

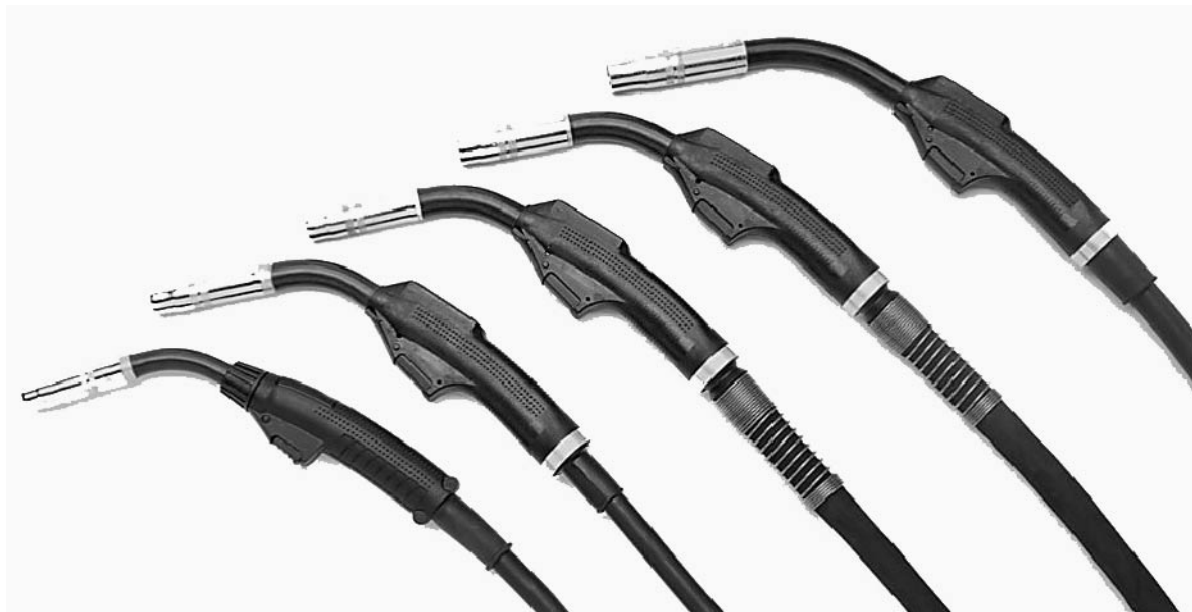


***PSF 305, 405, 505,***

***PSF 405 RS3***

***PSF 410W-510W***

***PSF 410W RS3-510W RS3***



**Bruksanvisning  
Brugsanvisning  
Bruksanvisning  
Käyttöohjeet  
Instruction manual  
Betriebsanweisung**

**Manuel d'instructions  
Gebruiksaanwijzing  
Instrucciones de uso  
Istruzioni per l'uso  
Manual de instruções**

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Rätt till ändring av specifikationer utan avisering förbehålles.  
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**Reservdelsförteckning Reservdelsfortegnelse Reservedelsliste  
 Varaosaluettelo Spare parts list Ersatzteilliste Liste de pièces détachées  
 Reserveonderdelenlijst Lista de repuestos Elenco ricambi Lista de peças  
 sobressalentes**

Valid from manufacturing week 105

**Ordering numbers for PSF 305, 405, 505, 405 RS3**

Order Nos	Type	Description	Notes
0458 401 880	PSF 305	Welding Gun 3.0 m	EURO connection
0458 401 881	PSF 305	Welding Gun 4.5 m	EURO connection
0458 401 882	PSF 405	Welding Gun 3.0 m	EURO connection
0458 401 883	PSF 405	Welding Gun 4.5 m	EURO connection
0458 401 884	PSF 505	Welding Gun 3.0 m	EURO connection
0458 401 885	PSF 505	Welding Gun 4.5 m	EURO connection
0458 401 886*	PSF 305	Welding Gun 3.0 m	ESAB connection
0458 401 887*	PSF 305	Welding Gun 4.5 m	ESAB connection
0458 401 888*	PSF 405	Welding Gun 3.0 m	ESAB connection
0458 401 889*	PSF 405	Welding Gun 4.5 m	ESAB connection
0458 401 890*	PSF 505	Welding Gun 3.0 m	ESAB connection
0458 401 891*	PSF 505	Welding Gun 4.5 m	ESAB connection
0458 401 892	PSF 405 RS3	Welding Gun 3.0 m	EURO connection
0458 401 893	PSF 405 RS3	Welding Gun 4.5 m	EURO connection

