

# Aristo<sup>®</sup> Feed 3004 *U6 and Aristo<sup>®</sup> U8<sub>2</sub>*

# Aristo<sup>®</sup> Feed 4804 *U6 and Aristo<sup>®</sup> U8<sub>2</sub>*

## 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 disturbance.

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

All adjustments are made on the man-machine communication panel (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 are available with the man-machine communication panel Aristo U6 and the operator pendant Aristo U8<sub>2</sub>. The MMC panel Aristo U6 and the operator pendant Aristo U8<sub>2</sub> are easy to operate with accurate settings to suit 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.

Panel (MMC) functions	U6	U8 <sub>2</sub>	U8 <sub>2</sub> Plus
QSet™	X	X	X
2/4 stroke	X	X	X
Crater filling	X	X	X
Creep start, hot start and adjustable burn-back time	X	X	X
Gas pre/post flow	X	X	X
Digital V/A meters	X	X	X
Pre-programmed synergic lines	X (60)	X (92)	X (>230)
Gas purge/wire inching	X	X	X
Memory 10 set	X		
Memory 255 set		X	X
Pulse/synergic pulse	X	X	X
Limit editor, set and measured values		X	X
Create synergic lines			X
SuperPulse™			X
Production statistics			X
Auto save mode			X

- **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** replace 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.
- **The ability to create synergic lines**
- **Memory for 10 (Aristo U6) or 255 (Aristo U8<sub>2</sub>) parameter sets**
- **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.
- **SuperPulse™**, the welding process with the ability to control the heat input (Aristo U8<sub>2</sub>).

## Technical data

	<b>Feed 3004</b>	<b>Feed 4804</b>
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**)
<b>Setting data</b>		
Wire feed speed, m/min	0.8-25.0	0.8-25.0
Dimension (l x w x h), mm		
Enclosed (Encl)	690 x 275 x 420	690 x 275 x 420
<b>Weight, kg</b>		
Enclosed (Encl)	15	19
<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

## Ordering information

Aristo Feed 3004, (U <sub>8</sub> ) Encl	-10 pole	0460 526 881
Aristo Feed 3004w, (U <sub>8</sub> ) Encl	-10 pole	0460 526 891
Aristo Feed 3004, U <sub>6</sub> , Encl	-10 pole	0460 526 886
Aristo Feed 3004w, U <sub>6</sub> , Encl	-10 pole	0460 526 896
Aristo Feed 4804, (U <sub>8</sub> ) Encl	-10 pole	0460 526 981
Aristo Feed 4804w, (U <sub>8</sub> ) Encl	-10 pole	0460 526 991
Aristo Feed 4804, U <sub>6</sub> , Encl	-10 pole	0460 526 986
Aristo Feed 4804w, U <sub>6</sub> , Encl	-10 pole	0460 526 996
Aristo U <sub>8</sub> , complete incl. holder		0460 820 880
Aristo U <sub>8</sub> Plus, complete incl. holder		0460 820 881
Control cable extension 7.5 m		0460 877 891

For further Aristo U<sub>8</sub> information, see separate fact sheet XA00141820

### Accessories for 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 (Only when Trolley 2)		0458 705 880
Spool cover, steel		0459 431 880
Remote control MTA1 CAN		0459 491 880
Remote control M1 10Prog CAN		0459 491 882
Remote interconn. cable 5 m, 12p *		0459 554 880
Remote interconn. cable 5 m, 10p		0459 960 880
Remote interconn. cable HD 5 m, 10p		0459 960 980
Remote adapter kit MXH™ PP		0459 681 881
Remote adapter kit Miggy-/ Railtrac		0459 681 880
MXH 300/400w PP connection kit		0459 020 883

\* For Feed 3004/4804 (U<sub>8</sub>) Encl -10 pole

## Interconnection cables 10/10 pole

<b>70 mm<sup>2</sup></b>	<b>Air cooled</b>	<b>Water cooled</b>
1.7 m	0459 528 780	0459 528 790
5.0 m	0459 528 781	0459 528 791
10.0 m	0459 528 782	0459 528 792
15.0 m	0459 528 783	0459 528 793
25.0 m	0459 528 784	0459 528 794
35.0 m	0459 528 785	0459 528 795
<b>95 mm<sup>2</sup></b>		
1.7 m	0459 528 980	0459 528 990

## QSet™ – Stable short arc in no time

Simply set the wire feed speed and the QSet™ will automatically select the correct welding parameters for the required wire/gas combination. QSet™ does this for all valid gas and wire combinations, CO<sub>2</sub> and MAG Brazing alike and without any need for synergic lines.

QSet™ is a quick way to find optimised welding parameters for the best quality weld. Spatter is reduced to a minimum.

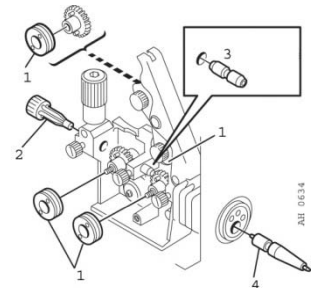
It is simple and straightforward to set a new working point with QSet™. Just change wire feed speed to match the required welding power and then QSet™ will select all other parameters for an optimised welding result in the whole short arc area.

All this with only one knob control.

## Wear parts 3004

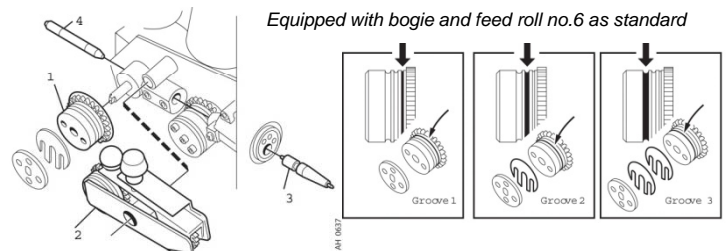
Wire Ø mm	Wire type	1 Feed roller	2 Inlet nozzle	3 Intermediate nozzle	4 Outlet nozzle	Groove type	! Marking
0.6 / 0.8	Fe, Ss, C	459052-001	455049-001	455072-002	469837-880	V	0.6 S2 & 0.8 S2
0.8 / 0.9-1.0	Fe, Ss, C	459052-002	455049-001	455072-002	469837-880	V	0.8 S2 & 1.0 S2
0.9-1.0 / 1.2	Fe, Ss, C	459052-003	455049-001	455072-002	469837-880	V	1.0 S2 & 1.2 S2
1.4 / 1.6	Fe, Ss, C	459052-013	455049-001	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	455049-001	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 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			



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