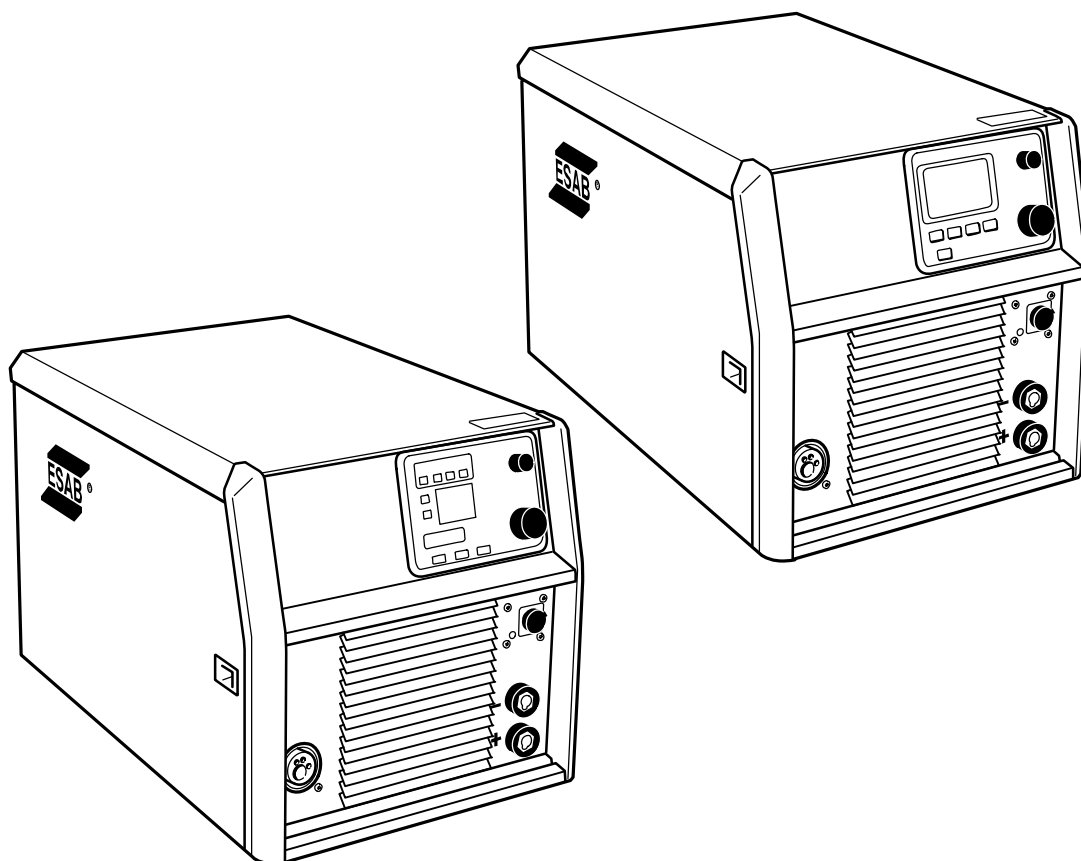


Aristo[®] / Origo[™]

Mig C3000i



Instruction manual



DECLARATION OF CONFORMITY

According to

The Low Voltage Directive 2006/95/EC, entering into force 16 January 2007

The EMC Directive 2004/108/EC, entering into force 20 July 2007

Type of equipment

Arc welding power source and wire feed unit

Type designation

Mig C3000i, U6, MA24, from serial number 802 xxx xxxx (2008 w.02)

Mig C3000i, is a member of the ESAB Aristo[®] and Origo[™] product families

Brand name or trade mark

ESAB

Manufacturer or his authorized representative established within the EEA:

Name, address, phone, website:

ESAB AB

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Box 8004, 402 77 GÖTEBORG, Sweden

Phone: +46 31 509 000

Website: www.esab.com

The following harmonized standards, in force within the EEA, has been used in the design:

EN 60974-1, Arc welding equipment – Part 1: Welding power sources

EN 60974-5, Arc welding equipment – Part 5: Wire feeders

EN 60974-10, Arc welding equipment – Part 10: Electromagnetic compatibility (EMC) requirements

Additional information:

Restrictive use, Class A equipment, intended for use in locations other than residential.

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorized representative established within EEA, that the equipment in question complies with the safety requirements stated above.

Date
2012-09-27

Signature

Jerker Funnemark
Clarification

Position
Managing Director
Equipment & Automation

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1 SAFETY

Users of ESAB equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the equipment must be familiar with:
 - its operation
 - location of emergency stops
 - its function
 - relevant safety precautions
 - welding and cutting
2. The operator must ensure that:
 - no unauthorised person is stationed within the working area of the equipment when it is started up.
 - no-one is unprotected when the arc is struck
3. The workplace must:
 - be suitable for the purpose
 - be free from drafts
4. Personal safety equipment
 - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
 - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. General precautions
 - Make sure the return cable is connected securely.
 - Work on high voltage equipment **may only be carried out by a qualified electrician.**
 - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
 - Lubrication and maintenance must **not** be carried out on the equipment during operation.



WARNING



Arc welding and cutting can be injurious to yourself and others. Take precautions when welding and cutting. Ask for your employer's safety practices which should be based on manufacturers' hazard data.

ELECTRIC SHOCK - Can kill

- Install and earth the unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

FUMES AND GASES - Can be dangerous to health

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.

ARC RAYS - Can injure eyes and burn skin.

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

FIRE HAZARD

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

NOISE - Excessive noise can damage hearing

- Protect your ears. Use earmuffs or other hearing protection.
- Warn bystanders of the risk.

MALFUNCTION - Call for expert assistance in the event of malfunction.

Read and understand the instruction manual before installing or operating.

PROTECT YOURSELF AND OTHERS!



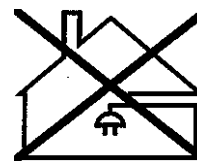
WARNING

Do not use the power source for thawing frozen pipes.



CAUTION

Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility of class A equipment in those locations, due to conducted as well as radiated disturbances.



