



# Aristo<sup>®</sup> Mig 4004i Pulse Aristo<sup>®</sup> Feed 3004, U6/U8<sub>2</sub> Aristo<sup>®</sup> YardFeed 2000, U6

Low weight multi process inverter equipment

**Aristo<sup>®</sup> Mig 4004i Pulse is an electronic controlled MIG/MAG/MMA lightweight inverter based welding power source, designed for high productivity and quality welding applications.**

The floor space (footprint) and the weight are reduced by 70% compared to conventional equipment. The new compact design combined with inverter technology has made **Aristo<sup>®</sup> 4004i Pulse** truly transportable.

Fan on demand cooling systems increase the welding time of the equipment. The cooling unit **COOL 1** provides cooling of liquid-cooled torches to support great comfort to the welder. The cooling fans in the power source and the cooling system for the torch automatically turn off after 6.5 minutes inactivity, significantly reducing the idle time energy consumption.

This 4th generation inverter offers considerable improved efficiency with a power factor better than 0.95. This gives you minimized energy consumption and will offer significant reductions in your energy cost with the same welding conditions.

Technology	Weight	Efficiency
Chopper	>149 kg	<70%
Inverter	46 kg	>85%



## Applications

- **Highly productive MIG/MAG welding**
- **Advanced MMA welding**
- **Typical market segments:**
  - General Industrial Fabrication
  - Energy Generation
  - Windmills
  - Trucks Busses and Trailers
  - Trains & Railway Cars
  - Earthmoving and Mining Equipment
  - Mobile Machinery
  - Steel Sections
  - Shipbuilding/Offshore

XA00166520

- **High Duty Cycle** – suitable for long runs
- **Wide mains input tolerance:** 380 - 440 V +/- 10%
- **Generator compatible** – for on site use
- Standby Function – energy saving system
- **Pre-programmed synergic lines** to ensure optimum settings with a wide choice of materials, wire dimensions and gas combinations
- **Memory** for 10 (U6) or 255 (U8<sub>2</sub>) welding schedules
- **Customized synergic lines** (U8<sub>2</sub>)
- **SuperPulse™**, the welding process with the ability to control the heat input (U8<sub>2</sub>)
- **QSet™** – Intelligent welding system
- **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
- **TrueArcVoltage™** (valid only in combination with the PSF torch range) measures the correct arc voltage value independent of length of the interconnection cable, return cable or welding torch assembly.

QSet™ - The intelligence welding system which simplifies welding

QSet™ monitors the welding arc and optimizes welding parameters in dip transfer, just weld and the arc condition will be optimized within a few seconds. Then simply adjust the wire feed speed to suit the application and let QSet™ do the rest.

A robust fully enclosed design protects the welding wire from moisture, dust and other airborne contaminants.

Aristo® Feed 3004 is available with 2 operational solutions, the U6 panel and the U8<sub>2</sub> pendant.

A 7.5 m connection cable to provide a wider working range is available for the U8<sub>2</sub> pendant. Access for remote controls at the front of the feeder.

Adapter kit for PSF RS3 torches and MXH Push-Pull guns provide access to pre-programmed welding schedules from the torch (PSF RS3) or control of the wire feed speed from the PP guns (MXH 300/400w PP). The feeder accept standard 200, 300 and 440 mm spools additional to MarathonPac™. (See Ordering information, Accessories).

### LiveTig™

The LiveTig™ start function that electronically limit the start current by 12-15A is implemented to U6 and U8<sub>2</sub>.

**Aristo® Mig 4004i Pulse** combined with U6 or U8<sub>2</sub> offer a complete multi-process package supporting MMA, TIG, MIG/MAG and pulse MIG.

The package support welding of mild steel and stainless steel in all processes and Aluminium in MMA, MIG/MAG and pulse MIG.

