

# Origo™ Feed 3004/4804 MA23, MA24

## Optimum welding solutions

### Sturdy and reliable

The sturdy design of the ESAB Origo™ Feed 3004 and 4804, with their galvanised metal casing, makes these units ideal for use in tough environments. Electronically controlled feeding gives an accurate and stable arc and the 4-wheel feeder mechanism with grooves in both the feed roll and pressure roll give a stable feed with low wear on the wire, all of which helps 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**, ensures 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 help eliminate breakdowns.

### Flexibility

A variety of combinations are available with the man-machine communication panels (MMC) Origo™ MA23 and MA24. All feeders are delivered with an enclosed wire spool area and the "w" option (water cooled) equipped with quick connectors for easy connection of water-cooled torches.

The control panels are easy to operate and allow accurate settings to satisfy a range of different user demands.

Feed 3004 and 4804 can be equipped with a counterbalance device, lifting eye or a wheel kit for increased mobility.

### PSF RS3

The PSF RS3, with the three program memory switch, makes three pre-programmed parameters available directly from the torch.

### Easy service and maintenance

All wear parts can be exchanged without tools (Feed 3004). One single pressure device makes it easy to adjust the appropriate feeding pressure.

All electronic components are protected in a separate compartment.



The MA24 panel version has a unique setting for the welding parameters in short arc.

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 of 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™. Simply 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.

- **2/4 stroke**, simplifies handling of the welding torch.
- **Creep start, (MA24)** provide a soft and more direct start with less spatter.
- **Crater filling, (MA24)** provides a smooth finish, extends the lifetime of the contact tip and eliminates cracking at the end of the weld run.
- **Pre-programmed synergic lines, (MA24)** to ensure optimum settings with a wide choice of materials, wire dimensions and gas combinations.
- **QSet™(MA24)** - Stable short arc
- **Memory for 3 parameter set**
- **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	MA23	MA24
2/4 stroke	X	X
Gas pre/post flow	X	X
Digital V/A meters	X	X
Gas purge/wire inching	X	X
Memory 3 set	X	X
QSet™		X
Crater filling		X
Creep start		X
Pre-programmed synergic lines		X

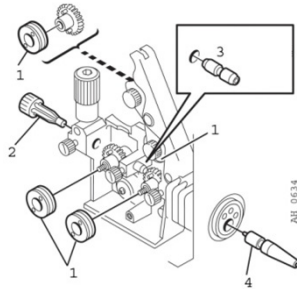
## Technical data

	<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

## 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					

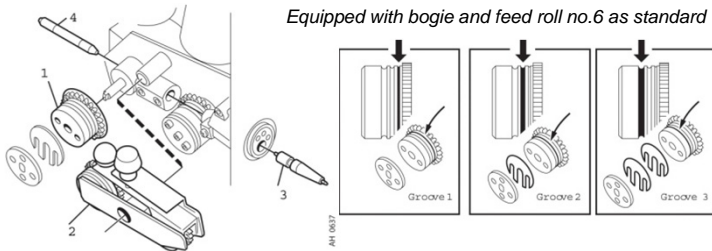
\* Equipped as standard for Feed 3004



## 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	332 322-002	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 10 pole

70 mm <sup>2</sup>	Air-cooled	Water-cooled
1.7 m 10 pole	0459 528 780	0459 528 790
5.0 m 10 pole	0459 528 781	0459 528 791
10.0 m 10 pole	0459 528 782	0459 528 792
15.0 m 10 pole	0459 528 783	0459 528 793
25.0 m 10 pole	0459 528 784	0459 528 794
35.0 m 10 pole	0459 528 785	0459 528 795
95 mm <sup>2</sup>	Air-cooled	Water-cooled
1.7 m 10 pole	0459 528 980	0459 528 990

## Ordering information

Origo™ Feed 3004 MA23 Encl	10 pole	0460 526 887
Origo™ Feed 3004w MA23 Encl	10 pole	0460 526 897
Origo™ Feed 4804w MA23 Encl	10 pole	0460 526 997
Origo™ Feed 3004 MA24 Encl	10 pole	0460 526 889
Origo™ Feed 3004w MA24 Encl	10 pole	0460 526 899
Origo™ Feed 4804w MA24 Encl	10 pole	0460 526 999

## 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
Spool cover	0458 674 880
Spool cover, steel	0459 431 880
Adapter for spool diameter 440 mm	0459 233 880 **
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 960 880
Remote adapter kit Miggy-/ Railtrac	0459 681 880
Remote adapter kit MXH™ PP and PSF RS3	0459 681 881
MXH™ 300/400w PP connection kit	0459 020 883

