

PF 44 & 46

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Spare Parts

SP50274/50275 REV04
27/05

ASSEMBLY PAGE NAME			Machine Assembly	Machine Assembly	Machine Assembly	Divider Assembly	Wire Drive Assembly	User Interface Assembly	Miscellaneous Items
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	D	E	F	-
50274	K14108-1	PF 44	1	1	1	1	1	1	1
50275	K14109-1	PF 46	2	2	2	2	2	2	2

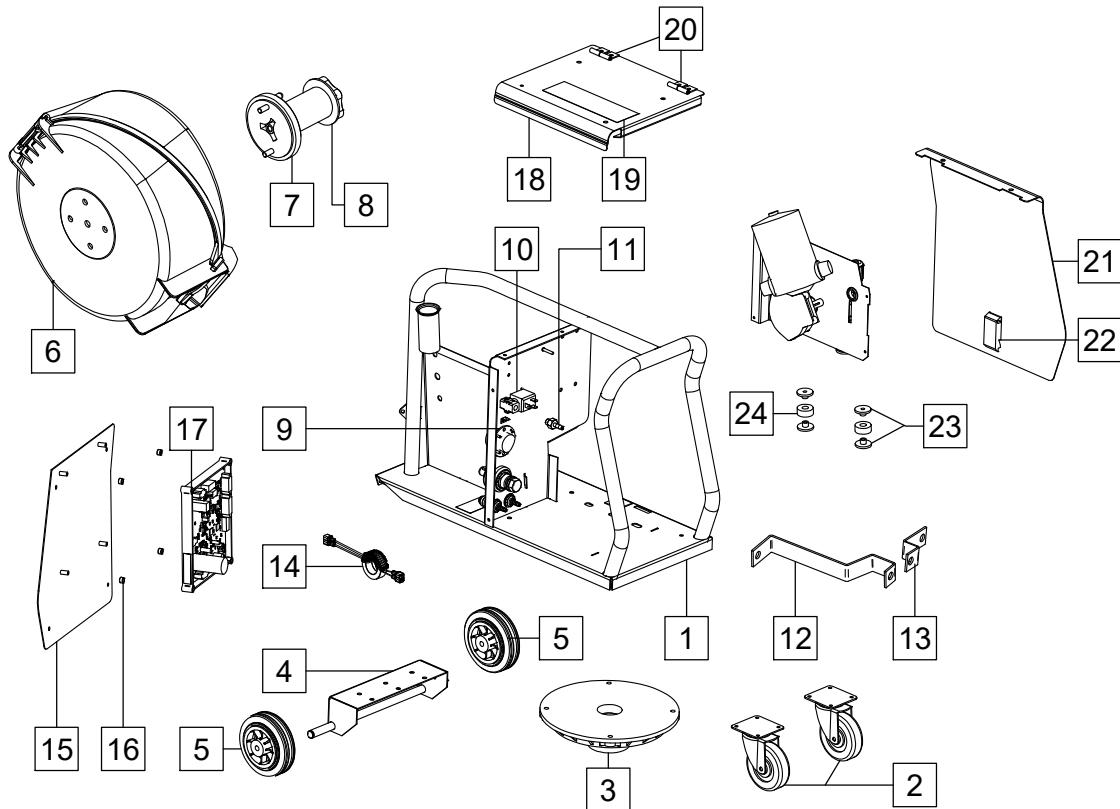


Figure A

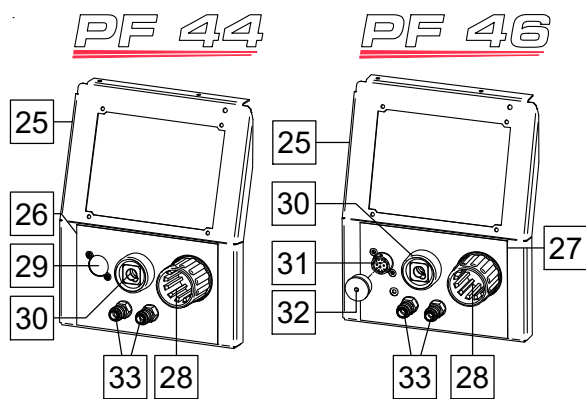


Figure B

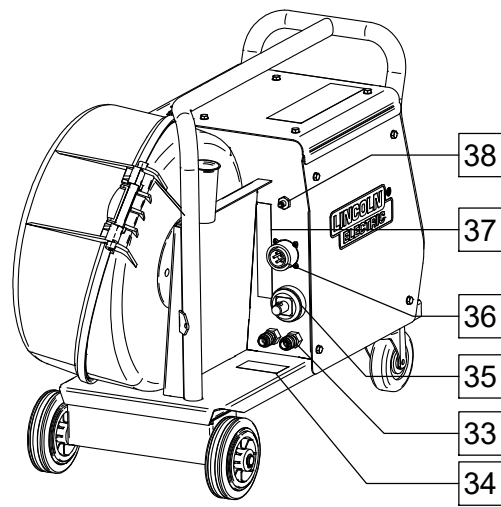
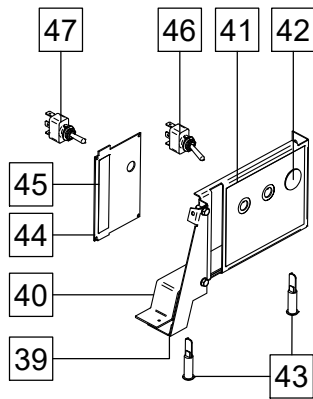


