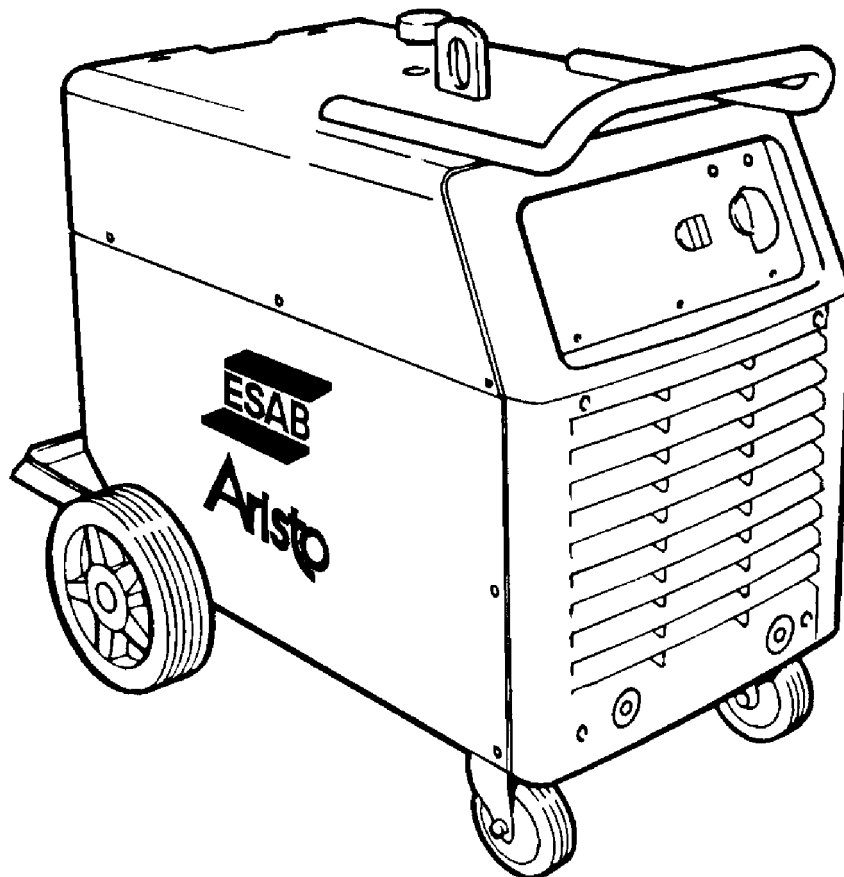




Aristo 320

Aristo 450

LUD 320, LUD 450

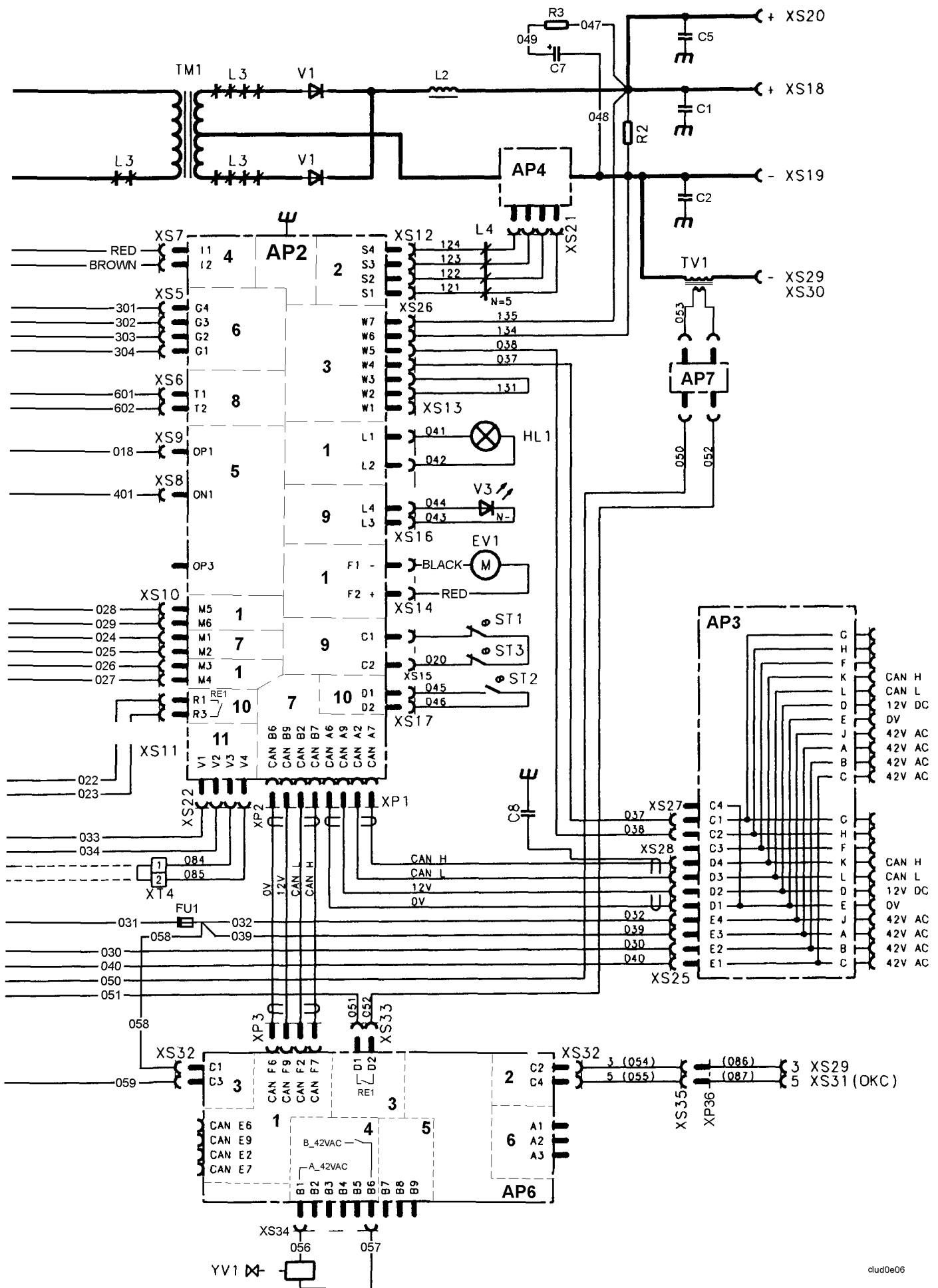


**Bruksanvisning
Brugsanvisning
Bruksanvisning
Käyttöohjeet
Instruction manual
Betriebsanweisung**

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

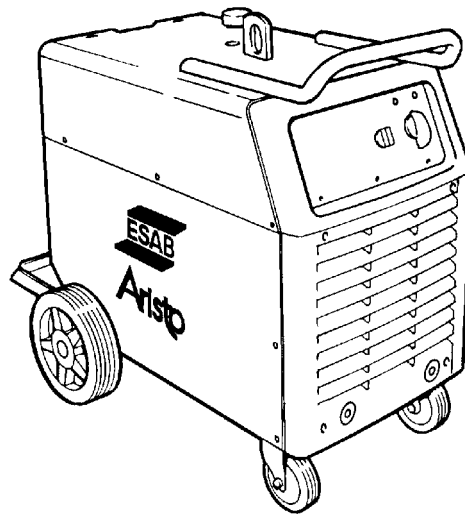
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**Reservdelsförteckning Reservdelsfortegnelse Reservedelsliste
 Varaosaluettelo Spare parts list Ersatzteilliste Liste de pièces détachées
 Reserveonderdelenlijst Lista de repuestos Elenco ricambi Lista de peças
 sobressalentes Πίνακας ανταλλακτικών μερών**



