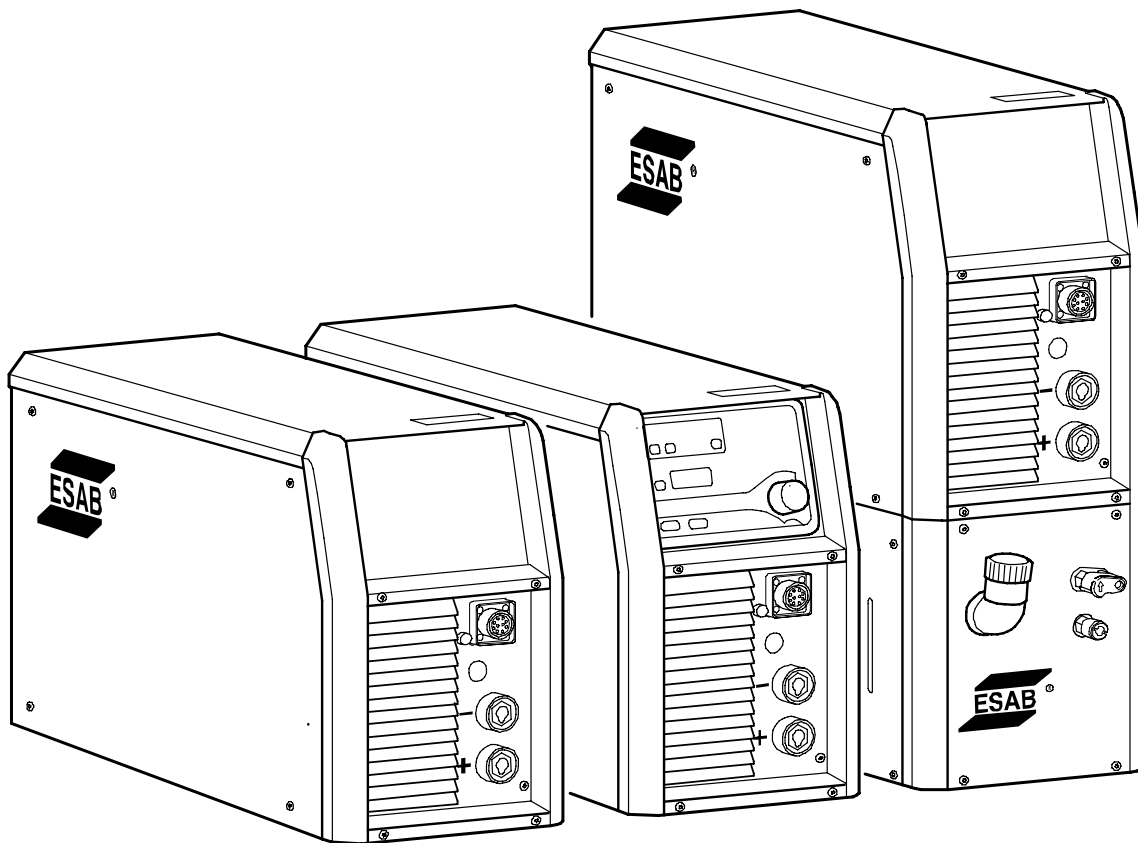


# *Origo™ Aristo™*

# *Mig 3001i*



**Instruction manual**

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## 1 DIRECTIVE

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### DECLARATION OF CONFORMITY

ESAB AB, Welding Equipment, SE-695 81 Laxå, Sweden, gives its unreserved guarantee that welding power source Mig 3001i from serial number 835 are constructed and tested in compliance with the standard EN 60974-1 and EN 60974-10 (Class A) in accordance with the requirements of directive (2006/95/EC) and (2004/108/EEC).

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Laxå 2008-08-14



Kent Eimbrodt  
Global Director  
Equipment and Automation

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## 2 SAFETY

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Users of ESAB welding 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 welding 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 welding 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 welding equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding
2. The operator must ensure that:
  - no unauthorized 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. Ask for your employer's safety practices which should be based on manufacturers' hazard data.**

**ELECTRIC SHOCK - Can kill**

- Install and earth the welding 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!**



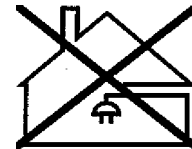
**WARNING!**

**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.*



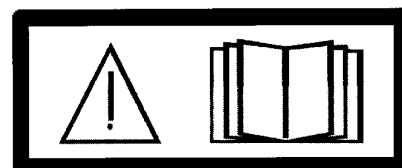
**CAUTION!**

*This product is solely intended for arc welding.*



**CAUTION!**

*Read and understand the instruction manual before installing or operating.*





**Do not dispose of electrical equipment together with normal waste!**

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative.

