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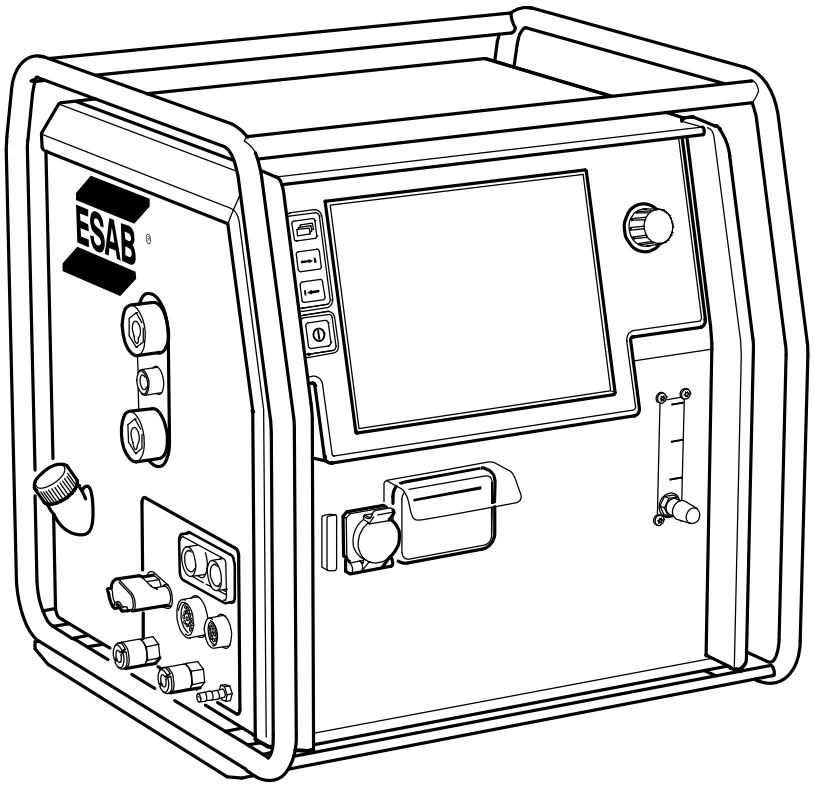
ESAB®

Aristo®

MechTig C2002i



Instruction manual

0444 620 101 GB 110120

Valid for serial no. 810-xxx-xxxx, 049-xxx-xxxx

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1 DIRECTIVE

DECLARATION OF CONFORMITY

ESAB AB, Welding Equipment, SE-695 81 Laxå, Sweden, gives its unreserved guarantee that welding power source MechTig C2002i from serial number 810 are constructed and tested in compliance with the standard EN 60974-1 /-3 and EN 60974-10 (Class A) in accordance with the requirements of directive (2006/95/EC) and (2004/108/EEC).

Laxå 2008-05-20

Kent Eimbrodt
Global Director
Equipment and Automation

2 SAFETY

Users of ESAB 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 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 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 equipment must be familiar with:
   - its operation
   - location of emergency stops
   - its function
   - relevant safety precautions
   - welding and cutting
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. **Note!** *Do not use safety gloves when replacing wire.*
   - 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 extinquishing equipment must be clearly marked and close at hand.
   - Lubrication and maintenance must **not** be carried out on the equipment during operation.

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WARNING

Arc welding and cutting can be injurious to yourself and others. Take precausions 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.

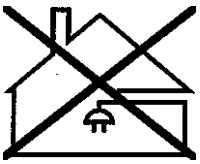
PROTECT YOURSELF AND OTHERS!

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.

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Dispose of electronic equipment at the recycling facility!

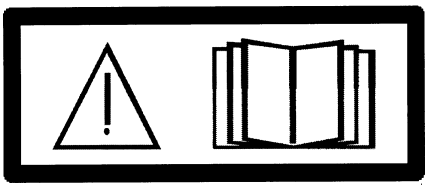
In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

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.

CAUTION

Read and understand the instruction manual before installing or operating.



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

3 INTRODUCTION

MechTig C2002i is a welding power source intended for mechanized TIG welding.

ESAB's accessories for the product can be found on page 21.

3.1 Equipment

The power source is supplied with:

- instruction manual for the welding power source
- instruction manual for the control panel
- 5 m return cable
- terminating resistor.

3.2 Control panel WO 100

See the separate instruction manual for a detailed description of the control panel.

4 TECHNICAL DATA

MechTig C2002i	
Mains voltage	230 V ±10%, 1~ 50/60 Hz
Mains supply	Z_{max} 0.35 Ω
Primary current I_{max}	22 A
Setting range	5 A - 200 A
Permitted load	
30% duty cycle	200 A / 18 V
35% duty cycle	180 A / 17 V
60 % duty cycle	150 A / 16 V
100% duty cycle	110 A / 14 V
Power factor at maximum current	0.98
Efficiency at maximum current	73 %
Open-circuit voltage	92 V
Operating temperature	-10 to +40° C
Transportation temperature	-20 to + 55° C
Constant A-weighted sound pressure	< 70 dB
Dimensions l x w x h	470 x 479 x 472 mm
Weight	30 kg
Enclosure class	IP 23
Application class	S

Cooling unit	
Cooling power	
at 50 Hz	670 W at 40° C temp. difference and flow 1.0 l/min
at 60 Hz	650 W at 40° C temp. difference and flow 1.0 l/min
Type of cooling	50 % water / 50% monoethylene glycol
Coolant quantity	2.0 l
Maximum water flow	
at 50 Hz	1.22 l/min
at 60 Hz	1.44 l/min
Maximum water pressure	
at 50 Hz	0.32 MPa (3.2 bar)
at 60 Hz	0.42 MPa (4.2 bar)

Mains supply, Z_{max}

Maximum permissible line impedance of the network in accordance with IEC 61000-3-11.