Valid for serial no. 716-xxx-xxxx to serial no. 852-xxx-xxxx

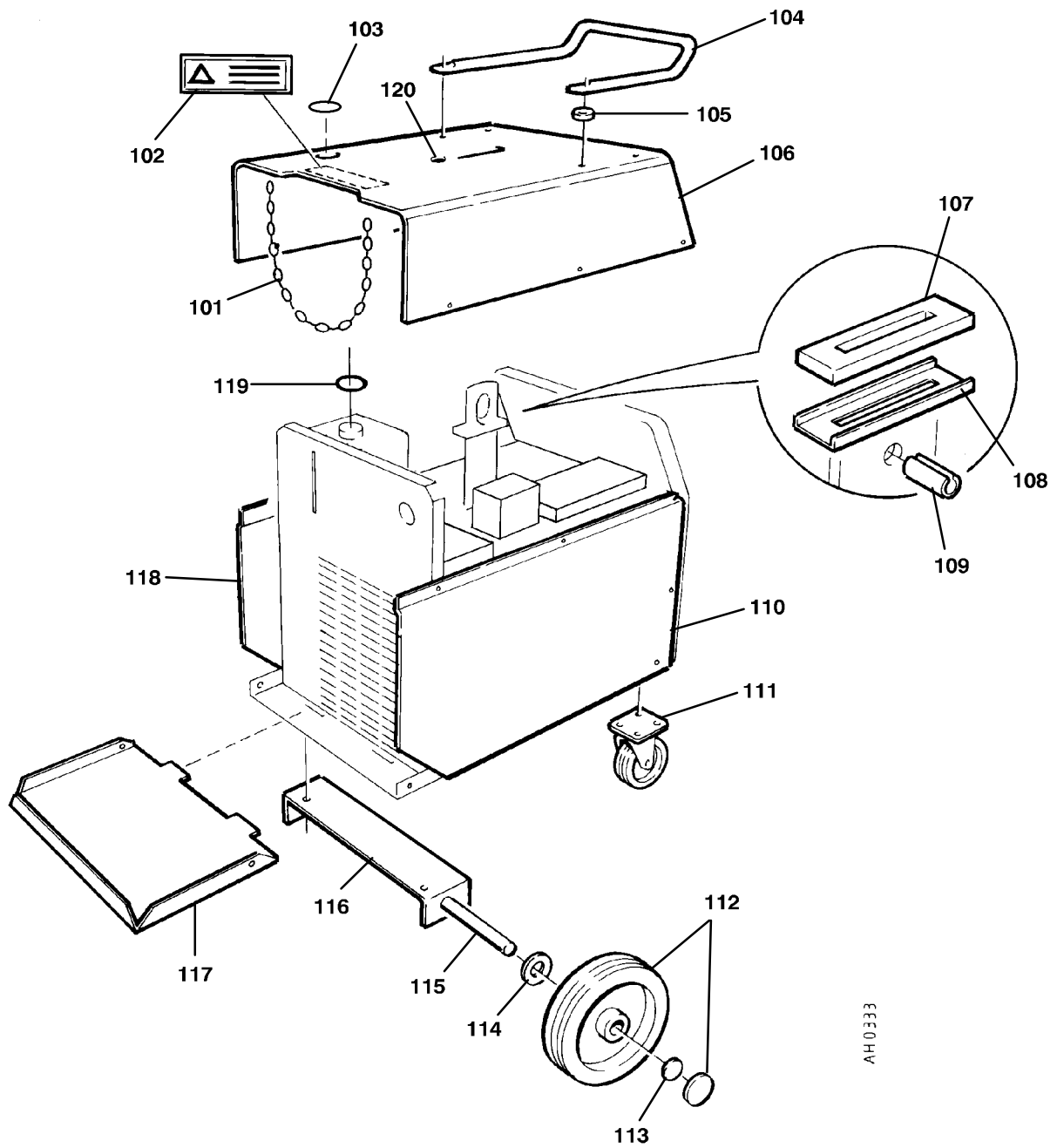
Ordering numbers for LUD 320, LUD 450

Ordering no.	Denomination	Mains voltage	Notes
0456 600 880	LUD 320	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG
0456 600 882	LUD 320	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG
0456 600 881	LUD 320W	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG
0456 600 883	LUD 320W	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG
0456 600 884	LUD 320W	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG, TIG with OKC connection
0456 600 885	LUD 320W	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG, TIG with central connection
0456 600 886	LUD 320W	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG, TIG with OKC connection
0456 600 887	LUD 320W	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG, TIG with central connection
0456 300 881	LUD 450W	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG
0456 300 883	LUD 450W	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG
0456 300 884	LUD 450W	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG, TIG with OKC connection
0456 300 885	LUD 450W	400 V 3 ~ 50/60 Hz	MMA, MIG/MAG, TIG with central connection
0456 300 886	LUD 450W	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG, TIG with OKC connection
0456 300 887	LUD 450W	230/400/500 V 3 ~ 50 Hz; 208/230/460/475 V 3 ~ 60 Hz	MMA, MIG/MAG, TIG with central connection

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.

Item	Qty	Ordering no.	Denomination	Notes
101	1	0321 173 001	Securing chain	
102	1	0367 437 001	Sticker	
103	1	0192 992 001	Cover	Only for machines without water cooler
104	1	0469 868 001	Handle	
105	4	0366 481 002	Seal	
106	1	0456 296 001	Cover	
107	1	0468 797 001	Seal	
108	1	0468 796 001	Support plate	
109	1	0211 103 005	Roll pin	∅ 8x28
110	1	0456 297 001	Side panel, left	With text
111	2	0469 873 001	Castor wheel	∅ 125mm h=150mm
112	2	0469 872 001	Wheel	∅ 250mm
113	2	0192 859 126	Locking washer	
114	2		Washer	∅ 36/21x3
115	1	0469 516 005	Shaft	
116	1	0456 682 001	Clamp	
117	1	0456 683 001	Shelf	
118	1	0456 297 002	Side panel, right	With text
119	1	0366 481 004	Seal	Only LUD 320W/450W
120	1	0456 167 002	Blind plug	