By applying this European Directive you will improve the environment and human health!

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

### 3 INTRODUCTION

**Mig 3001i** is a welding power source intended for MIG/MAG welding, as well as for welding with powder filled cored wire (FCAW-S), TIG welding and for welding with coated electrodes (MMA).

**ESAB’s accessories for the product can be found on page 17.**

#### 3.1 Equipment

Mig 3001i can be supplied with or without cooling unit. The cooling unit can be retro fitted. Installation kit for the cooling unit is available as an accessory, see page 17 .

The power source is supplied with:

- 4.5 m return cable with contact clamp
- 5 m mains cable with 32 ampere connector
- instruction manual for the welding power source
- instruction manual in English for the control panel (if applicable)
- instruction manual for the cooling unit (if applicable)

Instruction manuals in other languages can be downloaded from the website, <http://www.esab.com>.

#### 3.2 Control panel A24



Welding process parameters are controlled via the control panel. See the separate instruction manual for a detailed description of the panels.

## 4 TECHNICAL DATA

<b>Mig 3001i</b>	
<b>Mains voltage</b>	400 V $\pm$ 10%, 3 ~ 50/60 Hz
<b>Mains supply</b>	S <sub>sc min</sub> 1.4 MVA
<b>Primary current</b>	
I <sub>max</sub> MIG/MAG	16 A
I <sub>max</sub> TIG	13 A
I <sub>max</sub> MMA	19 A
<b>No-load power</b> demand when in the energy-saving mode, 6.5 min. after welding	30 W
<b>Setting range</b>	
MIG/MAG	16 A / 8 V – 300 A / 48 V
TIG	4 – 300 A
MMA	16 – 300 A
<b>Permissible load at MIG/MAG</b>	
35 % duty cycle	300 A / 29 V
60 % duty cycle	240 A / 26 V
100% duty cycle	200 A / 24 V
<b>Permissible load at TIG</b>	
35 % duty cycle	300 A / 22 V
60 % duty cycle	240 A / 19.6 V
100% duty cycle	200 A / 18 V
<b>Permissible load at MMA</b>	
30 % duty cycle	300 A / 32 V
60 % duty cycle	230 A / 29.2 V
100% duty cycle	190 A / 27.6 V
<b>Power factor</b> at maximum current	
MIG/MAG	0.90
TIG	0.89
MMA	0.90
<b>Efficiency</b> at maximum current	
MIG/MAG	85 %
TIG	82%
MMA	84 %
<b>Open-circuit voltage</b>	67 V
<b>Operating temperature</b>	-10 to +40 °C
<b>Transportation temperature</b>	-20 to +55 °C
<b>Continual sound pressure at no-load</b>	<70 db (A)
<b>Dimensions l x w x h</b>	
with cooling unit	652 x 249 x 423 mm 714 x 249 x 693 mm
<b>Weight</b>	
with cooling unit	33 kg 53.5 kg
<b>Insulation class</b> transformer	H
<b>Enclosure class</b>	IP23
<b>Application class</b>	<b>S</b>

### Mains supply, S<sub>sc min</sub>

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 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.