**Ordering numbers for PSF 410W, 510W, 410W RS3, 510W RS3**

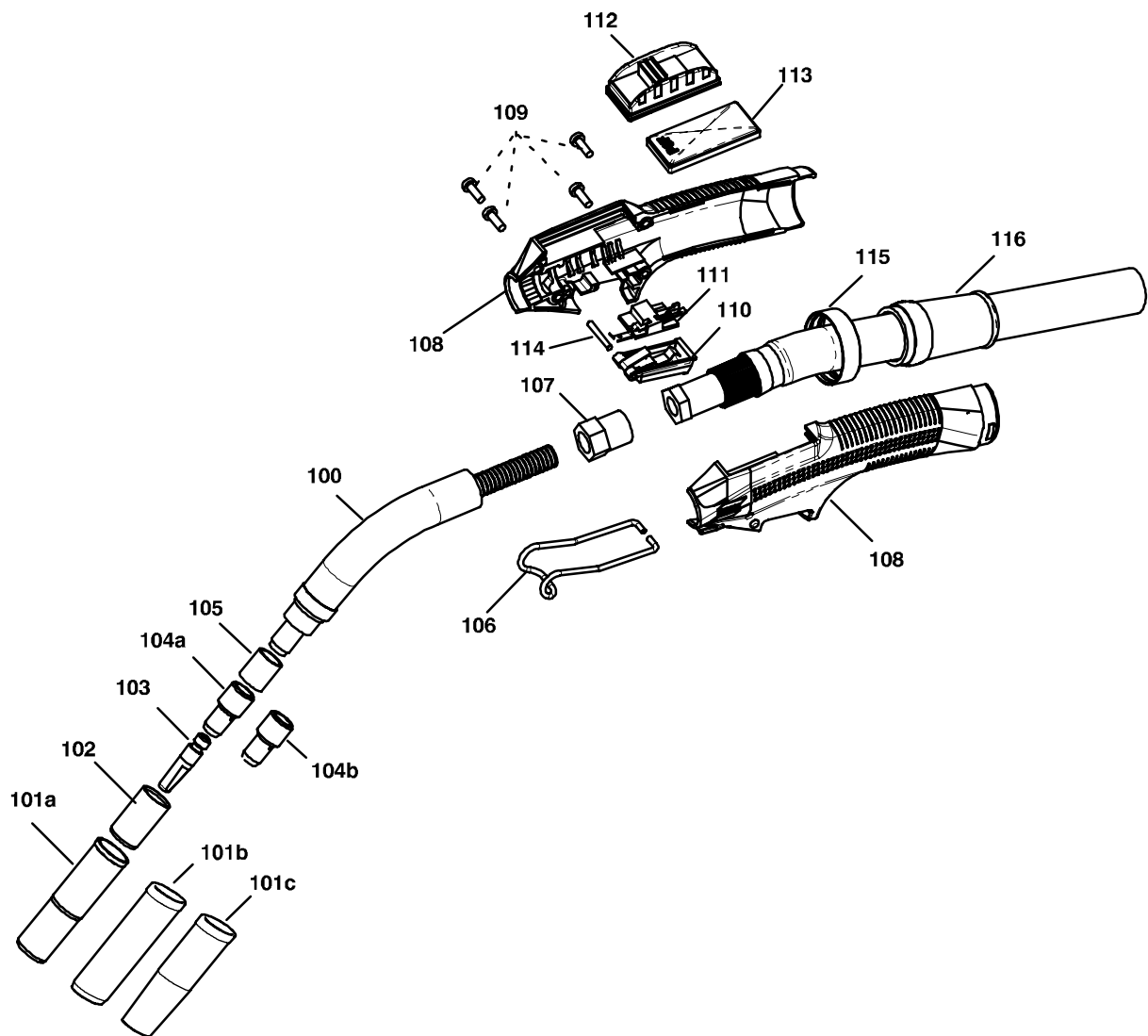
Order Nos	Type	Description	Notes
0458 400 882	PSF 410W	Welding Gun 3.0 m	EURO connection
0458 400 883	PSF 410W	Welding Gun 4.5 m	EURO connection
0458 400 884	PSF 510W	Welding Gun 3.0 m	EURO connection
0458 400 885	PSF 510W	Welding Gun 4.5 m	EURO connection
0458 400 890*	PSF 410W	Welding Gun 3.0 m	ESAB connection
0458 400 891*	PSF 410W	Welding Gun 4.5 m	ESAB connection
0458 400 892*	PSF 510W	Welding Gun 3.0 m	ESAB connection
0458 400 893*	PSF 510W	Welding Gun 4.5 m	ESAB connection
0458 400 898*	PSF 410W RS3	Welding Gun 3.0 m	EURO connection
0458 400 899	PSF 410W RS3	Welding Gun 4.5 m	EURO connection
0458 400 900*	PSF 510W RS3	Welding Gun 3.0 m	EURO connection
0458 400 901	PSF 510W RS3	Welding Gun 4.5 m	EURO connection

