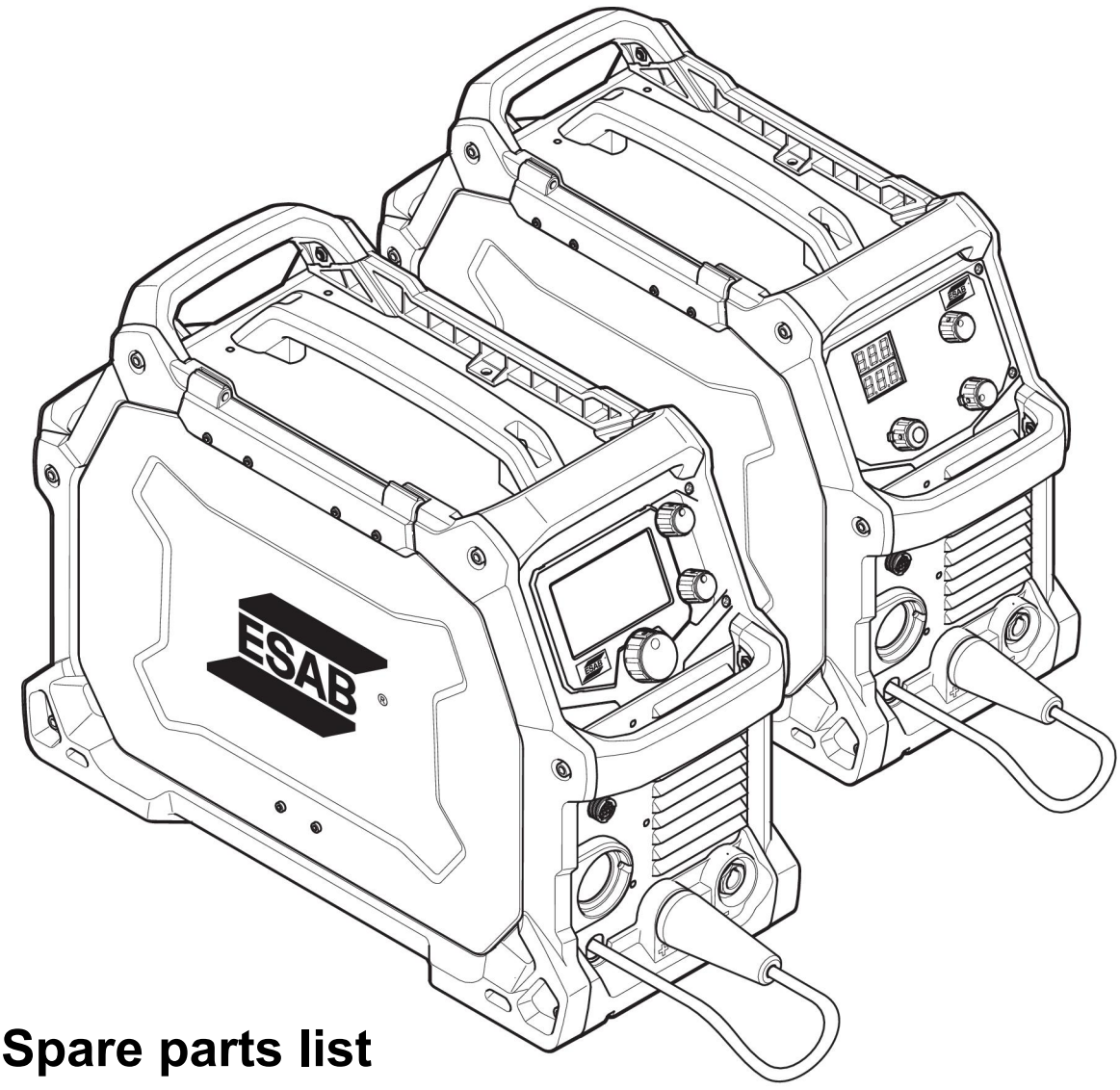
EMS215ic, EMP215ic, EM215ic



Spare parts list

0463 412 001 GB 20161123

Valid for: serial no. EMP215ic: 552-, 615-, 643-xxx-xxx,
EMS215ic: 612-xxx-xxxx, EM215ic: 623-xxx-xxxx