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.

The duty cycle is valid for 40° C.

Enclosure class

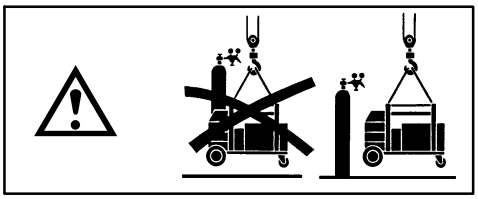
The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP23** is designed for indoor and outdoor use.

Application class

The symbol S indicates that the power source is designed for use in areas with increased electrical hazard.

5 INSTALLATION

The installation must be executed by a professional.

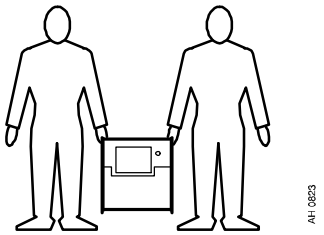


Note

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 distrubution network operator if necessary, that the equipment may be connected.

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 power supply

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.

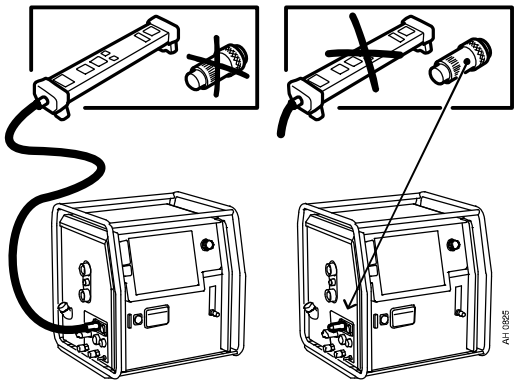
Recommended fuse sizes and minimum cable area

MechTig C2002i	
Mains voltage	230 V 1 ~ 50/60 Hz
Mains cable area	3 G 2.5 mm^2
Phase current I RMS	12 A
Fuse	
anti-surge	16 A
type C MCB	16 A
Welding cable area	50 mm^2

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.*

5.4 Connecting the terminating resistor

To avoid communication interference, the remote socket must be fitted with a terminating resistor, when a remote control unit is not connected.

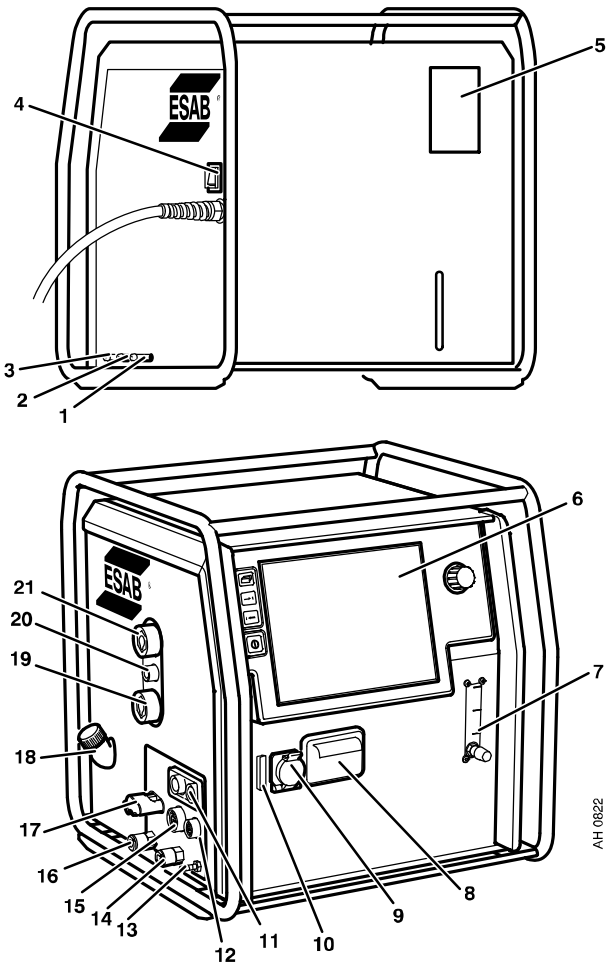


6 OPERATION

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

1 Connection for start gas in
2 Connection for weld gas in
3 Connection for root gas in
4 Switch for mains power
5 Rating plate for connection data
6 Control panel, see separate instruction manual
7 Gas flow meter
8 Printer
9 USB connection, see point 6.3.
10 Connection for documentation system WMS 4000
11 Connection (CAN) for remote control unit, terminating resistor or welding station A25
12 Connection for wire feed
13 Root gas connection out
14 Weld and start gas connection out
15 Connection for rotation
16 Connection for coolant from tube welding tool RED
17 Connection with ELP* for coolant to the tube welding tool BLUE
18 Topping up with coolant
19 Connection for welding current (-)
20 Connection for manual TIG torch
21 Return cable connection (+)



*ELP = ESAB Logic Pump, see point 6.4.

6.2 Gas flow meter

NOTE! To achieve the correct flow, the flow must be measured at the tool.

The flow meter is calibrated for Argon gas at 4 bar pressure. The gas flow obtained from the tool can vary depending on the connected tool. If other pressures or gases are used, the gas flow must be measured at the workpiece.

ESAB recommends that a pressure regulator set for 4 bar is used.

6.3 USB connection

The external USB memory can be used to transfer programs to and from systems.

Note!
During normal use there is no risk of ”viruses” ”infecting” equipment. To eliminate the risk entirely, we recommend that the memory, which is used together with this equipment, not be used for any other purpose other than its intended.