\* *Delivered on request only*

Spare parts are to be ordered through the nearest ESAB agency as per the list on the back of the cover. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

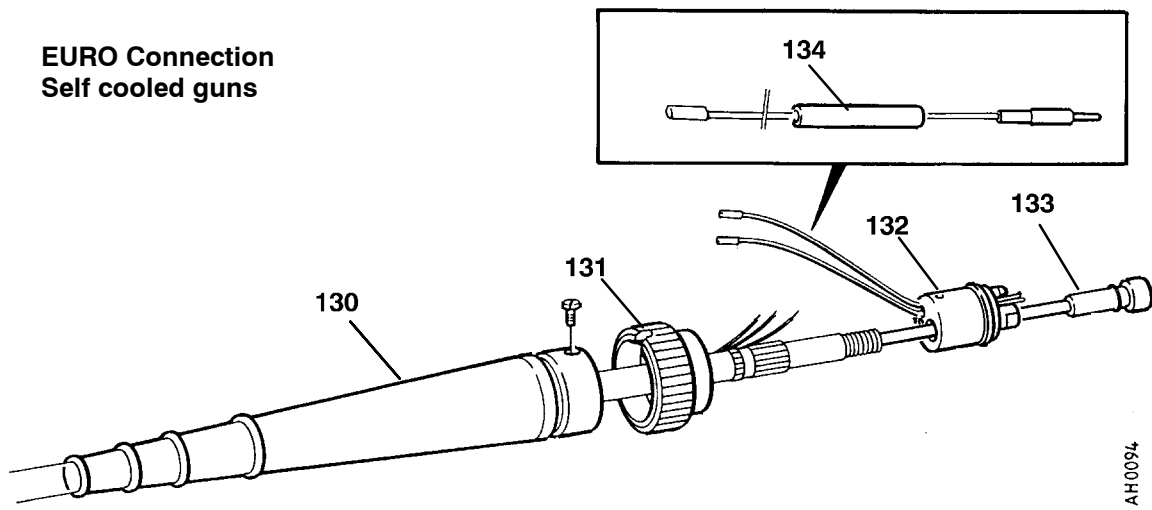
Pos	Denomination	Ordering no.	PSF 305	PSF 405	PSF 505	PSF 405 RS3	Notes
	<b>Welding Gun 3.0 m</b>	<b>0458 401</b>	<b>-880</b>	<b>-882</b>	<b>-884</b>	<b>-892</b>	EURO Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 401</b>	<b>-881</b>	<b>-883</b>	<b>-885</b>	<b>-893</b>	EURO Connection
	<b>Welding Gun 3.0 m</b>	<b>0458 401</b>	<b>-886</b>	<b>-888</b>	<b>-890</b>	-	ESAB Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 401</b>	<b>-887</b>	<b>-889</b>	<b>-891</b>	-	ESAB Connection
100	Swan neck Complete std	0366 388 880	x				Include 101a, 104a
100	Swan neck Complete std	0366 389 880		x		x	Include 101a, 104b
100	Swan neck Complete std	0366 390 880			x		Include 101a, 104b
100	Swan neck Complete 60°	0467 988 881	x				Include 101a, 104a
100	Swan neck Complete 60°	0467 988 880		x		x	Include 101a, 104b
100	Swan neck Complete 60°	0467 989 881			x		Include 101a, 104b
100	Swan neck Complete straight	0469 333 880	x				Include 101a, 104a
100	Swan neck Complete straight	0469 334 880		x		x	Include 101a, 104b
100	Swan neck Complete straight	0469 335 880			x		Include 101a, 104b
101a	Gas nozzle standard Ø16	0458 464 882	x				Include 105
101a	Gas nozzle standard Ø17	0458 464 883		x		x	Include 105
101a	Gas nozzle standard Ø18	0458 464 884			x		Include 105
101b	Gas nozzle straight Ø19	0458 470 882	x				Include 105
101b	Gas nozzle straight Ø21	0458 470 883		x		x	Include 105
101b	Gas nozzle straight Ø21	0458 470 884			x		Include 105
101c	Gas nozzle conical Ø14	0458 465 882	x				Include 105
101c	Gas nozzle conical Ø15	0458 465 883		x		x	Include 105
101c	Gas nozzle conical Ø15	0458 465 884			x		Include 105
102	Spatter protection	0458 471 003	x				
102	Spatter protection	0458 471 004		x		x	
102	Spatter protection	0458 471 005			x		
103	Contact tip see table 1-3						
104a	Adapter standard M6	0366 394 001	x	x		x	
104b	Adapter standard M8	0366 394 002	x	x	x	x	
104c	Adapter Helix M7	0368 311 001	x	x	x	x	
105	Insulation bushing	0366 397 002	x	x		x	PSF 305, 405
105	Insulation bushing	0366 397 003			x		PSF 505
106	Hook	0458 445 001	x	x	x	x	
107	Lock nut with screw	0458 406 881	x	x	x	x	
108	Handle spare	0458 440 881	x	x	x	x	Incl 109, 113, 114
109	Screw 4 pcs (12 mm)	-	x	x	x	x	included in 108
110	Trigger complete	0458 810 880	x	x	x	x	incl.spring
111	Mech. Switch	0369 611 880	x	x	x	x	
112	Remote switch, compl	0458 420 880				x	
113	Blind cover	-	x	x	x		Included in 108
114	Pin	-	x	x	x	x	Included in 108
115	Swivel ring	0458 730 001	x	x	x	x	
116	Support sleeve	0466 859 001	x	x		x	PSF 305, 405
116	Support sleeve	0466 856 002			x		PSF 505