Ordering number	Product	Notes	Serial no.
0558 102 239	EMS215ic	Bobbin Ø4-8" (100-200 mm). CSA/Bayonet	612-xxx-xxxx
0558 102 240	EMP215ic	Bobbin Ø4-8" (100-200 mm). CSA/Bayonet	552-xxx-xxxx
0558 102 436	EM215ic	Bobbin Ø4-8" (100-200 mm). CSA/Bayonet	623-xxx-xxxx
0700 300 985	EMP215ic	Bobbin Ø100-200 mm (4-8") CE, euro connection	615-xxx-xxxx
0700 300 988	EMP215ic	Bobbin Ø100-200 mm (4-8"), euro connection (Middle East)	643-xxx-xxxx

Spare parts and wear parts are to be ordered through the nearest ESAB agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

SPARE PARTS **4**

Housing **4**

Connections including drive system **6**

User interface **8**

Control modules **10**

WEAR PARTS - CSA **12**

WEAR PARTS - CE **13**

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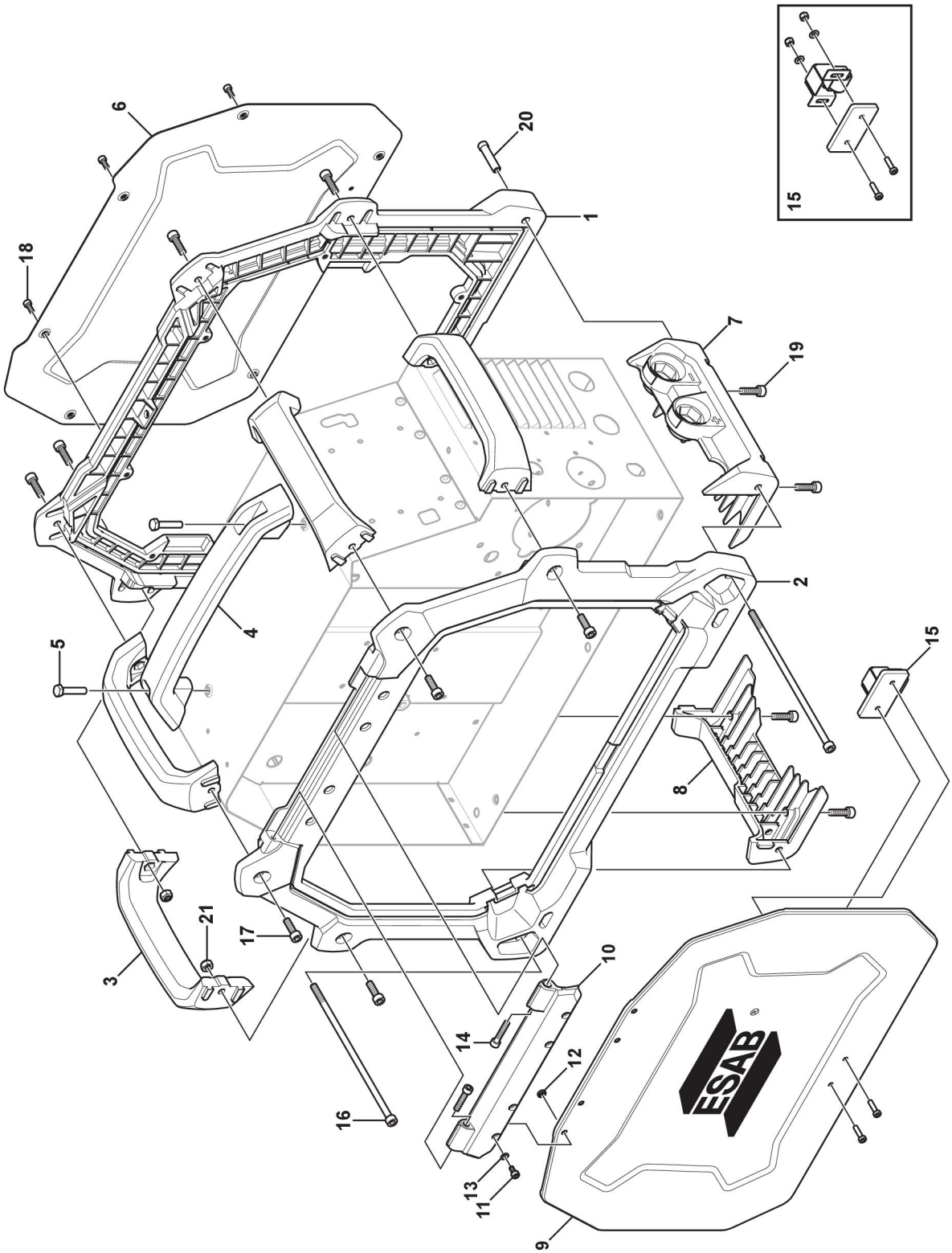
SPARE PARTS

