



# Origo™ Feed 304 M13

# Origo™ Feed 484 M13

## Feeder units for thyristor controlled power sources

### 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 disturbance.

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

All adjustments are made on the front panel 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.

FeedSelector is an efficient solution for applications which require a quick and easy exchange between 2 different wire dimensions or wire types. Connect 2 x Origo™ Feed to 1 Origo™ Mig and the selector provides automatically power to the one in operation.

### 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

The panel M13 can be equipped with digital V/A meters and a toggle switch for inching/gas purge can be installed inside the feeder cabinet. The panel is easy to operate with accurate setting that suits different needs and demands.

Extra versatility can be provided by utilising one of the following mounting options for the Origo™ Feed. Counterbalance & Mast, Wheel Kit or Hanging Bracket.



Miggytrac and Railtrac connector as standard make the welding process easy to mechanise and increase the productivity.

### Easy service and maintenance

The feeder mechanism is easy to access and all wear parts can be exchanged without tools (Origo™ Feed 304). One single pressure device makes it easy to adjust the appropriate feeding pressure.

All electronic components are protected in a separate compartment.

- **2/4 stroke and Creep start**, simplifies start/stop and gradual feed of wire optimise the starts.
- **Crater filling**, eliminates cracks and gives high quality welds.
- **Adjustable burn-back time** to correct stick-out and reduce wear of contact tips.
- **Digital V/A meters.**
- **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 functions	M 13
2/4 stroke	X
Crater filling	X
Adjustable burn-back time	X
Creep start	X
Digital V/A meters	(x)
Inching/gas purge, option	(x)

## Technical data

	<b>Origo™ Feed 304</b>	<b>Origo™ Feed 484</b>
Power supply	42 V AC, 50/60 Hz	42 V AC, 50/60 Hz
Wire spool capacity	18 kg (30 kg**)	18 kg (30 kg**)
Maximum spool diameter	300mm (440mm**)	300mm (440mm**)
Setting data		
Wire feed speed	1.9-25.0 m/min	1.9-25.0 m/min
Bum-back time	0-0.5 s	0-0.5 s
Crater filling time	0-5.0 s	0-5.0 s
Dimension (l x w x h)		
enclosed version (Encl)	690 x 275 x 420 mm	690 x 275 x 420 mm
<b>Weight</b>		
enclosed version (Encl)	15 kg	19 kg
<b>Wire dimensions</b>		
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

## Interconnection cables

	<b>Air 400 A</b>	<b>Water 400A</b>
1,7 m	0469 836 880	0469 836 885
5,0 m	0469 836 981	0469 836 983
10,0 m	0469 836 881	0469 836 886
15,0 m	0469 836 882	0469 836 887
25,0 m	0469 836 883	0469 836 888
35,0 m	0469 836 884	0469 836 889
	<b>Air 500 A</b>	<b>Water 500 A</b>
1,7 m	0469 836 890	0469 836 895
10,0 m	0469 836 891	0469 836 896
15,0 m	0469 836 892	0469 836 897
25,0 m	0469 836 893	0469 836 898
35,0 m	0469 836 894	0469 836 899

## Ordering information

Origo™ Feed 304, M13, enclosed	0459 116 883
Origo™ Feed 304w, M13, enclosed	0459 116 893
Origo™ Feed 304, M13 incl. V/A meters, enclosed	0459 116 884
Origo™ Feed 304w, M13 incl. V/A meters, enclosed	0459 116 894
Origo™ Feed 484, M13, enclosed	0459 116 983
Origo™ Feed 484w, M13, enclosed	0459 116 993
Origo™ Feed 484, M13 incl. V/A meters, enclosed	0459 116 984
Origo™ Feed 484w, M13 incl. V/A meters, enclosed	0459 116 994

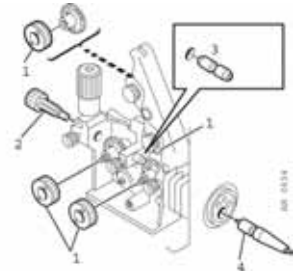
## Accessories Origo™ Feed

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
Adapter for spool diameter 440 mm	0459 233 880 **
Spool cover, steel	0459 431 880
Digital V/A meter in feeder to fit Origo™ Mig 630wt	On request
Remote control M1	0459 491 895
Remote interconnection cable M1 5m	0459 553 880
Remote control MIG 2	0349 501 028
FeedSelector	0349 308 248
Inching or gas purge kit M13	0459 465 880

## Wear parts 30-4 / 304

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	

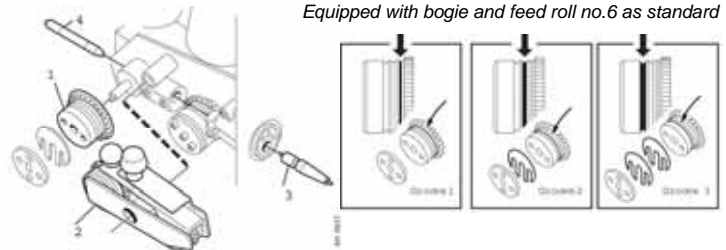
\* Equipped as standard



## Wear parts 48-4 / 484

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



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