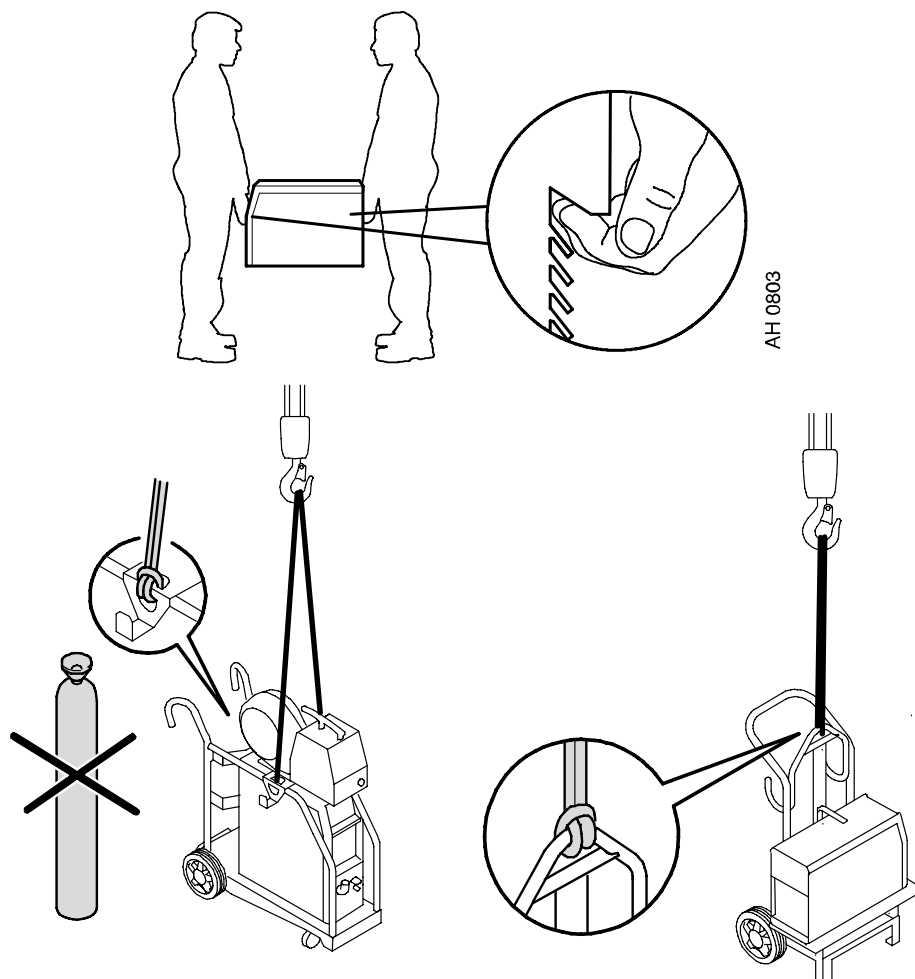
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## 5 INSTALLATION

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*The installation must be executed by a professional.*

### 5.1 Lifting instructions



## 5.2 Location

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

## 5.3 Mains supply

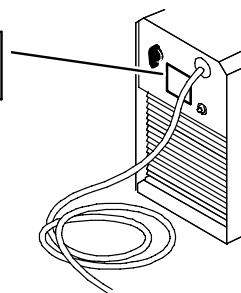
### Note!

#### 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.

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

*Rating plate with supply connection data*



**NOTE!** The welding power source is designed for connection to a 400 volt system with four conductors.

If the power source is to be used in countries with a higher or lower supply voltage, the power source must be connected via a safety transformer.

### Recommended fuse sizes and minimum cable area

Mig 3001i	
<b>Mains voltage</b>	400 V 3~ 50 Hz
<b>Mains cable area</b> mm <sup>2</sup>	4G2.5 mm <sup>2</sup>
<b>Phase current</b> I <sub>eff</sub>	10 A
<b>Fuse</b>	
anti-surge	16 A
type C MCB	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.

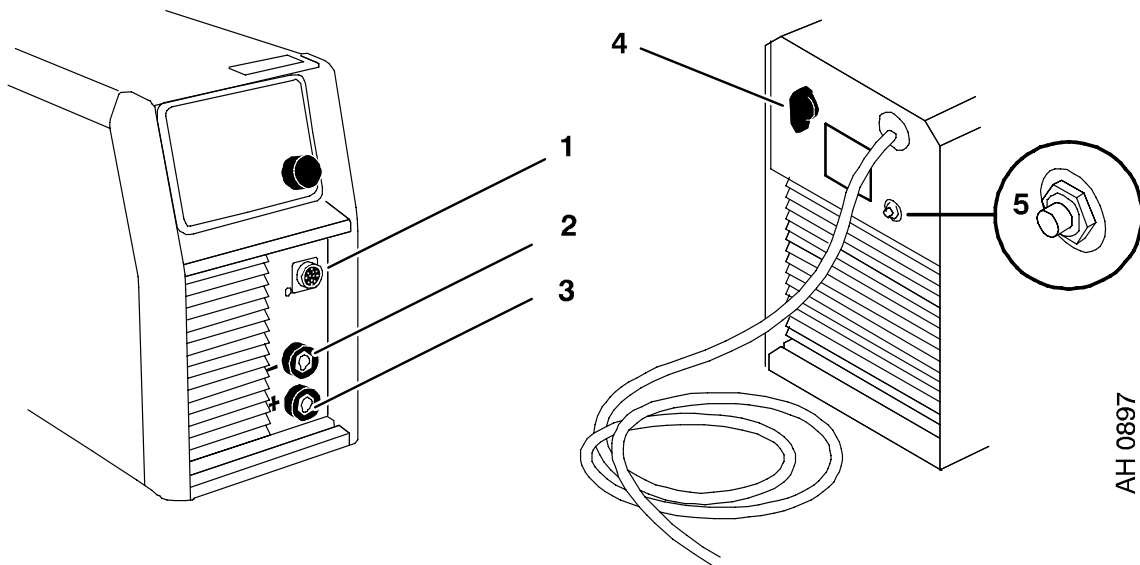


## 6 OPERATION

**General safety regulations for the handling of the equipment can be found on page 3. Read through before you start using the equipment!**