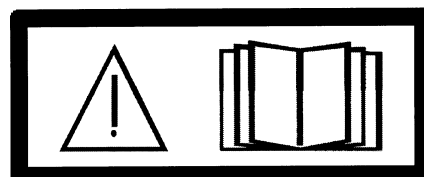
CAUTION

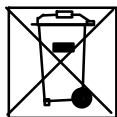
This product is solely intended for arc welding.



CAUTION

Read and understand the instruction manual before installing or operating.





Dispose of electronic equipment at the recycling facility!

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

As the person responsible for the equipment, it is your responsibility to obtain information on approved collection stations.

For further information contact the nearest ESAB dealer.

ESAB can provide you with all necessary welding protection and accessories.

2 INTRODUCTION

Mig C3000i is a welding power source intended for MIG/MAG welding with solid wire made of steel, stainless steel, aluminium as well as cored wire with or without shielding gas. It is also possible to weld with coated electrodes (MMA welding).

The power sources comes in different variants, see page 18

ESAB's accessories for the product can be found on page 22.

2.1 Equipment

The welding power source is supplied with:

- Instruction manual for the welding power source
- Instruction manual in english for the control panel
- Decal with recommended wear parts
- 5 metre return cable

2.2 Control panel

The welding power source is supplied with one of the following control panels:



With knobs for setting the voltage and wire feed speed / current. Other settings by pushbuttons, with text indication on the display panel.



With knobs for setting the voltage / QSet™ and wire feed speed / current. Other settings by pushbuttons.

Detailed descriptions of the control panels can be found in separate Instruction manual.

Instruction manuals in other languages can be downloaded from the website, www.esab.com.

3 TECHNICAL DATA

Mig C3000i	
Mains voltage	400 V, $\pm 10\%$, 3~ 50/60 Hz
Mains supply	$S_{sc \text{ min}}$ 1,4 MVA
Primary current	
I_{max} MIG/MAG	16 A
I_{max} MMA	19 A
No-load power demand when in the energy-saving mode, 6.5 min. after welding	30 W
Setting range	
MIG/MAG	8-48 V / 16-300 A
MMA	16 - 300 A
Permissible load at MIG/MAG	
35% duty cycle	300 A / 29 V
60% duty cycle	240 A / 26 V
100% duty cycle	200 A / 24 V
Permissible load at MMA	
30% duty cycle	300 A / 32 V
60% duty cycle	230 A / 29.2 V
100% duty cycle	190 A / 27.6 V
Power factor at maximum current	
MIG/MAG	0.90
MMA	0.90
Efficiency at maximum current	
MIG/MAG	85 %
MMA	84 %
Open-circuit voltage $U_0 \text{ max}$	
MIG/MAG without VRD function ¹⁾	70 - 80 V
MMA without VRD function ¹⁾	57 - 67 V
VRD function deactivated ²⁾	60 V
VRD function activated ²⁾	<35 V
Operating temperature	-10 to +40° C
Constant A-weighted sound pressure	< 70 dB
Dimensions l x w x h	652 x 412 x 423 mm
Weight	40.5 kg
Insulation class transformer	H
Enclosure class	IP 23C
Application class	S
Gun connection	EURO
Wire feed speed	0.8 - 25.0 m/min
Max. diameter wire bobbin	300 mm
Wire dimension	
Fe	0.6 - 1.2 mm
Ss	0.6 - 1.2 mm
Al	1.0 - 1.2 mm
Cored wire	0.8 - 1.2 mm

Mig C3000i	
Shielding gas max pressure	All types intended for MIG/MAG welding 5 bar
Motor current I_{max}	3.5 A

- 1) Valid for power sources without VRD specification on the rating plate.
- 2) Valid for power sources with VRD specification on the rating plate. The VRD function is explained in the instructions for the control panel, if the panel has that function.

Mains supply, $S_{sc\ min}$

Minimum short circuit power on the network in accordance with IEC 61000-3-12

Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld or cut at a certain load without overloading. The duty cycle is valid for 40°C.

Enclosure class

The IP code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP23** is designed for indoor and outdoor use.

Application class

The symbol **S** indicates that the power source is designed for use in areas with increased electrical hazard.

4 INSTALLATION

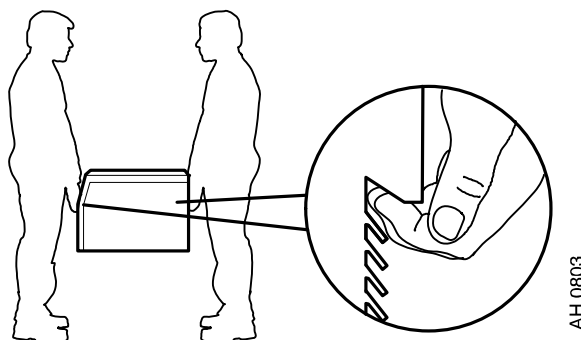
The installation must be carried out by a professional.

Note

Mains supply requirements

High power equipment may, due to the primary current drawn from the mains supply, influence the power quality of the grid. Therefore connection restrictions or requirements regarding the maximum permissible mains impedance or the required minimum supply capacity at the interface point to the public grid may apply for some types of equipment (see technical data). In this case it is the responsibility of the installer or user of the equipment to ensure, by consultation with the distribution network operator if necessary, that the equipment may be connected.

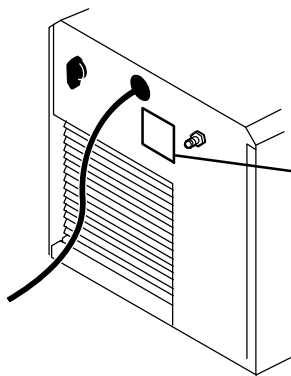
4.1 Lifting instruction



4.2 Location

Position the welding power source such that its cooling air inlets and outlets are not obstructed.

4.3 Mains power supply



Check that the welding power source is connected to the correct mains power supply voltage, and that it is protected by the correct fuse size. A protective earth connection must be made in accordance with regulations.