Housing

C = Component designation in circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0558 102 397	Side frame, left		
2	1	0558 102 398	Side frame, right		
3	4	0558 102 399	Handle		
4	1	0558 102 400	Top handle		
5	2		Screw		
6	1	0558 102 401	Side panel, left	CSA, with ESAB logo and welding decal	
	1	0464 581 001	Side panel, left	CE, with ESAB logo and welding decal	
7	1	0558 102 402	Front foot	With decals	
8	1	0558 102 403	Rear foot		
9	1	0558 102 404	Side panel right	CSA, with ESAB logo	
	1	0464 582 001	Side panel right	CE, with ESAB logo	
10	1	0558 102 406	Hinge		
11	4		Screw	M4 × 8 mm	
12	4		Nut	M4 × 0.7 mm	
13	4		Washer	M4	
14	2	0558 102 407	Hinge pin		
15	1	0558 102 405	Roller latch asssembly		
16	2		Screw	M6 × 180 mm	
17	8		Screw	M6 × 20 mm	
18	6		Screw	M4 × 10 mm	
19	4		Screw	M6 × 20 mm	
20	2		Sex bolt	M6	
21	8		Nut	M6	

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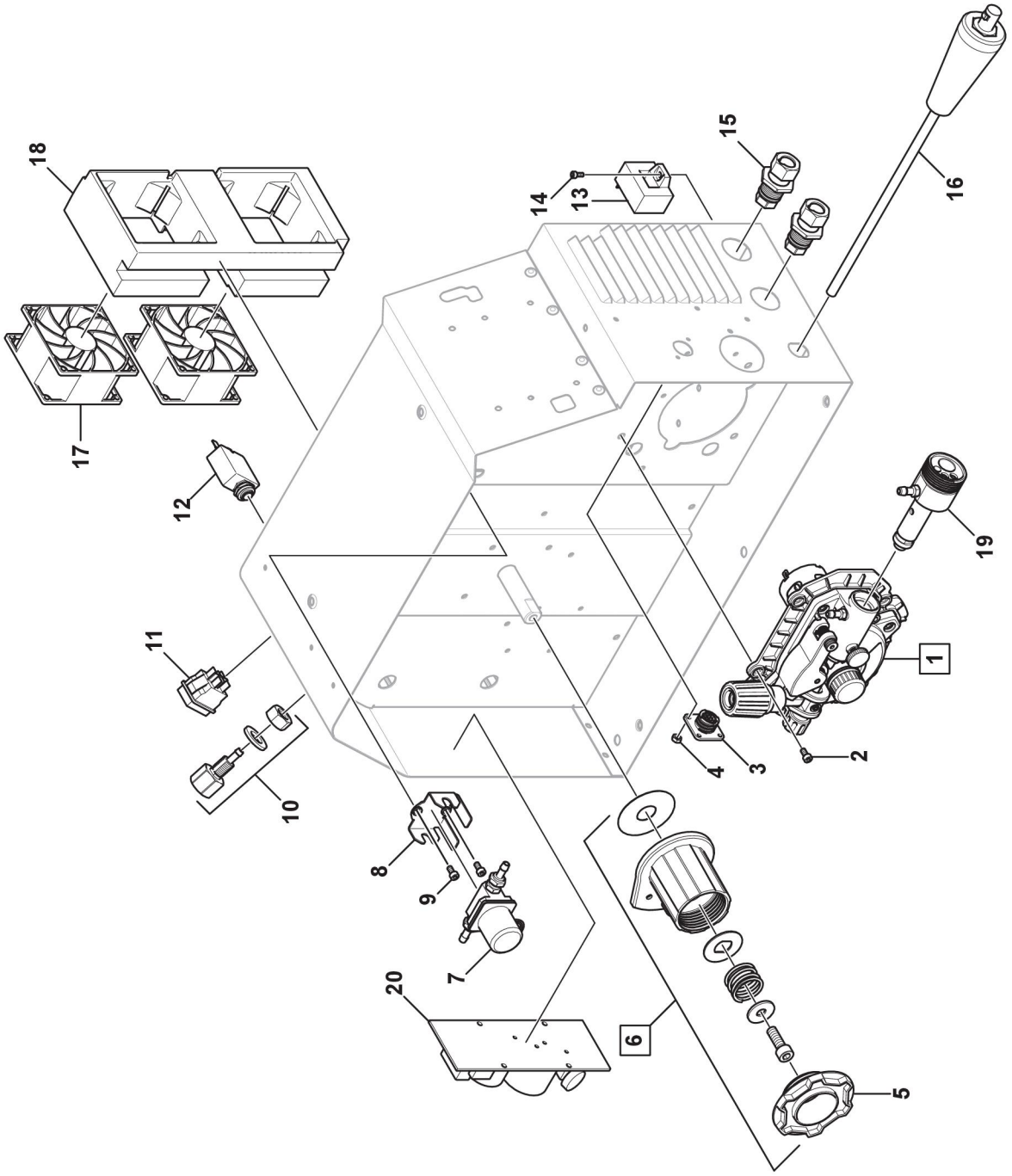
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Connections including drive system

