



Aristo™ Feed 3004 MA4, MA6

Aristo™ Feed 4804 MA4, MA6

Optimum welding solutions

Sturdy and reliable

Sturdy design with galvanised metal casing for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The 4-wheel feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire, all to avoid operational disturbances.

The feeders are available with either Ø30 mm for wires up to Ø1.6 mm, or Ø48 mm rolls for wires up to Ø2.4 mm.

All adjustments are made on the man-machine communication panels (MMC) of the feeder, giving a good overview of the settings.

ESAB LogicPump ELP *, secures automatic start of the water pump when a water cooled torch is connected. This prevents overheating of the welding torch.

With safety in mind

Designed to meet the most rigid safety standard IEC 60974-5 with low voltage (42 V/AC) operations and overload protection circuit to eliminate breakdowns.

Flexibility

A variety of combinations with man-machine communication panels (MMC) Aristo™ MA4 and Aristo™ MA6.

The control panels are easy to operate with accurate settings that suits different needs and demands.

The Aristo™ Feed can be equipped with a counterbalance device, lifting eye or a wheel kit for increased mobility.



Easy service and maintenance

The feeder mechanism is easy to access and all wear parts can be exchanged without tools (Aristo™ Feed 3004). One single pressure device makes it easy to adjust the appropriate feeding pressure.

All electronic components are protected in a separate compartment.

* Not applicable in combination with Aristo™ Mig 4500i.

- **2/4 stroke**, simplifies handling of the welding torch.
- **Creep start, gas pre-flow and hot start** provide a soft and more direct start with less spatter.
- **Crater filling, adjustable burn-back time and post gas** provides a smooth finish, extend the lifetime of the contact tip and guarantee no cracks at the end.
- **Pre-programmed synergic lines**, to ensure optimum settings with a wide choice of materials, wire dimensions and gas combinations.
- **Memory for 10 parameter set** (Aristo™ MA6).
- **Quick connectors-** shortest possible set-up times.
- **ESAB LogicPump ELP ***, secures automatic start of water pump by connection of a water cooled welding torch.
- **TrueArcVoltage System™**, measures the correct arc voltage value independent of the length of the interconnection cable, return cable or welding torch.

| Panel (MMC) functions | Aristo™ MA4 | Aristo™ MA6 |
|-------------------------------|-------------|-------------|
| 2/4 stroke | X | X |
| Crater filling | X | X |
| Adjustable burn-back time | X | X |
| Creep start | X | X |
| Hot start | | X |
| Gas pre/post flow | X | X |
| Digital V/A meters | X | X |
| Gas purge/wire inching | | X |
| Pre-programmed synergic lines | | X |
| Memory 10 set | | X |
| Pulse/synergic pulse | | X |

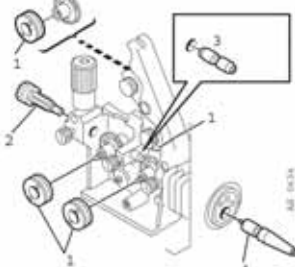
Technical data

| | Aristo™ Feed 3004 | Aristo™ Feed 4804 |
|---------------------------|--------------------------|--------------------------|
| Power supply, Vac, Hz | 42, 50/60 | 42, 50/60 |
| Wire spool capacity, kg | 18 (30**) | 18 (30**) |
| Max. spool diameter, mm | 300 (440**) | 300 (440**) |
| Setting data | | |
| Wire feed speed, m/min | 0.8-25.0 | 0.8-25.0 |
| Dimension (l x w x h), mm | | |
| Enclosed (Encl) | 680 x 285 x 420 | 680 x 285 x 420 |
| Weight, kg | | |
| Enclosed (Encl) | 17.5 | 22.5 |
| Wire dimensions: | | |
| steel | 0.6-1.6 | 0.6-2.4 |
| stainless steel | 0.6-1.6 | 0.6-2.4 |
| aluminium | 1.0-1.6 | 1.0-2.4 |
| cored wire | 0.8-1.6 | 0.8-2.4 |

Wear parts 30-4 3004

| Wire Ø mm | Wire type | 1 Feed roller | 2 Inlet nozzle | 3 Intermediate nozzle | 4 Outlet nozzle | Groove type | ! Marking |
|---------------|-----------|---------------|----------------|-----------------------|-----------------|------------------|-----------------|
| 0.6 / 0.8 | Fe, Ss, C | 459052-001 | 455049-001 | 455072-002 | 469837-880 | V | 0.6 S2 & 0.8 S2 |
| 0.8 / 0.9-1.0 | Fe, Ss, C | 459052-002 | 455049-001 | 455072-002 | 469837-880 | V | 0.8 S2 & 1.0 S2 |
| 0.9-1.0 / 1.2 | Fe, Ss, C | 459052-003 | 455049-001 | 455072-002 | 469837-880 | V | 1.0 S2 & 1.2 S2 |
| 1.4 / 1.6 | Fe, Ss, C | 459052-013 | 459049-001 | 455072-002 | 469837-880 | V | 1.4 S2 & 1.6 S2 |
| 0.9-1.0 / 1.2 | C | 458825-001 | 455049-001 | 455072-002 | 469837-880 | V-K | 1.0 R2 & 1.2 R2 |
| 1.2 / 1.4 | C | 458825-002 | 455049-001 | 455072-002 | 469837-880 | V-K | 1.2 R2 & 1.4 R2 |
| 1.6 | C | 458825-003 | 459049-001 | 455072-002 | 469837-880 | V-K | 1.6 R2 |
| 0.8 / 0.9-1.0 | Al | 458824-001 | 455049-001 | 456615-001 | 469837-881 | U | 0.8 A2 & 1.0 A2 |
| 1.2 / 1.6 | Al | 458824-003 | 455049-001 | 456615-001 | 469837-881 | U | 1.2 A2 & 1.6 A2 |
| C=cored wire | | | | | | K=knurled groove | |