Rating plate with supply connection data

Recommended fuse sizes and minimum cable area

Mig C3000i	MIG/MAG	MMA
Mains voltage	400 V 3~ 50 Hz	400 V 3~ 50 Hz
Mains cable area mm²	4G4	4G4
Phase current, I_{eff}	10 A	10 A
Fuse		
Anti-surge	16 A	16 A
Type C MCB	16 A	16 A

Note! The mains cable areas and fuse sizes as shown above are in accordance with Swedish regulations. Use the welding power source in accordance with the relevant national regulations.

Note! This welding power source is designed for connection to a four wire 230/400 volt system.

If the power source is to be used in a country with a higher mains voltage, the power source shall be connected via a safety transformer.

5 OPERATION

General safety regulations for handling the equipment can be found on page 4. Read through before you start using the equipment!

NOTE: When moving the equipment use intended handle. Never pull on the gun.



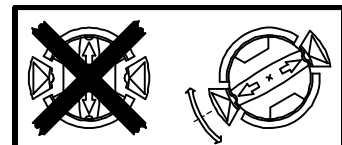
WARNING

Assure that the side panels are closed during operation.



WARNING

To prevent the reel from sliding off the hub: Lock the reel in place by turning the red knob as shown on the warning label attached next to the hub.



WARNING

Rotating parts can cause injury, take great care.

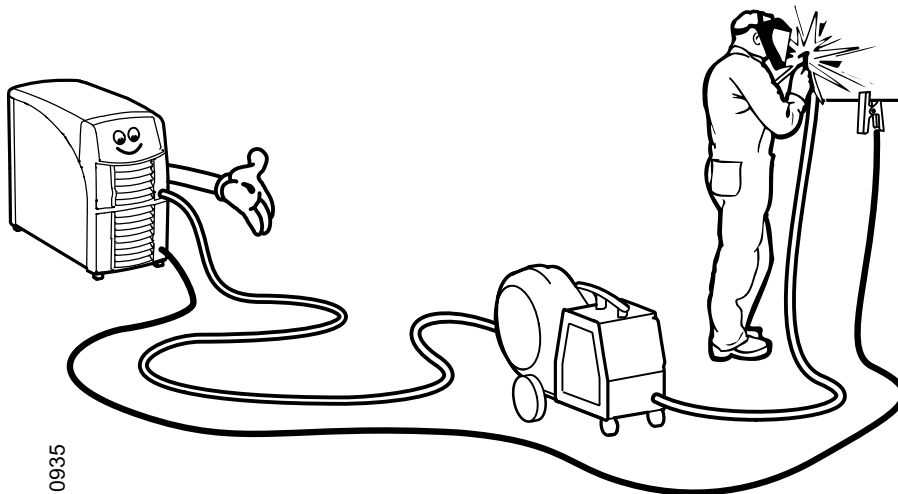
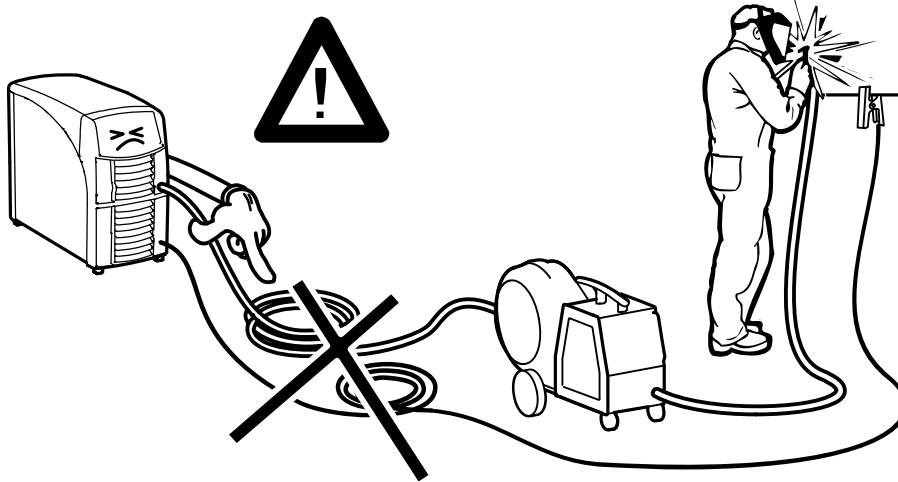




WARNING

Risk of crushing when replacing the wire bobbin!

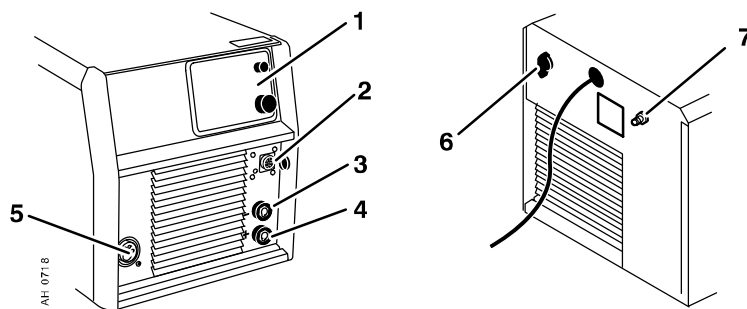
Do not use safety gloves when inserting the welding wire between the feed rollers.



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5.1 Connections and control devices

- | | | | |
|---|-----------------------------------------------------------|---|------------------------------|
| 1 | Control panel,
see separate instruction manual | 5 | Connection for welding gun |
| 2 | CAN connection for cooling unit or remote
control unit | 6 | Mains voltage switch |
| 3 | Connection for return cable (-) | 7 | Connection for shielding gas |
| 4 | Connection for welding current cable (+)
(MMA welding) | | |



5.2 Fan control

The power source has a time control that means that the fans continue to run for 6.5 minutes after welding has stopped, and the unit switches to energy-saving mode. The fans start again when welding restarts.

The fans run at reduced speed for welding currents up to 110 A, and at full speed for higher currents.