Figure C

Figure A, B, C: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
1	RACK	R-3019-315-1/08R	1	X	X					
2	FRONT WHEELS	1029-660-004R	2	X	X					
3	ROTARY BRACKET	1361-598-180R	1	X	X					
4	WHEELS BRACKET	R-1019-356-1/08R	1	X	X					
5	REAR WHEELS	1029-660-006R	2	X	X					
6	PLASTIC COVER	R-0010-178-1R	1	X	X					
7	REEL HUB STANDARD	0744-000-192R	1	X	X					
8	PLASIC NUT	B11035-1	1	X	X					
9	RING	R-2013-032-5R	1	X	X					
10	GAS SOLENOID	W8500004R	1	X	X					
11	COUPLER	R-2013-060-1R	1	X	X					
12	CONDUCTOR RAIL	R-1010-040-1R	1	X	X					
13	CONDUCTOR RAIL	R-1010-039-1R	1	X	X					
14	CHOKE	R-5041-228-1R	1	X	X					
15	LEFT SIDE PANEL	R-1019-227-1R	1	X	X					
16	SLEEVES	1131-155-001R	4	X	X					
17	MOTOR BOARD	R-6042-053-1R	1	X	X					
18	COVER	R-3019-162-1/02R	1	X	X					
19	STICKER	2719-107-728R	1	X	X					
20	HINGLES	D-3574-007-1/33R	2	X	X					
21	WIRE DRIVE DOOR	R-1019-224-1R	1	X	X					
22	LOCK	0654-610-004R	1	X	X					
23	SLEEVS	1361-599-720R	4	X	X					
24	SLEEVS	D-1869-033-3R	2	X	X					
25	FRONT PANEL	R-3019-275-8/08R	1	X	X					
26	STICKER (FRONT PANEL)	R-0010-477-2R	1	X	-					
27	STICKER (FRONT PANEL)	R-0010-468-1R	1	-	X					
28	EURO SLEEVE	1361-599-708R	1	X	X					
29	SHIELD	R-1019-361-1/08R	1	X	-					
30	SOCKET X3	C-2986-001-3R	1	X	X					
31	SOCKET X10	1158-641-149R	1	-	X					
32	SOCKET X10 CAP	1158-641-159R	1	-	X					
33	QUICK CONNECTOR FEMALE	0744-000-152R	4	X	X					
34	STICKER	R-0010-290-1R	1	X	X					
35	SOCKET X2	D-2985-002-1R	1	X	X					
36	SOCKET X1	1158-641-148R	1	X	X					
37	STICKER	R-0010-354-1R	1	X	X					
38	QUICK CONNECT COUPLING	0744-000-149R	1	X	X					

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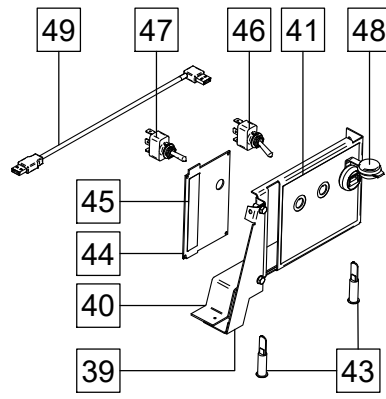


Figure D.

Figure D: Divider Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
39	DIVIDER	R-3019-287-5/08R	1	X	X					
40	SHIELD	R-0010-528-1R	1	X	X					
41	STICKER	R-0010-484-1R	1	X	X					
42	HOLE PLUG	0744-000-258R	1	X	-					
43	LED 1 , 2	0917-421-049R	2	X	X					
44	SHIELD	R-1019-329-1/08R	1	X	X					
45	STICKER	R-0010-502-1R	1	X	X					
46	SWITCH S2	1115-280-005R	1	X	X					
47	SWITCH S1	1115-280-004R	1	X	X					
48	USB SOCKET X11	1158-641-061R	1	-	X					
49	USB CABLE	R-0010-495-1R	1	-	X					