Certain USB memories may not work with this equipment. We recommend using USB memories from a reputable supplier.

ESAB assumes no responsibility for any damage caused as a consequence of incorrect use of the USB memory.

6.4 Water connection

The power source is equipped with a detection system **ELP** (**E**SAB **L**ogic **P**ump) which checks that the water hoses are connected. When connecting a water-cooled tube welding tool, the water pump starts.

6.5 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 red flashing field with the text ”OVERHEAT” appears in the lower right-hand corner of the control panel.

When the temperature drops, the overheat protection is automatically reset and the field stops flashing red.

For further information see the control panel user manual.

6.6 Flow guard, water

The water flow guard blocks the power source if the coolant stops (minimum water flow 0.7 l/min). When this occurs the welding current is interrupted and an error message is shown on the control panel.

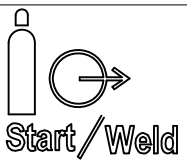
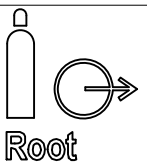
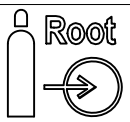
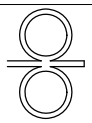
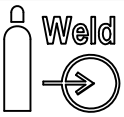
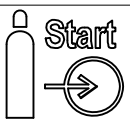
For further information see the control panel user manual.

6.7 Flow guard, gas

The flow guard stops the welding process if the gas flow falls below 4 l/min. When this occurs an error message appears on the control panel.

For further information see the control panel user manual.

6.8 Symbol explanations

	TIG-torch		Start and weld gas out
	Tube welding tool		Root gas out
	Rotation		Root gas in
	Wire feed		Weld gas in
			Start gas in

For detailed description of the function see instruction manual for the control panel.

7 MAINTENANCE

Regular maintenance is important for safe, reliable operation.

Only those persons who have appropriate electrical knowledge (authorized personnel) may remove the 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 Inspection and cleaning

Power source

Check regularly that the welding power source is not clogged with dirt.

How often and which cleaning methods apply depend on:

- welding process
- arc time
- placement
- surrounding environment.

It is normally sufficient to blow down the power source with dry compressed air (reduced pressure) once a year.

Clogged or blocked air inlets and outlets can cause overheating.

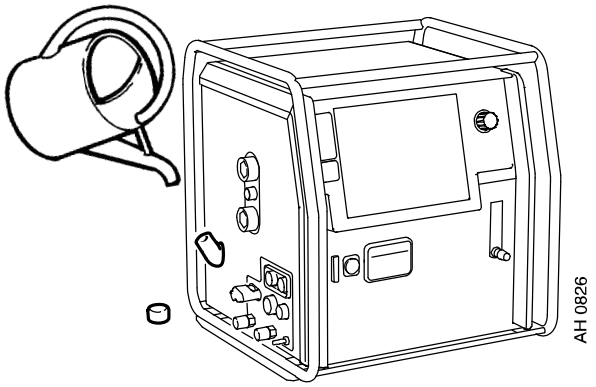
Tube welding tool

The tube welding tool's wear parts should be cleaned and replaced at regular intervals in order to achieve trouble-free welding.

7.2 Topping up the coolant

Top up with coolant to the level of the filling hole.

ESAB's refrigerant is recommended for use. See accessories on page 21.



CAUTION

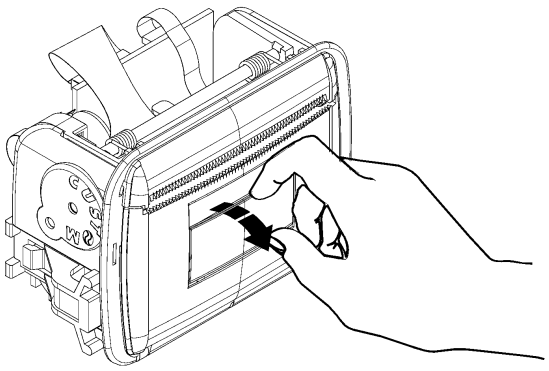
The coolant must be handled as chemical waste.

7.3 Printer

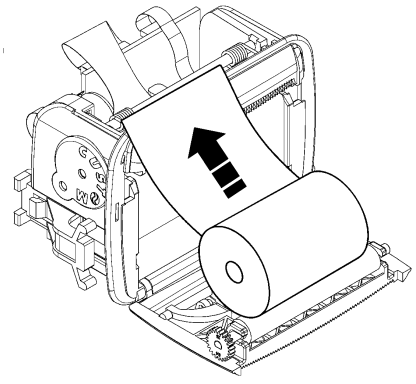
Changing the paper roll

To change the paper roll, proceed as described below:

1. Open the printer cover as shown in the figure.
2. Position the paper roll making sure it unrolls in the proper direction as shown in the figure.

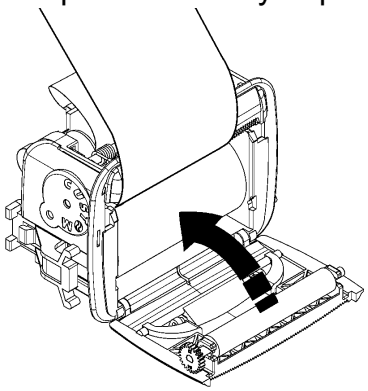


Opening the printer cover

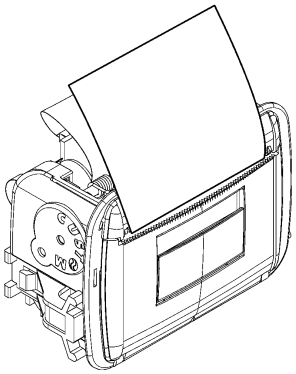


Positioning the paper roll

3. Pull out the paper and close the cover, as shown in the figure.
4. The printer is ready to print.



Closing the printer cover



Ready to print

8 FAULT-TRACING

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

Type of fault	Corrective action
No arc.	• Check that the mains power supply switch is turned on. • Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check the coolant flow. • Check the coolant level.
The welding current is interrupted during welding.	• Check whether the overheating protection has operated (fault code *6 2* is displayed on the control panel). • Check the coolant flow. • Check the mains power supply fuses.
The overheating protection trips frequently.	• Make sure that you are not exceeding the rated data for the welding power source (i.e. that the unit is not being overloaded).
Poor welding performance.	• Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check that the correct electrodes are being used. • Check the mains power supply fuses. • Check that the correct welding gas is being used.