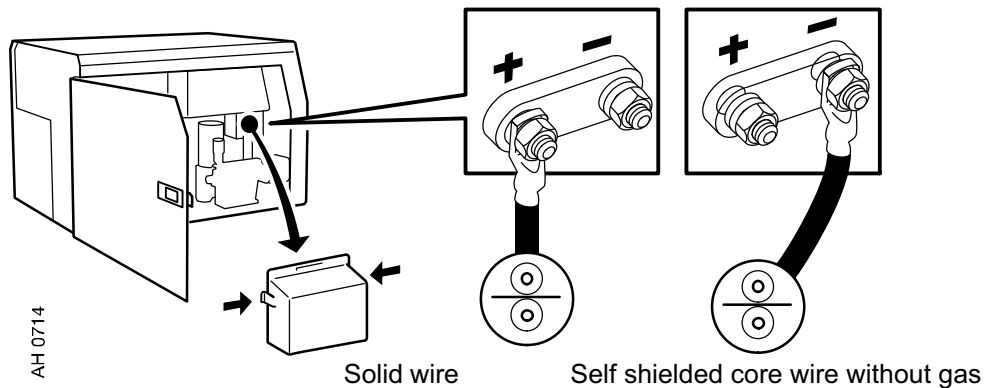
5.3 Overheating protection

The welding power source has overheating protection which operate if the temperature becomes too high, When this occurs the welding current is interrupted and a fault code is displayed on the control panel.

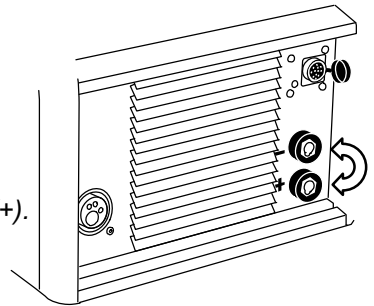
The overheating protection resets automatically when the temperature has fallen.

5.4 Welding without gas

It is possible to switch between welding with a solid wire and shielding gas, or welding with self shielded cored wire without gas.

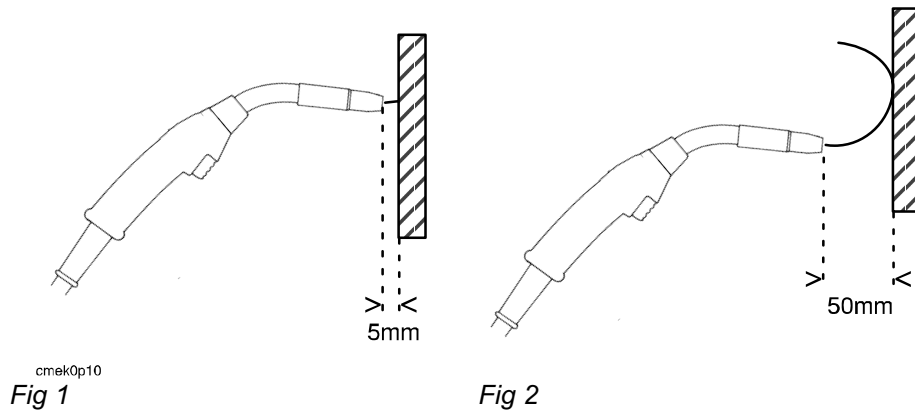


- Disconnect the welding power source from the mains current supply.
- Open the side panel. Remove the protective cover.
- Recheck the positive connection (+) and negative connection (-) on the terminal block above the feed mechanism.
- Reinstall the protective cover. Close the side panel.
- Move the return cable from the negative outlet (-) to the positive outlet (+).



5.5 Wire feed pressure

Start by making sure that the wire moves smoothly through the wire guide. Then set the pressure of the wire feeder's pressure rollers. It is important that the pressure is not too great.



To check that the feed pressure is set correctly, you can feed out the wire against an insulated object, e.g. a piece of wood.

When you hold the gun approx. 5 mm from the piece of wood (fig. 1) the feed rollers should slip.

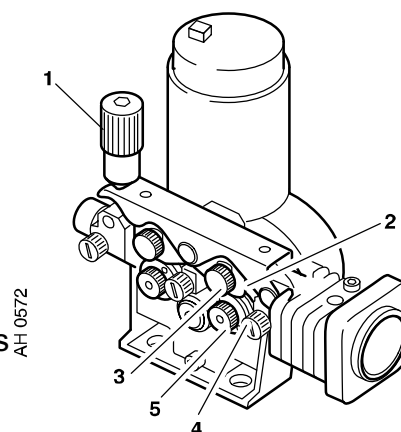
If you hold the gun approx. 50 mm from the piece of wood, the wire should be fed out and bend (fig. 2).

5.6 Replacing and inserting wire

- Open the side panel.
- Disconnect the pressure sensor by folding it backwards, the pressure rollers slide up.
- Straighten out the new wire 10-20 cm. File away burrs and sharp edges from the end of the wire before inserting it into the wire feed unit.
- Make sure that the wire goes properly into the feed roller's track and into the outlet nozzle and the wire guide.
- Secure the pressure sensor.
- Close the side panel.

5.7 Changing feed rollers

- Open the side panel.
- Disconnect the pressure sensor (1) by folding it backwards, the pressure rollers slide up.
- Disconnect the pressure rollers (2) by turning the axle (3) 1/4 turn clockwise and pulling out the axle. The pressure rollers disconnect.
- Disconnect the feed rollers (4) by unscrewing the nuts (5) and pulling out the rollers.



During installation, repeat the above in the reverse order.

Choice of tracks in the feed rollers

Turn the feed roller with the dimensioning mark for the required track towards you.

6 MAINTENANCE

Regular maintenance is important for safe, reliable operation.



CAUTION

All guarantee undertakings from the supplier cease to apply if the customer attempts any work to rectify any faults in the product during the guarantee period.

Only those persons who have appropriate electrical knowledge (authorized personnel) may remove the safety plates.

6.1 Inspection and cleaning

Power source

Check regularly that the welding power source is not clogged with dirt.

How often and which cleaning methods apply depend on: the welding process, arc times, placement, and the surrounding environment. It is normally sufficient to blow the dust out of the power source with dry compressed air (reduced pressure) once a year.

Clogged or blocked air inlets and outlets otherwise result in overheating.

