

- PSF™ 250***
- PSF™ 250C***
- PSF™ 305***
- PSF™ 315C LD***
- PSF™ 405***
- PSF™ 405 RS3***
- PSF™ 405C***
- PSF™ 405C RS3***
- PSF™ 410w***
- PSF™ 410w RS3***
- PSF™ 410Cw***
- PSF™ 410Cw RS3***
- PSF™ 505***
- PSF™ 510w***
- PSF™ 510w RS3***



Instruction manual



DECLARATION OF CONFORMITY

According to

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

Type of equipment

Welding Torches for MIG and MAG welding

Type designation etc.

PSF 250, PSF 250C, PSF 305, PSF 315C LD, PSF 405, PSF 405 RS3, PSF 405C, PSF 405C RS3, PSF 410w, PSF 410w RS3, PSF 410Cw, PSF 410Cw RS3, PSF 505, PSF 510w, PSF 510w RS3

Brand name or trade mark

ESAB

Manufacturer or his authorised representative established within the EEA

Name, address, telephone No, telefax No:

ESAB AB, Welding Equipment
Esabvägen, SE-695 81 LAXÅ, Sweden
Phone: +46 584 81 000, Fax: +46 584 411 924

The following harmonised standard in force within the EEA has been used in the design:

EN 60974-7, Arc welding equipment – Part 7: Torches

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 authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.

Date
Laxå 2007-03-08

Signature

A handwritten signature in dark ink, appearing to read "Kent Eimbrodt". The signature is written in a cursive style with some loops and flourishes.

Kent Eimbrodt
Clarification

Position
Global Director
Equipment and Automation

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1 SAFETY



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

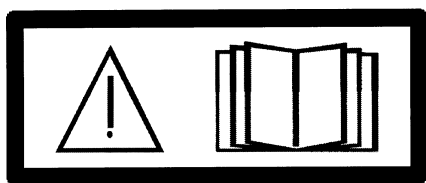
- Protect your ears. Use earmuffs or other hearing protection.
- Warn bystanders of the risk.

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

Read and understand the instruction manual before installing or operating.

PROTECT YOURSELF AND OTHERS!

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



Read the instruction manuals for the components included in the equipment!

2 INTRODUCTION

PSF 250, 305, 405 and 505 form a series of self-cooling swan neck welding torches.

PSF w form a series of water-cooled swan neck welding torches.

PSF RS3 welding torches are equipped with program selectors for switching between preset programs. (Programs are preset at the welding power source.)

PSF C form a series of welding torches with smoke exhausters. The welding torches are available with either self-cooling or water cooling systems and are of a swan-neck design.

PSF LD is a smaller welding torch.



This welding torch is available in a variety of types; for more information see the ordering number on page 13.

A range of accessories including welding tips, swan necks and contact tips are also available.

Details of ESAB's welding torch accessories can be found on page 22.

3 SHIPMENT AND PACKAGING

The components are carefully checked and packaged, however, damage may occur during shipping.

Checking procedure on receipt of goods

- Check that the shipment is correct by referring to the shipping note.

In case of damage

- Check the package and components for damage (visual inspection).

In case of complaints

If the package and/or components have been damaged during shipment:

- Contact the last carrier immediately
- Keep the packaging (for possible inspection by the carrier or supplier, or for returning the goods).

Storage in an enclosed space

Ambient temperature

- for shipment and storage: -25 °C to + 55 °C

Relative air humidity: up to 90 % at a temperature of 20 °C

4 TECHNICAL DATA

General torch data with reference to IEC/EN 60974-7	
Type of voltage:	DC voltage
Wire type:	Standard round wire
Voltage measurement:	Peak value of 113V
Connection protection Machine side (EN 60 529):	IP3X
Shielding gas:	CO ₂ or Ar/CO ₂

Enclosure class

The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects of 2,5 mm Ø and greater.

Welding torch	PSF 250	PSF 305	PSF 405, 405 RS3	PSF 505	PSF 410w, 410w RS3	PSF 510w, 510w RS3
Permitted load at 60% duty cycle						
Carbon dioxide CO ₂	250 A	315 A	380 A	475 A	-	-
Mixed gas, Argon (Al wire)	225 A	285 A	325 A	410 A	-	-
Permitted load at 100% duty cycle						
Carbon dioxide CO ₂	-	-	-	-	400 A	500 A
Mixed gas, Argon (Al wire)	-	-	-	-	350 A	440 A
Recommended gas flow	8-13 l/min	10-15 l/min	11-16 l/min	12-18 l/min	11-16 l/min	12-18 l/min
Wire diameter	0.6-1.0 mm	0.8-1.2 mm	0.8-1.6 mm	1.0-2.4 mm	0.8-1.6 mm	1.0-2.4 mm
Weight 3.0 m hose package	1.8 kg	2.5 kg	3.1 kg	3.9 kg	3.0 kg	3.3 kg
Weight 4.5 m hose package	2.5 kg	3.3 kg	4.2 kg	5.3 kg	3.9 kg	4.0 kg

Welding torch	PSF 250C	PSF 315C LD	PSF 405C, PSF 405C RS3	PSF 410Cw, 410Cw RS3
Permitted load at 60% duty cycle				
Carbon dioxide CO ₂	250 A	315 A	380 A	-
Mixed gas, Argon (Al wire)	225 A	285 A	325 A	-
Permitted load at 100% duty cycle				
Carbon dioxide CO ₂	-	-	-	380 A
Mixed gas, Argon (Al wire)	-	-	-	325 A
Recommended gas flow	8-13 l/min	10-15 l/min	11-16 l/min	11-16 l/min
Wire diameter	0.6-1.0 mm	0.8-1.2 mm	1.0-1.6 mm	0.8-1.6 mm
Weight 3.0 m hose package	3,5 kg	4,3 kg	4.6 kg	4.0 kg
Weight 4.5 m hose package	5,0 kg	5,4 kg	6.8 kg	6.2 kg

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.