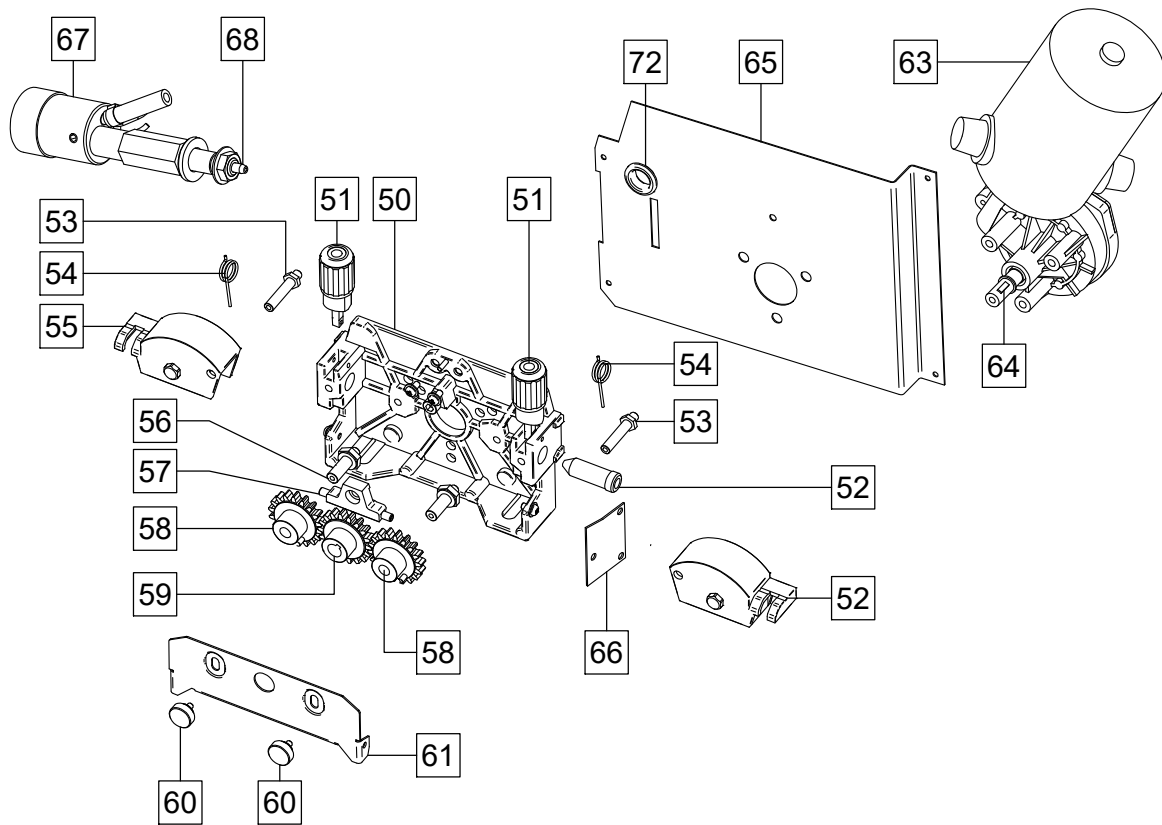


Figure E

Figure E: Wire Drive Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
	WIRE DRIVE ASSEMBLY	0744-000-241R	1	X	X					
50	FEED PLATE	0646-233-002R	1	X	X					
51	FIXING ARMS COMPL.	0646-233-015R	2	X	X					
52	INLET GUIDE	0646-233-025R	1	X	X					
53	AXIS PRESSURE ARMS	0646-233-003R	2	X	X					
54	SPRING PRESSURE ARMS	0646-233-013R	2	X	X					
55	PRESSURE ARM COMPL.L	0646-233-007R	1	X	X					
56	AXIS DRIVE ROLL	0646-233-020R	1	X	X					
57	INTERMEDIATE GUIDES	0646-233-023R	2	X	X					
58	GEAR WHEEL ROLLS	0646-231-090R	2	X	X					
59	GEAR WHEEL MOTOR	0646-233-028R	1	X	X					
60	FIXING CAPS	0744-000-190R	2	X	X					
61	METAL COVER	0646-233-027R	1	X	X					
62	PRESSURE ARM COMPL.R	0646-233-005R	1	X	X					
63	MOTOR	R-8040-024-4R	1	X	X					
64	WOODROF KEY	0646-231-102R	1	X	X					
65	DIVIDER	R-1019-207-1/08R	1	X	X					
66	WIRE DRIVE SHIELD	R-1019-385-1/08R	1	X	X					
67	EURO SOCKET X3	R-8040-140-7R	1	X	X					
68	OUTLET GUIDE	D-1829-066-3R	1	X	X					
69	RUBBER BUSH	1373-182-002R	1	X	X					