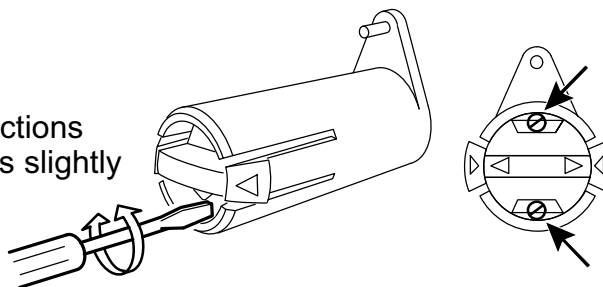
Wire feed unit

Check regularly that the wire feed unit is not clogged with dirt.

- Cleaning and replacement of the wire feed unit mechanism's worn parts should take place at regular intervals in order to achieve trouble-free wire feed. Note that if pre-tensioning is set too hard, this can result in abnormal wear on the pressure roller, feed roller and wire guide.

The brake hub

The hub is adjusted when delivered, if readjustment is required, follow the instructions below. Adjust the brake hub so that wire is slightly slack when wire feed stops.



- **Adjusting the braking torque:**

- Turn the red handle to the locked position.
- Insert a screwdriver into the springs in the hub.

Turn the springs clockwise to reduce the braking torque

Turn the springs counter-clockwise to increase the braking torque. **NB:** Turn both springs the same amount.

Welding gun

- The welding gun's wear parts should be cleaned and replaced at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean regularly and clean the contact tip.

7 FAULT-TRACING

Try these recommended checks and inspections before sending for an authorised service technician.

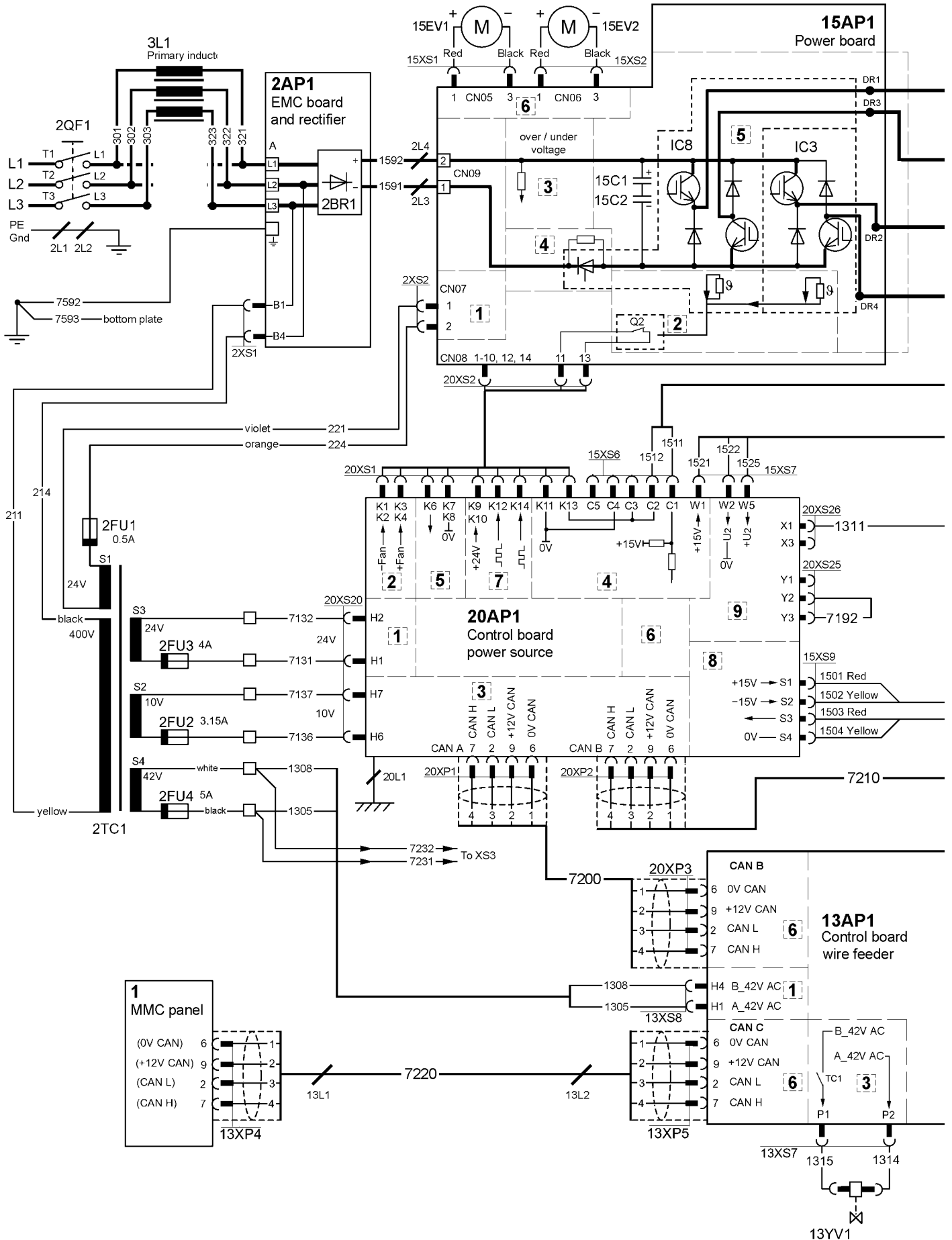
Type of fault	Action
No arc.	<ul style="list-style-type: none"> • Check that the mains power supply switch is turned on. • Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set.
The welding current is interrupted during welding.	<ul style="list-style-type: none"> • Check whether the overheating protection has operated (fault code E6 is displayed on the control panel). • Check the mains power supply fuses.
The overheating protection trips frequently.	<ul style="list-style-type: none"> • Make sure that you are not exceeding the rated data for the welding power source (i.e. that the unit is not being overloaded).
Poor welding performance.	<ul style="list-style-type: none"> • Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check that the correct wire is being used. • Check the mains power supply fuses.