Liquid cooled torches	PSF 410w, PSF 410w RS3, PSF 510w, PSF 510w RS3, PSF 410Cw, PSF 410Cw RS3
Type of cooling	50% water / 50% ethylglykol
Pressure max.	3.5 bar
Pressure min.	2.0 bar
Temperature, max	50 °C
Flow	1.0 l/min

5 OPERATION

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

5.1 Contact tip

The hole size of the contact tip is determined by the diameter of the wire, the type of inert gas and the level of current used. See on page 16-20.

5.2 Wire liner

The spiral steel wire liner that comes as standard with the welding torch can be used for all types of wire of the intended size with exception of aluminium.

PTFE-wire liners are suitable for welding with all types of wires (Al, Ss, and Fe).

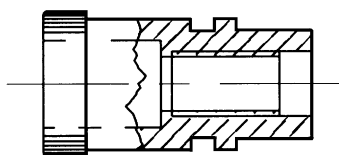
However, it is recommended that PTFE-wire liners are not used when welding using Fe and CW wires that are thicker than 1.2 mm due to the increased instance of wear.

PTFE-wire liners have a considerably shorter life than the standard steel spiral.

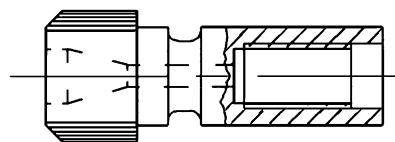
In order to ensure that you enjoy a satisfactory level of wire feed, select a wire liner on page 21.

5.3 Replacing the wire liner

1. Fit the correct nipple



ESAB Connection



EURO Connection

NB Each wire guide is supplied with 2 nipples, 1 for ESAB connection and 1 for EURO connection.

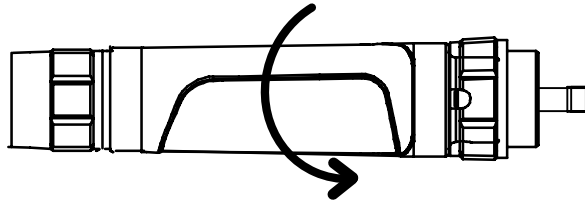
2. Remove the gas nozzle and tip adaptor.
3. Fit the wire liner in the hose package.
4. Cut the wire guide to the correct length

During cutting, the welding torch must be extended with the wire guide fully inserted into the rear connector.

Cut the wire guide using a projectile "X" as shown on the page 12.

Remove sharp edges inside the liner after cutting.

5. Re-fit the tip adaptor and gas nozzle
6. Fit the welding torch on the machine.



- a) Turn the connecting section counterclockwise until resistance is met
- b) The wire guide should go in

5.4 Gas nozzle

There is a spatter protector fitted inside the gas nozzle. This must be in position during welding in order to prevent the welding spatter jamming and thereby causing a short circuit in the swan neck.

Gas nozzles with larger and smaller openings are available as accessories for each type of welding torch. See on page 16-20.

5.5 Gas protection

Several factors come into play for good gas protection. The most important ones are:

1. Selection of shielding gas
 - Mixed gas and Argon require a greater flow than carbon dioxide
2. Set flow quantity
 - See Technical data (to be measured at the gas nozzle).
3. Set welding current
 - High welding currents require greater gas flows.
4. Position of welding joint
 - A vertical position requires greater gas flow
5. Type of welding joint
 - External corner joints require a greater gas flow than butt joints. Conversely, fillet joints require a lower gas flow.
6. Smoke evacuation on welding torch
 - Using smoke evacuation increases the need for inert gas by 10-12%
7. Angle of welding torch to the job.
 - Angling the welding torch at less than 45° may result in poor gas protection.

5.6 Gas flow meter

A gas flow meter to measure gas flow through the welding torch is available as an accessory see on page 22.

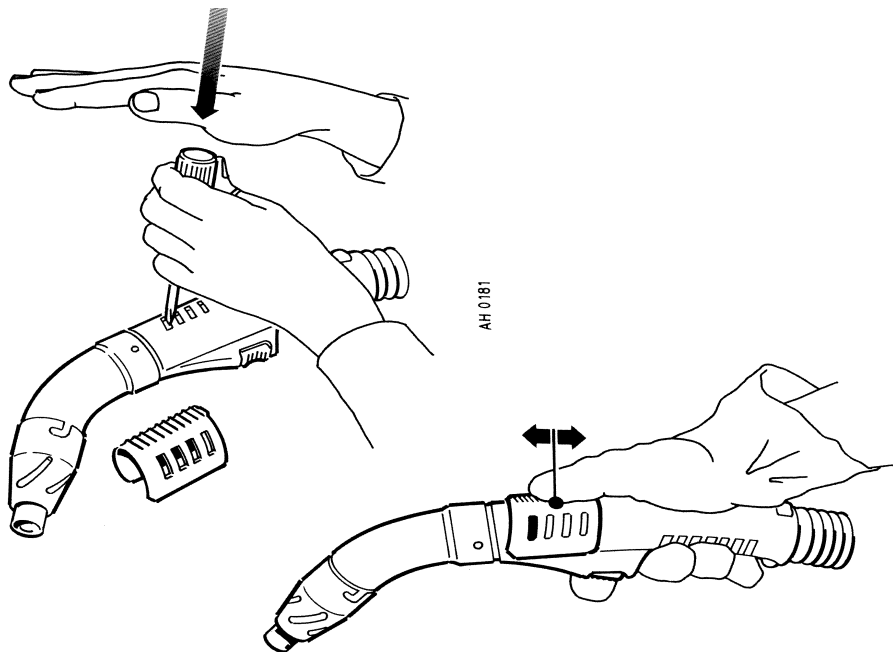
5.7 Centrovac

Integrated smoke evacuation

You can tailor the level of suction by opening the damper on the topside of the handle.