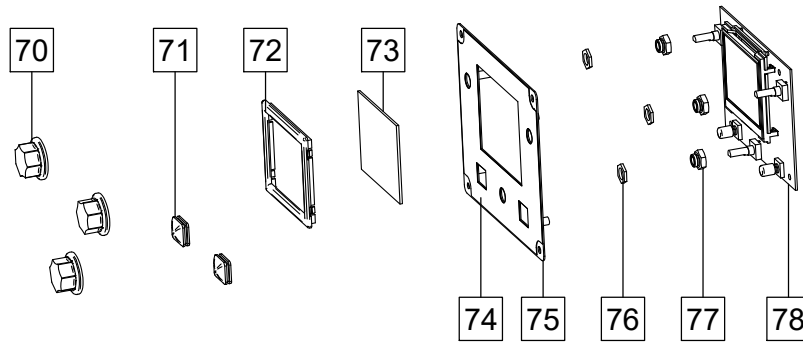


Figure F

Figure F: User Interface Assembly

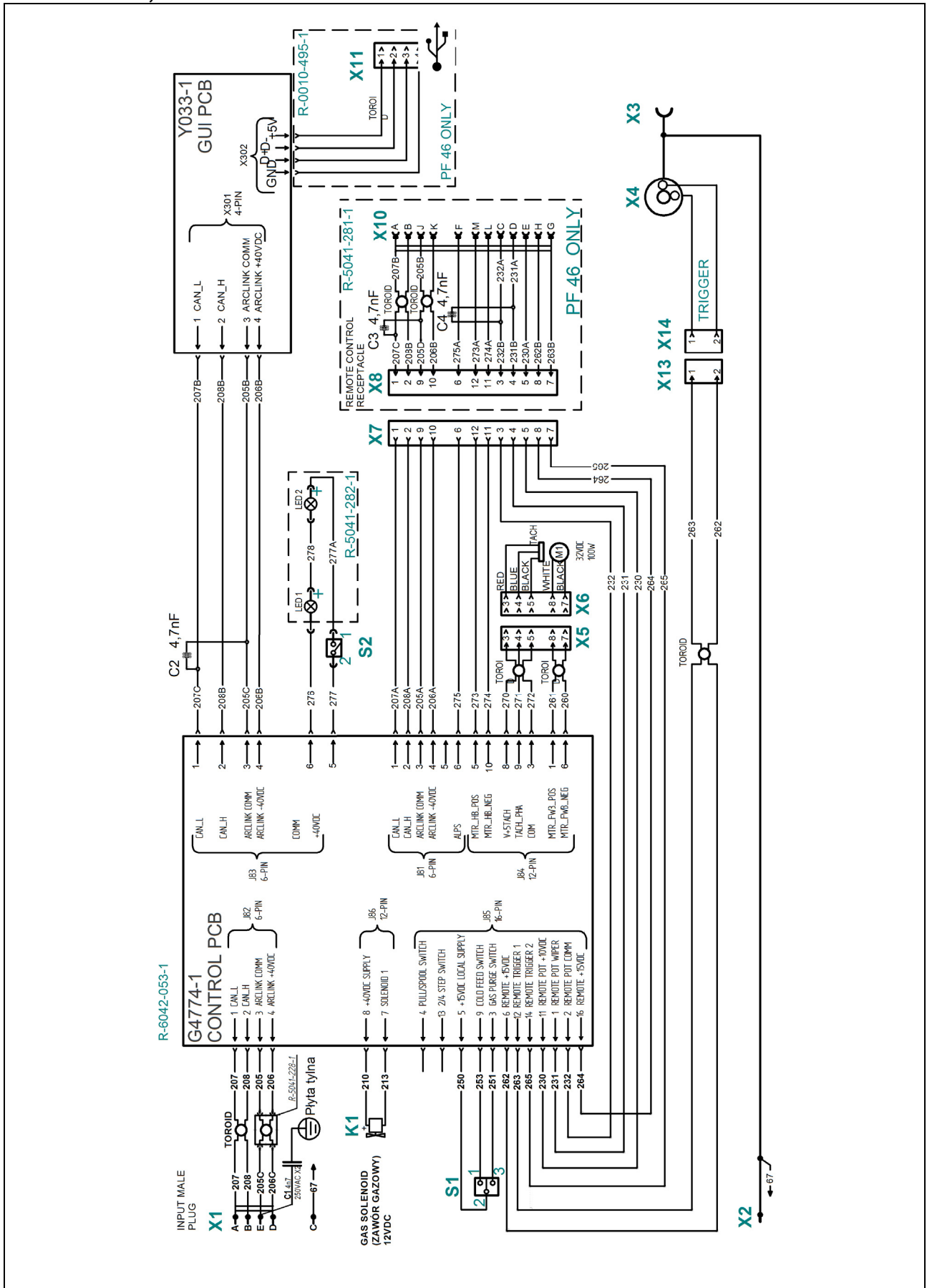
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
70	CONTROLS	9SS18425-1	3	X	X					
71	BUTTONS	1373-182-005R	2	X	X					
72	FRAME	R-0010-423-1R	1	X	X					
73	PROTECTIVE SCREEN	R-0010-450-1R	1	X	X					
74	STICKER	R-0010-469-1R	1	X	X					
75	PANEL	R-3019-274-1/08R	1	X	X					
76	NUT	R-2013-128-1R	3	X	X					
77	SLEEVE NUT	R-2013-124-1R	3	X	X					
78	USER INTERFACE (WITH DISPLAY)	R-6042-066-1R	1	X	-					
	USER INTERFACE (WITH DISPLAY)	R-6042-067-1R	1	-	X					
	DISPLAY	W4505306R	1	X	X					

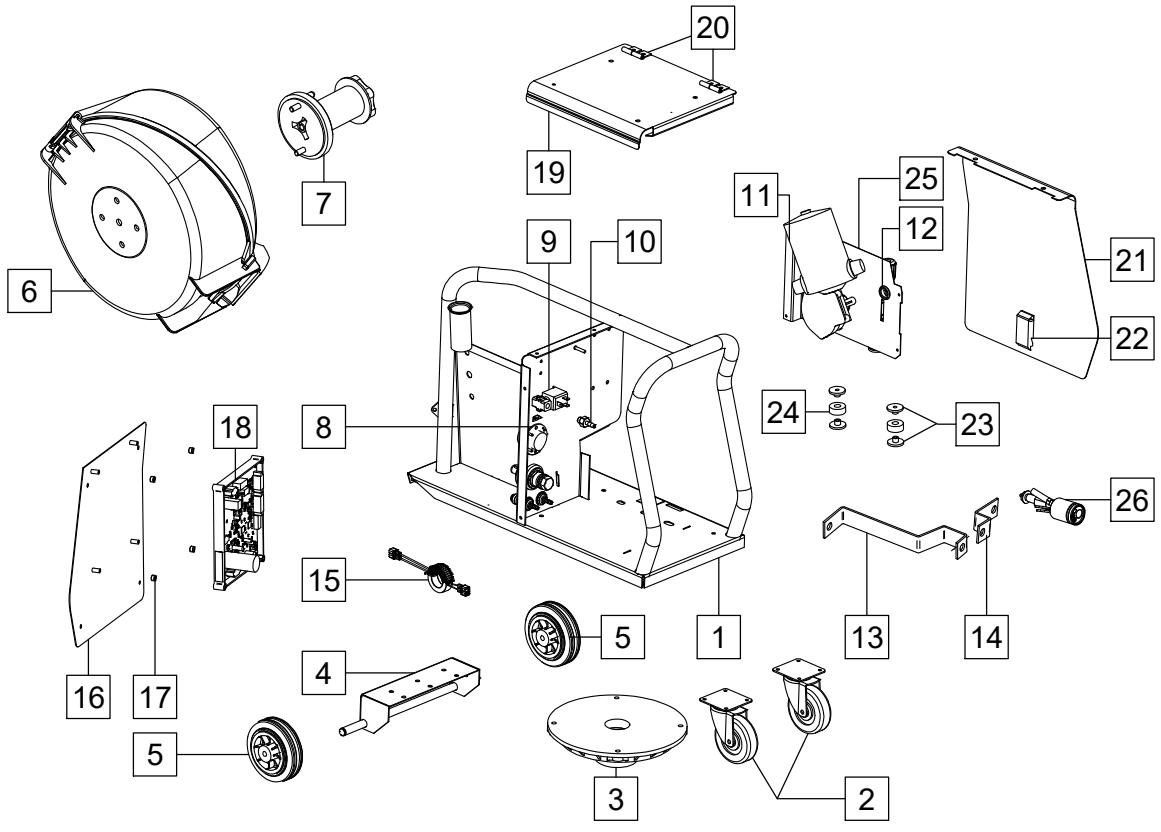
Miscellaneous Items (not shown in figure A, B, C, D, E, F)