9 ORDERING SPARE PARTS

MechTig C2002i is designed and tested in accordance with the international and European standards 60974-1, 60974-2, 60974-3 and 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.

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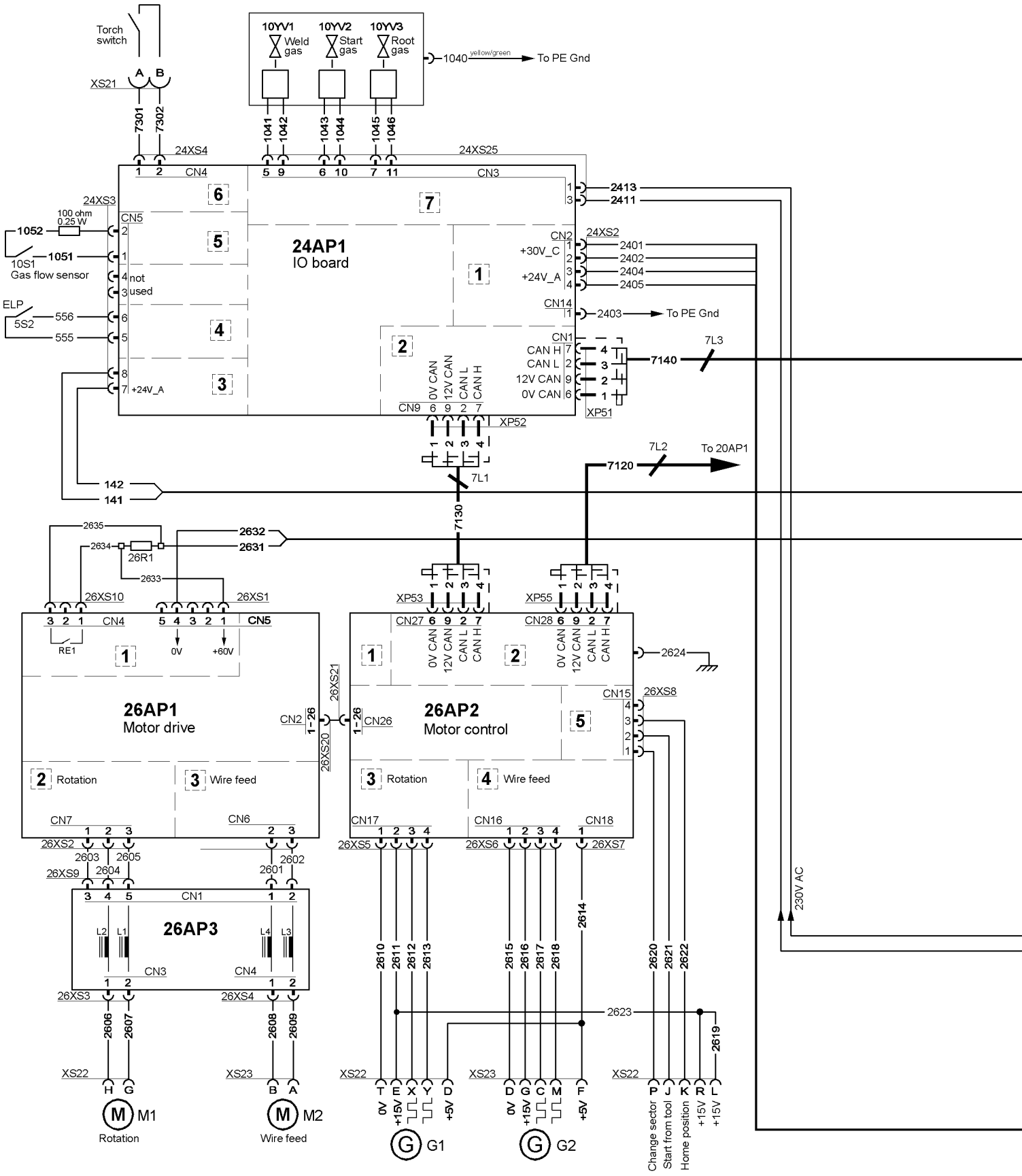