C = Component designation in circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0558 102 408	Wire feeder mechanism	CSA, including motor and harness	
	1	0464 583 880	Wire feeder mechanism	CE, including motor and harness	
2	1		Screw	M5 × 16 mm	
3	1	0558 102 409	Remote connection outlet with harness	8-pin connector	
4	2		Nut	M3 × 0.5 mm	
5	1	0558 102 410	Brake hub nut		
6	1	0558 102 411	Brake hub kit		
7	1	0558 102 412	Solenoid assembly with hoses	With gas valve, hose clamps and hoses	
8	1	0558 102 413	Bracket for solenoid valve		
9	2		Screw	M4 × 10 mm	
10	1	0558 102 414	Gas connector	CSA	
	1	0464 587 880	Gas connector	CE	
11	1	0558 102 415	Main supply switch		
12	1	0558 102 416	Circuit breaker		
13	1	0558 102 417	Current sensor		
14	1		Screw	M3 × 8 mm	
15	2	0558 102 418	OKC contact female		
16	1	0558 102 419	Polarity changeover cable complete		
17	2	0558 102 420	Fan + wire harness	Including wire harness	
18	1	0558 102 421	Fan protection foam		
19	1	0464 588 880	Euro connection with harness	CE only	
20	1	0464 589 880	EMI PCB assembly incl. wire harness	CE only	
21	1	0558 102 442	Warning pinch-shock label	Not included in illustration	

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User interface

C = Component designation in circuit diagram

EM 215ic

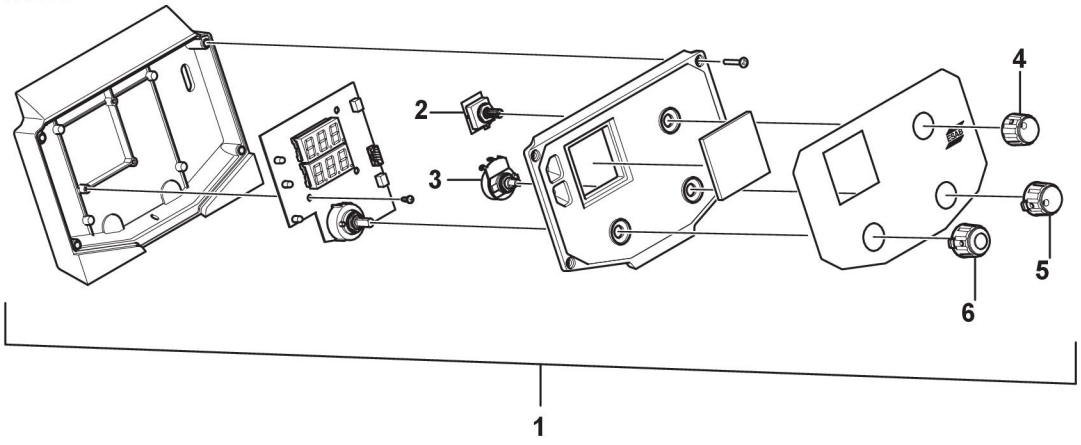
Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0558 102 486	User interface complete		
2	1	0558 102 423	Knob encoder with retaining ring		
3	1	0558 102 487	WF Pot Assembly		
4	1	0558 102 440	Knob, small		
5	2	0558 102 489	WF Pot Knob		
6	1	0558 102 488	Process Select Knob		