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
79	WIRING HARNESS	R-5041-280-1R	1	X	X					
80	LED HARNESS	R-5041-282-1R	1	X	X					

Electrical Schematic

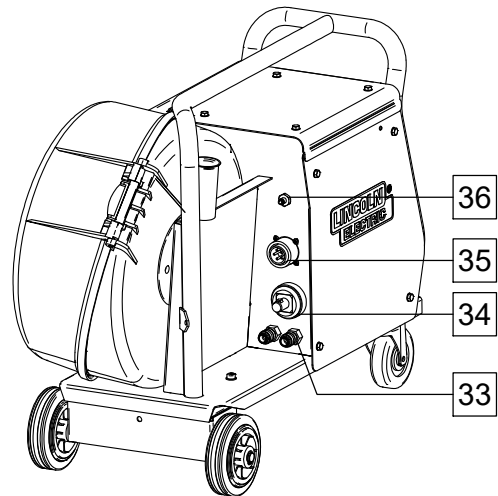
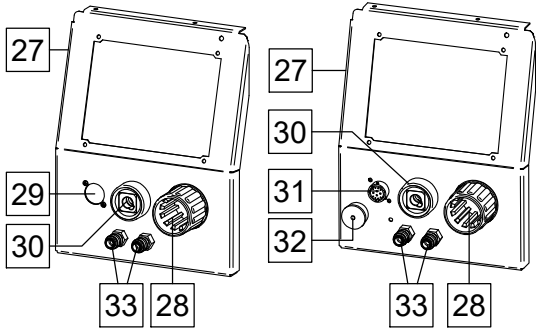
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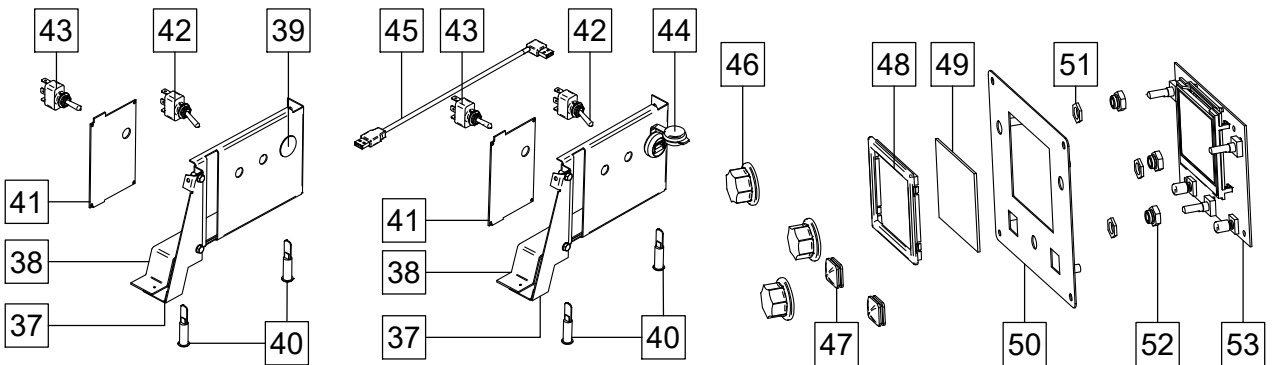
PF 44

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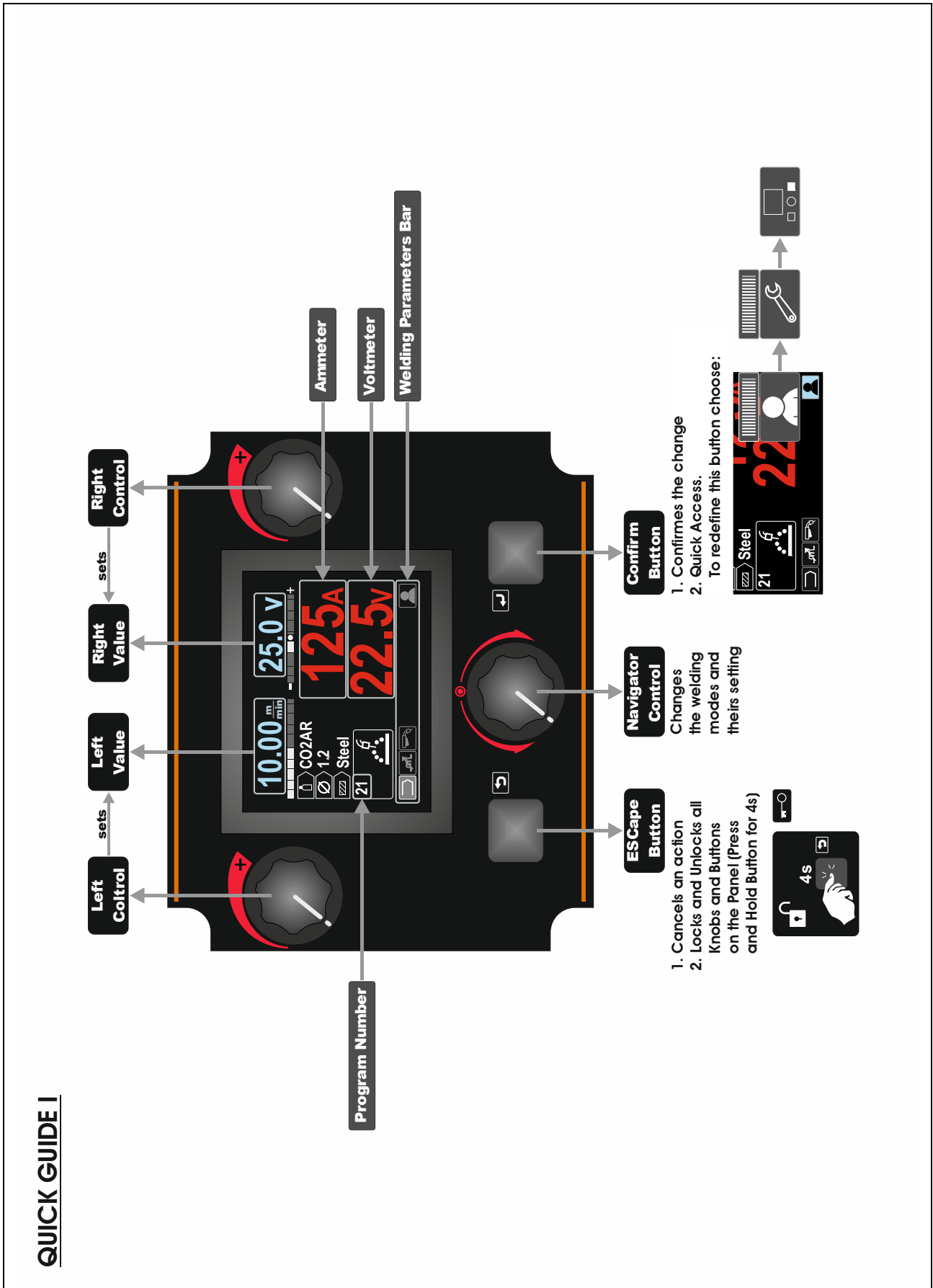
PF 44