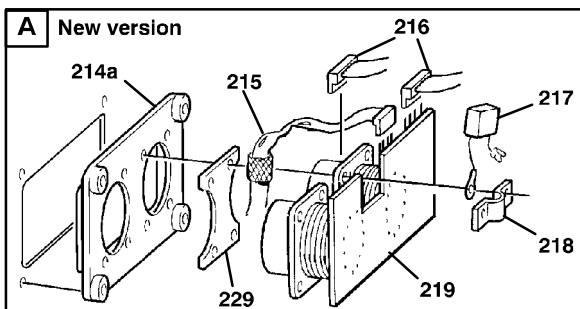
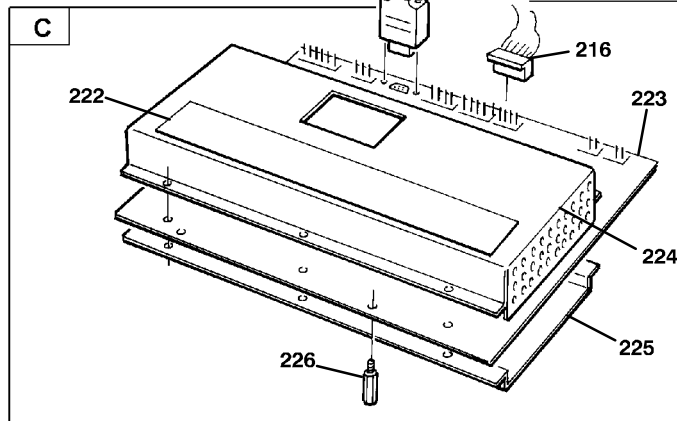
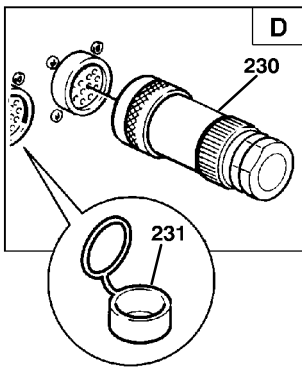
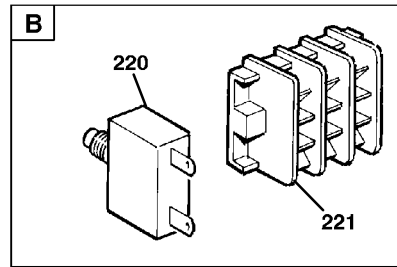
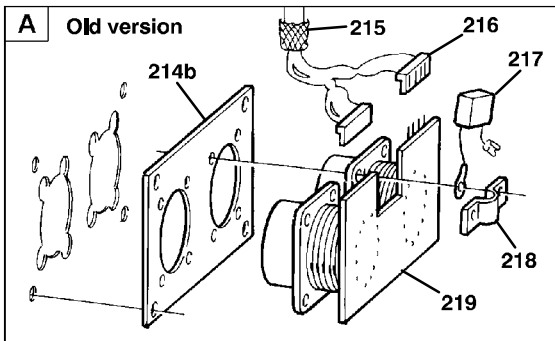
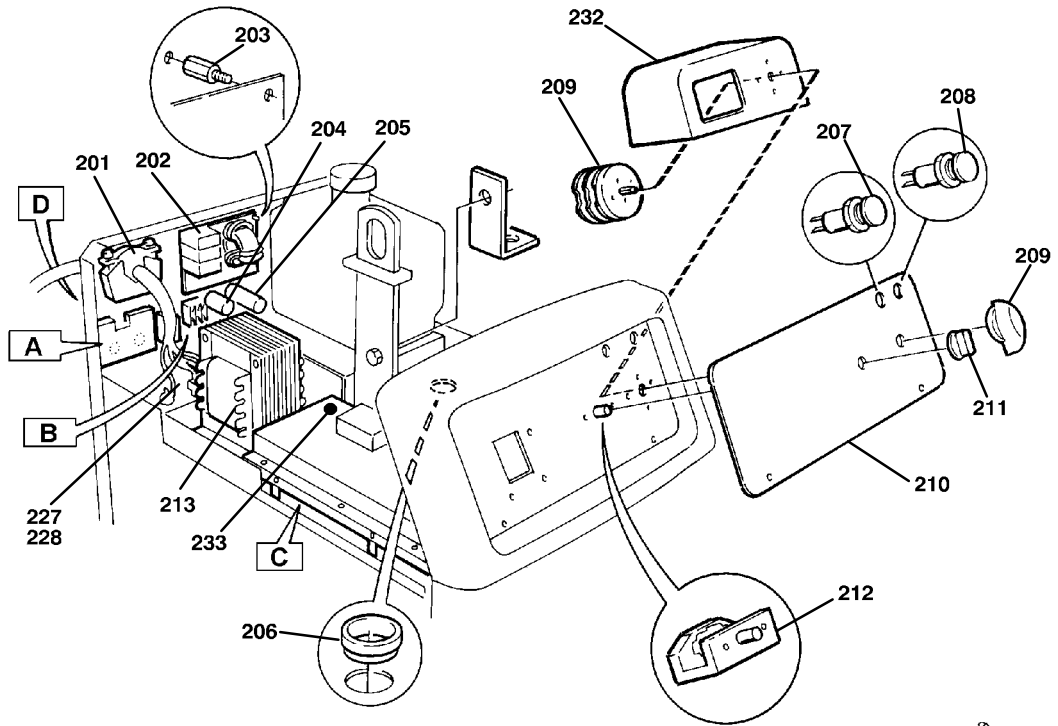


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C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
201	1	0469 950 880	Cable inlet		
202	1	0455 803 880	Circuit board	EMC	AP5
203	2	0394 516 035	Spacer		
204	1	0191 085 203	Capacitor	3 μ F 400V	C4
205	1	0191 085 206	Capacitor	6 μ F 400V	C6
206	4	0192 041 131	Grommet		
207	1	0369 733 005	Light-emitting diode	Yellow	V3
208	1	0369 733 008	Indicating lamp	White	HL1
209	1	0455 159 001	Switch	With knob	QF1
210	1	0456 593 001	Panel LUD 320	With text	
	1	0456 594 001	Panel LUD 320W	With text	
	1	0456 518 001	Panel LUD 450	With text	
	1	0456 291 001	Panel LUD 450W	With text	
211	1	0366 296 003	Knob	Only LUD 320W/450W	
212	1	0366 295 006	Switch	Only LUD 320W/450W	QF2
213	1	0456 292 001	Control transformer		TC1
-	1		Fuse	2A slow blow	FU2
214a	1	0457 801 001	Insulation	Used from April 1999	
214b	1	0486 449 880	Insulation board	Used to April 1999	
215	1	0456 677 881	Cable	CAN-cable complete with connectors XP1 and XS28	
216	3	0193 260 061	Connector	2 pole	XS8, XS15, XS17
	4	0193 260 063	Connector	4 pole	XS5, XS12, XS22, XS28
	1	0193 260 001	Connector	2 pole	XS14
	3	0193 260 150	Connector	2 pole	XS6, XS7, XS13
	2	0193 260 151	Connector	3 pole	XS9, XS11
	3	0193 260 152	Connector	4 pole	XS16, XS26, XS27
	1	0193 260 154	Connector	6 pole	XS10
	1	0193 260 153	Connector	5 pole	XS25
217	1	0467 911 883	Capacitor	0.1 μ F 250 V, with cable lugs	C8
218	1	0456 686 880	Clamp		
219	1	0486 388 880	Connection board		AP3
220	1	0193 586 102	Circuit breaker	10 A	FU1
221	1	0466 884 003	Terminal	3 pole	XT2
222	1	0456 525 001	Sticker		
223	1	0486 418 881	Circuit board	For LUD 320 with MMA and MIG/MAG	AP2
		0486 418 882	Circuit board	For LUD 320 with MMA, MIG/MAG and TIG	AP2
		0486 418 883	Circuit board	For LUD 450 with MMA and MIG/MAG	AP2
		0486 418 884	Circuit board	For LUD 450 with MMA, MIG/MAG and TIG	AP2
224	1	0458 619 001	Cover		
225	1	0458 620 001	Box		
226	4	0394 516 023	Spacer		
227	1	0320 378 011	Terminal	3 pole	XT1
228	1	0468 882 004	Sticker		
229	1	0457 799 001	Screen plate		
230	1	0456 680 880	Termination resistance		
231	1	0366 285 001	Protection cap		
232	1	0456 897 001	Protection cover		
233	1	0457 213 001	Protection cover	Plastic cover protecting the connectors on circuit board AP2	