### 6.1 Connections and control devices

- |   |  |
|---|--|
| <p>1 Connection for wire feed unit or remote control unit</p> <p>2 Connection (-) MIG/MAG: Return cable<br/>TIG: Welding torch<br/>MMA: Return cable or welding cable</p> <p>3 Connection (+) MIG/MAG: Welding cable<br/>TIG: Return cable<br/>MMA: Welding cable or return cable</p> | <p>4 Mains voltage switch 1 / 0</p> <p>5 Fuse for supply voltage for feeder unit, 42 V</p> |
|---|--|



AH 0897

### 6.2 Connection of welding and return cable

The power source has two outputs, a positive terminal (+) and a negative terminal (-), for connecting welding and return cables. The output to which the welding cable is connected depends on the welding method or type of electrode used.

Connect the return cable to the other output on the power source. Secure the return cable's contact clamp to the work piece and ensure that there is good contact between the work piece and the output for the return cable on the power source.

For MMA welding, the welding cable can be connected to the positive terminal (+) or negative terminal (-) depending on the type of electrode used. The connecting polarity is stated on the electrode packaging.



### **6.3 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.

### **6.4 Overheating protection**

The welding power source has overheating protection that operates 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.

### **6.5 MIG/MAG and FCAW-S welding**

An arc melts a continuously supplied wire. The weld pool is protected by shielding gas.

For MIG/MAG and FCAW-S welding, the power source is supplemented with:

- wire feed unit
- welding torch
- connection cable between power source and wire feed unit
- gas bottle

To ensure problem-free operation, the installation height from the cooling unit to the welding gun must be max. 7 m. Heights in excess of this can cause problems, such as long starting times, air bubbles, vacuums, etc.

If an installation height in excess of 7 m is required, we recommend an installation kit comprising a non-return valve and a solenoid valve, refer to accessories on page 17. Once these valves have been installed, the hose package must be horizontal during the initial startup so that everything fills with water. Then raise the wire feed unit and hose package to the high height. Continued safe operation at installation heights of up to 12 m can now commence.

### **6.6 TIG welding**

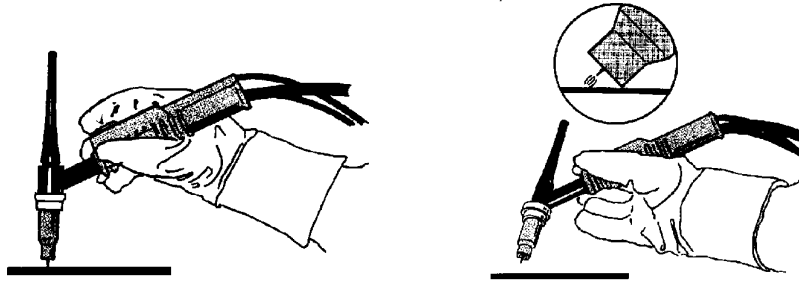
TIG welding melts the metal of the workpiece, using an arc struck from a tungsten electrode, which does not itself melt. The weld pool and the electrode are protected by shielding gas.

For TIG welding, the welding power source is supplemented with:

- a TIG torch with gas valve
- an argon gas cylinder
- an argon gas regulator
- tungsten electrode

### "Live TIG-start"

At a "Live TIG-start" the tungsten electrode is placed against the workpiece. When the electrode is then lifted away from workpiece, the arc is struck at a limited current level (12 - 15 A).



## 6.7 MMA welding

For welding with coated electrodes, the power source is supplemented with:

- welding cable with electrode clamp

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## 7 MAINTENANCE

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Regular maintenance is important for safe, reliable operation.

*Only personnel with the appropriate electrical skills (authorised staff) may remove safety plates.*



### **CAUTION!**

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

### 7.1 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 power source clean with dry compressed air (reduced pressure) once a year.

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

### 7.2 Welding torch

Wear parts should be cleaned and replaced at regular intervals in order to achieve trouble-free welding.