PF 46



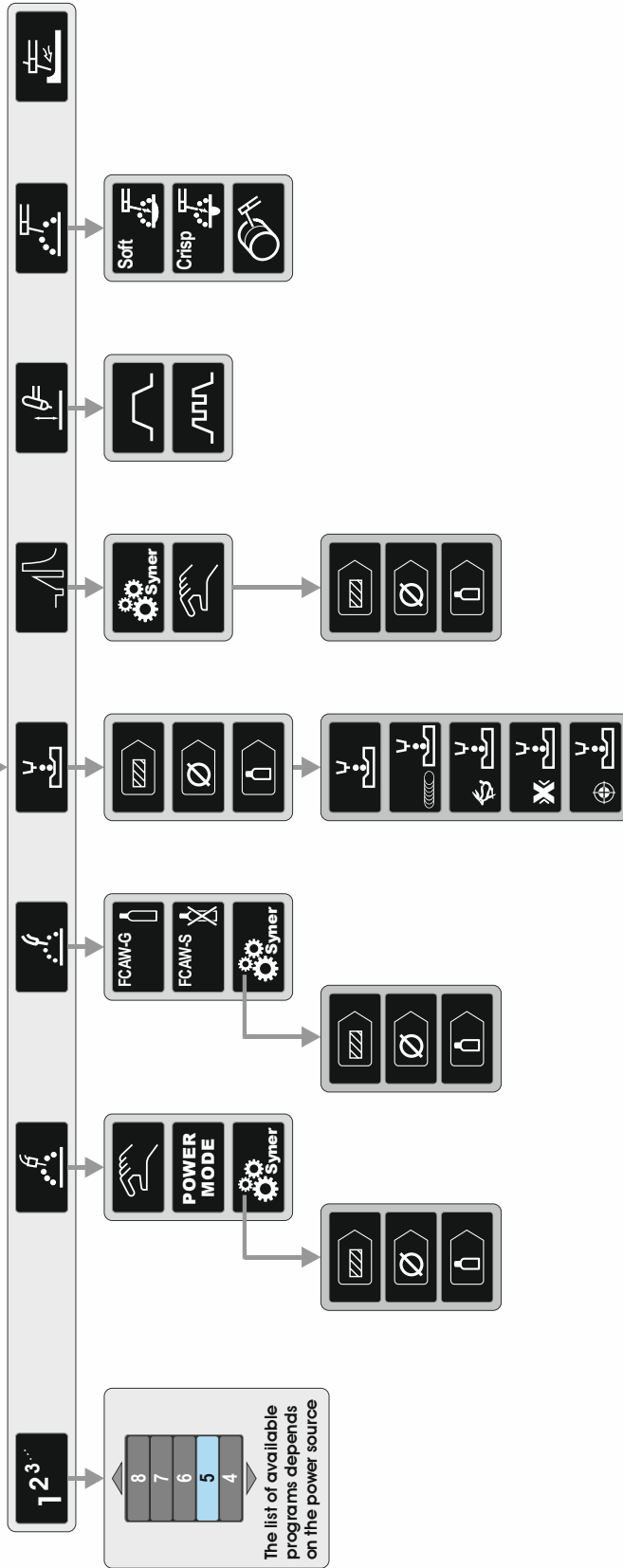
		Recycle				ST				
		Fe	Al	Cu	Brass	Boards	Plastics	Liquid Cristal	External Electric Cables	Capacitors
Description	Ref.									
RACK	1	X								
COVER	19	X								
SIDE PANEL	16, 21	X								
LOCK	22						X			
HINGLES	20	X								
WHEELS	2, 5		X				X			
ROTARY BRACKET	3						X			
WHEELS BRACKET	4	X								
PLASTIC COVER	6						X			
REEL HUB	7	X					X			
RING	8		X							
GAS SOLENOID	9	X		X	X					
COUPLER	10, 33, 36				X					
WIRE DRIVE ASSEMBLY	11	X		X			X			
RUBBER CABLE BUSH	12						X			
CONDUCTOR RAILS	13, 14			X						
CHOKE	15	X							X	
P.C. BOARDS	16, 53					X				
SLEEVES	17, 23, 24						X			
DIVIDER	25, 37	X								
EURO SOCKET	26				X					
FRONT PANEL	27	X								
EURO SLEEVE	28						X			
SHIELD	29, 41	X								
SHIELD	38						X			
SOCKETS	30, 31, 34, 35	X		X			X			
CAP	32						X			
SWITCHES	42, 43	X			X					
HOLE PLUG	39						X			
LED LAMPS	40	X			X		X			
USB SOCKET	44	X			X					
USB CABLE	45	X			X		X		X	
PANEL	50	X								
CONTROLS	46						X			
BUTTONS	47						X			
PROTECTIVE SCREEN	49						X			
FRAME	48						X			
WASHERS	51,52	X								