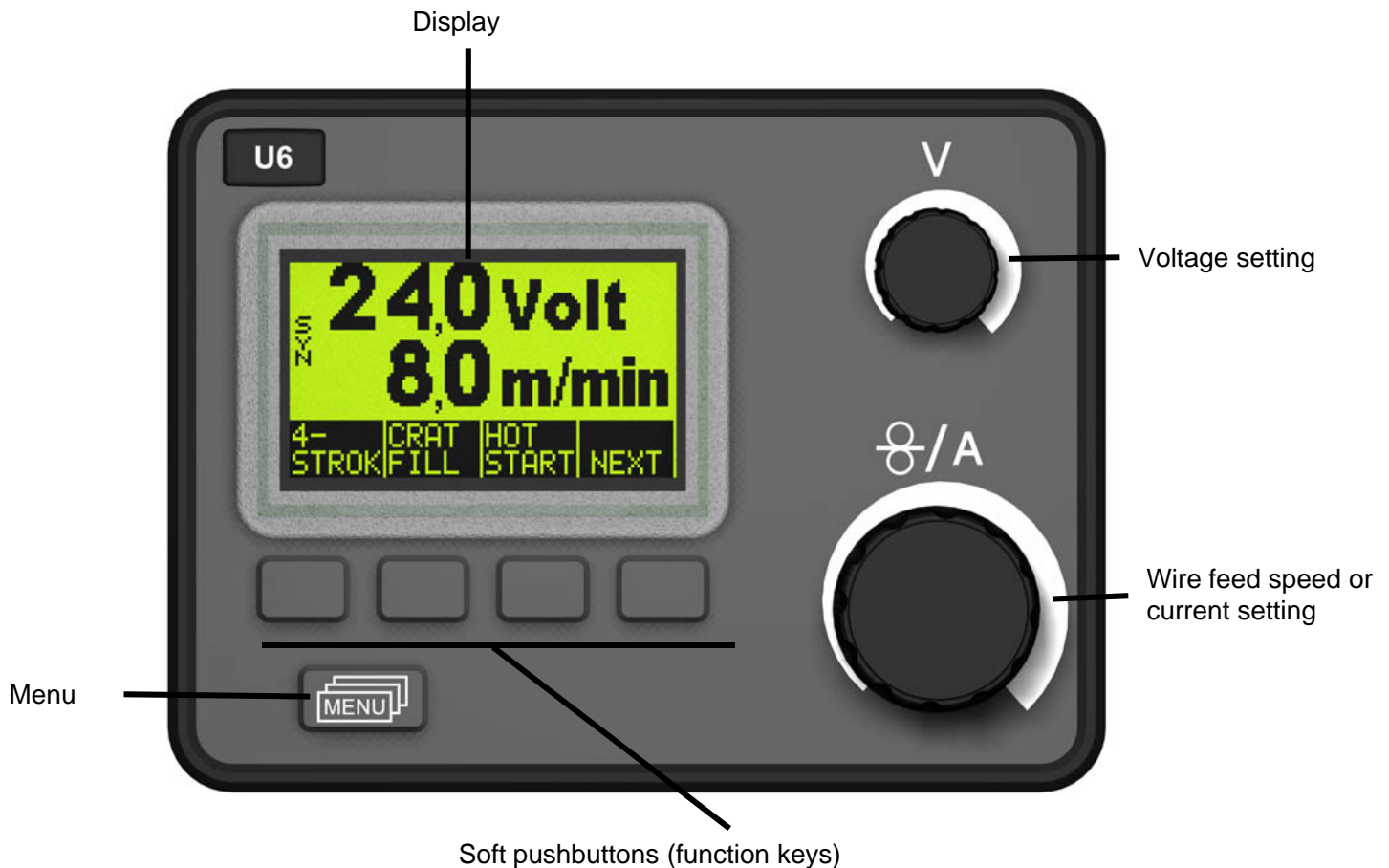
### SuperPulse™

SuperPulse™ (U8<sub>2</sub>) is the optimum MIG/MAG process for control of the heat input or bridging of variable gaps.



Aristo® Feed 3004 U6 and MXH 400w PP

## Aristo® U6



# Aristo® U8<sub>2</sub>



For more details about Aristo® U8<sub>2</sub>, see fact sheet XA00141820

## Technical data Aristo® Mig 4004i Pulse

Mains supply, V/Hz	380–440, 3–50/60
Mains cable, Ø mm <sup>2</sup>	4 x 4
Fuse, anti surge, A	20
<b>Permissible load at MIG/MAG</b>	
100% duty cycle A/V	300/29
60% duty cycle A/V	400/34
<b>Setting range A</b>	
MIG/MAG	16-400
MMA	16-400
TIG (LiveTIG)	4-400
Open circuit voltage, V	55
Open circuit voltage VRD, V	< 35
Idle power, W	137
Efficiency at max current, %	88
Power factor at max current	0.94
Dimensions L x W x H, mm	610 x 250 x 445
Weight, Kg	44.5
Incl COOL 1 excl. coolant, Kg	58
Operating temperature, °C	-10 to +40
Enclosure class	IP23
Application class	S
Insulation class	H
Certification	CE