## 8 FAULT-TRACING

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

Type of fault	Corrective action
No arc	<ul style="list-style-type: none"> <li>• Check that the mains power supply switch is turned on.</li> <li>• Check that the welding and return cables are correctly connected.</li> <li>• Check that the correct current value is set.</li> <li>• Check the mains power supply fuses.</li> </ul>
The welding current is interrupted during welding.	<ul style="list-style-type: none"> <li>• Check whether the overloading protection has tripped (indicated in the control panel).</li> <li>• Check the mains power supply fuses.</li> </ul>
The overloading protection trips frequently.	<ul style="list-style-type: none"> <li>• Check to see whether the dust filter is clogged.</li> <li>• Make sure that you are not exceeding the rated data for the power source (i.e. that the unit is not being overloaded).</li> </ul>
Poor welding performance	<ul style="list-style-type: none"> <li>• Check that the welding and return cables are correctly connected.</li> <li>• Check that the correct current value is set.</li> <li>• Check that the correct wire or electrode is used.</li> <li>• Check the mains power supply fuses.</li> </ul>

## 9 ORDERING SPARE PARTS

*Repair and electrical work should be performed by an authorized ESAB serviceman. Use only ESAB original spare and wear parts.*

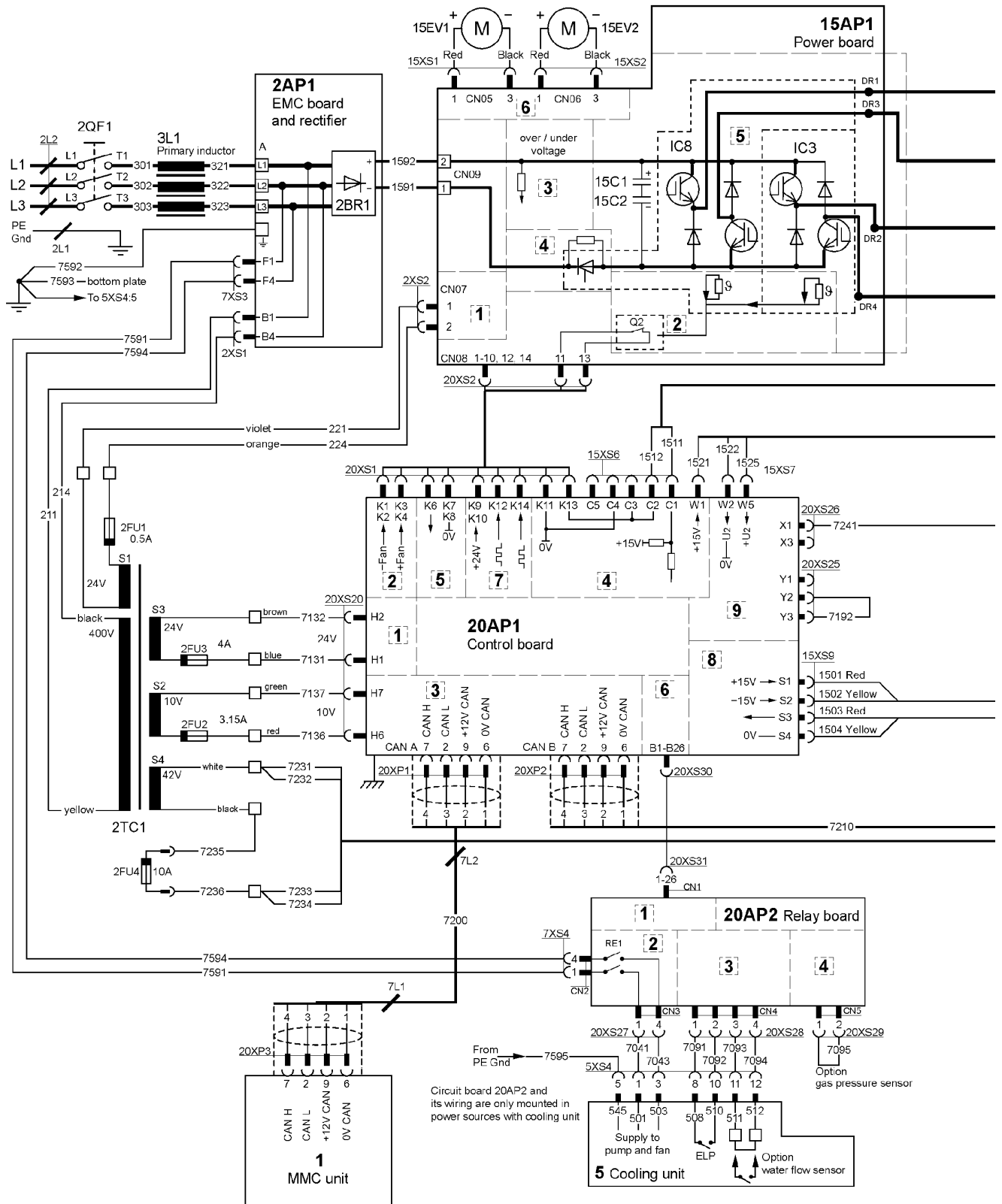
**Mig 3001i is designed and tested in accordance with the international and European standards EN 60974-1 and EN 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.**