PSF 250C/PSF 315C LD

When welding in narrow positions it may be necessary to reduce the suction. This can be achieved by opening the slots as shown below.



Suction source for welding torches with integrated smoke evacuation

In order to achieve full suction power, the smoke evacuation welding torch must be connected to a suction source where pressure does not fall below 15 kPa.

6 MAINTENANCE

Regular maintenance is important for safe, reliable operation.



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.

6.1 Daily or as necessary

A regular programme of care and maintenance reduces unnecessary and expensive downtime.

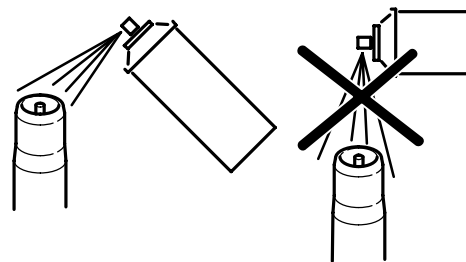
- Each time an wire bobbin is changed, the welding hose should be removed from the supply unit and blown clean with compressed air.
- The wire end must not have sharp edges when inserted into the wire liner. This is especially important when using PTFE wire liners.

Tips and nozzles

- Remove the gas nozzle, spatter protector, tip adaptor and contact tip.
- Clean any spatter from the gas nozzle, tip adaptor and contact tip so that the shielding gas can flow freely, thus eliminating the risk of a short circuit.
- Check that the gas nozzle is free from defects. Damaged or worn tips/nozzles should be replaced with a new one.
- The spatter protector in the gas nozzle must be replaced once its front end wears thin.
- Select contact tip to suit wire dimension.
- Mount the fittings.
- Welding spray in the gas nozzle diminishes gas protection and increases the danger of spark-over.
Clean the equipment on a regular basis and use sparing amounts of welding paste or welding spray.

- The gas nozzle and the front parts of the welding torch must be kept free of weld spatter. Spray anti-spatter agent at an angle into the gas nozzle from two directions. Use ESAB anti-spatter agent to prevent spatter sticking.

Note! Never spray directly into the nozzle. Too much spray can attract dirt.



- The contact tip should be replaced when the hole opening is worn to more than double the wire diameter. Make sure that the new tip is screwed into the base.

6.2 Centrovac

Cleaning welding torches with integrated smoke evacuation

In order to maintain a constant level of suction, the inside of the welding torch handle should be cleaned on a regular basis. The appropriate length of time between cleans is dependant on how often the equipment is used and the amount of dust and oil contained in the welding smoke.

7 FAULT-TRACING

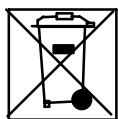
Please also read the operating instructions for the welding components, e.g. power source and wire feed unit.

If the measures described below are not successful, please consult your dealer or the manufacturer.

Problem	Cause	Solution
Welding torch becomes too hot	<ul style="list-style-type: none"> • Contact tip is not tight enough. • Electrical connections to the welding torch and to the workpiece are loose. 	<ul style="list-style-type: none"> • Check and tighten. • Check and tighten.
No trigger function	<ul style="list-style-type: none"> • Control cable interrupted/faulty. 	<ul style="list-style-type: none"> • Check/repair.

Problem	Cause	Solution
Wire burnt back onto the contact tip at stop	<ul style="list-style-type: none"> • Wrong burn back time set. • Worn contact tip. 	<ul style="list-style-type: none"> • Decrease the burn back time. • Replace.
Irregular wire feed	<ul style="list-style-type: none"> • Liner blocked. • Contact tip and wire diameter do not match. • Wrong tension set on the wire feed unit. 	<ul style="list-style-type: none"> • Blow through in both directions. • Replace contact tip. • Correct according to manufacturer's instructions.
Short arc between the gas nozzle and workpiece	<ul style="list-style-type: none"> • Spatter bridge between the contact tip and gas nozzle. 	<ul style="list-style-type: none"> • Clean and spray the inside of the gas nozzle.
Variable arc	<ul style="list-style-type: none"> • Contact tip is worn or does not match the wire diameter. • Incorrect welding parameters set. • Liner worn. 	<ul style="list-style-type: none"> • Check/replace the contact tip • Correct the welding parameters. • Replace the wire liner.
Porous welds	<ul style="list-style-type: none"> • Large amount of spatter in the gas nozzle. • Insufficient or total lack of shielding gas. • Draught is disturbing the shielding gas. 	<ul style="list-style-type: none"> • Clean the gas nozzle. • Check contents of the gas bottle/hoses and the pressure setting. • Shield welding area with protective screens.

8 DISASSEMBLY AND DISPOSAL



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.

The welding torch system is mainly made from steel, plastics and non-ferrous metal and must be disposed of in compliance with local environmental regulations. The disposal of coolant is also subject to local requirements.

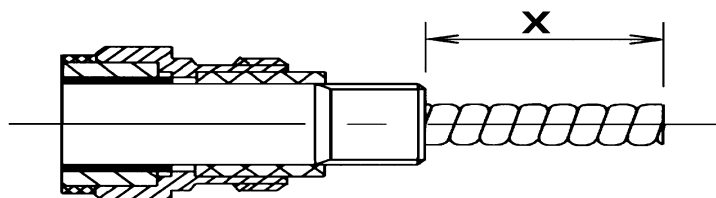
9 ORDERING OF SPARE PARTS

PSF 250/305/405/505/405 RS3, PSF 410w/510w/410w RS3/510w RS3, PSF 250C/315C LD/405C/405C RS3/410Cw, 410Cw RS3 is designed and tested in accordance with the international and European standards EN 60974-7 and IEC/EN 60974-7 . 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.