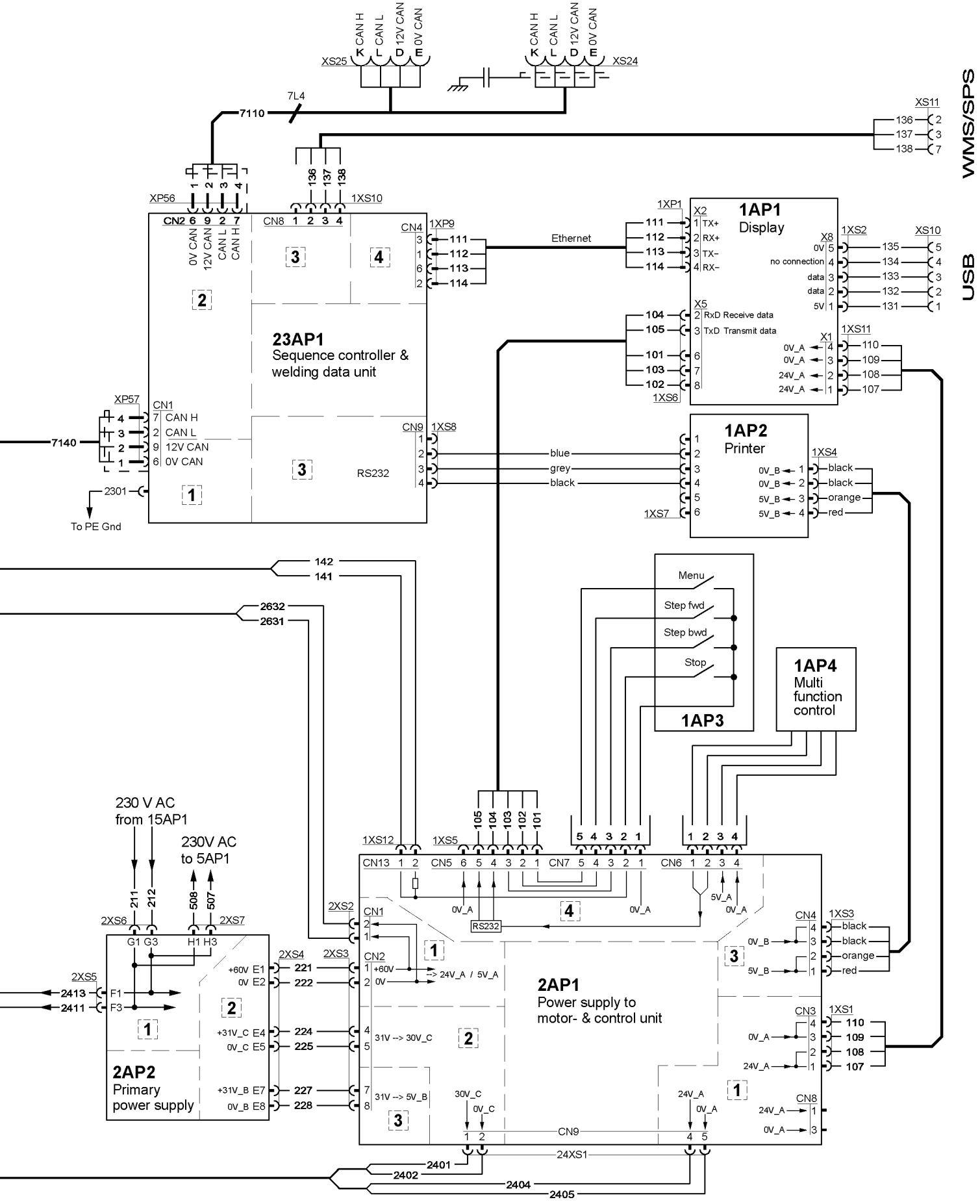
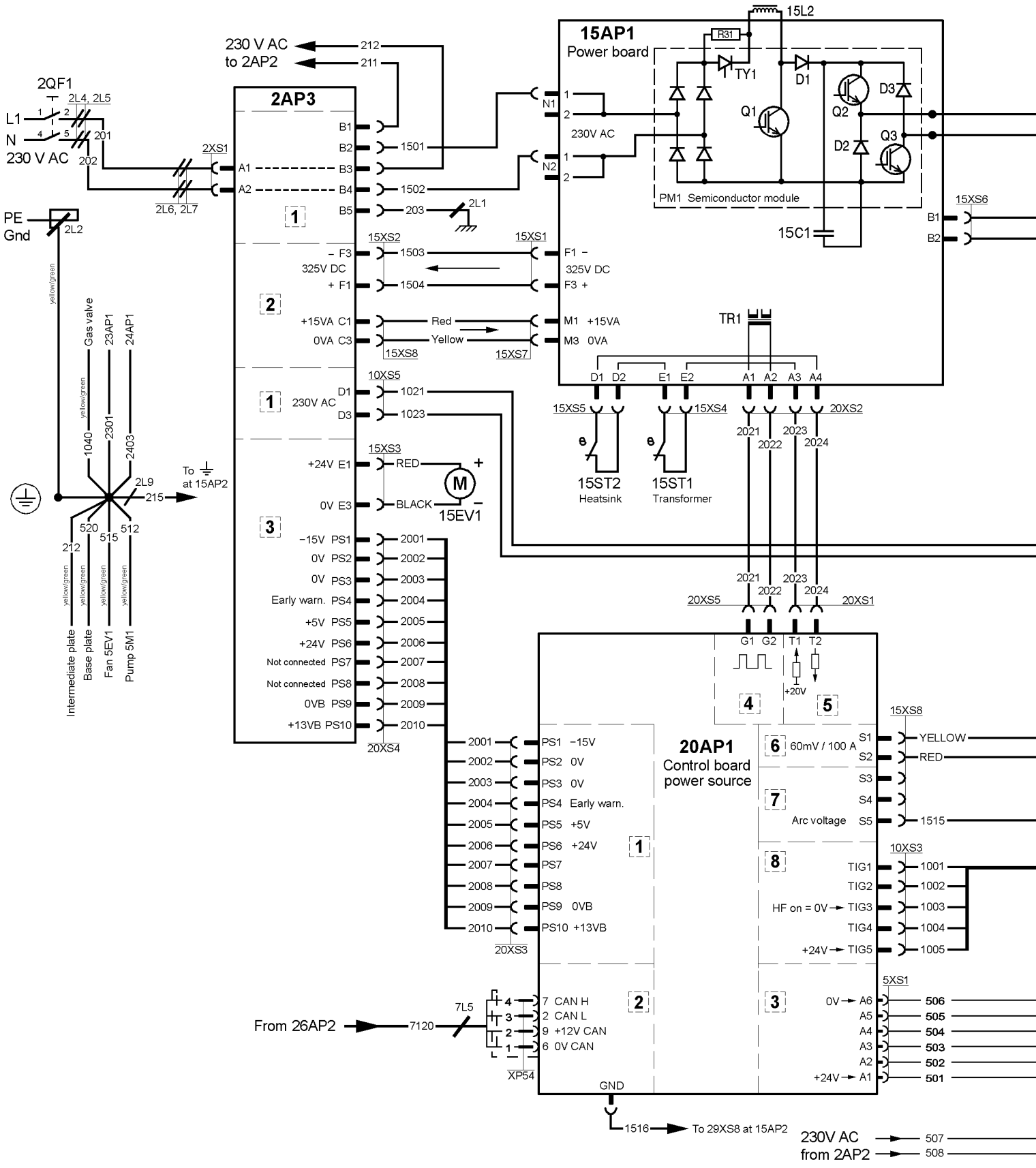
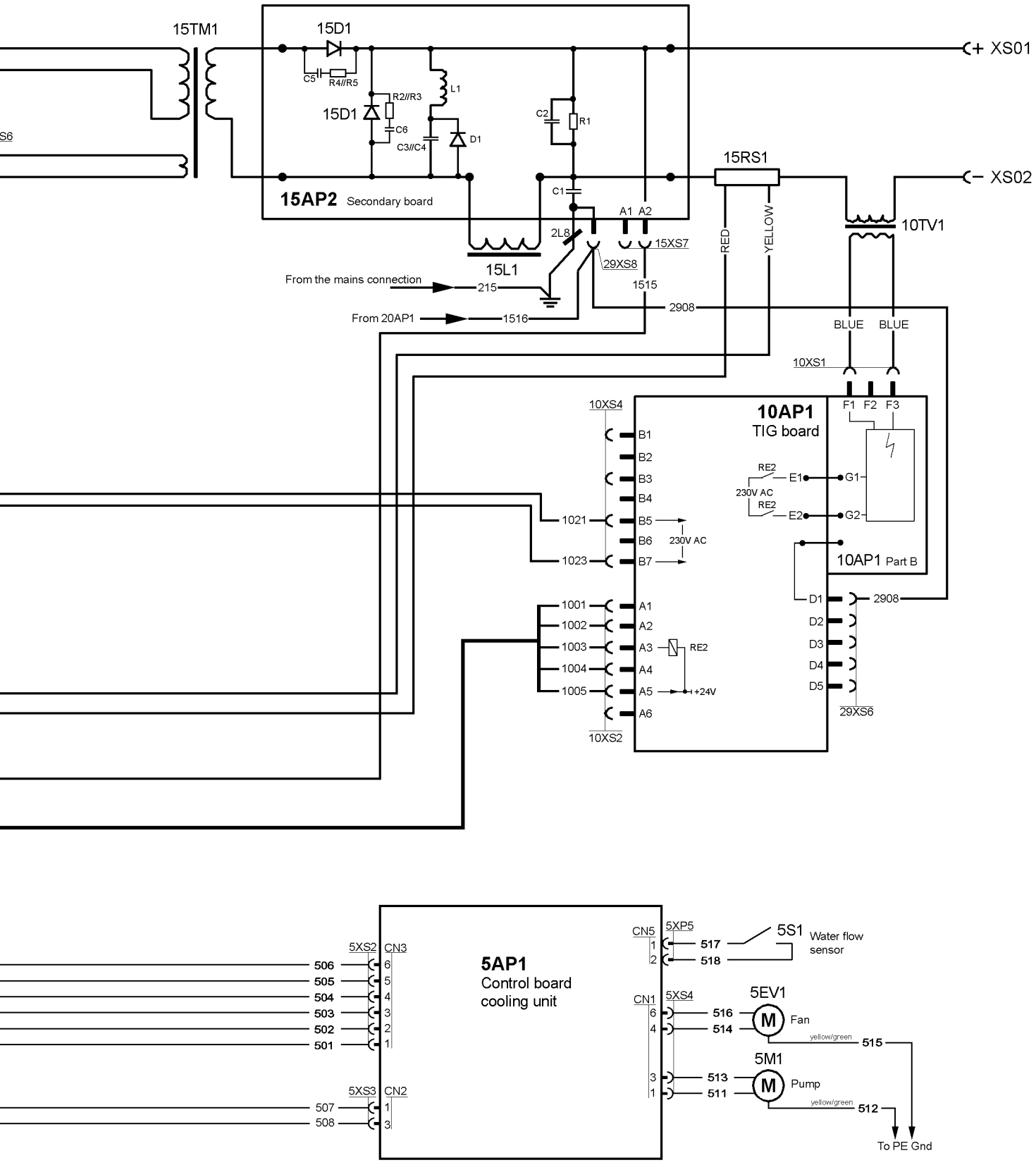
Diagram