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

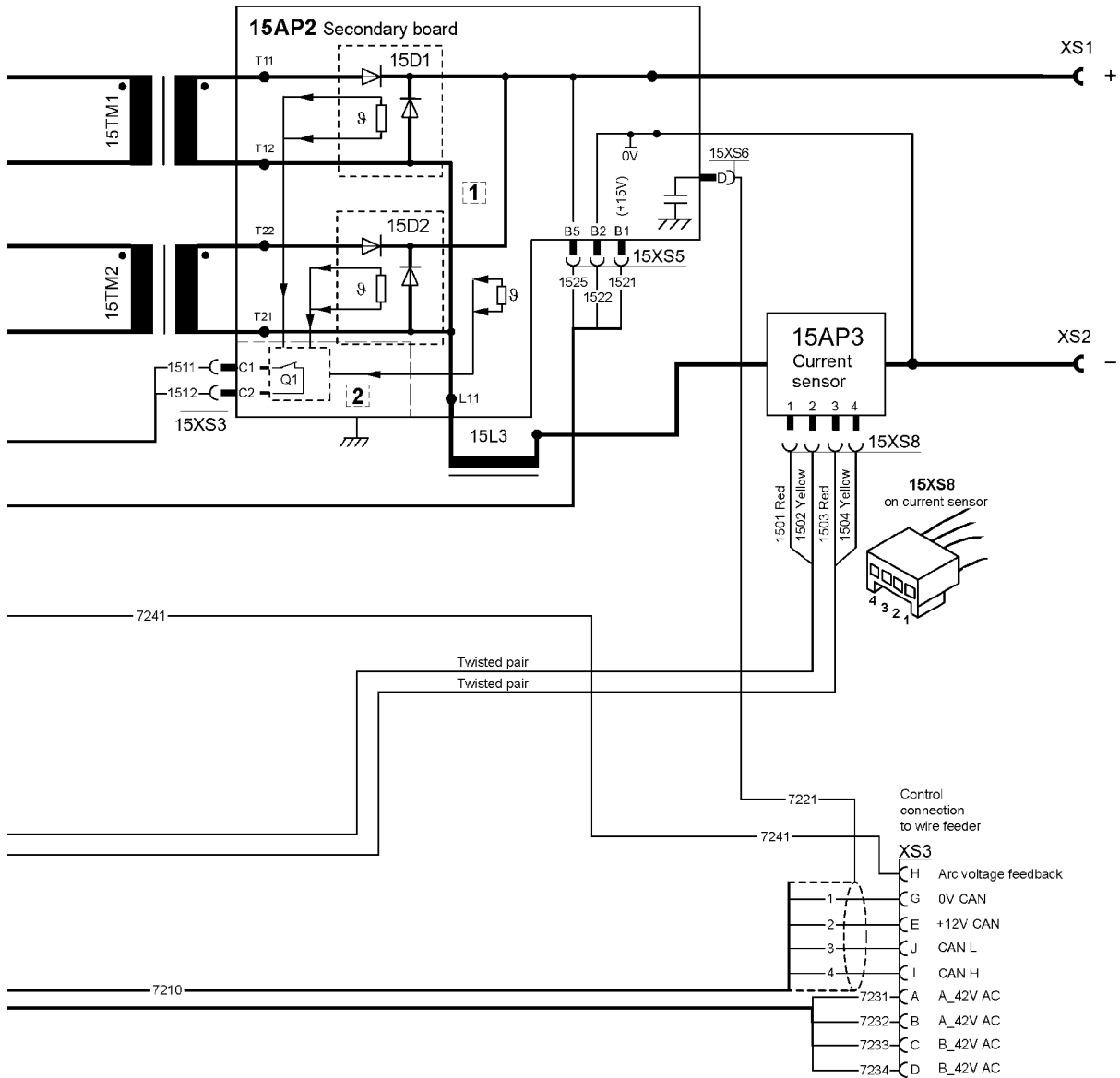


# Diagram

## Mig 3001i

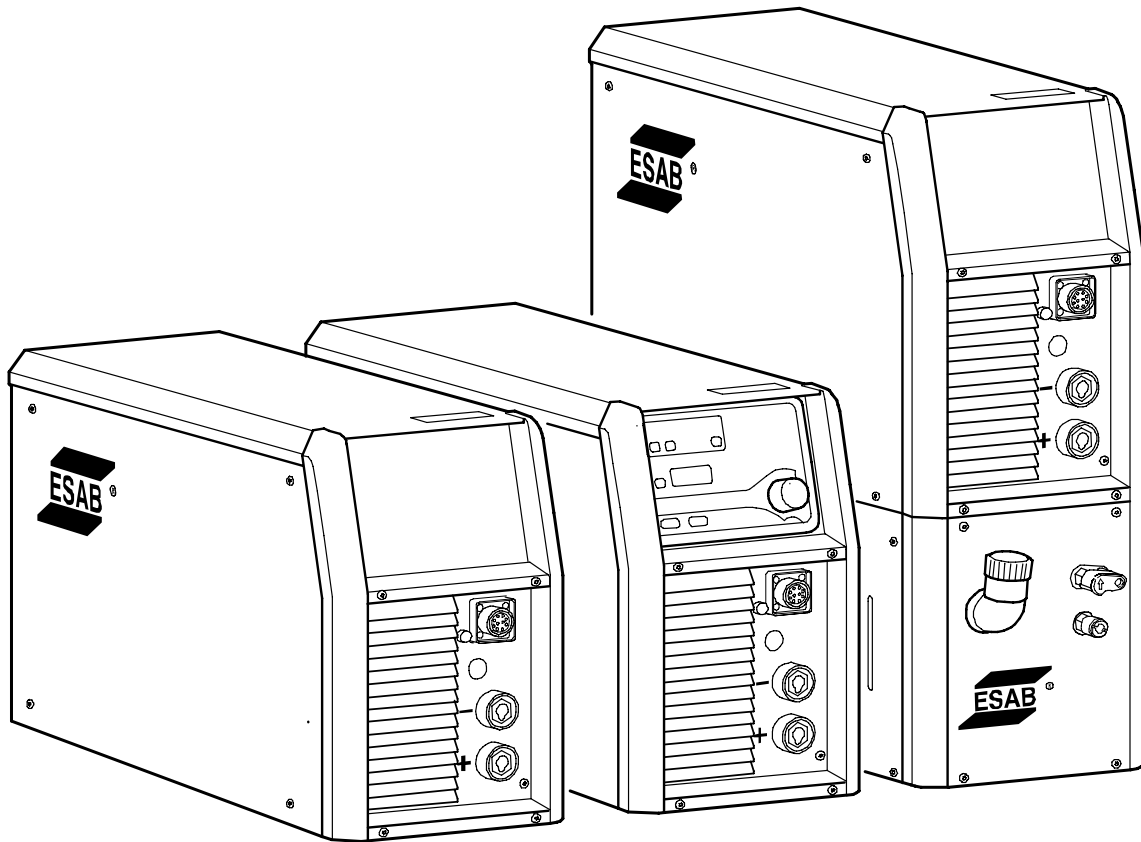


# Diagram



## Mig 3001i

### Ordering number



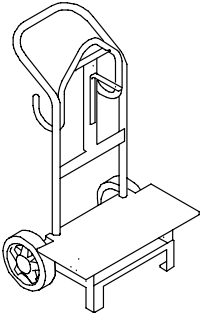
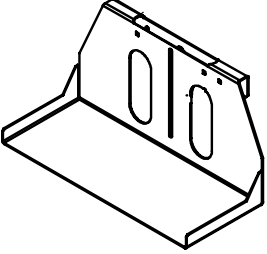
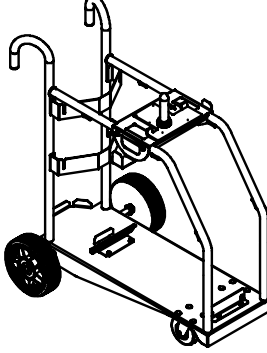
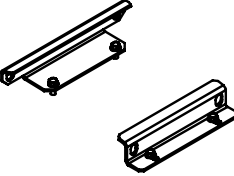
Ordering no.	Denomination	Type	Notes
0459 740 882	Welding power source	Origo™ Mig 3001i	
0459 740 883	Welding power source	Origo™ Mig 3001iw	with cooling unit
0459 740 884	Welding power source	Origo™ Mig 3001i A24	with control panel A24
0459 839 031	Spare parts list	Mig 3001i	
0460 737 0	Instruction manual	Control panel A22, A24	