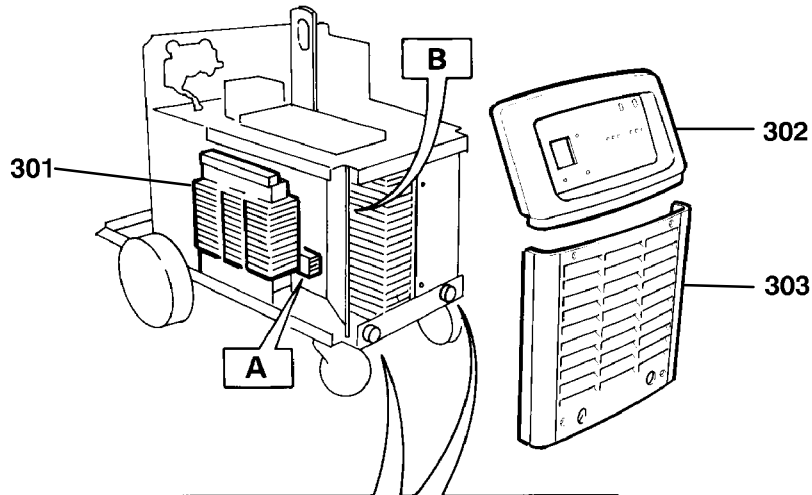


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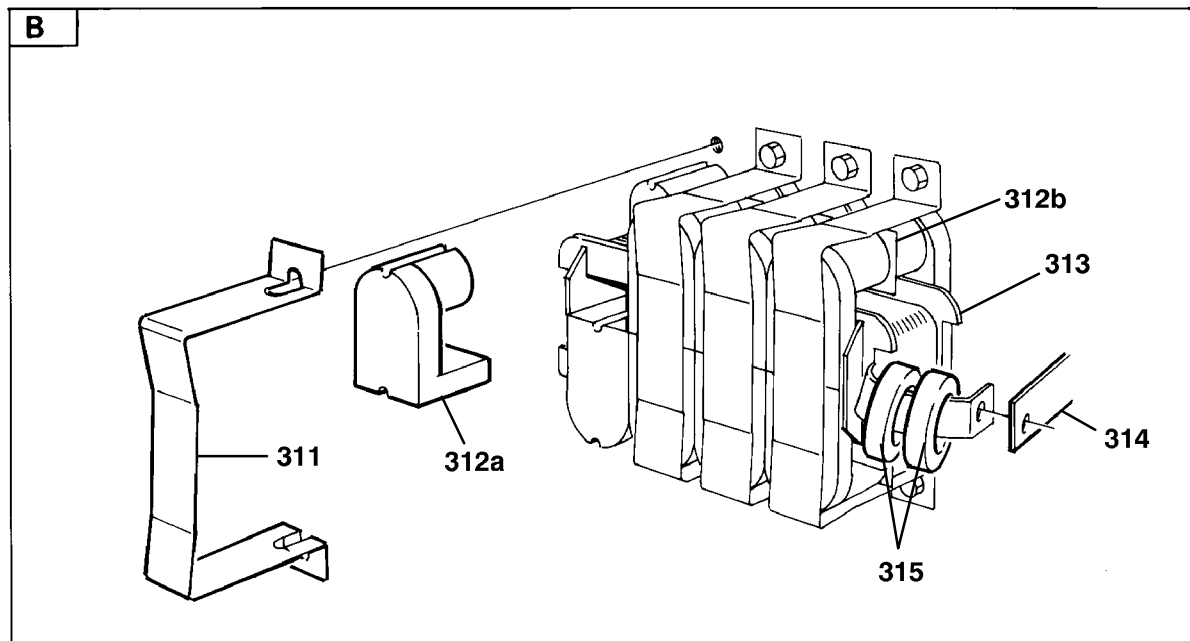
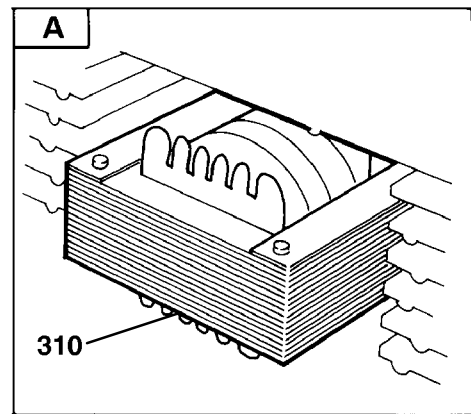
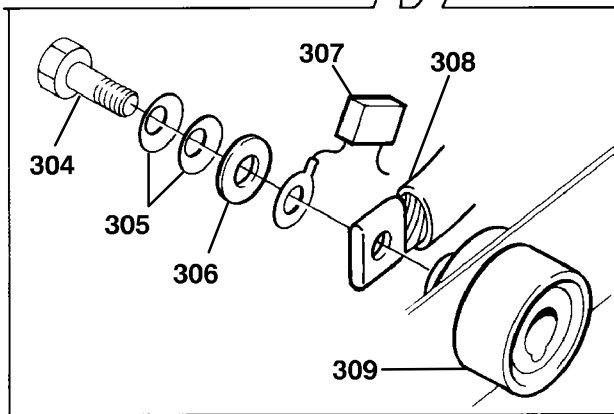
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C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
301	1	0456 271 001	Auto transformer		
302	1	0469 704 001	Front panel		
303	1	0469 703 003	Front grill	For machines with MMA, MIG and TIG	
	1	0469 703 004	Front grill	For machines with MMA and MIG	
304	3		Screw	M10x25	
305	6		Spring washer	∅ 20/10.2x1.1	
306	3		Washer	∅ 22/10.5x2	
307	3	0467 911 881	Capacitor	0.1 µF 250 V, with cable lugs	C1, C2, C5
308	1	0469 879 882	Cable set	For LUD 450	
	1	0469 879 883	Cable set	For LUD 320	
309	3	0160 362 881	Current terminal	OKC	XS18-XS20
310	1	0455 550 880	Inductor	Thermal switches ST2 and ST3 are included	L2
		0320 655 014	Thermal switch	Closing at 80°C , opening at 60°C	ST2
		0320 655 013	Thermal switch	Opening at 160°C, closing at 130°C	ST3
311	4	0455 538 001	Clamp		
312a	16	0193 312 101	Ferrite core		
312b		0365 652 002	Tape	For air gap, length: 3x150mm	
313	1	0455 536 880	Transformer coil		TM1
314	1	0455 552 001	Bus bar		
315	2	0455 569 001	Ferrite ring		L3