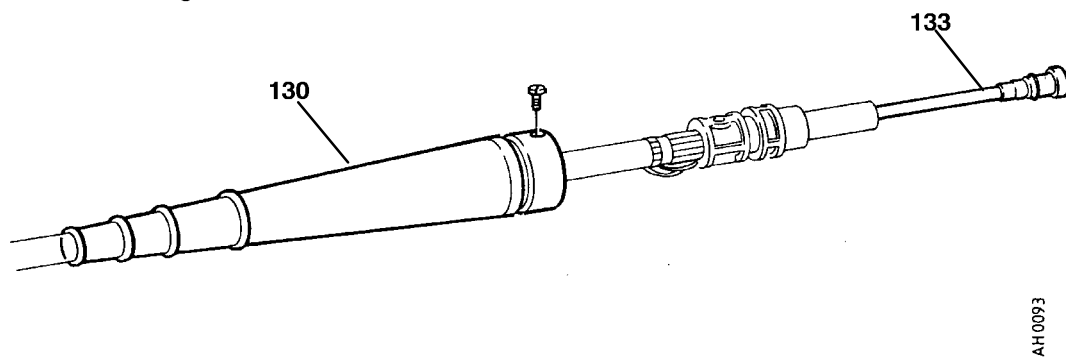
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Pos	Denomination	Ordering no.	PSF 305	PSF 405	PSF 505	PSF 405 RS3	Notes
	<b>Welding Gun 3.0 m</b>	<b>0458 401</b>	<b>-880</b>	<b>-882</b>	<b>-884</b>	<b>-892</b>	EURO Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 401</b>	<b>-881</b>	<b>-883</b>	<b>-885</b>	<b>-893</b>	EURO Connection
	<b>Welding Gun 3.0 m</b>	<b>0458 401</b>	<b>-886</b>	<b>-888</b>	<b>-890</b>	-	ESAB Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 401</b>	<b>-887</b>	<b>-889</b>	<b>-891</b>	-	ESAB Connection
130	Support sleeve	0467 867 881	x	x	x	x	
131	Nut	0369 401 880	x	x	x	x	
132	Connection block complete	0457 910 880	x	x	x	x	
133	Liner - See table 4						
134	Contact pin	0467 582 880	x	x	x	x	