EMP 215ic, EMS 215ic

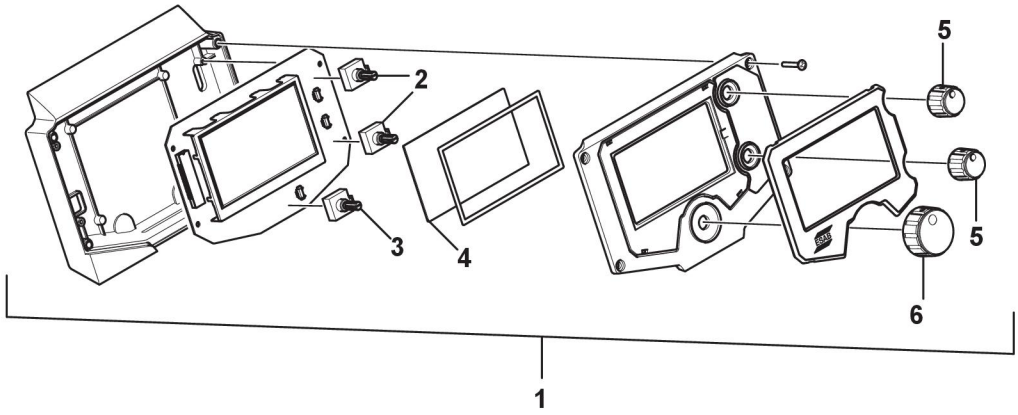
Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0558 102 422	EMP215ic panel assembly	CSA	
	1	0464 590 880	EMP215ic panel assembly	CE	
	1	0558 102 485	EMS215ic panel assembly	CSA	
2	2	0558 102 423	Encoder for small knob		
3	1	0558 102 424	Encoder for large knob		
4	1	0558 102 438	Replaceable display lens		
5	2	0558 102 440	Knob, small		
6	1	0558 102 441	Knob, large		
7	1	0558 102 437	EMP215ic lens assembly kit		
	1	0558 102 484	EMS215ic lens assembly kit		

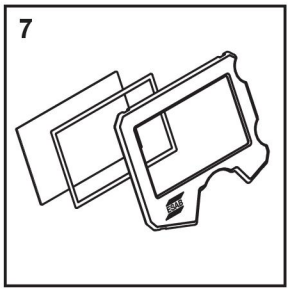
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EM 215ic