Cutting length

Welding torch	Length	Adapter	Size X	Helix	Size X
PSF™ 250	3.0 m	0366 314 001	21 mm	0368 310 001	14 mm
PSF™ 250	4.5 m	0366 314 001	25 mm	0368 310 001	18 mm
PSF™ 305	3.0 m	0366 394 001	24 mm	0368 311 001	20 mm
PSF™ 305	4.5 m	0366 394 001	27 mm	0368 311 001	23 mm
PSF™ 405/405 RS3	3.0 m	0366 394 002	17 mm	0368 311 001	20 mm
PSF™ 405/405 RS3	4.5 m	0366 394 002	20 mm	0368 311 001	23 mm
PSF™ 505	3.0 m	0366 395 001	21 mm	0368 312 001	20 mm
PSF™ 505	4.5 m	0366 395 001	24 mm	0368 312 001	23 mm
PSF™ 410w/410w RS3	3.0 m	0366 394 002	23 mm	0368 311 001	26 mm
PSF™ 410w/410w RS3	4.5 m	0366 394 002	32 mm	0368 311 001	35 mm
PSF™ 510w/510w RS3	3.0 m	0366 394 002	23 mm	0368 311 001	26 mm
PSF™ 510w/510w RS3	4.5 m	0366 394 002	32 mm	0368 311 001	35 mm
PSF™ 250C	3.0 m	0366 314 001	21 mm	0368 310 001	14 mm
PSF™ 250C	4.5 m	0366 314 001	25 mm	0368 310 001	18 mm
PSF™ 315C LD	3,0 m	0366 394 001	24 mm	0366 311 001	20 mm
PSF™ 315C LD	4,5 m	0366 394 001	27 mm	0366 311 001	23 mm
PSF™ 405C	3.0 m	0366 394 002	17 mm	0368 311 001	20 mm
PSF™ 405C	4.5 m	0366 394 002	20 mm	0368 311 001	23 mm
PSF™ 410Cw/410Cw RS3	3.0 m	0366 394 002	23 mm	0366 311 001	26 mm
PSF™ 410Cw/410Cw RS3	4.5 m	0366 394 002	32 mm	0366 311 001	35 mm



PSF™ Welding torches

Ordering number



Order Nos	Type	Description
0368 100 882	PSF™ 250	Welding torch 3.0 m
0368 100 883	PSF™ 250	Welding torch 4.5 m
0458 401 880	PSF™ 305	Welding torch 3.0 m
0458 401 881	PSF™ 305	Welding torch 4.5 m
0458 401 882	PSF™ 405	Welding torch 3.0 m
0458 401 883	PSF™ 405	Welding torch 4.5 m
0458 401 884	PSF™ 505	Welding torch 3.0 m
0458 401 885	PSF™ 505	Welding torch 4.5 m
0458 401 893	PSF™ 405 RS3	Welding torch 4.5 m
0459 694 990	Spare Parts Catalogue	

Order Nos	Type	Description
0458 400 882	PSF™ 410w	Welding torch 3.0 m
0458 400 883	PSF™ 410w	Welding torch 4.5 m
0458 400 884	PSF™ 510w	Welding torch 3.0 m
0458 400 885	PSF™ 510w	Welding torch 4.5 m
0458 400 898	PSF™ 410w RS3	Welding torch 3.0 m
0458 400 899	PSF™ 410w RS3	Welding torch 4.5 m
0458 400 900	PSF™ 510w RS3	Welding torch 3.0 m
0458 400 901	PSF™ 510w RS3	Welding torch 4.5 m
0459 694 990	Spare Parts Catalogue	