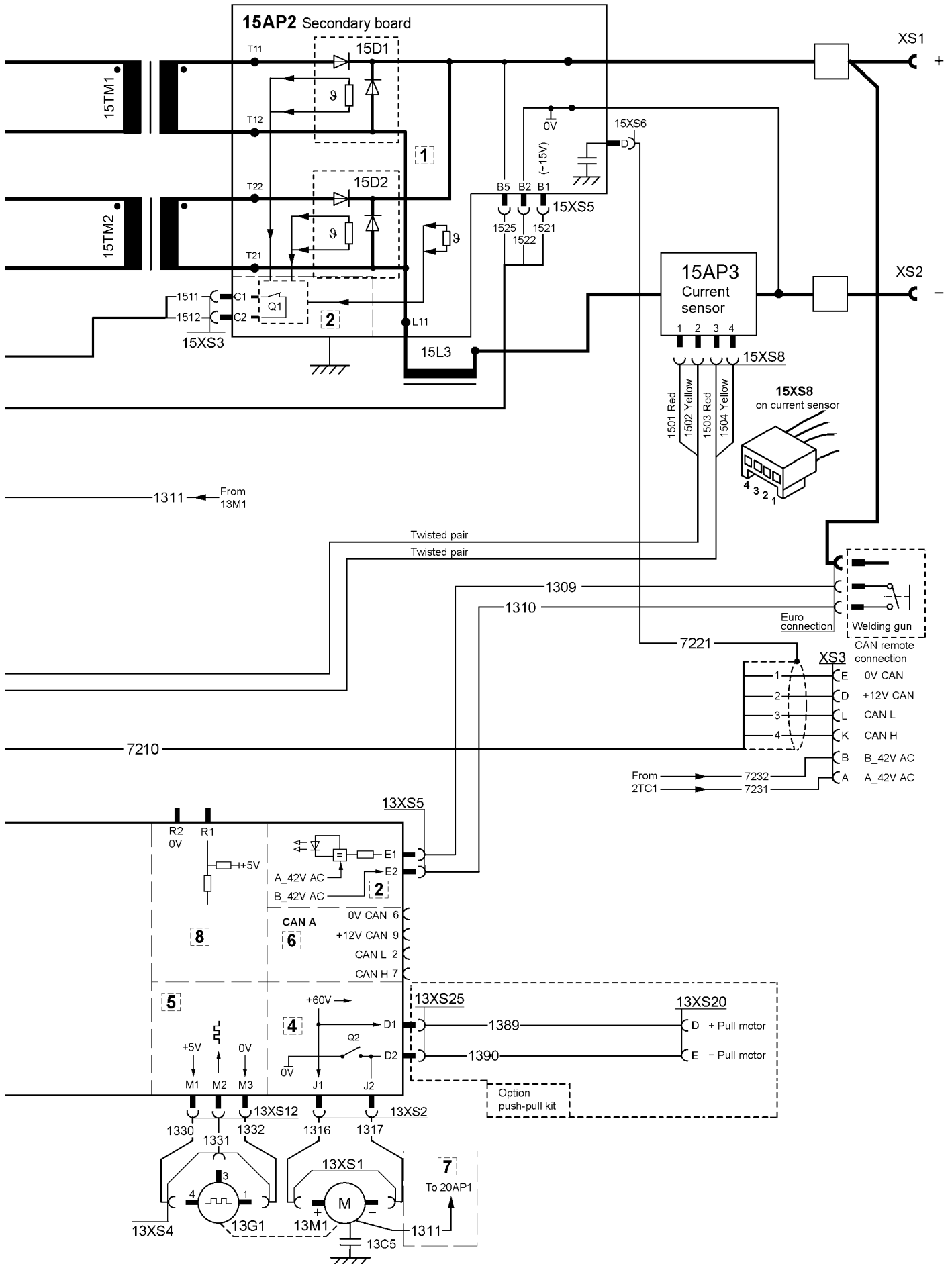
8 ORDERING SPARE PARTS

Mig C3000i is designed and tested in accordance with the international and European standards 60974-1, 60974-5 and 60974-10 . It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts may be ordered through your nearest ESAB dealer, see the last page of this publication.