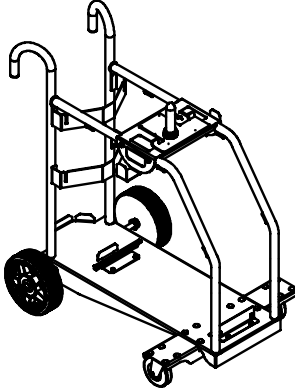
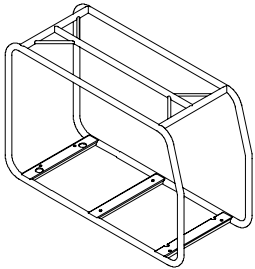
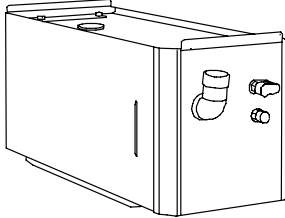
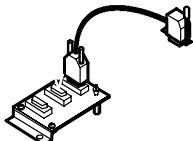
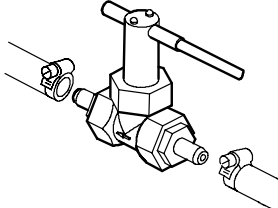
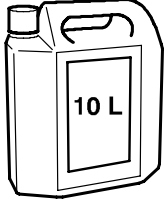
The spare parts list is available on the Internet at [www.esab.com](http://www.esab.com)

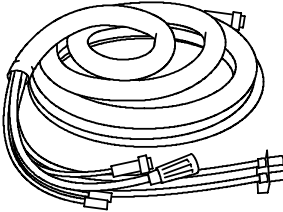



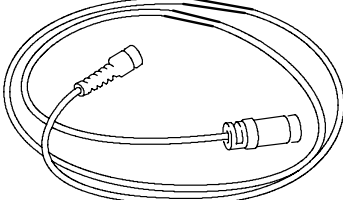


# Mig 3001i

## Accessories

	<p><b>Trolley with two wheels</b> ..... 0460 564 880</p>
	<p><b>Feeder platform for trolley with two wheels</b> 0460 815 880</p>
	<p><b>Trolley with four wheels</b> ..... 0460 565 880</p>
	<p><b>Mounting brackets</b> ..... 0460 911 880</p>

	<p><b>Stabilizer kit for counter balance</b> ..... 0460 946 880</p>
	<p><b>Protection frame</b> ..... 0460 459 880</p>
	<p><b>Cooling unit CoolMidi 1000</b> ..... 0460 490 880</p>
	<p><b>Connection kit for cooling unit</b> ..... 0460 685 881</p>
	<p><b>Installation kit water return flow guard</b> ..... 0461 203 880</p>
	<p><b>Water flow guard 0.7 l/min</b> ..... 0456 855 881</p>
	<p><b>Coolant</b> (Ready mixed) 50% water and 50% mono-ethylene glycol (10 l) ..... 0007 810 012</p>

	<p><b>Connection set 70mm<sup>2</sup></b></p> <p>1.7 m ..... 0459 528 780</p> <p>5 m ..... 0459 528 781</p> <p>10 m ..... 0459 528 782</p> <p>15 m ..... 0459 528 783</p> <p>25 m ..... 0459 528 784</p> <p>35 m ..... 0459 528 785</p> <p><b>Connection set water 70mm<sup>2</sup></b></p> <p>1.7 m ..... 0459 528 790</p> <p>5 m ..... 0459 528 791</p> <p>10 m ..... 0459 528 792</p> <p>15 m ..... 0459 528 793</p> <p>25 m ..... 0459 528 794</p> <p>35 m ..... 0459 528 795</p>
	<p><b>Remote control unit MTA1 CAN</b> ..... 0459 491 880</p> <p>MIG/MAG: wire feed speed and voltage MMA: current and arc force TIG: current, pulse and background current</p>
	<p><b>Remote control unit AT1 CAN</b> ..... 0459 491 883</p> <p>MMA and TIG: current</p>
	<p><b>Remote control unit AT1 CF CAN</b> ..... 0459 491 884</p> <p>MMA and TIG: rough and fine setting of current.</p>
	<p><b>Remote control cable 10 pole - 4 pole</b></p> <p>5 m ..... 0459 960 880</p> <p>10 m ..... 0459 960 881</p> <p>25 m ..... 0459 960 882</p>

Information on PSF welding torches can be found in separate brochures.

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