The spare parts list is available on the Internet at www.esab.com

PSF™ Welding torches

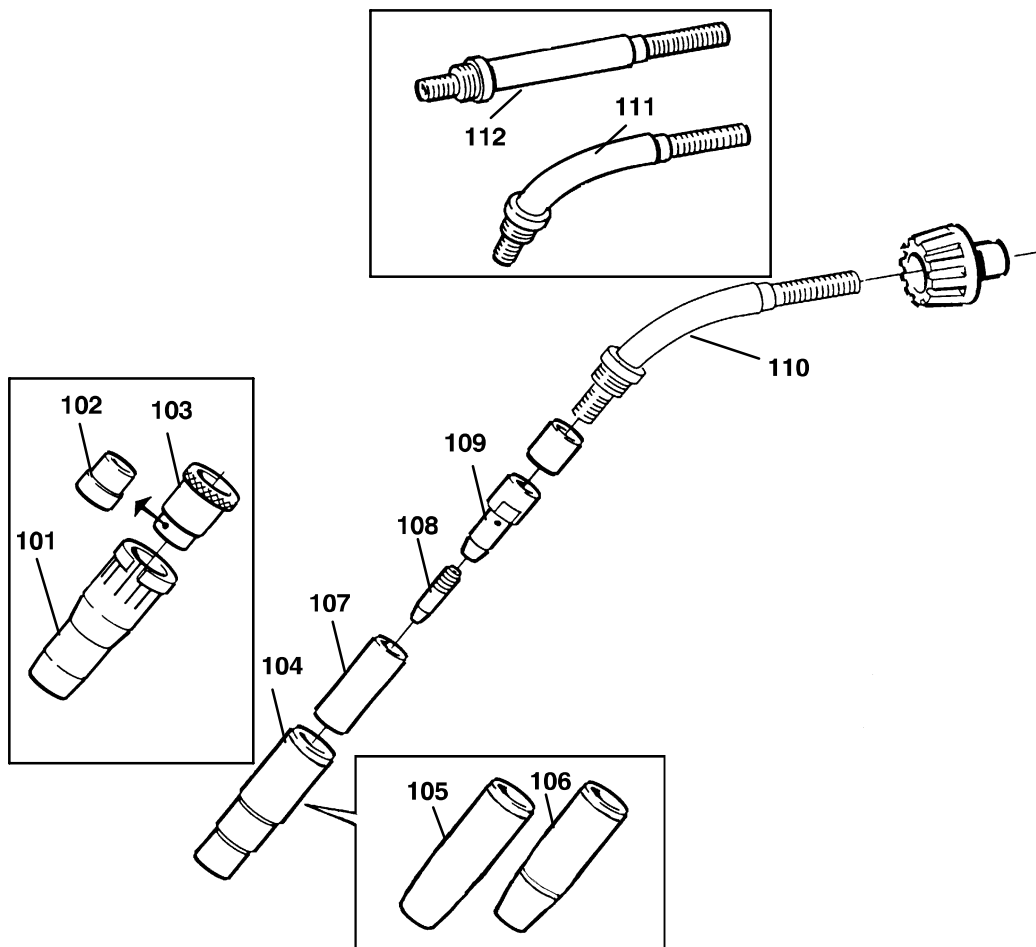


Order Nos	Type	Description
0468 410 882	PSF™ 250C	Welding torch 3.0 m
0468 410 883	PSF™ 250C	Welding torch 4.5 m
0468 410 885	PSF™ 315C LD	Welding torch 3.0 m
0468 410 886	PSF™ 315C LD	Welding torch 4.5 m
0458 499 882	PSF™ 405C	Welding torch 3.0 m
0458 499 883	PSF™ 405C	Welding torch 4.5 m
0458 450 880	PSF™ 410Cw	Welding torch 3.0 m
0458 450 881	PSF™ 410Cw	Welding torch 4.5 m
0458 450 884	PSF™ 410Cw RS3	Welding torch 3.0 m
0458 450 885	PSF™ 410Cw RS3	Welding torch 4.5 m
0459 694 990	Spare Parts Catalogue	

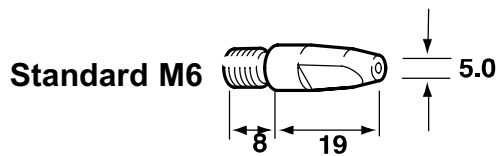
The spare parts list is available on the Internet at www.esab.com

Wear parts

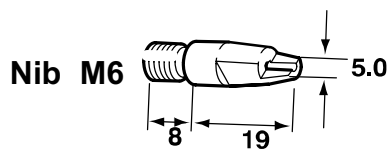
Item	Denomination	Ordering number	Notes
101	Gas Nozzle "slip-on"	0469 752 880	
102	Spatter protection "slip-on"	0469 538 001	
103	Cooling sleeve	0469 756 880	
104	Gas nozzle	0458 464 881	Standard
105	Gas nozzle	0458 470 881	Straight
106	Gas nozzle	0458 465 881	Conical
107	Spatter protection	0458 471 003	
108	Contact tip		See table on page 16.
109	Tip adaptor M6	0366 314 001	Standard
	Tip adaptor M7	0368 310 001	Helix
110	Swan neck complete	0366 315 880	Standard
111	Swan neck complete	0467 985 880	60°
112	Swan neck complete	0366 329 880	Straight



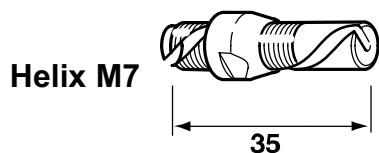
Contact tips



Shielding gas / Welding wire Ø		Contact tip M 6	
CO ₂	Mix / Ar		
0.6	-	0468 500 001	W0.6 0.8
-	0.6	0468 500 002	W0.8 0.9
0.8	-	0468 500 003	W0.8 1.0
0.9	0.8	0468 500 004	W0.9 1.1
1.0	0.9	0468 500 005	W1.0 1.2
1.2	-	0468 500 006	W1.2 1.4
1.2	1.0	0468 500 007	W1.2 1.5