Quick Guide



QUICK GUIDE II

Welding Program Selection



Available Welding Programs (06Aug2013)

Process	Mode
Stick Soft (7018)	1
Stick Crisp (6010)	2
Stick Pipe	4
gouging (Compressed Air)	9
TIG Lift	3
TIG Lift Pulse	8
GMW, STANDARD CV	5
GMW, POWER MODE®	40
FCAW-SS, STANDARD CV	6
FCAW-GS, STANDARD CV	7

Material	Synergic: GMAW (MIG), Standard CV					
	0.8	0.9	1.0	1.2	1.4	1.6
Steel	93	13.8	10	20	24	-
Stainless	AMiX	94	139	11	21	107
Stainless	ArHe/CO ₂	63	-	33	43	-
Aluminum AlSi (4043)	Ar	-	-	71	-	73
Aluminum AlMg (6356)	Ar	-	-	181	75	77
MetalCore	AMiX	-	-	-	81	-
CordWire	CO ₂	-	-	-	90	-
CordWire	AMiX	-	-	-	91	-

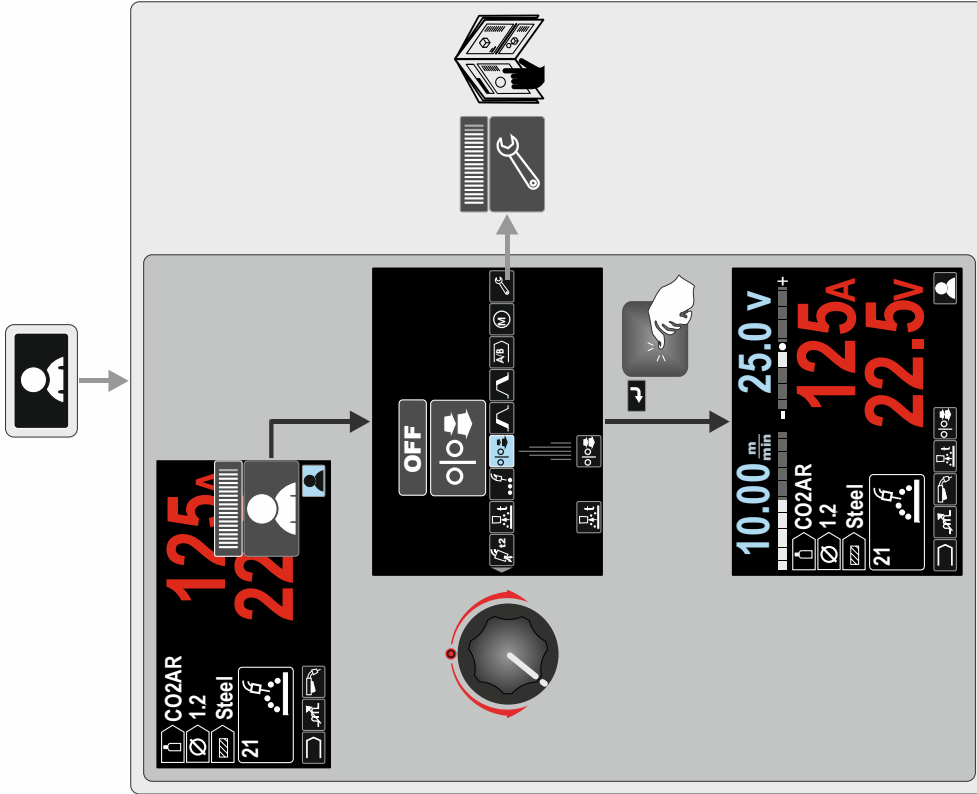
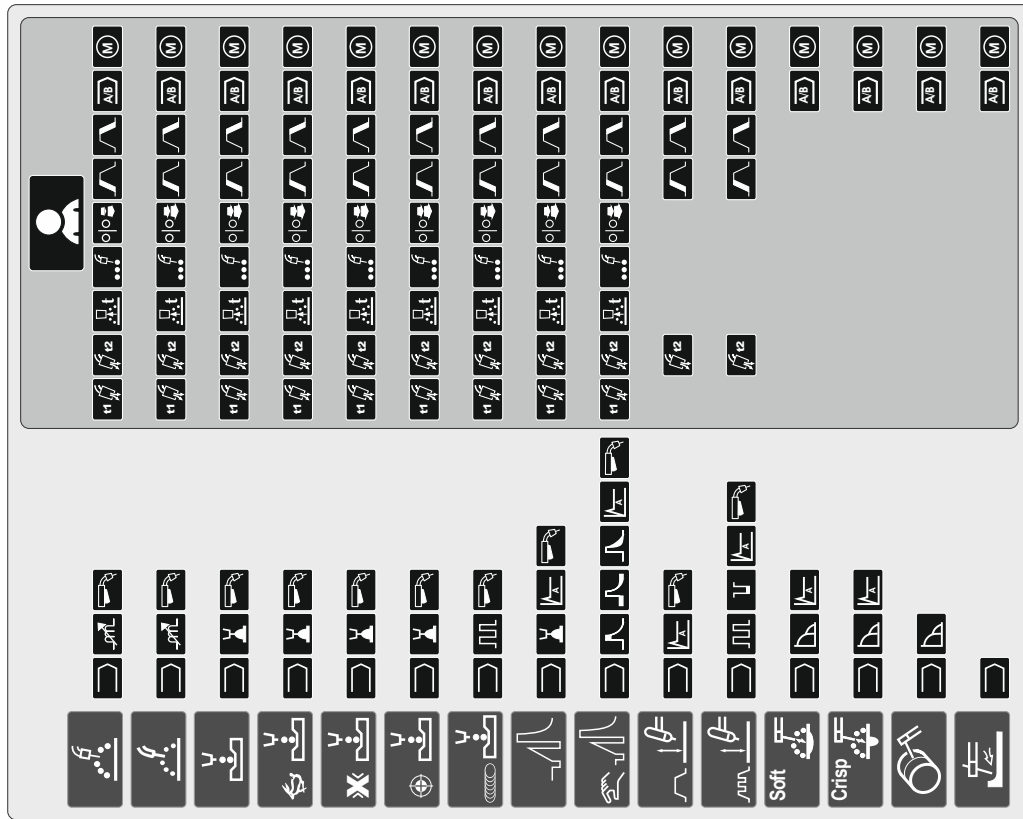
Material	GMANFP (Pulse) / GMAW-PP (Pulse-on-Pulse®)					
	0.8	0.9	1.0	1.2	1.4	1.6
Steel	AMiX	95	140	12	22	108
Steel (RapidArc®)	AMiX	-	141	13	18	27
Steel (Precision Pulse™)	AMiX	410	411	412	413	-
Stainless	AMiX	66	30	36	46	-
Stainless (Precision Pulse™)	ArCO ₂	-	-	421	422	423
MetalCore	AMiX	-	-	-	82	84
N Alloy	70Ar/30He	-	-	170	175	-
Si Bronze	Ar	-	-	192	-	-
Copper	ArHe	-	-	198	196	-
Aluminum AlSi	Ar	-	-	72	-	74
Aluminum AlMg	Ar	-	-	98	99	100
Aluminum AlMg	Ar	-	-	152	76	78
Aluminum AlMg - PP	Ar	-	-	101	102	-