EURO Connection  
Self cooled guns

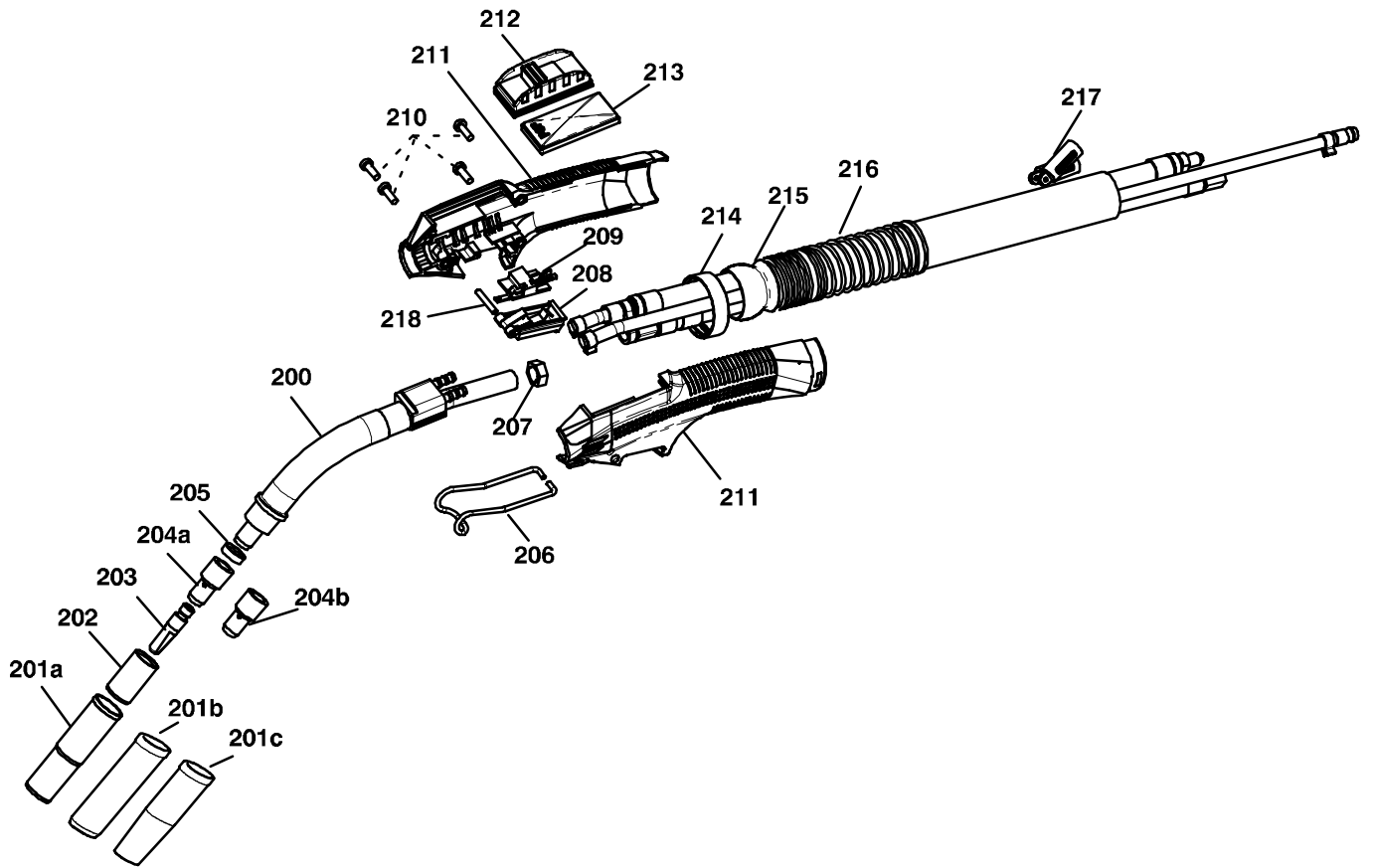


ESAB Connection  
Self cooled guns

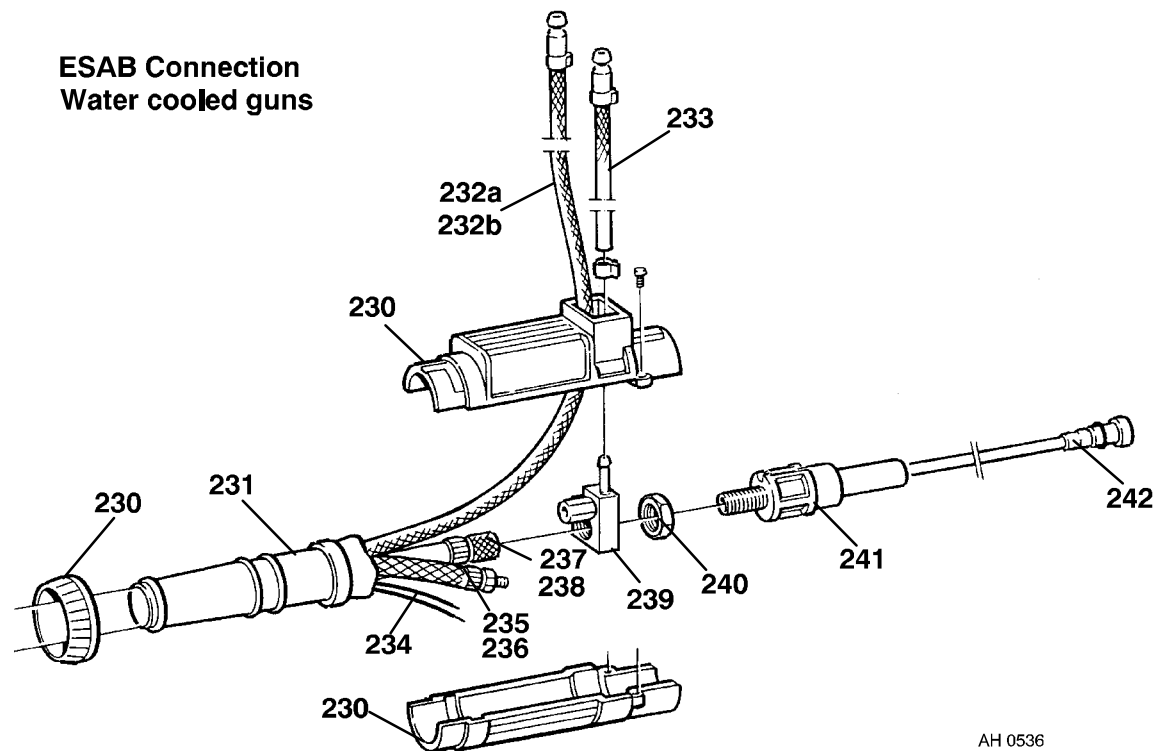
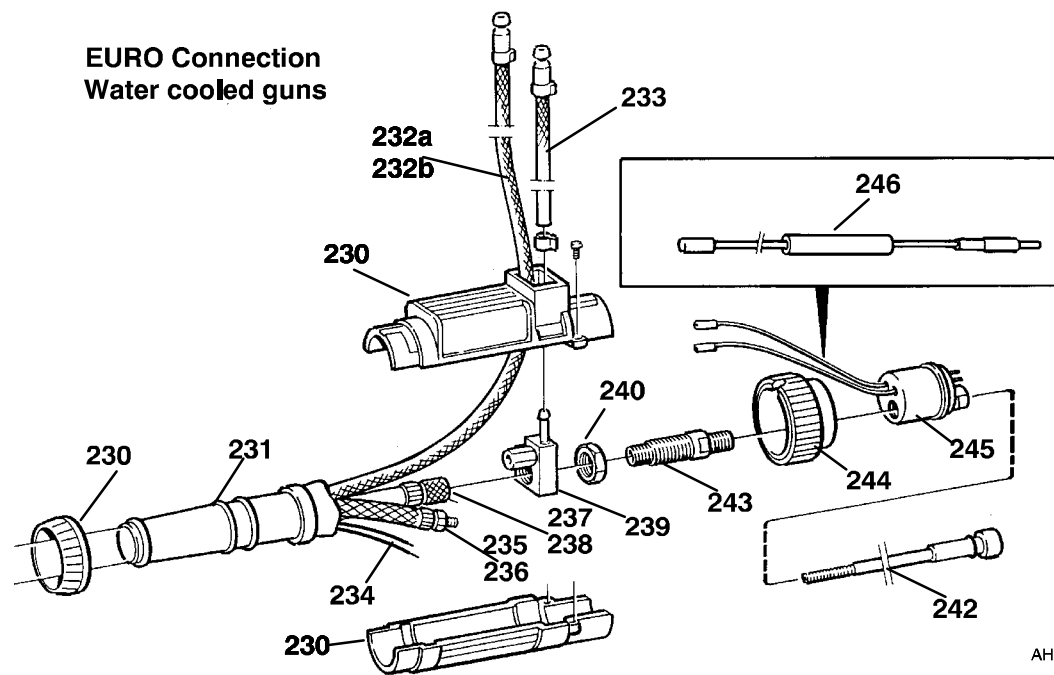


Pos	Denomination	Ordering no.	PSF 410W	PSF 510W	PSF 410W RS3	PSF 510W RS3	Notes
	<b>Welding Gun 3.0 m</b>	<b>0458 400</b>	<b>-882</b>	<b>-884</b>	<b>-898</b>	<b>-900</b>	EURO Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 400</b>	<b>-883</b>	<b>-885</b>	<b>-899</b>	<b>-901</b>	EURO Connection
	<b>Welding Gun 3.0 m</b>	<b>0458 400</b>	<b>-890</b>	<b>-892</b>			ESAB Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 400</b>	<b>-891</b>	<b>-893</b>			ESAB Connection
200	Swan neck Complete std	0458 403 881	x		x		Include 201a, 204a, 205
200	Swan neck Complete std	0458 403 882		x		x	Include 201a, 204a, 205
200	Swan neck Complete 60°	0458 403 884	x		x		Include 201a, 204a, 205
200	Swan neck Complete 60°	0458 403 885		x		x	Include 201a, 204a, 205
200	Swan neck Complete straight	0458 403 886	x		x		Include 201a, 204a, 205
200	Swan neck Complete straight	0458 403 887		x		x	Include 201a, 204a, 205