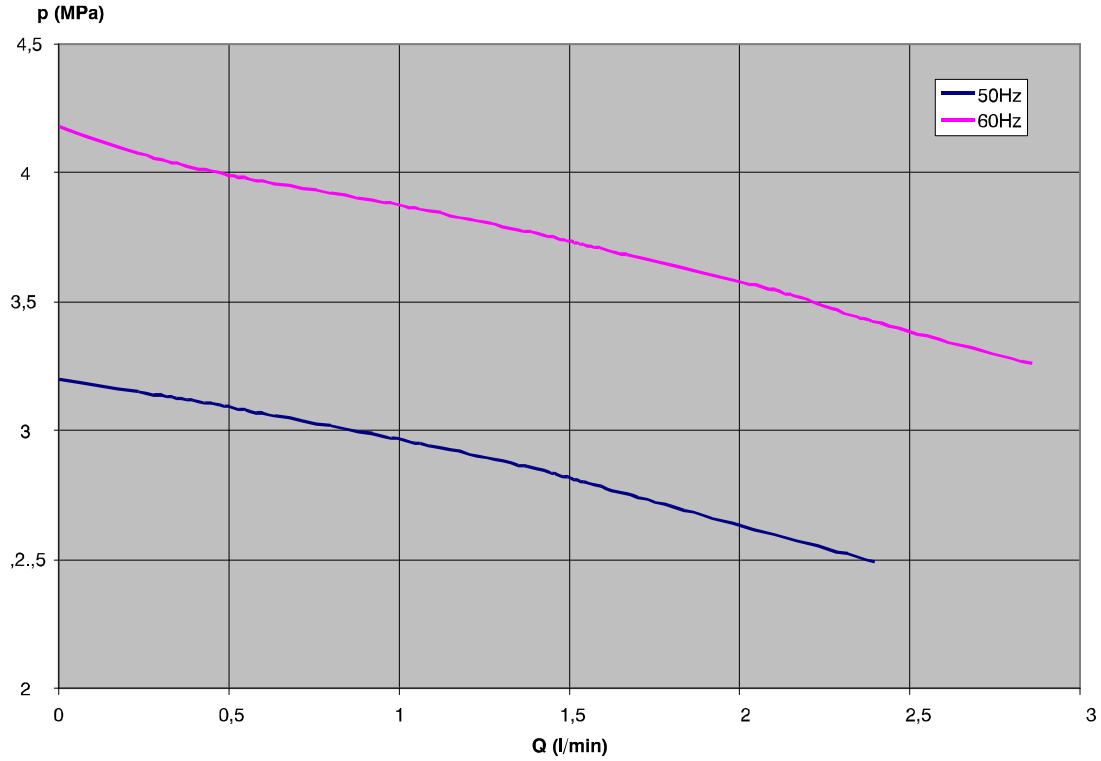

Torch switch
XS21
A
B
7301
7302
10YV1 Weld gas
10YV2 Start gas
10YV3 Root gas
1040 yellow/green
To PE Gnd
1041
1042
1043
1044
1045
1046
24XS4
24XS25
CN4
CN3
24XS3
CN5
100 ohm 0.25 W
1052
1051
10S1
Gas flow sensor
not used
ELP
5S2
556
555
+24V_A
24AP1
IO board
CN2
+30V_C
+24V_A
24XS2
2401
2402
2404
2405
CN14
2403
To PE Gnd
CN1
CAN H
CAN L
12V CAN
0V CAN
CN9
XP51
XP52
7L3
7140
7L2
7120
To 20AP1
7L1
7130
142
141
2635
2634
26R1
2633
2632
2631
26XS10
26XS1
XP53
XP55
CN4
CN5
RE1
0V
+60V
26AP1
Motor drive
CN2
26XS21
26XS20
CN26
26AP2
Motor control
CN27
CN28
2624
CN15
26XS8
Rotation
Wire feed
CN7
CN6
CN17
CN16
CN18
26XS2
26XS9
26XS5
26XS6
26XS7
2603
2604
2605
2601
2602
26AP3
CN1
CN3
CN4
26XS3
26XS4
2606
2607
2608
2609
2610
2611
2612
2613
2614
2615
2616
2617
2618
2620
2621
2622
2623
2619
XS22
XS23
M1
Rotation
M2
Wire feed
G1
G2
0V
+15V
+5V
Change sector
Start from tool
Home position
230V AC


WMS/SPS
USB
XS25
XS24
CAN H
CAN L
12V CAN
0V CAN
7L4
7110
XS11
136
137
138
XP56
1XS10
CN2
CN8
CN4
1XP9
23AP1
Sequence controller &
welding data unit
Ethernet
1XP1
1AP1
Display
X2
X8
1XS2
XS10
X5
X1
1XS11
1XS6
XP57
CN1
7140
CN9
1XS8
RS232
1AP2
Printer
1XS4
1XS7
2301
To PE Gnd
blue
grey
black
Menu
Step fwd
Step bwd
Stop
1AP3
1AP4
Multi
function
control
142
141
2632
2631
230 V AC
from 15AP1
230V AC
to 5AP1
211
212
508
507
2XS6
2XS7
2XS5
2413
2411
F1
F3
2AP2
Primary
power supply
2XS4
2XS3
2XS2
1XS12
1XS5
CN13
CN5
CN7
CN6
105
104
103
102
101
2AP1
Power supply to
motor- & control unit
+60V
0V
24V_A / 5V_A
31V --> 30V_C
31V --> 5V_B
30V_C
0V_C
24V_A
0V_A
5V_A
CN3
CN8
CN9
24XS1
2401
2402
2404
2405