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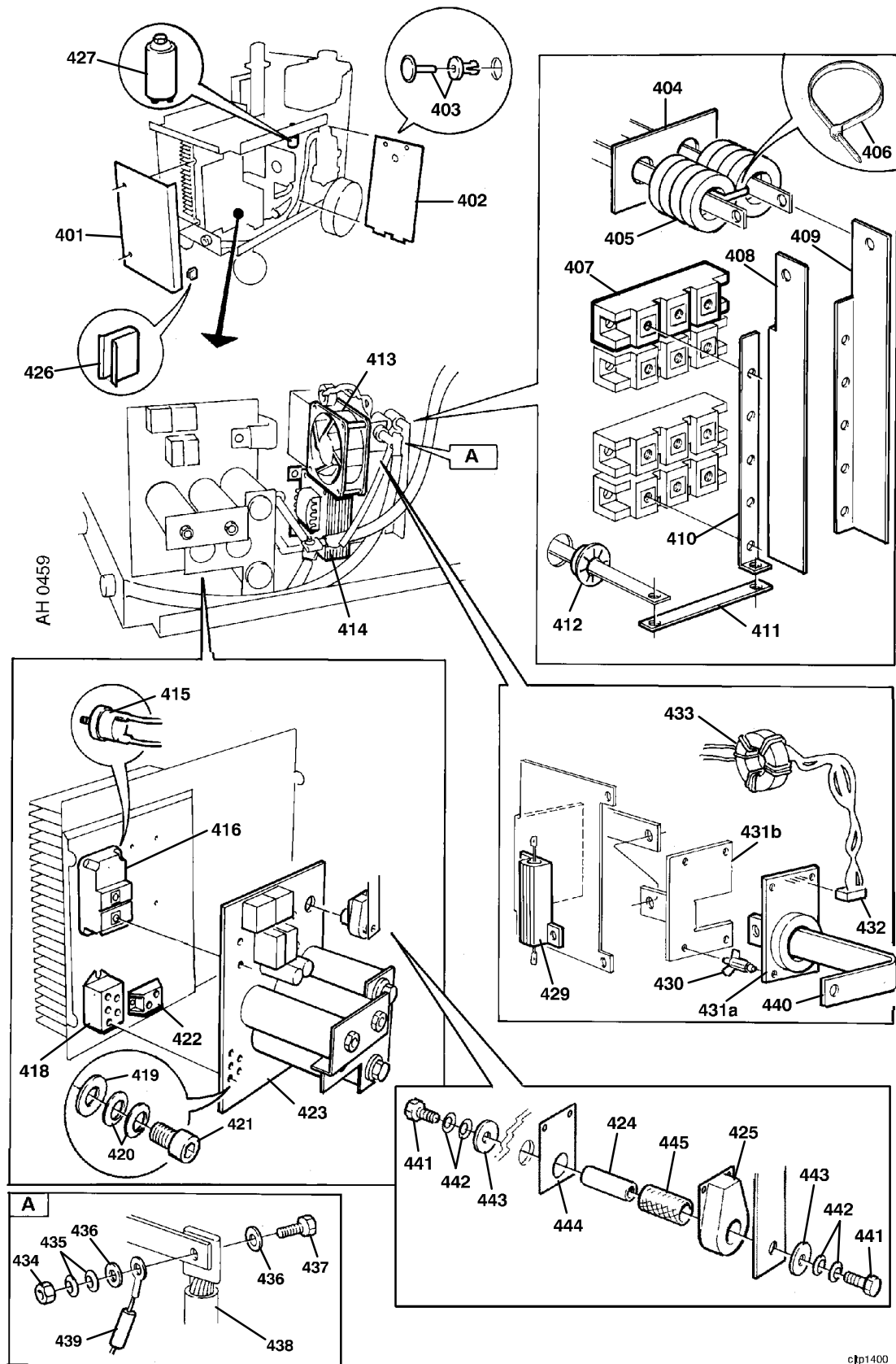
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C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
401	1	0455 807 001	Insulation		
402	1	0455 809 001	Insulation		
403	2	0455 661 019	Plastic rivet		
404	1	0455 544 001	Insulation		
405	8	0455 569 001	Ferrite ring		L3
406	3	0040 953 611	Cable tie, blue	Heat resistant	
407	5	0455 564 001	Diode module	LUD 450	V1
	4	0455 564 001	Diode module	LUD 320	V1
-		0192 058 101	Thermal compound	For fitting of ST1, Q1, Q2, V1, V2 and VC1	
408	1	0455 537 002	Bus bar		
409	1	0455 537 001	Bus bar		
410	1	0455 553 001	Bus bar		
411	1	0455 559 001	Bus bar		
412	5	0455 566 005	Grommet		
413	1	0469 479 001	Fan	24 VDC	EV1
414	1	0193 758 002	Inductor		L1
415	1	0467 864 006	Thermal cutout	Opens at 80 °C, closes at 60 °C	ST1
416	2	0455 563 001	IGBT-module		Q1, Q2
-		0192 058 101	Thermal compound	For fitting of ST1, Q1, Q2, V1, V2 and VC1	
418	1		Rectifier bridge	See item 450	VC1
419			Washer	∅ 10/5.3x1	
420			Spring washer	∅ 10/5.2x0.5	
421			Screw	M5x12	
422	1	0455 565 001	Thyristor module		V2
423	1	0455 799 881	Circuit board	Replacing circuit board 0455 799 880	AP1
	2	0193 767 001	Fuse	Fuses FU1 and FU2 on circuit board AP1 The fuses are not included in the main diagram	
-	3	0193 260 061	Connector	2 pole, to be used for early and late versions of circuit board AP1.	XS1, XS2, XS4
-	3	0193 260 001	Connector	2 pole, to be used for late versions of circuit board AP1.	XS1, XS2, XS4
-	1	0193 260 063	Connector	4 pole	XS3
424	1	0191 745 010	Spacer sleeve	Before ser.no. 839-xxx-xxxx	
	1	0457 902 001	Spacer	From ser.no. 839-xxx-xxxx	
425	1	0320 729 001	Current transformer		TA1
426	2	0457 212 001	Clips		
427	1	0192 903 051	Capacitor	220 µF 250V	C7
	1	0320 901 002	Nut	Plastic	
429	1	0192 579 218	Resistor	20Ω 50W	R3
430	1		Spacer/Screw	Included in item 431a.	
431a	1	0455 560 880	Current sensor	Includes items 430, 431b, 432 and 433.	AP4
431b	1		Bracket	Included in item 431a.	AP4
432	1		Connectors and cable	Included in item 431a.	XS12, XS21
433	1		Ferrite ring	Included in item 431a.	L4
434			Nut	M8	
435			Spring washer	∅ 16/8.2x0.9	
436			Washer	∅ 16/8.4x1.5	
437			Screw	M8x30	
438	1	0469 879 882	Cable set	The same as item 308	
439	1	0367 133 883	Resistor		R2
440	1	0456 876 001	Bus bar		
441	2		Screw	M5x16mm From ser.no. 839-xxx-xxxx	
442	4		Spring washer	10/5.2x0.5mm From ser.no. 839-xxx-xxxx	
443	2		Washer	19/5x1.0mm From ser.no. 839-xxx-xxxx	
444	1	0457 903 001	Insulating washer	From ser.no. 839-xxx-xxxx	
445	1	0190 209 116	Hose	D=11.6/10 L=25 mm. To be ordered per metre From ser.no. 839-xxx-xxxx	

SPARE PARTS SET

Item	Ordering no.	Denomination	Notes
450	0458 920 881	Rectifier set	Includes item 418 rectifier bridge, thermal compound, roller and mounting instruction.
-	0458 910 002	Roller handle	For the roller in the spare parts set above.