EMP 215ic / EMS 215ic





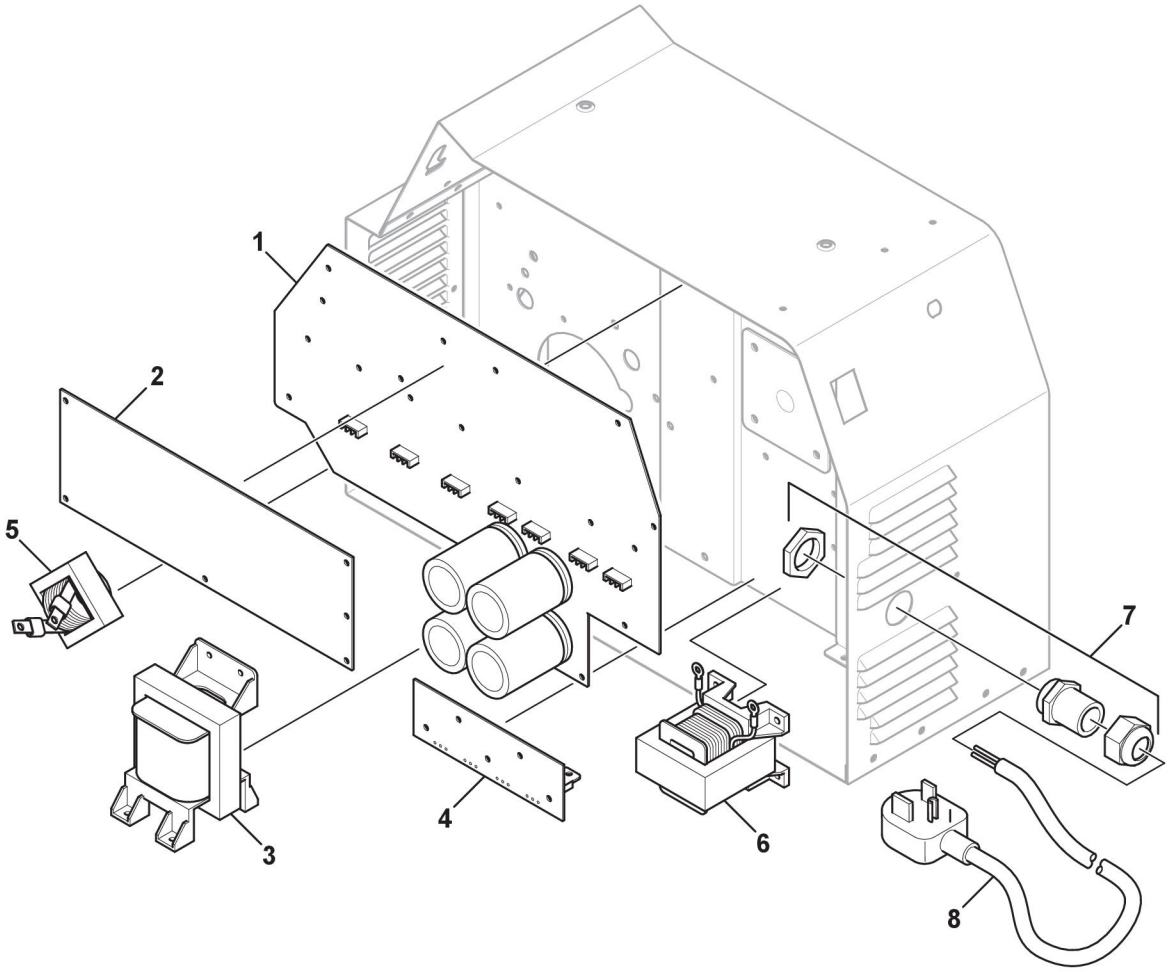
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Control modules

C = Component designation in circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0558 102 426	PCB Power board assembly	CSA	
	1	0464 591 880	PCB Power board assembly	CE	
2	1	0558 102 427	PCB Control board complete	CSA	
	1	0464 592 880	PCB Control board complete	CE	
3	1	0558 102 428	Main transformer with NTC (3x)		
4	1	0558 102 429	Output diode assembly		
5	1	0558 102 430	Output inductor assembly		
6	1	0558 102 431	PFC inductor assembly		
7	1	0558 102 432	Strain relief assembly assembly		
8	1	0558 102 433	Mains cable complete	CSA only	
9	1	0558 102 434	Warning label	Not included in illustration	