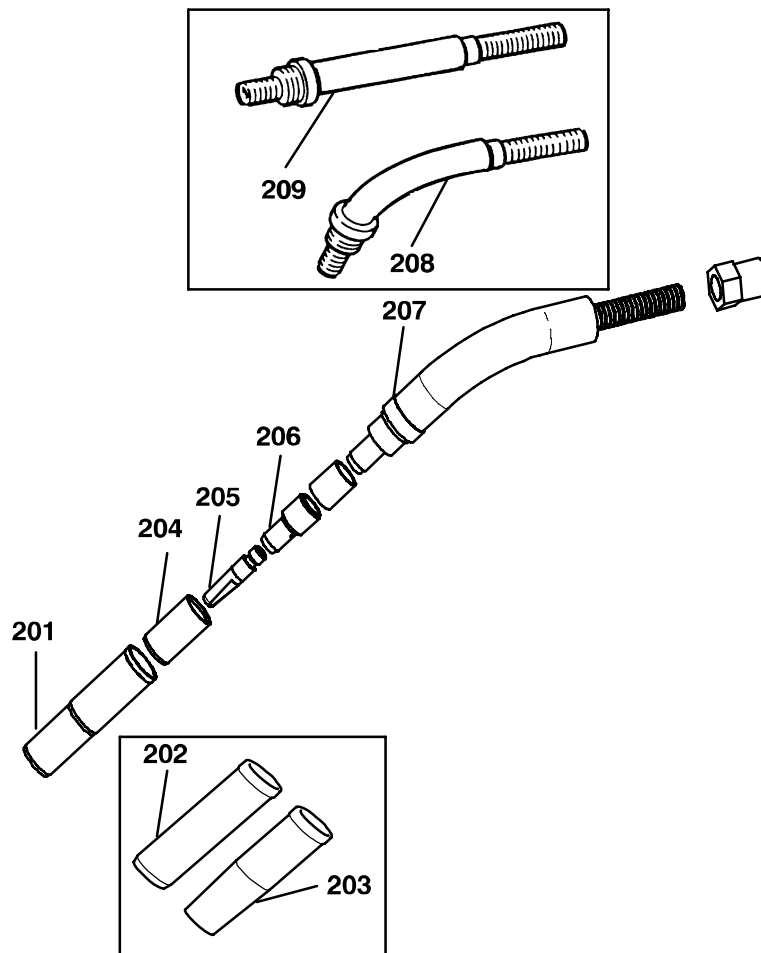
Shielding gas / Welding wire Ø		Contact tip M 6	
CO ₂	Mix / Ar		
0.6	-	0468 501 001	W0.6 0.8
-	0.6	0468 501 002	W0.8 1.0
0.8	-	0468 501 003	W0.9 1.1
0.9	0.8	0468 501 004	W1.0 1.2
1.0	0.9	0468 501 005	W1.2 1.5
1.2	-	0468 501 006	W1.4 1.7
1.2	1.0	0468 501 007	W1.6 1.9



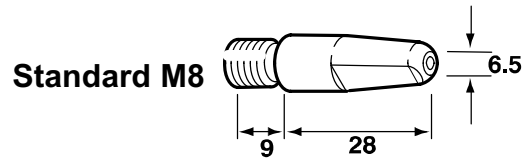
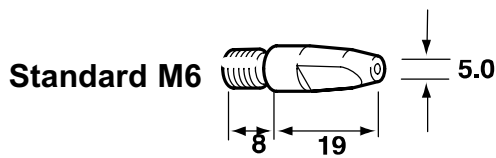
Shielding gas / Welding wire Ø		Contact tip M 7	
CO ₂	Mix / Ar		
0.6	-	0468 313 880	W0.6
-	0.6	0468 313 881	W0.8
0.8	-	0468 313 882	W0.9
0.9	0.8	0468 313 883	W1.0
1.0	0.9	0468 313 884	W1.2
1.2	-	0468 313 885	W1.4
1.2	1.0	0468 313 886	W1.6

PSF™ 305, PSF™ 405, PSF™ 505, PSF™ 410w, PSF™ 510w

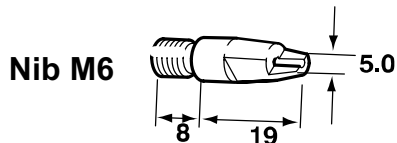
Item	Denomination	PSF 305, PSF 410w	PSF 405, PSF 510w	PSF 505	Notes
201	Gas nozzle	0458 464 882	0458 464 883	0458 464 884	Standard
202	Gas nozzle	0458 470 882	0458 470 883	0458 470 884	Straight
203	Gas nozzle	0458 465 882	0458 465 883	0458 465 884	Conical
204	Spatter protection	0458 471 003	0458 471 004	0458 471 005	
205	Contact tip				See table on page 18.
206	Tip adaptor M6	0366 394 001	0366 394 001	-	Standard
	Tip adaptor M8	0460 819 001	0460 819 001	0366 395 001	Standard
	Tip adaptor M7	0368 311 001	0368 311 001	0368 312 001	Helix
207	Swan neck	0366 388 880	0366 389 880	0366 390 880	Standard
	Swan neck water	0458 403 881	0458 403 882	-	Standard
208	Swan neck	0467 988 881	0467 988 880	0467 989 880	60°
	Swan neck water	0458 403 884	0458 403 885	-	
209	Swan neck	0469 333 880	0469 334 880	0469 335 880	Straight
	Swan neck water	0458 403 886	0458 403 887	-	



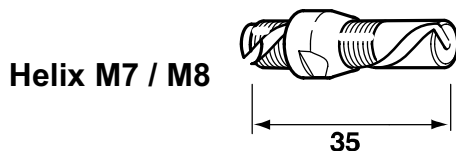
Contact tips



Gas / wire Ø		PSF 305, PSF 410w		PSF 405, PSF 510w		PSF 505		
CO ₂	Mix / Ar	M 6	M 8	M 6	M 8	M 8	M 6	M 8
0.6	-	0468 500 001	-	0468 500 001	-	-	W0.6 0.8	-
-	0.6	0468 500 002	-	0468 500 002	-	-	W0.8 0.9	-
0.8	-	0468 500 003	0468 502 003	0468 500 003	0468 502 003	0468 502 003	W0.8 1.0	W0.8 1.0
0.9	0.8	0468 500 004	0468 502 004	0468 500 004	0468 502 004	0468 502 004	W0.9 1.1	W1.0 1.1
1.0	0.9	0468 500 005	0468 502 005	0468 500 005	0468 502 005	0468 502 005	W1.0 1.2	W1.0 1.2
1.2	-	0468 500 006	0468 502 006	0468 500 006	0468 502 006	0468 502 006	W1.2 1.4	W1.2 1.4
1.2	1.0	0468 500 007	0468 502 007	0468 500 007	0468 502 007	0468 502 007	W1.2 1.5	W1.2 1.5
1.4	1.2	0468 500 008	0468 502 008	0468 500 008	0468 502 008	0468 502 008	W1.4 1.7	W1.4 1.7
1.6	-	0468 500 009	0468 502 009	0468 500 009	0468 502 009	0468 502 009	W1.6 1.9	W1.6 1.9
-	1.6	0468 500 010	0468 502 010	0468 500 010	0468 502 010	0468 502 010	W1.6 2.1	W1.6 2.1
2.0	2.0	-	-	-	0468 502 011	0468 502 011	-	W2.0 2.4
2.4	2.4	-	-	-	0468 502 012	0468 502 012	-	W2.4 2.8