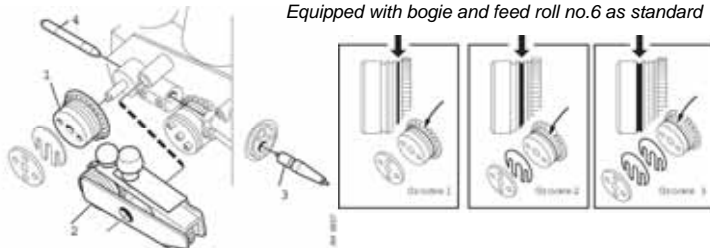
* Equipped as standard



Wear parts 48-4 4804

| Wire Ø mm | Wire type | 1 Feed roller | 2 Bogie | 3 Outlet nozzle | 4 Intermediate nozzle | Groove type | ! Marking | 1 | 2 | 3 |
|--------------|-----------|---------------|-------------|-----------------|-----------------------|------------------|-----------|---------|----------|----------|
| 0.6-1.2 | Fe,Ss,C | 366 966-880 | 366 902-880 | 469 837-880 | 156 603-001 | V | 1 | 0.6-0.8 | 0.9-1.0 | 1.2 |
| 0.9-1.6 | Fe,Ss,C | 366 966-900 | 366 902-900 | 469 837-880 | 156 603-001 | V | 6 | 0.9-1.0 | 1.2 | 1.4-1.6 |
| 1.2 | Fe,Ss,C | 366 966-889 | 366 902-894 | 469 837-880 | 156 603-001 | V | 7 | 1.2 | 1.2 | 1.2 |
| 1.4-1.6 | Fe,Ss,C | 366 966-881 | 366 902-881 | 469 837-880 | 156 603-001 | V | 2 | 1.4-1.6 | 2.0 | 2.4 |
| 2.0-2.4 | Fe,Ss,C | 366 966-881 | 366 902-881 | 469 837-882 | 156 603-002 | V | 2 | 1.4-1.6 | 2.0 | 2.4 |
| 1.2-1.6 | C | 366 966-882 | 366 902-882 | 469 837-880 | 332 322-001 | V-K | 3 | 1.2 | 1.4-1.6 | 2.0 |
| 2.0 | C | 366 966-882 | 366 902-882 | 469 837-882 | 332 322-001 | V-K | 3 | 1.2 | 1.4-1.6 | 2.0 |
| 2.4 | C | 366 966-883 | 366 902-883 | 469 837-882 | 333 322-002 | V-K | 4 | 2.4 | not used | not used |
| 1.0-1.6 | Al | 366 966-899 | 366 902-899 | 469 837-881 | 156 603-001 | U | U4 | 1.0 | 1.2 | 1.6 |
| 1.2 | Al | 366 966-885 | 366 902-886 | 469 837-881 | 156 603-001 | U | U2 | 1.2 | 1.2 | 1.2 |
| C=cored wire | | | | | | K=knurled groove | | | | |

Equipped with bogie and feed roll no.6 as standard



Interconnection cables

| | Air cooled | Water-cooled |
|--------|-------------------|---------------------|
| 1,7 m | 0456 528 880 | 0456 528 885 |
| 5,0 m | 0456 528 890 | 0456 528 895 |
| 10,0 m | 0456 528 881 | 0456 528 886 |
| 15,0 m | 0456 528 882 | 0456 528 887 |
| 25,0 m | 0456 528 883 | 0456 528 888 |
| 35,0 m | 0456 528 884 | 0456 528 889 |

Ordering information

| | |
|-----------------------------------|--------------|
| Aristo™ Feed 3004, MA4, Enclosed | 0458 806 884 |
| Aristo™ Feed 3004w, MA4, Enclosed | 0458 806 894 |
| Aristo™ Feed 3004, MA6, Enclosed | 0458 806 886 |
| Aristo™ Feed 3004w, MA6, Enclosed | 0458 806 896 |
| Aristo™ Feed 4804, MA4, Enclosed | 0458 806 984 |
| Aristo™ Feed 4804w, MA4, Enclosed | 0458 806 994 |
| Aristo™ Feed 4804, MA6, Enclosed | 0458 806 986 |
| Aristo™ Feed 4804w, MA6, Enclosed | 0458 806 996 |

Accessories Aristo™ Feed

| | |
|---|-----------------|
| Wheel kit | 0458 707 880 |
| Strain relief for welding torch | 0457 341 881 |
| Strain relief for interconnection cables | 0459 234 880 |
| Lifting eye | 0458 706 880 |
| Quick connector MarathonPac™ | F102 440 880 |
| Adapter for 5 kg:s spool | 0455 410 001 |
| Counter balance device | 0458 705 880 |
| Spool cover | 0458 674 880 |
| Spool cover, steel | 0459 431 880 |
| Adapter for spool diameter 440 mm | 0459 233 880 ** |
| Remote adapter RA 23 (23 pole) for connection of analogue remotes and RS3 | 0459 491 911 |
| Remote control MTA1 CAN | 0459 491 880 |
| Remote control M1 10Prog CAN | 0459 491 882 |
| Remote interconn. cable MTA1 and M1 10Prog 5 m | 0459 554 880 |
| Remote adapter kit Miggy-/ Railtrac | 0459 491 880 |
| Remote adapter kit MXH™ PP | 0459 491 881 |



ESAB AB
 Box 8004
 SE-402 77 GÖTEBORG SWEDEN
 Phone: +46 31 50 90 00 Fax +46 31 22 04 49
 E-mail: info@esab.se
www.esab.com