201a	Gas nozzle standard Ø16	0458 464 882	x		x		Include 202
201a	Gas nozzle standard Ø17	0458 464 883		x		x	Include 202
201b	Gas nozzle straight Ø19	0458 470 882	x		x		Include 202
201b	Gas nozzle straight Ø21	0458 470 883		x		x	Include 202
201c	Gas nozzle conical Ø14	0458 465 882	x		x		Include 202
201c	Gas nozzle conical Ø15	0458 465 883		x		x	Include 202
202	Spatter protection	0366 396 003	x		x		
202	Spatter protection	0366 396 004		x		x	
203	Contact tip see table 1-3						
204a	Adapter standard M8	0366 394 002	x	x	x	x	
204b	Adapter Helix M7	0368 311 001	x	x	x	x	
205	Insulation washer	0458 874 001	x	x	x	x	
206	Hook	0458 445 001	x	x	x	x	
207	Brass nut	0458 419 001	x	x	x	x	
208	Trigger complete	0458 810 880	x	x	x	x	Incl.spring
209	Mech. Switch	0369 611 880	x	x	x	x	
210	Screw 4 pcs (12 mm)	-	x	x	x	x	Included in 211
211	Handle spare	0458 440 881	x	x	x	x	Incl 210, 213 and 218
212	Remote switch, compl	0458 420 880			x	x	
213	Blind cover	-	x	x			Included in 211
214	Squeeze ring	0458 446 001	x	x	x	x	
215	Swivel	0458 443 001	x	x	x	x	
216	Support spring	0458 444 001	x	x	x	x	
217	Mosscap	0458 199 001	x	x	x	x	
218	Pin	-	x	x	x	x	Included in 211