Compartment for wear parts



COOL 1

## Technical data, Water cooler COOL 1

Power supply, from power source, VDC	24
Coolant flow capacity, l/min	2.0
Coolant quantity, l	4.5
Cooling power, kW	1.3
Max pressure, bar	4.5
Max pressure height to torch, m	8.5
Weight / incl. coolant, kg	12 / 16.5
Dimensions incl. filler tube L x W x H, mm	610 x 256 x 256

## Technical data, Aristo® Feed 3004

Power supply, AC	42
Wire spool capacity, kg	18 (30**)
Max. spool diameter, mm	300 (440**)
Wire feed speed, m/min	0.8-25.0
Dimension L x W x H, mm	690 x 275 x 420
Weight, kg	15

This welding equipment complies to IEC-EN974-1, IEC-EN974-2, IEC-EN974-5, IEC-EN974-10



## Ordering information, Power source

Aristo® Mig 4004i Pulse	0465 152 881
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## Ordering information, Feeders

	Air-cooled	Water-cooled
Aristo® Feed 3004, U6 Encl. 10 pole	0460 526 886	0460 526 896
Aristo® Feed 3004, U8 <sub>2</sub> Encl. 10 pole	0460 526 881	0460 526 891
Aristo® YardFeed 2000w U6 Encl. 10 pole	0459 906 896	

## Ordering information, Aristo® U8<sub>2</sub>

Aristo® U8 <sub>2</sub> complete incl. holder	0460 820 880
Aristo® U8 <sub>2</sub> Plus complete incl. holder	0460 820 881
Control cable extension U8 <sub>2</sub> 7.5 m	0460 877 891

## Ordering information, Interconnection cables

50 mm <sup>2</sup> YardFeed	Air-cooled	Water-cooled
10.0 m, 10 pole	0459 528 562	0459 528 572
15.0 m, 10 pole	0459 528 563	0459 528 573
25.0 m, 10 pole	0459 528 564	0459 528 574
35.0 m, 10 pole	0459 528 565	0459 528 575
70 mm <sup>2</sup> Feed 3004		
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

## Ordering information, Accessories

Wheel kit for feeder	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 spool	0455 410 001
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 MT1 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
Water cooler, COOL 1	0462 300 880
Flow guard, COOL 1	0456 855 881
Trolley, 4-wheel	0462 151 880
Trolley bracket (without COOL 1)	0463 125 880
Trolley, 2-wheel for YardFeed	0460 564 880
Trolley, 4-wheel	0460 565 880
Bracket kit to assembly 4004i/5004i to the 2/4-wheel trolley 0460 564/565	0461 310 880
Stabilizer 4-wheel for counter balance	0460 946 880
Counter balance device	0458 705 880

## Synergic lines

Synergic lines is a tool to guide the operator into an optimum setting of the welding parameter. Definition of the wire type and dimension, shielding gas and process (short arc/spray arc or pulse) result in this optimum setting of the parameters.

Wire feed speed can be adjusted and will follow the line. Trimming of the voltage +/- relatively to the synergic line make it easy to adapt to the different welding positions or applications.

A synergic line helps the operator to avoid the global regions between short arc and spray arc.

The optimum arc control type\* is provided by the synergic line.

\* = dynamic regulation

## Consumables for Pulse MIG

ESAB is offering a large range of consumables for welding of mild steel, stainless steel and aluminium. **Pulse MIG** is recommended as the method for positional welding from sheet metal up to medium thickness as it provides better control of the heat.

The listed consumables combined with the pulse MIG synergic lines available from **U6** or **U8<sub>2</sub>** are our recommendation for high productivity and quality welding.

### Mild Steel:

OK AristoRod 12.50/12.63 in Ø0.8 - Ø1.2 mm

OK Autrod 12.51/12.64 in Ø0.8 - Ø1.2 mm

### Stainless Steel:

OK Autrod 308LSi in Ø0.8 - 1.6 mm

OK Autrod 316LSi in Ø0.8 - 1.6 mm

### Aluminium:

OK Autrod 4043/4047 in Ø1.0 - 1.6 mm

OK Autrod 5183/5356 in Ø1.0 - 1.6 mm