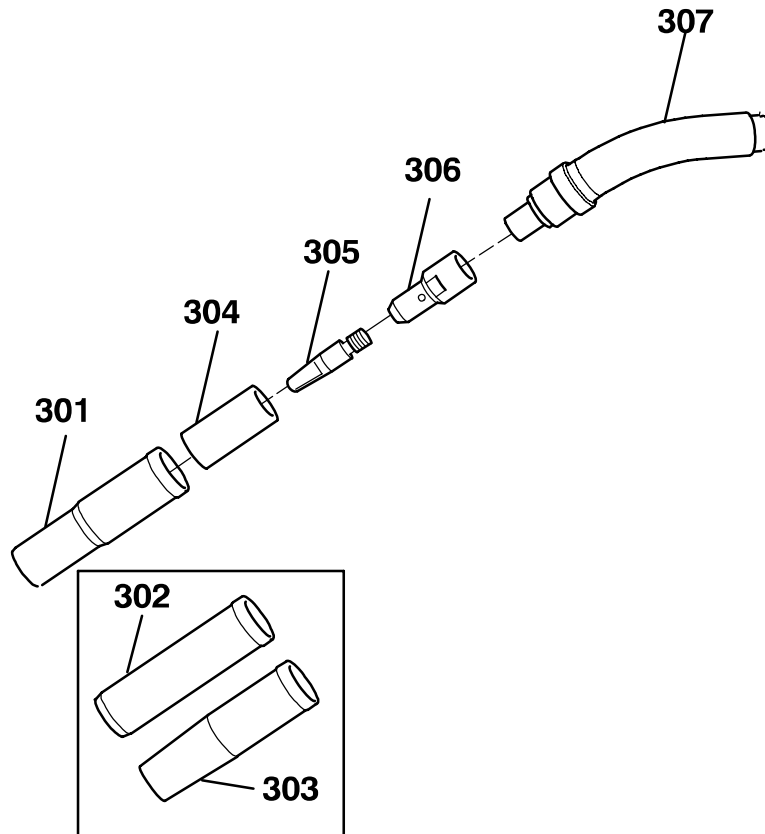
Shielding gas / Welding wire Ø		Contact nozzle		
CO ₂	Mix / Ar	M 6		
0.6	-	0468 501 001	W0.6	0.8
-	0.6	0468 501 002	W0.8	1.0
0.8	-	0468 501 003	W0.9	1.1
0.9	0.8	0468 501 004	W1.0	1.2
1.0	0.9	0468 501 005	W1.2	1.5
1.2	-	0468 501 006	W1.4	1.7
1.2	1.0	0468 501 007	W1.6	1.9



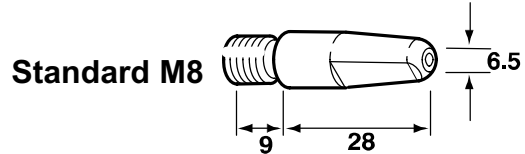
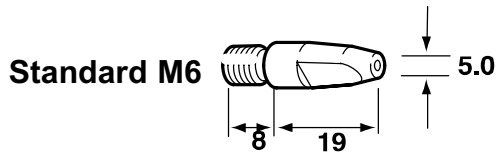
Shielding gas / Welding wire Ø		Contact nozzle			
CO ₂	Mix / Ar	M 7	M 8		
0.6	-	0468 313 880	-	W0.6	
-	0.6	0468 313 881	-	W0.8	
0.8	-	0468 313 882	-	W0.9	
0.9	0.8	0468 313 883	0368 313 983	W1.0	
1.0	0.9	0468 313 884	0368 313 984	W1.2	
1.2	-	0468 313 885	-	W1.4	
1.2	1.0	0468 313 886	-	W1.6	

PSF™ 250C, PSF™ 315C LD, PSF™ 405C, PSF™ 410Cw

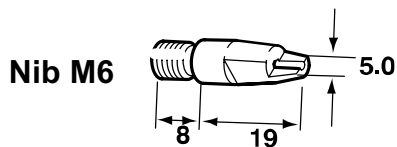
Item	Denomination	PSF 250C	PSF 315C LD	PSF 405C	PSF 410Cw	Notes
301	Gas nozzle	0458 464 881	0458 464 882	0458 464 883	0458 464 882	Standard
302	Gas nozzle	0458 470 881	0458 470 882	0458 470 883	0458 470 882	Straight
303	Gas nozzle	0458 465 881	0458 465 882	0458 465 883	0458 465 882	Conical
304	Spatter protection	0458 471 002	0458 471 003	0458 471 004	0458 471 003	
305	Contact tip					See table on page 20.
306	Tip adaptor M6	0366 314 001	0366 394 001	0366 394 001	0366 394 001	Standard
	Tip adaptor M8	-	0460 819 001	0460 819 001	0460 819 001	Standard
	Tip adaptor M7	0368 310 001	0368 311 001	0368 311 001	0368 311 001	Helix
	Tip adaptor M8	-	0460 819 001	0460 819 001	0460 819 001	Helix
307	Swan neck	0366 315 880	0457 862 880	0459 763 880	0458 487 880	