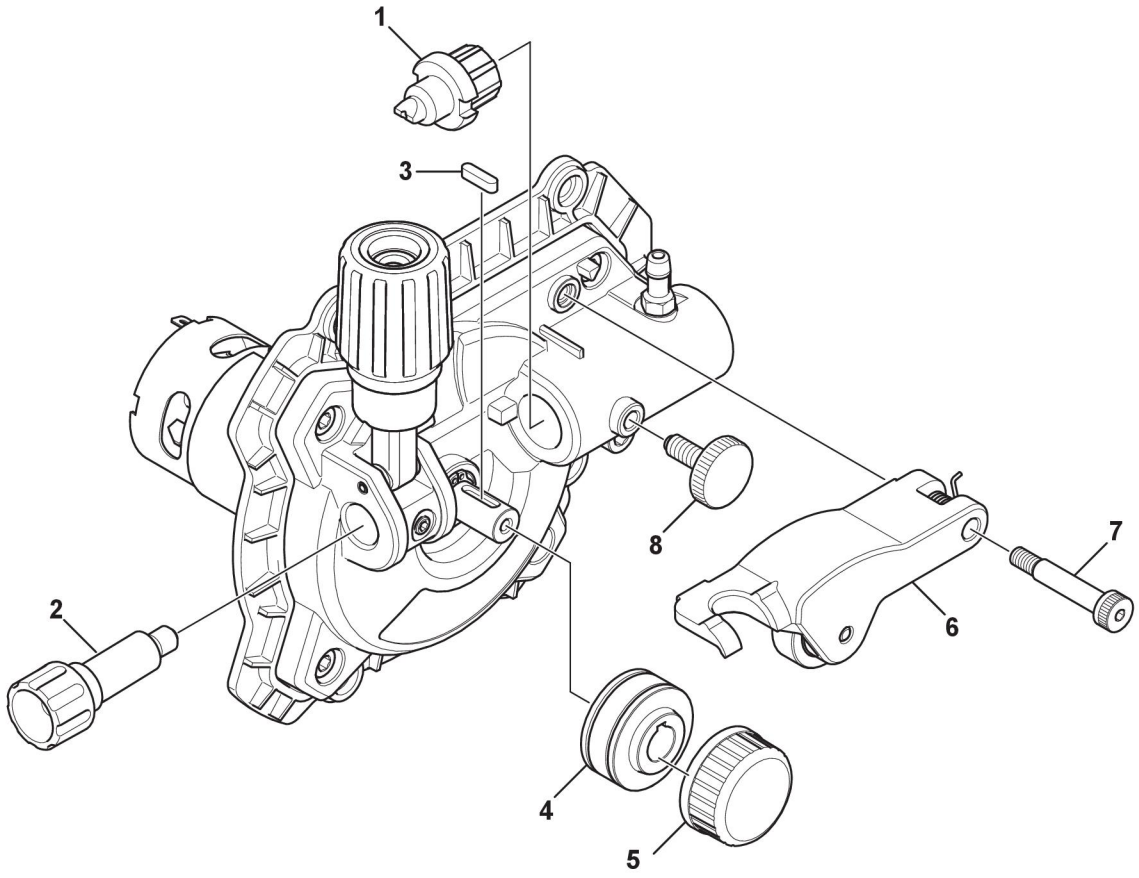
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WEAR PARTS - CSA