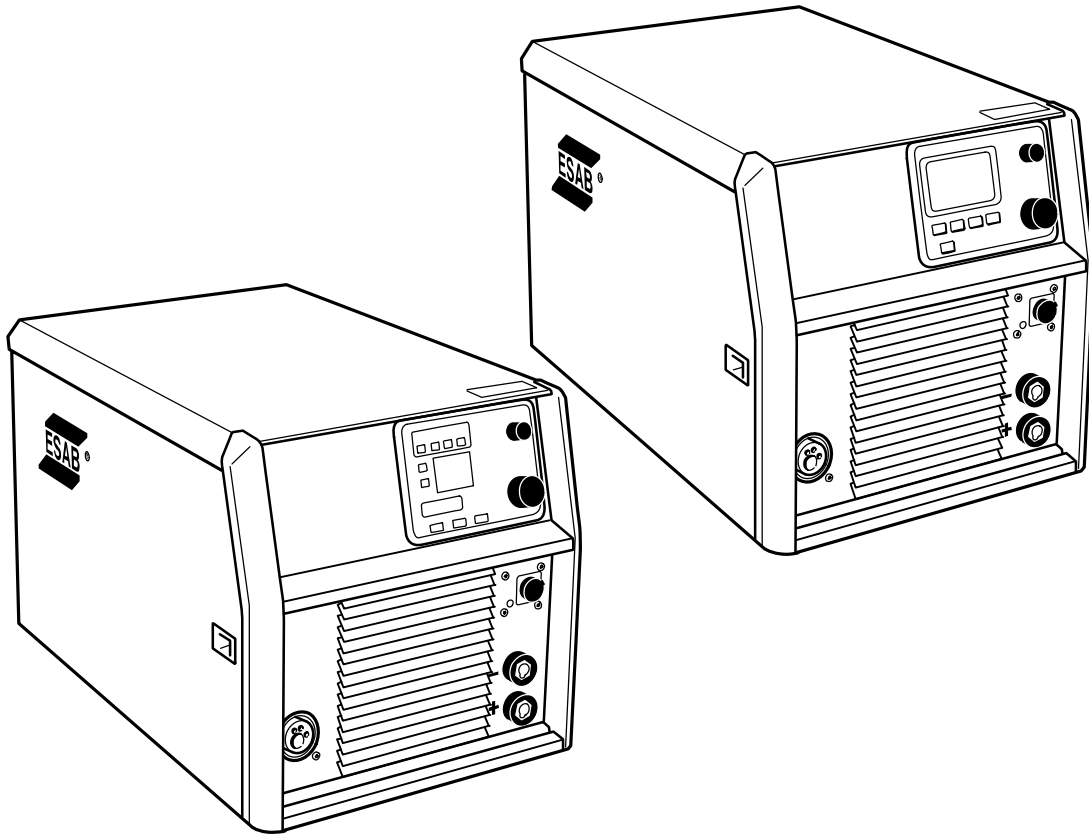
Diagram





Mig C3000i

Order number



Ordering no.	Denomination	Type
0459 750 881	Welding power source	Origo™ Mig C3000i, MA24 with gun PSF 305
0459 750 882	Welding power source	Aristo® Mig C3000i, U6
0459 839 002	Spare parts list	Mig C3000i
0460 454 xxx	Instruction manual	Control panel Origo™ MA23 and Origo™ MA24
0459 839 024	Spare parts list	Control panel Origo™ MA23 and Origo™ MA24
0459 287 xxx	Instruction manual	Control panel Aristo® U6
0458 818 990	Spare parts list	Control panel Aristo® U6
0458 870 201	Instruction manual	Welding gun PSF 305, 4,5 m

Instruction manuals and the spare parts list are available on the Internet at www.esab.com

Mig C3000i

Wear parts

S= Standard, HD = Heavy Duty

Item	Ordering no.	Denomination	Wire type	Wire dimensions
HI 1	0455 072 002 0456 615 001	Intermediate nozzle (S) Intermediatenozzle	Fe, Ss & cored Al	Ø 2.0 mm steel for 0.6-1.2 mm Ø 2.0 mm plastic for 0.8-1.2 mm
HI 2	0469 837 880 0469 837 881	Outlet nozzle (S) Outlet nozzle	Fe, Ss & cored Al	
HI 3	0191 496 114	Key		
HI 4	0215 701 007	Locking washer		
HI 5a	0459 440 001	Motor gear euro		

Item	Ordering no.	Denomination	Wire type	Wire dimensions	Groove typ	Roller markings
HI 5b	0459 052 001	Feed/pressure rollers	Fe, Ss & cored	Ø 0.6 & 0.8 mm	V	0.6 S2 & 0.8 S2
	0459 052 002	Feed/pressure rollers	Fe, Ss & cored	Ø 0.8 & 0.9/1.0 mm	V	0.8 S2 & 0.9/1.0 S2
	0459 052 003	Feed/pressure rollers	Fe, Ss & cored	Ø 0.9/1.0 & 1.2 mm	V	0.9/1.0 S2 & 1.2 S2
	0458 825 001	Feed/pressure rollers	Cored	Ø 0.9/1.0 & 1.2 mm	V-Knurled	1.0 R2 & 1.2 R2
	0458 824 001	Feed/pressure rollers	Al	Ø 0.8 & 0.9/1.0 mm	U	0.8 A2 & 1.0 A2
	0458 824 002	Feed/pressure rollers	Al	Ø 1.0 & 1.2 mm	U	1.0 A2 & 1.2 A2
	0458 824 003	Feed/pressure rollers	Al	Ø 1.2 mm	U	1.2 A2

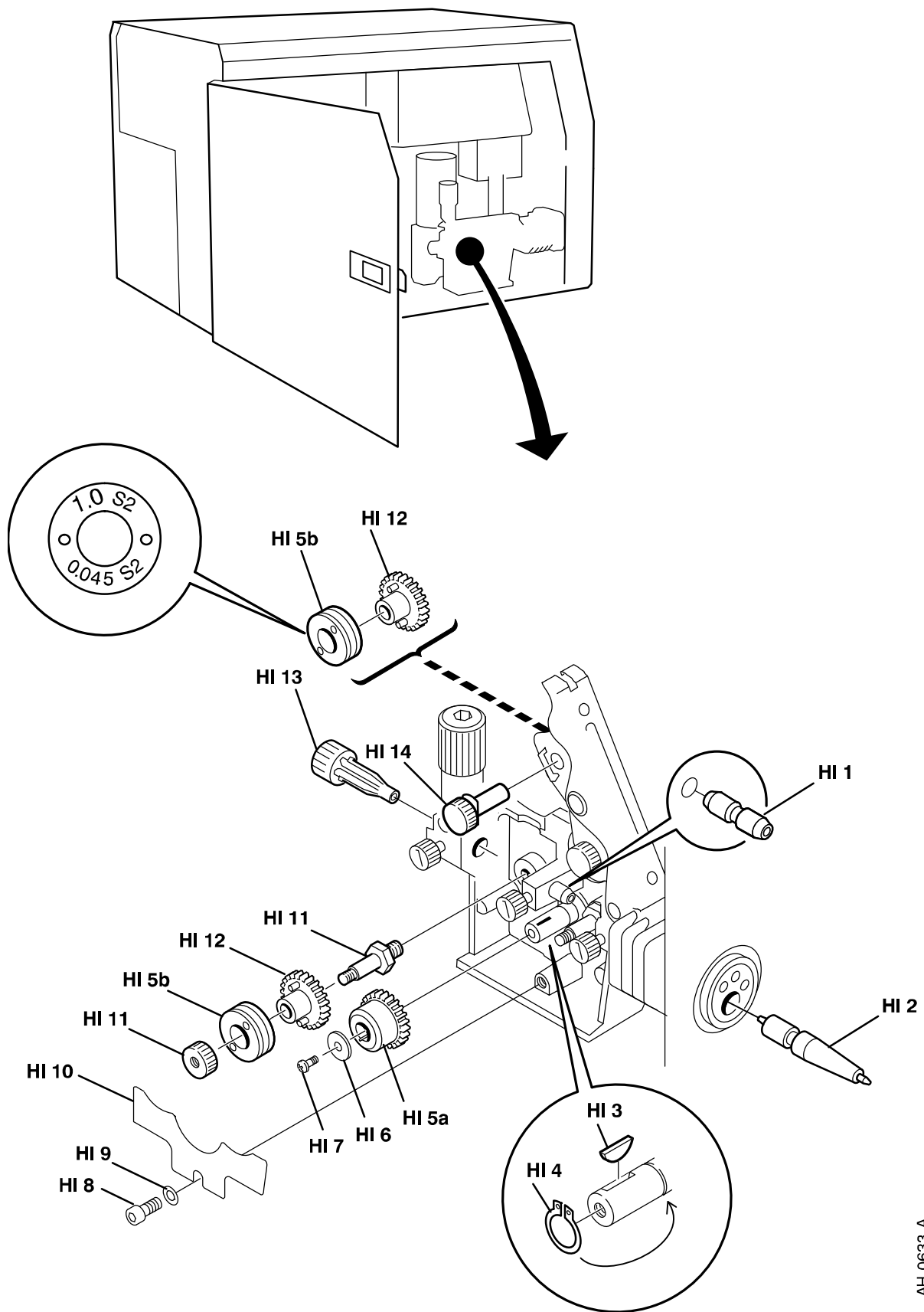
Use only pressure and feed rollers marked **A2**, **R2** or **S2**.
The rollers are marked with wire dimension in mm, some are also marked with inch.