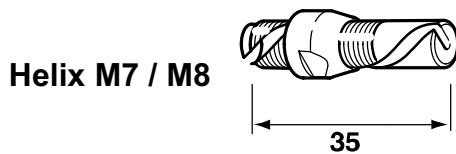
Contact tips



Gas / wire Ø		PSF 250C	PSF 315 C LD	PSF 405C		PSF 410Cw			
CO ₂	Mix / Ar	M 6	M 6	M 6	M 8	M 6	M 8	M 6	M 8
0.6	-	0468 500 001	0468 500 001	0468 500 001	-	0468 500 001	-	W0.6 0.8	-
-	0.6	0468 500 002	0468 500 002	0468 500 002	-	0468 500 002	-	W0.8 0.9	-
0.8	-	0468 500 003	0468 500 003	0468 500 003	0468 502 003	0468 500 003	0468 502 003	W0.8 1.0	W0.8 1.0
0.9	0.8	0468 500 004	0468 500 004	0468 500 004	0468 502 004	0468 500 004	0468 502 004	W0.9 1.1	W1.0 1.1
1.0	0.9	0468 500 005	0468 500 005	0468 500 005	0468 502 005	0468 500 005	0468 502 005	W1.0 1.2	W1.0 1.2
1.2	-	0468 500 006	0468 500 006	0468 500 006	0468 502 006	0468 500 006	0468 502 006	W1.2 1.4	W1.2 1.4
1.2	1.0	0468 500 007	0468 500 007	0468 500 007	0468 502 007	0468 500 007	0468 502 007	W1.2 1.5	W1.2 1.5
1.4	1.2	-	0468 500 008	0468 500 008	0468 502 008	0468 500 008	0468 502 008	W1.4 1.7	W1.4 1.7
1.6	-	-	-	0468 500 009	0468 502 009	0468 500 009	0468 502 009	W1.6 1.9	W1.6 1.9
-	1.6	-	-	0468 500 010	0468 502 010	0468 500 010	0468 502 010	W1.6 2.1	W1.6 2.1



Shielding gas / Welding wire Ø		Contact nozzle	
CO ₂	Mix / Ar	M 6	
0.6	-	0468 501 001	W0.6 0.8
-	0.6	0468 501 002	W0.8 1.0
0.8	-	0468 501 003	W0.9 1.1
0.9	0.8	0468 501 004	W1.0 1.2
1.0	0.9	0468 501 005	W1.2 1.5
1.2	-	0468 501 006	W1.4 1.7
1.2	1.0	0468 501 007	W1.6 1.9



Shielding gas / Welding wire Ø		Contact nozzle		
CO ₂	Mix / Ar	M 7	M 8	
0.6	-	0468 313 880	-	W0.6
-	0.6	0468 313 881	-	W0.8
0.8	-	0468 313 882	-	W0.9
0.9	0.8	0468 313 883	0368 313 983	W1.0
1.0	0.9	0468 313 884	0368 313 984	W1.2
1.2	-	0468 313 885	-	W1.4
1.2	1.0	0468 313 886	-	W1.6

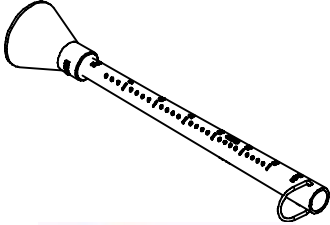

Wire liner

Welding torch	Welding wire	Steel spiral liner		PTFE ceramic liner*) (beige)	
		3 m	4.5 m	3 m	4.5 m
PSF™ 250, PSF™ 250C	0.6-0.8 mm	0366 549 882	0366 549 883	-	-
	0.9-1.0 mm	0366 549 884	0366 549 885	0457 969 882	0457 969 883
PSF™ 305, PSF™ 315C LD	1.2 mm	0366 549 886	0366 549 887	0457 969 882	0457 969 883
PSF™ 405, PSF™ 405C, PSF™ 410w, PSF™ 410Cw	1.4 mm	0366 549 888	0366 549 889	0457 969 884	-
	1.6 mm	0366 549 890	0366 549 891	-	-
PSF™ 505, PSF™ 510w	2.0 mm	-	0366 549 898	-	-
	2.4 mm	-	0366 549 899	-	-
<p>The wire guide is marked with the max. wire diameter (stamped on the nipple). *) No wear insert needed.</p>					

Welding torch	Welding wire	PTFE liner incl. wear insert (steel, white)		Wear insert separate for PTFE liner	
		3 m	4.5 m	Steel	PTFE (Al)
PSF™ 250, PSF™ 250C	0.6 mm	0366 550 880	0366 550 881	0366 545 880	0368 742 880
	0.8 mm	0366 550 882	0366 550 883	0366 545 880	0368 742 880
	0.9-1.0 mm	0366 550 884	0366 550 885	0366 545 881	0368 742 880
PSF™ 305, PSF™ 315C LD	1.2 mm	0366 550 886	0366 550 887	0366 545 882	0368 742 883
PSF™ 405, PSF™ 405C, PSF™ 410w, PSF™ 410Cw	1.4 mm	0366 550 888	0366 550 889	0366 545 883	0368 742 881
	1.6 mm	0366 550 890	0366 550 891	0366 545 884	0368 742 881
PSF™ 505, PSF™ 510w	2.0/2.4 mm	0366 550 892	0366 550 893	-	-
<p>The wire guide is marked with the max. wire diameter (stamped on the nipple).</p>					

PSF™ Welding torches

Accessories

	Gas flow meter	0155 716 880
	MIG handy support with strong magnetic foot	0760 022 300
Spot welding accessory Self and water cooled PSF™ 250, PSF™ 250C 0366 643 881 PSF™ 305, PSF™ 410w, PSF™ 315C LD, 0366 643 882 PSF™ 410Cw PSF™ 405, PSF™ 510w, PSF™ 405C 0366 643 883 PSF™ 505 0366 643 884		

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