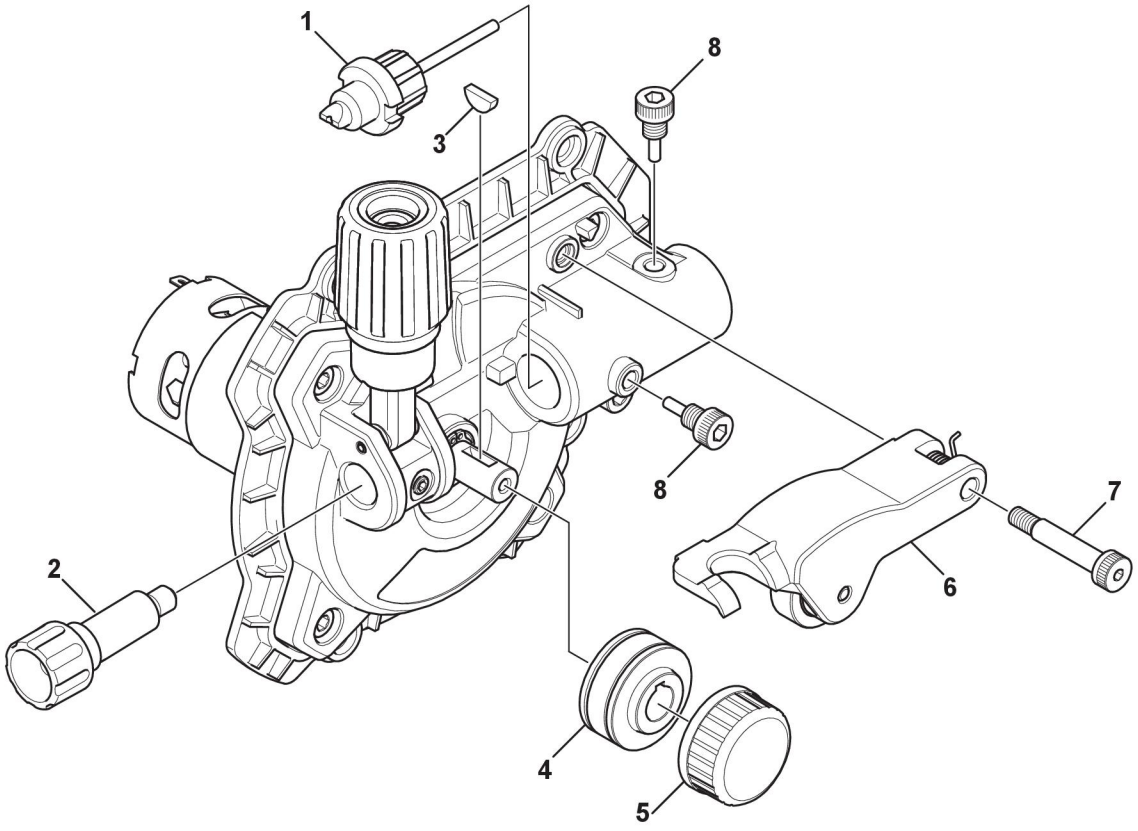
Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 326	Wire outlet guide	Fe/SS/Flux Cored	0.030” / 0.035” / 0.045” (0.8 mm / 0.9 mm / 1.2 mm)
	0558 102 327	Wire outlet guide	Fe/SS/Flux Cored	0.024” (0.6 mm)
2	0558 102 328	Wire inlet guide	Fe/SS/Flux Cored	0.024” / 0.030” / 0.035” / 0.045” (0.6 mm / 0.8 mm / 0.9 mm / 1.2 mm)
3	0558 102 334	Key-drive shaft	N/A	N/A
4	7977036	Feed roll “V” groove	Fe/SS	0.024” / 0.030” (0.6 mm / 0.8 mm)
	W4014800	Feed roll “V” groove	Fe/SS	0.024” / 0.035” (0.6 mm / 0.9 mm)
	7977732	Feed roll “V” knurled	Flux Cored	0.030” / 0.035” (0.8 mm / 0.9 mm)
	7044277	Feed roll "V" knurled	Flux Cored	0.045" (1.1 mm)
5	0558 102 329	Locking knob	N/A	N/A
6	0558 102 331	Pressure arm complete assembly	N/A	N/A
7	0558 102 330	Screw	N/A	N/A
8	0558 102 332	MIG gun locking knob	N/A	N/A



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WEAR PARTS - CE

Item	Ordering no.	Denomination	Wire type	Wire dimensions
1	0558 102 460	Wire outlet guide steel	Fe/SS/Flux Cored	1.0 mm - 1.2 mm (0.040” / 0.045”)
	0558 102 461	Wire outlet guide steel	Fe/SS/Flux Cored	0.6 mm - 0.8 mm (0.023” - 0.030”)
2	0558 102 328	Wire inlet guide	Fe/SS/Flux Cored	0.6 mm / 0.8 mm / 0.9 mm / 1.2 mm (0.023” / 0.030” / 0.035” / 0.045”)
3	0191 496 114	Key-drive shaft crescent	N/A	N/A
4	0367 556 001	Feed roll “V” groove	Fe/SS/Flux Cored	0.6 mm / 0.8 mm (0.023” / 0.030”)
	0367 556 002	Feed roll “V” groove	Fe/SS/Flux Cored	0.8 mm / 1.0 mm (0.030” / 0.040”)
	0367 556 003	Feed roll “V” knurled	Fe/SS/Flux Cored	1.0 mm / 1.2 mm (0.040" / 0.045")
	0367 556 004	Feed roll "U" groove	Aluminium	1.0 mm / 1.2 mm (0.040" / 0.045")
5	0558 102 329	Locking knob	N/A	N/A
6	0558 102 331	Pressure arm complete assembly	N/A	N/A
7	0558 102 330	Screw	N/A	N/A
8	0558 102 459	Euro adapter locating screw	N/A	N/A



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