Material	Rapid X™					
	0.8	0.9	1.0	1.2	1.4	1.6
Steel	ArMiX	-	-	273	274	-
Stainless	ArMiX	-	-	283	284	-
MetalCore	ArMiX	-	-	-	294	-

Material	STI®					
	0.8	0.9	1.0	1.2	1.4	1.6
Steel (Non-Synergic)	CO ₂	-	304	306	308	-
Steel (Non-Synergic)	AMiX	-	305	307	309	-
Steel (Synergic)	CO ₂	-	324	326	328	-
Steel (Synergic)	AMiX	-	325	327	329	-
Stainless (Non-Synergic)	AMiX	-	344	346	348	-
Stainless (Non-Synergic)	ArHe/CO ₂	-	345	347	349	-
Stainless (Synergic)	ArMiX	-	364	366	368	-
Stainless (Synergic)	Ar/He/CO ₂	-	365	367	369	-



























































































QUICK GUIDE III

Welding Parameter Bar & User Settings



NOTE:
   **PF46 ONLY**

QUICK GUIDE IV

	Select Welding Process (TIG)		GTAW Process (TIG)		Run-In WFS		UltimArc™		Restore Factory Setting
	Select Welding Program		GTAW Welding		Spot Welding Setting		Setting and Configuration Menu		View Software and Hardware Version Information
	Non-synergic Programs		GTAW-PULSE Welding		Spot Timer		Memory Limits (PF46 only)		Setup Menu
	Synergic Programs		GTAW P program		Start Procedure		Display Configuration Settings		Switch Off Output Voltage (TIG/MMA only)
	GMAW Process (MIG/MAG)		GTAW-PULSE Program		Crater Procedure		Big Meters Menu (factory default)		Switch On Output Voltage (TIG/MMA only)
	POWER MODE		SMAW Process (MMA)		A/B Procedure (PF46 only)		Standard Menu		Welding Current
	FCAW Process		SMAW-Soft Process		Memory (PF46 only)		Weld Score™ Menu		Wire Feed Speed in [m/min]
	FCAW-SS Process		SMAW-Crisp Process		Save to the User Memory (PF46 only)		True Energy™ Menu		Wire Feed Speed in [m/min]
	FCAW-GS Process		SMAW-Pipe Process		Recall from The User Memory (PF46 only)		Assign Function to the Right Button		Welding Voltage
	GMAW-P Process		Gouging		Arc Force		Disabled		Trim
	GMAW-P Process RapidArc® Program		User Settings		Hot Start		Check Mark		Power in kW
	GMAW-P Process RapidX™ Program		Pinch		Frequency Settings (GTAW-PULSE)		Resignation Mark		Cold Feed
	GMAW-P Process Precision Pulse™ Program		Select Function of Gun Trigger (2-Step/4-Step)		Frequency (GTAW-PULSE)		Wave Controls		Gas Purge
	GMAW-P Process Pulse-On-Pulse® Program		2 - Step		Background Settings (GTAW-PULSE)		Brightness Level		Error
	STT® Process		4 - Step		Background Current (GTAW-PULSE)		Lock / Unlock Settings		USB Memory (PF46 only)
	Electrode Wire Type Selection		Prewflow Time		Background Current (STT®)		Locked		USB Memory is connected (PF46 only)
	Wire Size (diameter) Selection		Posiflow Time		Peak Current (STT®)		Unlocked		ESCAPE Button
	Gas Selection		Burnback		TailOut (STT®)		Set Passcode		Confirm Button