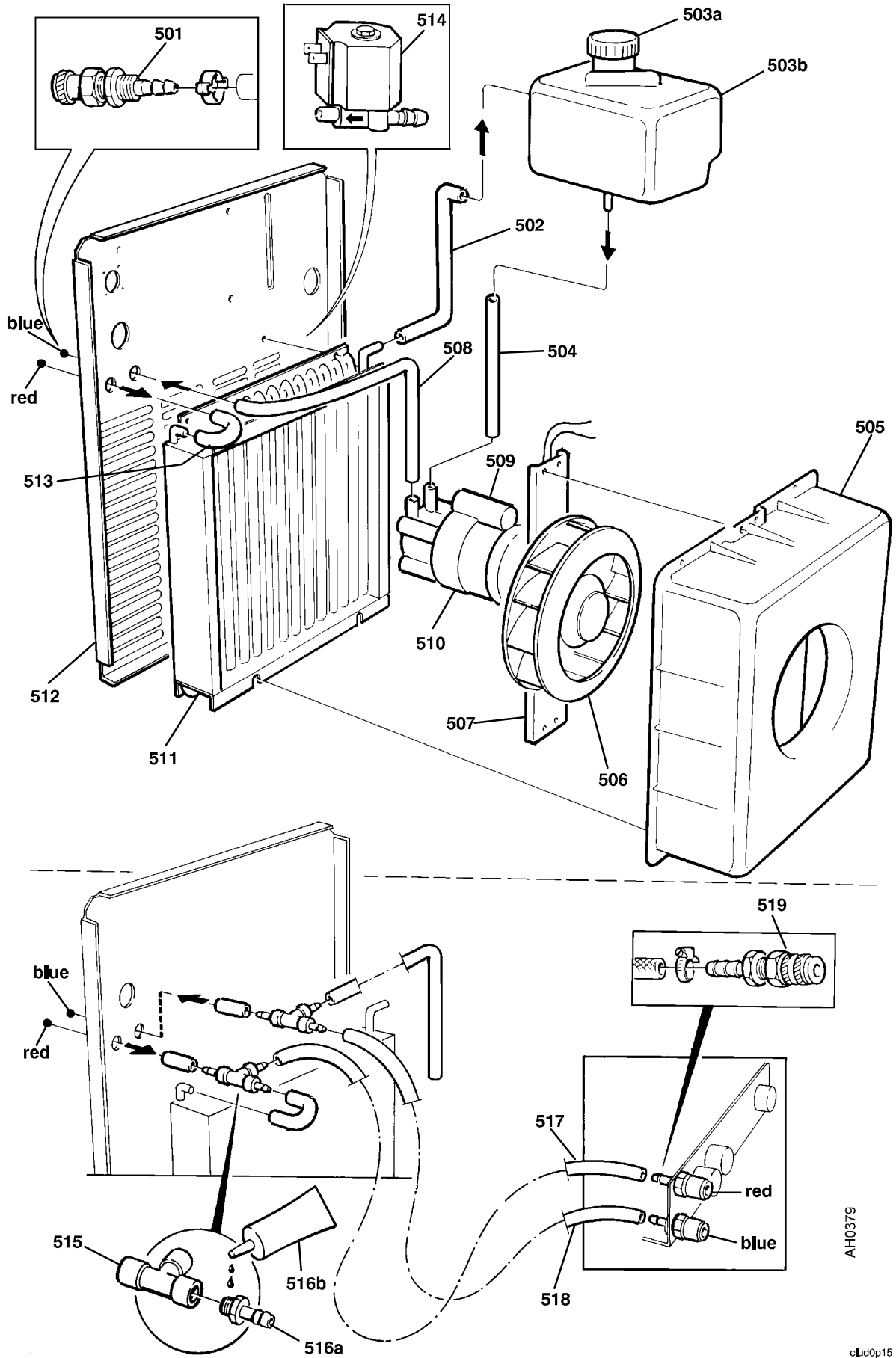
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LUD 3/4 = LUD 320/450

LUD 3/4W = LUD 320W/450W

C = component designation in the circuit diagram

Item	Qty LUD 3/4	Qty LUD 3/4W	Qty LUD 3/4W TIG	Ordering no.	Denomination	Notes	C
501	-	1	1	0365 803 011	Quick connector	Female, red	
	-	1	1	0365 803 012	Quick connector	Female, blue	
502	-	1	1	0455 162 001	Hose		
503a	-	1	1	0469 689 002	Cover		
503b	-	1	1	0469 689 001	Water tank		
504	-	1	1	0457 987 001	Hose	L=340 mm, to be ordered per metre	
505	1	1	1	0469 893 001	Fan housing		
506	1	1	1	0369 827 001	Fan	230 VAC	EV2
507	1	1	1	0455 165 001	Attachment		
508	-	1	1	0457 987 001	Hose	L=620 mm, to be ordered per metre	
509	-	1	1	0191 085 105	Capacitor	5 μ F 400V	C3
510	-	1	1	0469 692 001	Pump	1A 0.2kW 230V 50Hz, item 509 included	M1
511	-	1	1	0469 688 001	Cooler		
512	1	1	1	0455 806 001	Rear panel		
513	-	1	1	0455 161 001	Hose		
514	-	-	1	0193 054 002	Solenoid valve		YV1
515	-	-	2	0456 664 002	T-connection		
516a	-	-	6	0192 713 005	Hose nipple		
516b	-	-	1		Glue	Loctite 542 (Brown)	
517	-	-	1	0190 315 105	Hose	D14/8 reinforced PVC, L=1 metre To be ordered per metre	
518	-	-	1	0190 315 105	Hose	D14/8 reinforced PVC, L=0.9 metre To be ordered per metre	
519	-	-	1	0365 803 008	Quick connector	Red	
	-	-	1	0365 803 009	Quick connector	Blue	