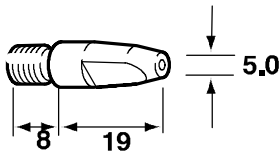
Pos	Denomination	Ordering no.	PSF 410W	PSF 510W	PSF 410W RS3	PSF 510W RS3	Notes
	<b>Welding Gun 3.0 m</b>	<b>0458 400</b>	<b>-882</b>	<b>-884</b>	<b>-898</b>	<b>-900</b>	EURO Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 400</b>	<b>-883</b>	<b>-885</b>	<b>-899</b>	<b>-901</b>	EURO Connection
	<b>Welding Gun 3.0 m</b>	<b>0458 400</b>	<b>-890</b>	<b>-892</b>			ESAB Connection
	<b>Welding Gun 4.5 m</b>	<b>0458 400</b>	<b>-891</b>	<b>-893</b>			ESAB Connection
230	Connection sleeve	0466 850 880	x	x	x	x	
231	Support sleeve	0466 767 001	x	x	x	x	
232a	Hose return 3.0 m	0455 285 880	x	x	x	x	
232b	Hose return 4.5 m	0455 285 881	x	x	x	x	
233	Hose	0455 418 880	x	x	x	x	
234	Cable (length has to be ordered)	0262 612 802	x	x	x	x	
235	Current cable 3.0 m	0458 416 882	x	x	x	x	Welding gun 3.0 m
236	Current cable 4.5 m	0458 416 883	x	x	x	x	Welding gun 4.5 m
237	Support hose 3 m	0466 556 882	x	x	x	x	Welding gun 3.0 m
238	Support hose 4.5 m	0466 556 883	x	x	x	x	Welding gun 4.5 m
239	Connection block	0458 262 880	x	x	x	x	
240	Nut M14x1.25	0468 398 001	x	x	x	x	
241	Connection tube	0369 705 881	x	x	-	-	
242	Liner See table on page						
243	Connection tube	0458 263 001	x	x	x	x	
244	Nut plastic	0369 401 880	x	x	x	x	
245	Connection block	0457 910 880	x	x	x	x	
246	Contact pin	0467 582 880	x	x	x	x	



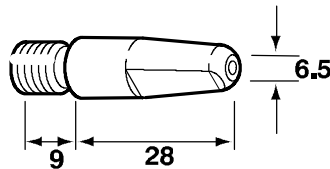
## Contact tip

The bore dimension of the contact tips is to be selected with regard to wire diameter, type of shielding gas and actual intensity of the current - we refer to the table below.

### Standard M6



### Standard M8

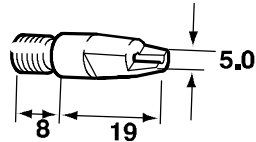


To start with, choose a contact nozzle as specified in the shortarc-table (CO<sub>2</sub>). Should binding occur with high parameters when using Argon or gas mixture, choose contact nozzle from the sprayarc-table.