Item	Ordering no.	Denomination	Notes
HI 6		Washer	Ø 16/5x1
HI 7		Screw	M4x12
HI 8		Screw	M6x12
HI 9		Washer	Ø 16/8.4x1.5
HI 10	0469 838 001	Cover	
HI 11	0458 722 880	Axle and Nut	
HI 12	0459 441 880	Gear adapter	
HI 13	0455 049 001	Inlet nozzle	
HI 14	0458 999 001	Shaft	

Welding with aluminium wire

In order to weld with aluminium wire, proper rollers, nozzles and liners for aluminium wire **MUST** be used, It is recommended to use 3 m long welding gun for aluminium wire, equipped with appropriate wear parts.

Mig C3000i

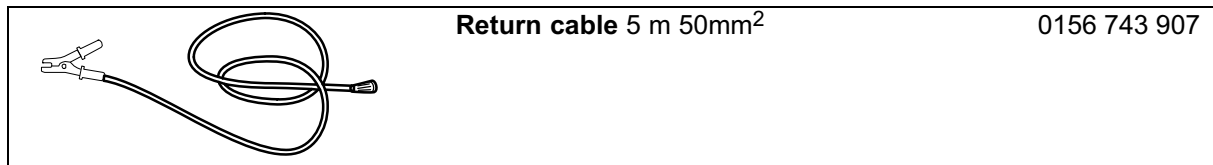


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Accessories

	<p>Cooling unit CoolMidi 1800i 0459 840 880</p>										
	<p>Remote control adapter RA12 12 pole 0459 491 910 For analogue remote controls to CAN based equipment.</p>										
	<p>Remote control unit MTA1 CAN 0459 491 880 MIG/MAG: wire feed speed and voltage MMA: current and arc force TIG: current, pulse and background current</p>										
	<p>Remote control unit M1 10Prog CAN 0459 491 882 Choice of on of 10 programs MIG/MAG: voltage deviation TIG and MMA: current deviation</p>										
	<p>Remote control unit AT1 CAN 0459 491 883 MMA and TIG: current</p>										
	<p>Remote control unit AT1 CF CAN 0459 491 884 MMA and TIG: rough and fine setting of current.</p>										
	<p>Remote control cable 12 pole - 4 pole</p> <table border="0"> <tr> <td>5 m</td> <td>0459 554 880</td> </tr> <tr> <td>10 m</td> <td>0459 554 881</td> </tr> <tr> <td>15 m</td> <td>0459 554 882</td> </tr> <tr> <td>25 m</td> <td>0459 554 883</td> </tr> <tr> <td>0.25 m</td> <td>0459 554 884</td> </tr> </table>	5 m	0459 554 880	10 m	0459 554 881	15 m	0459 554 882	25 m	0459 554 883	0.25 m	0459 554 884
5 m	0459 554 880										
10 m	0459 554 881										
15 m	0459 554 882										
25 m	0459 554 883										
0.25 m	0459 554 884										

Mig C3000i



Welding torch

Type	Ordering no.		Max welding current		Wire dimensions
	Hose length		Shielding gas		
	3 m	4.5 m	CO ₂	Mix Ar	
PSF 250	0368 100 882	0368 100 883	250A 60%	225A 60%	0.6 - 1.0
PSF 250 C	0468 410 882	0468 410 883	250A 60%	225A 60%	0.6 - 1.0
PSF 305	0458 401 880	0458 401 881	315A 60%	285A 60%	0.8 - 1.2
PSF 315 CLD	0468 410 885	0468 410 886	315A 60%	285A 60%	0.8 - 1.2
PSF 405	0458 401 882	0458 401 883	380A 60%	325A 60%	0.8 - 1.6
PSF 405 C	0458 499 882	0458 499 883	380A 60%	325A 60%	1.0 - 1.6
PSF 405 RS3	0458 401 892	0458 401 893	380A 60%	325A 60%	0.8 - 1.6
PSF 405 C RS3	-	0458 499 889	380A 60%	325A 60%	1.0 - 1.6
PSF 410 CW	0458 450 880	0458 450 881	380A 100%	325A 100%	0.8 - 1.6
PSF 410 W	0458 400 882	0458 400 883	400A 100%	350A 100%	0.8 - 1.6
PSF 410 CW RS3	0458 450 884	0458 450 885	380A 100%	325A 100%	0.8 - 1.6
PSF 410 W RS3	0458 400 898	0458 400 899	400A 100%	350A 100%	0.8 - 1.6

- C** = Self cooled
- C** = Smoke exhausters, Centrovac
- LD** = Smaller, Light duty
- W** = Water cooled
- RS3** = 3-step program switch for selecting preset programs.

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