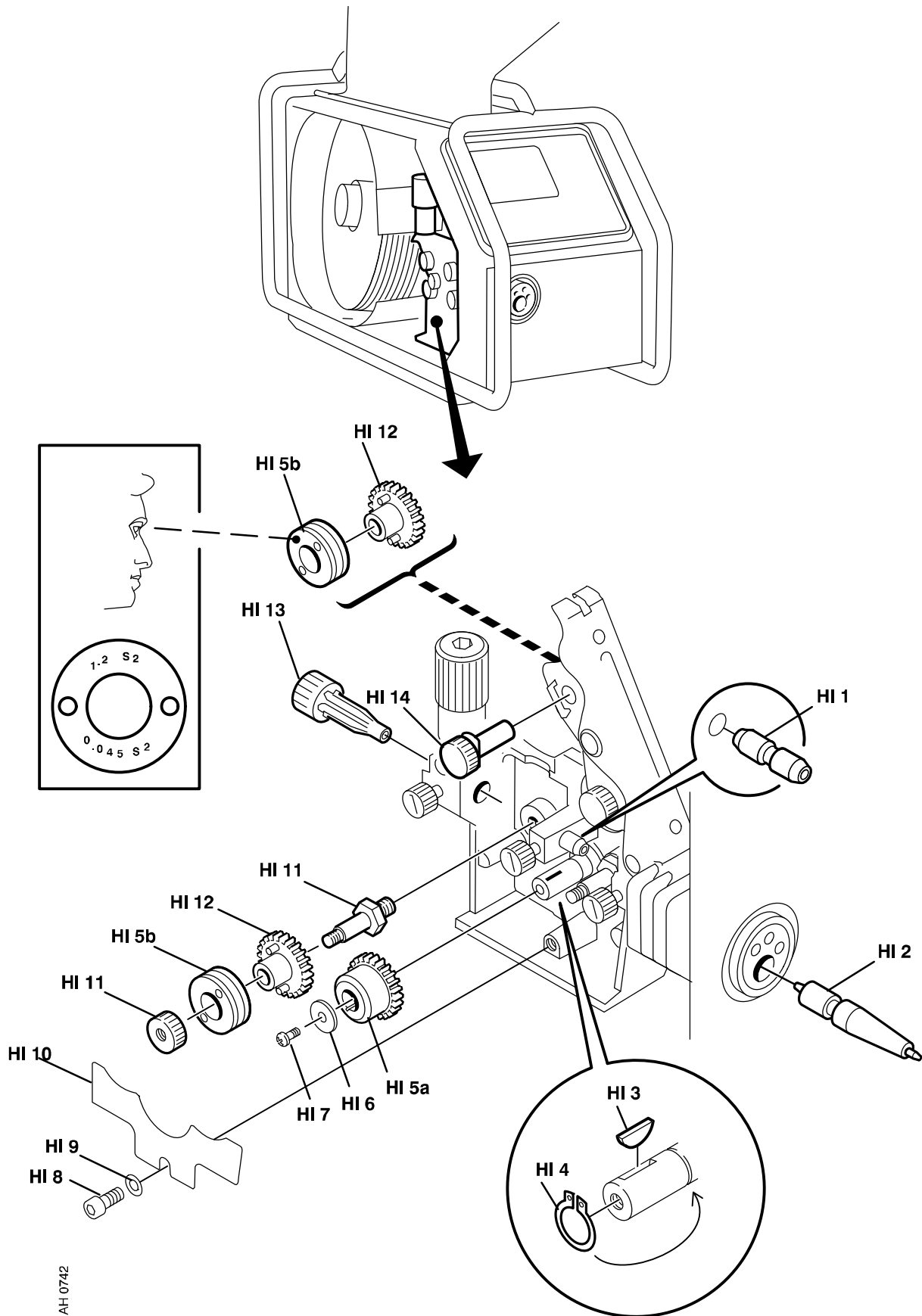
Item	Ordering no.	Denomination	Wire type	Wire dimensions	Groove typ	Roller markings
HI 5b	0459 052 001	Feed/pressure rollers	Fe, Ss & cored	Ø 0.6 & 0.8 mm	V	0.6 <b>S2</b> & 0.8 <b>S2</b>
	0459 052 002	Feed/pressure rollers	Fe, Ss & cored	Ø 0.8 & 0.9/1.0 mm	V	0.8 <b>S2</b> & 0.9/1.0 <b>S2</b>
	0459 052 003	Feed/pressure rollers	Fe, Ss & cored	Ø 0.9/1.0 & 1.2 mm	V	0.9/1.0 <b>S2</b> & 1.2 <b>S2</b>
	0458 825 001	Feed/pressure rollers	Cored	Ø 0.9/1.0 & 1.2 mm	V-Knurled	1.0 <b>R2</b> & 1.2 <b>R2</b>
	0458 824 001	Feed/pressure rollers	Al	Ø 0.8 & 0.9/1.0 mm	U	0.8 <b>A2</b> & 1.0 <b>A2</b>
	0458 824 002	Feed/pressure rollers	Al	Ø 1.0 & 1.2 mm	U	1.0 <b>A2</b> & 1.2 <b>A2</b>
	0458 824 003	Feed/pressure rollers	Al	Ø 1.2 mm	U	1.2 <b>A2</b>
Use only pressure and feed rollers marked <b>A2</b> , <b>R2</b> or <b>S2</b> . The rollers are marked with wire dimension in mm, some are also marked with inch.						