Welding electrode			Contact tip		
Short arc	Spray arc	Short/Spray-arc	Part Number		Marked
			M 6 PSF 305, 405, 505, 410W, 510W	M 8 PSF 305, 405, 505, 410W, 510W	
0.6	(0.6)	-	0468 500 001	-	W0.6 ESAB
(0.8)	0.6	0.8	0468 500 002	0468 502 002	W0.8 ESAB
0.8	(0.8)	0.9	0468 500 003	0468 502 003	W0.8 ESAB
0.9	0.8	1.0	0468 500 004	0468 502 004	W0.9 ESAB
1.0	0.9	-	0468 500 005	0468 502 005	W1.0 ESAB
1.1	(1.0)	1.2	0468 500 006	0468 502 006	W1.2 ESAB
1.2	1.0-1.1	-	0468 500 007	0468 502 007	W1.2 ESAB
1.4	1.2	1,4	0468 500 008	0468 502 008	W1.4 ESAB
1.6	1.4	1,6	0468 500 009	0468 502 009	W1.6 ESAB
(1.6)	1.6	-	0468 500 010	0468 502 010	W1.6 ESAB
2.0	2.0	-	-	0468 502 011	W2.0 ESAB
2.4	2.4	-	-	0468 502 012	W2.4 ESAB

Table 1

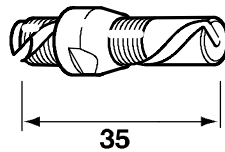
### Nib contact tip M6



Improved contact at low current.

Welding electrode			Contact tip	
Short arc	Spray arc	Short/Spray arc	Part number	
			M6 PSF 305, 405, 505 PSF 410W, 510W	
0.6	0.6	-	0468 501 001	W0.6 08
0.8	-	0.8	0468 501 002	W0.8 10
0.9	0.8	0.9	0468 501 003	W0.9 11
1.0	0.9	1.0	0468 501 004	W1.0 12
1.2	1.0	1.2	0468 501 005	W1.2 15
1.4	1.2	1.4	0468 501 005	W1.4 17
1.6	1.4	1.6	0468 501 007	W1.6 19

Table 2



### Helix M7 / M8

Helix M7 contact tip must be combined with special tip adapter. See spare parts list .

Welding electrode			Contact tip	
Short arc	Spray arc	Short/Spray arc	Ordering number	
			M7 HELIX	M8 HELIX
0.6	0.6	-	0368 313 880	0.6 -
0.8	-	0.8	0368 313 881	W0.8 -
0.9	0.8	0.9	0368 313 882	W0.9 -
1.0	0.9	1.0	0368 313 883	0368 313 983 W1.0 -
1.2	1.0	1.2	0368 313 884	0368 313 984 W1.2 -
1.4	1.2	1.4	0368 313 885	W1.4 -
1.6	1.4	1.6	0368 313 886	W1.6 -

Table 3

## Wire feed conduit

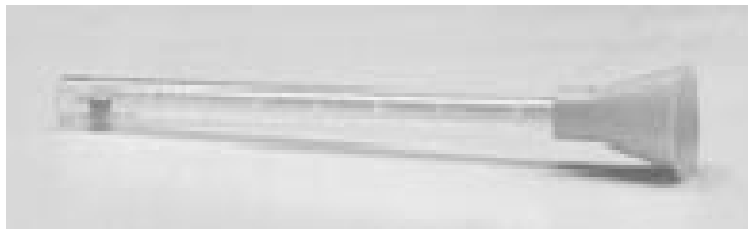
Welding electrode *)	Teflon conduit incl. wear insert (steel)		Wear insert separate		Steel spiral		Teflon ceramic liner**)	
	PSF 305, 405, 505, 410W, 510W				PSF 305, 405, 505, 410W, 510W		PSF 305, 405, 505, 410W, 510W	
	3 m	4.5 m	Steel	Teflon (Al)	3 m	4.5 m	3 m	4.5 m
0.6 mm	0366 550 880	0366 550 881	0366 545 880	0368 742 880	0366 549 882	0366 549 883	0457 969 880	0457 969 881
0.8 mm	0366 550 882	0366 550 883	0366 545 880	0368 742 880	0366 549 882	0366 549 883	0457 969 880	0457 969 881
0.9-1.0 mm	0366 550 884	0366 550 885	0366 545 881	0368 742 880	0366 549 884	0366 549 885	0457 969 882	0457 969 883
1.2 mm	0366 550 886	0366 550 887	0366 545 882	0368 742 883	0366 549 886	0366 549 887	0457 969 882	0457 969 883
1.4 mm	0366 550 888	0366 550 889	0366 545 883	0368 742 881	0366 549 888	0366 549 889	0457 969 884	0457 969 885
1.6 mm	0366 550 890	0366 550 891	0366 545 884	0368 742 881	0366 549 890	0366 549 891	0457 969 884	0457 969 885

\*) The wire guide aperture = 1.5 x wire diameter. The wire guide is marked with the max. wire diameter (stamped on the nipple).  
 \*\*) No wear insert needed.

Table 4

## Gasflow meter

To measure the current gas flow a gasflow meter is available as option with ordering number 0155 716 880.



## MIG gun holder

Practical holder with strong magnetic foot available as option with ordering number 0760 022 300.





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*For addresses and phone numbers to our distributors in other countries, please visit our home page*

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