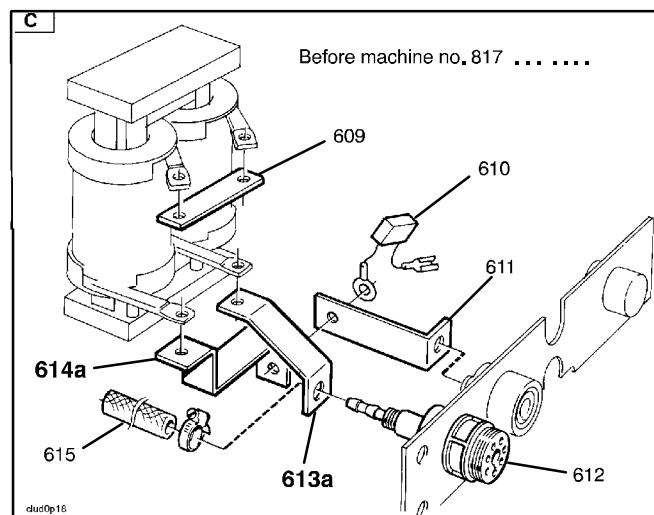


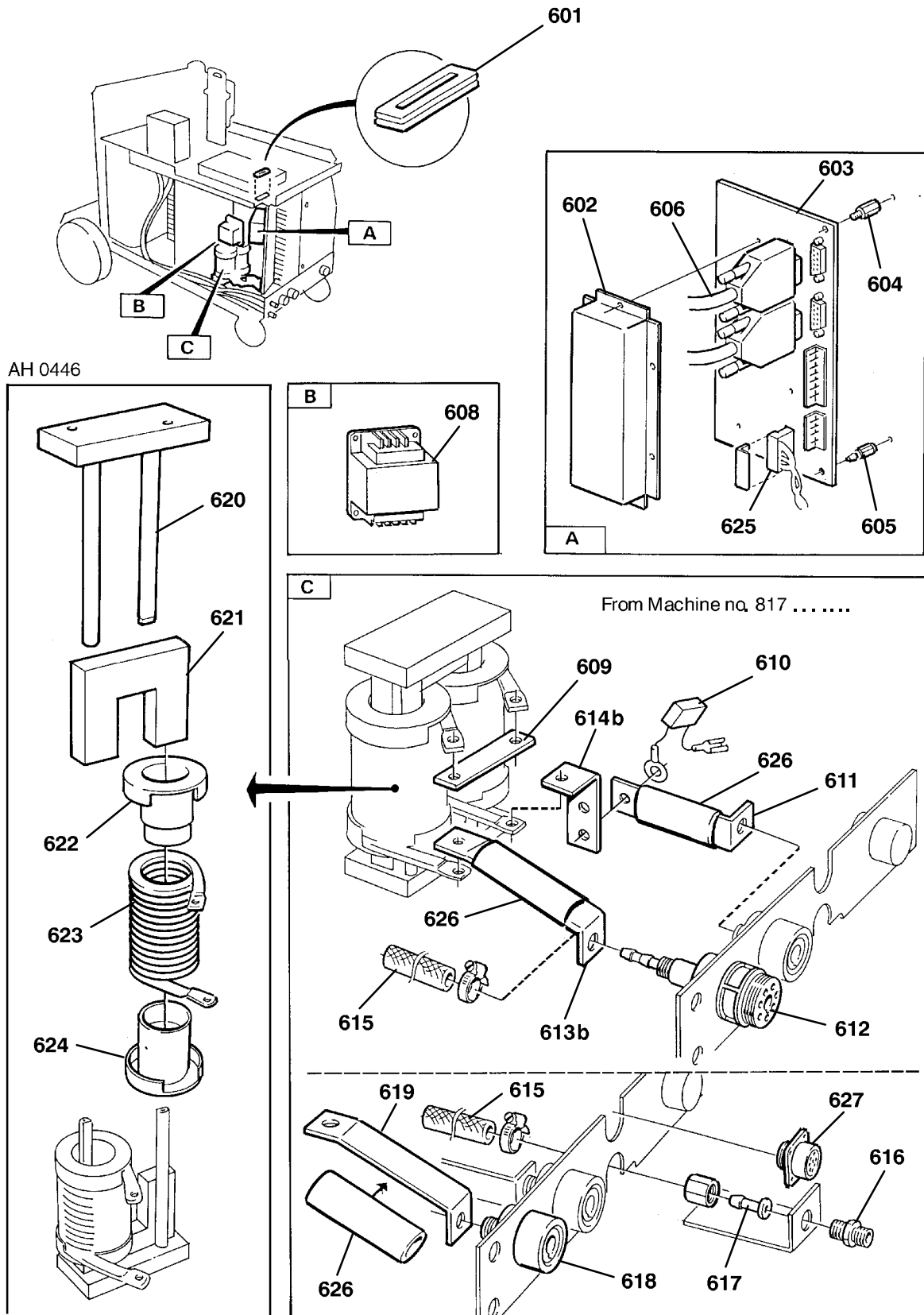
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C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
601	1	0369 033 001	Bushing	Leakproof	
602	1	0456 853 001	Cover		
603	1	0486 476 880	Circuit board		AP6
604	2	0394 516 022	Spacer screw	M4x20	
605	3	0192 927 105	Spacer		
606	1	0456 914 880	CAN cable	With connectors XP2 and XP3	
608	1	0367 268 001	HF unit		AP7
609	1	0467 757 001	Bus bar		
610	1	0467 911 881	Capacitor	0,1 µF 250V	C2
611	1	0456 811 001	Bus bar		
612	1	0367 258 880	Central adapter		XS29
613a	1	0456 810 001	Rail	Before machine no. 817-xxx-xxxx	
613b	1	0457 708 001	Rail	From machine no. 817-xxx-xxxx	
614a	1	0456 812 001	Rail	Before machine no. 817-xxx-xxxx	
614b	1	0457 710 001	Rail	From machine no. 817-xxx-xxxx	
615		0190 315 102	Gas hose	D11/4,8 reinforced PVC. To be ordered per metre	
616	1	0156 867 001	Gas outlet bushing		
617	1	0252 103 501	Nipple		
618	1	0156 868 880	Current terminal	OKC50 HF	XS30
619	1	0456 915 001	Rail	Before machine no. 817-xxx-xxxx	
	1	0457 709 001	Rail	From machine no. 817-xxx-xxxx	
620	2	0467 755 001	Bracket		
621	2	0466 895 001	Ferrit core		
		0193 534 102	Tape	For air gap. Two layers of tape in each airgap	
622	2	0466 598 001	Bobbin		
623	2	0467 350 001	HF coil		
624	2	0466 598 002	Bobbin		
625	1	0193 260 152	Connector	4 pole	XS32
	1	0193 260 150	Connector	2 pole	XS33
	1	0193 260 157	Connector	9 pole	XS34
	1	0192 784 002	Connector	2 pole	XS35
	1	0192 784 001	Connector	2 pole	XP36
626	2	0190 304 116	Hose	D=19/1.3 mm PVC, L=85 mm To be ordered per metre	
627	1	0538 500 902	Sleeve socket		XS31