Item	Ordering no.	Denomination	Notes
HI 6		Washer	Ø 16/5x1
HI 7		Screw	M4x12
HI 8		Screw	M6x12
HI 9		Washer	Ø 16/8.4x1.5
HI 10	0469 838 001	Cover	
HI 11	0458 722 880	Axle and Nut	
HI 12	0459 441 880	Gear adapter	
HI 13	0455 049 001	Inlet nozzle	For Fe, Ss, Al and cored wire
	0460 007 001	Inlet nozzle	<b>Long-life</b> for Fe, Ss, Al and cored wire
HI 14	0458 999 001	Shaft	

#### Welding with aluminium wire

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

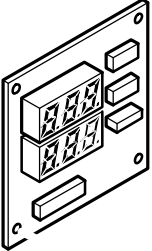
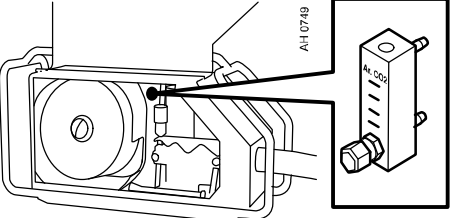
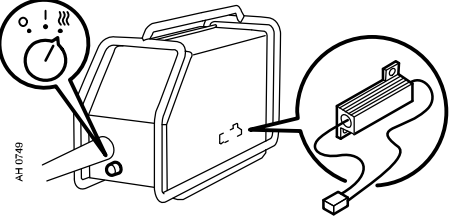
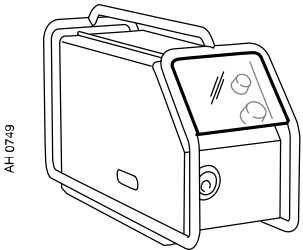
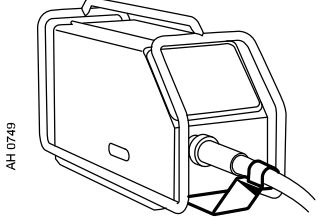
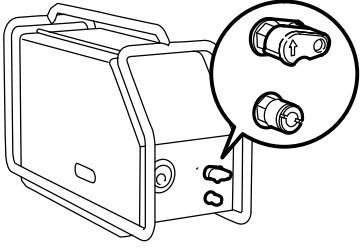
**YardFeed 200**



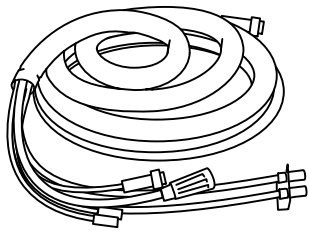
AH 0742

# YardFeed 200

## Accessories

	<b>Digital Volt / Ampere meter</b> ..... 0455 173 882
	<b>Gas flow meter</b> ..... 0460 005 880
	<b>Heating kit</b> ..... 0459 941 880
	<b>Control panel protection</b> ..... 0459 961 880
	<b>Strain relief for welding gun</b> ..... 0457 341 881
	<b>Water kit</b> ..... 0460 006 880

## YardFeed 200



### Connection set air, 19/23 pole

10 m .....	0459 836 582
15 m .....	0459 836 583
25 m .....	0459 836 584
35 m .....	0459 836 585
50 m .....	0459 836 586

### Connection set water, 19/23 pole

10 m .....	0459 836 592
15 m .....	0459 836 593
25 m .....	0459 836 594
35 m .....	0459 836 595
50 m .....	0459 836 596

### Connection set air, 19/19 pole

10 m .....	0459 836 562
15 m .....	0459 836 563
25 m .....	0459 836 564
35 m .....	0459 836 565
50 m .....	0459 836 566

### Connection set water, 19/19 pole

10 m .....	0459 836 572
15 m .....	0459 836 573
25 m .....	0459 836 574
35 m .....	0459 836 575
50 m .....	0459 836 576





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