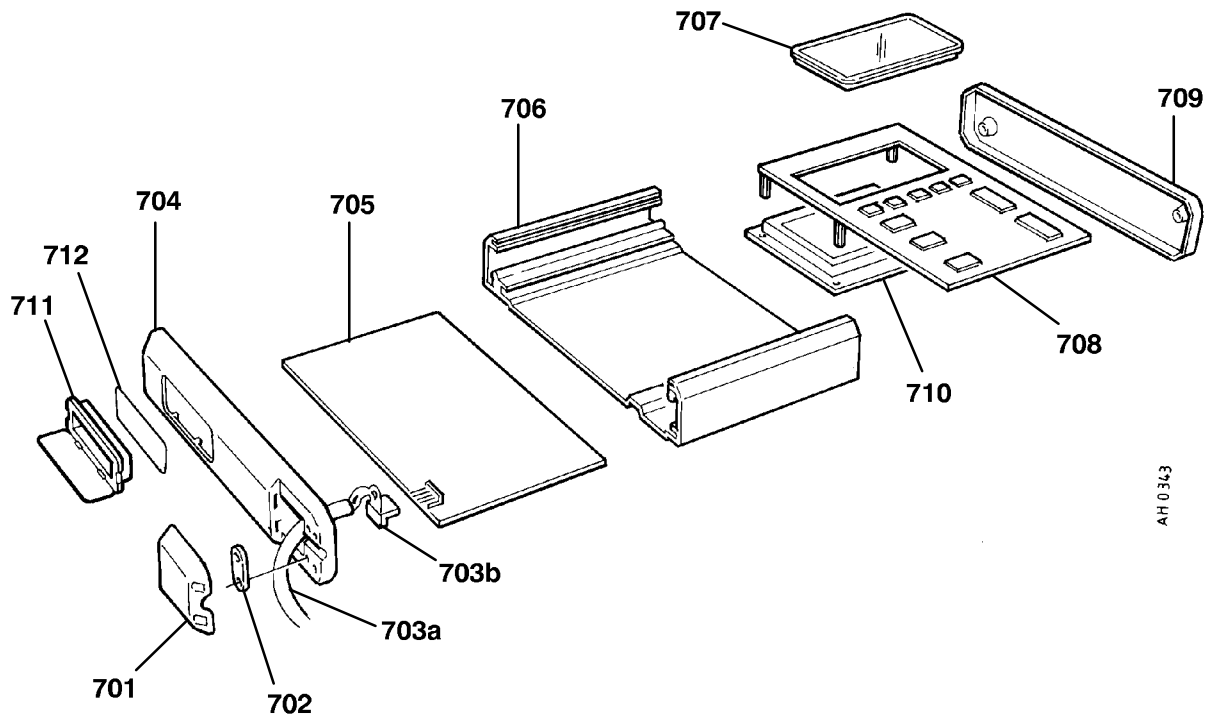




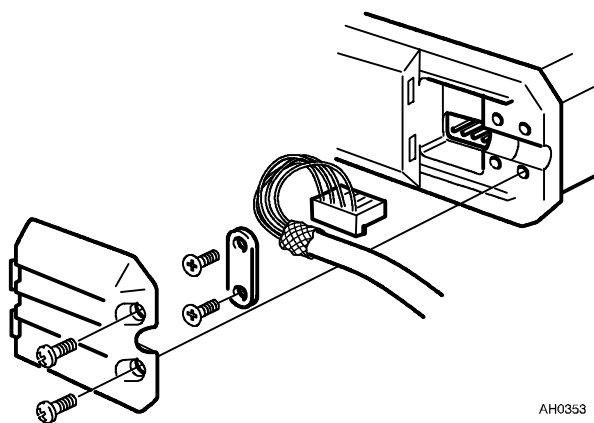
cludOp19

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
			Control box	The control box is complete with 0.7 metre control cable and software for the languages specified below	
		0456 290 881	Control box	English, French, German and Italian	
		0456 290 882	Control box	Danish English, Finnish, and Swedish	
		0456 290 883	Control box	Dutch, English, Portuguese and Spanish	
		0456 290 884	Control box	Czech, English, Hungarian and Polish	
		0456 290 885	Control box	American English, French, Portuguese and Spanish	
701	1	0456 283 001	Cover		
702	1	0456 686 880	Clamp		
703a	1	0456 280 880	Control cable	L = 0.7 m (Item 703b and Burndy connector included)	
		0456 280 881	Control cable	Accessory, L = 5 m, connectors included	
		0456 280 882	Control cable	Accessory, L = 10 m, connectors included	
703b	1	0193 260 003	Connector	4 pole	
704	1	0456 884 001	Side panel	Left	
705	1	0486 442 881	Circuit board	With software for English, French, German, Italian	AP1B
	1	0486 442 883	Circuit board	With software for Danish, English, Finnish, Swedish	AP1B
	1	0194 008 001	Battery	For circuit board AP1B	
706	1	0456 284 001	Profile		
707	1	0456 286 001	Instrument glass		
708	1	0456 285 001	Key pad		AP3B
709	1	0456 281 001	Side panel	Right	
710	1	0193 949 001	Graphic display		AP2B
711	1	0456 883 001	Cover		
712	1	0456 888 001	O-ring		



AH 0343



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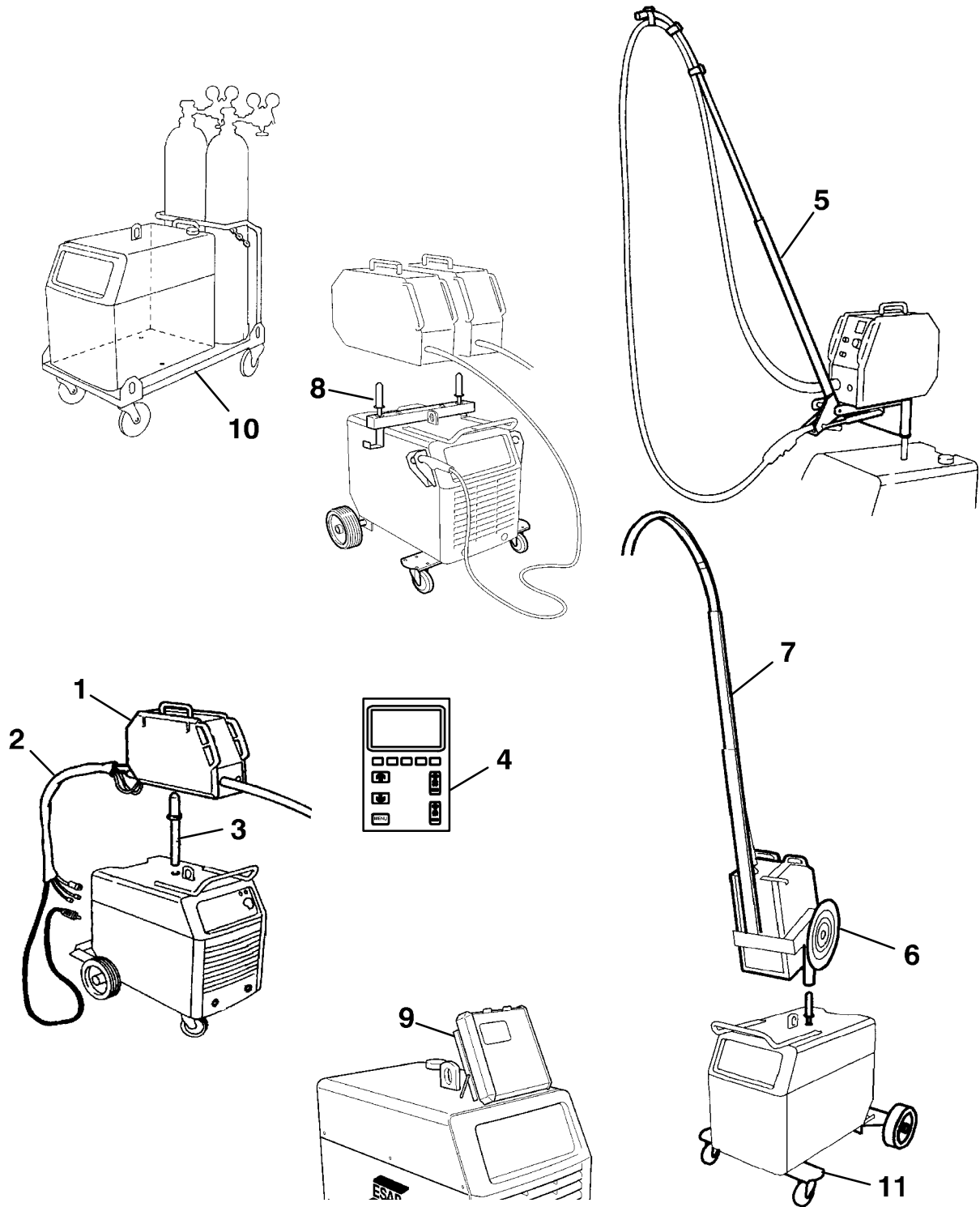
**Tillbehör Tilbehør Tilbehør Lisävarusteet Accessories Zubehör
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Item	Ordering no. when connected to LUD 320	Ordering no. when connected to LUD 320W/450W	Designation
1	0456 400 880	0456 400 881	Wire feed unit MEK 4C / MEK 4CW
	0456 800 880	0456 800 881	Wire feed unit MEK 44C / MEK 44CW
	0456 980 880	0456 980 881	Wire feed unit MEK 20C / MEK 20CW
	0457 040 880	0457 040 880	Wire feed unit MLC 30C
2	0456 528 880	0456 528 885	Connection set 1.7 metres
	0456 528 881	0456 528 886	Connection set 8 metres
	0456 528 882	0456 528 887	Connection set 16 metres
	0456 528 883	0456 528 888	Connection set 25 metres
	0456 528 884	0456 528 889	Connection set 35 metres
-	-	0456 855 880	Water flow guard

Item	Ordering number	Designation
3	0156 654 893	Guide pin (Delivered with LUD)
4	0456 290 881	Control box with different language combinations, please see the spare parts list
5	0469 792 881	Counter balance for MEK 4C, mast included
6	0456 693 880	Counter balance for MEK 4C, "sprung coil"
	0467 816 881	Counter balance for MEK 44C and MLC30C, "sprung coil"
7	0156 746 880	Mast for counter balance with "sprung coil"
8	0457 073 880	Connection set for two wire feed units
9	0457 348 881	Holder for the control box
10	0457 221 881	Trolley for two gas cylinders
11	0457 950 880	Stabilization kit
-	0457 043 880	Adapter set 230 V AC / 12 V DC, for control box. For training, with the control box disconnected from the machine.
-	0457 320 880	PCMCIA card for the control box
-	0457 410 880	Weldoc WMS 4000, software
-	0457 410 881	SPS 4000, software
-	0457 415 880	PC interface for LUD
-	0457 072 881	Opto cable for WMS 4000 and SPS 4000

Remote controls

Ordering number	Designation
0466 801 881	Aristo control 5 program box
0566 515 881	Aristo control 5 program bar
0466 801 880	Aristo control synergic box
0466 515 880	Aristo control synergic bar



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