15AP1
Power board
15L2
R31
TY1
D1
D3
Q1
Q2
Q3
D2
PM1 Semiconductor module
15C1
15XS6
B1
B2
230 V AC
to 2AP2
212
211
2AP3
2QF1
2L4, 2L5
L1
N
230 V AC
1
2
4
5
201
202
2XS1
2L6, 2L7
PE
Gnd
2L2
yellow/green
B1
B2
1501
A1
A2
B3
B4
1502
B5
203
2L1
1
N1
N2
230V AC
15XS2
15XS1
– F3
325V DC
+ F1
1503
1504
F1 –
325V DC
F3 +
2
+15VA C1
0VA C3
Red
Yellow
15XS8
15XS7
M1 +15VA
M3 0VA
TR1
D1 D2 E1 E2 A1 A2 A3 A4
10XS5
1
230V AC
D1
D3
1021
1023
15XS5
15XS4
20XS2
2021
2022
2023
2024
15ST2
Heatsink
15ST1
Transformer
15XS3
+24V E1
0V E3
RED
BLACK
M
15EV1
3
−15V PS1
0V PS2
0V PS3
Early warn. PS4
+5V PS5
+24V PS6
Not connected PS7
Not connected PS8
0VB PS9
+13VB PS10
2001
2002
2003
2004
2005
2006
2007
2008
2009
2010
20XS4
20XS5
20XS1
Gas valve
23AP1
24AP1
1040
2301
2403
2L9
215
To
at 15AP2
520
515
512
212
Intermediate plate
Base plate
Fan 5EV1
Pump 5M1
G1 G2 T1 T2
+20V
4
5
20AP1
Control board
power source
PS1 −15V
PS2 0V
PS3 0V
PS4 Early warn.
PS5 +5V
PS6 +24V
PS7
PS8
PS9 0VB
PS10 +13VB
20XS3
6
60mV / 100 A
S1
S2
S3
S4
S5
7
Arc voltage
15XS8
YELLOW
RED
1515
8
10XS3
TIG1
TIG2
HF on = 0V
TIG3
TIG4
+24V
TIG5
1001
1002
1003
1004
1005
5XS1
From 26AP2
7120
7L5
4
3
2
1
XP54
7 CAN H
2 CAN L
9 +12V CAN
6 0V CAN
2
3
0V
+24V
A6
A5
A4
A3
A2
A1
506
505
504
503
502
501
GND
1516
To 29XS8 at 15AP2
230V AC
from 2AP2
507
508

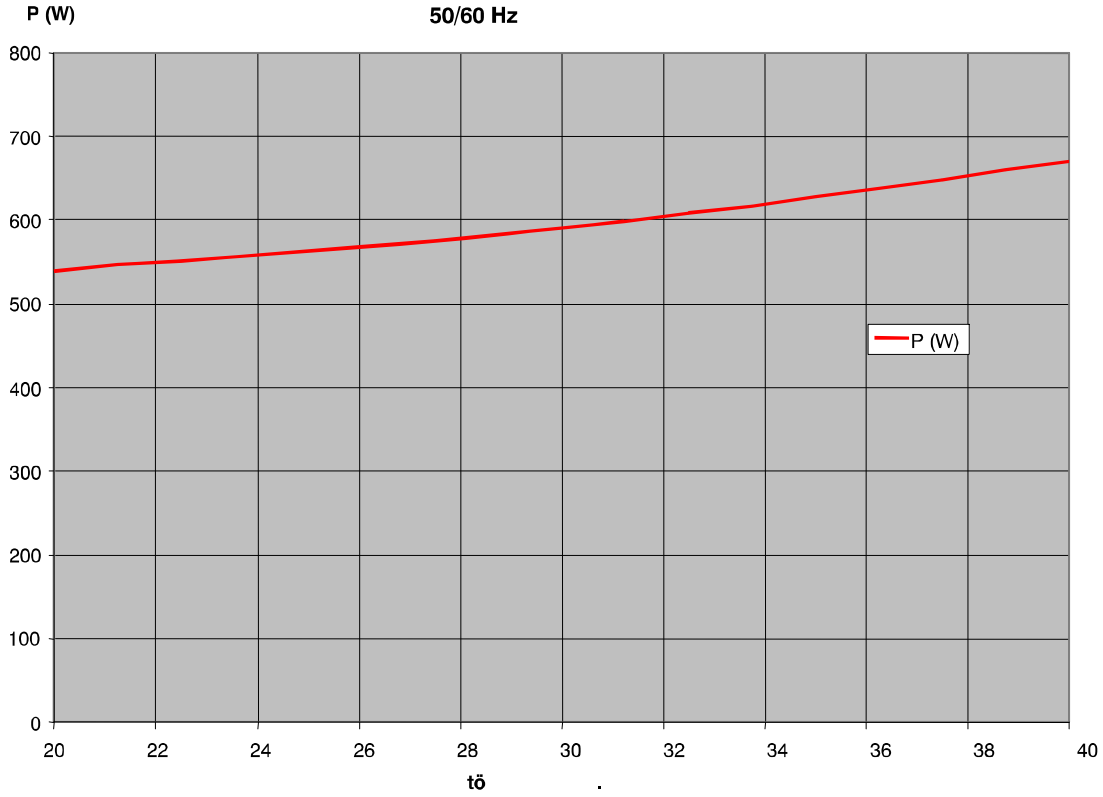

15TM1
15D1
C5
R4//R5
15D1
R2//R3
C6
C3//C4
L1
D1
C2
R1
C1
15AP2 Secondary board
15RS1
+ XS01
– XS02
10TV1
RED
YELLOW
A1 A2
2L8
15XS7
29XS8
15L1
From the mains connection
215
1515
From 20AP1
1516
2908
BLUE BLUE
10XS1
F1 F2 F3
10XS4
10AP1
TIG board
B1
B2
B3
B4
B5
B6
B7
1021
1023
230V AC
RE2
E1
G1
230V AC
RE2
E2
G2
10AP1 Part B
D1
D2
D3
D4
D5
2908
29XS6
1001
1002
1003
1004
1005
A1
A2
A3
A4
A5
A6
RE2
+24V
10XS2
5AP1
Control board
cooling unit
5XS2
CN3
506
505
504
503
502
501
5XS3
CN2
507
508
CN5
5XP5
517
518
5S1
Water flow
sensor
CN1
5XS4
516
514
5EV1
Fan
yellow/green
515
5M1
513
511
Pump
yellow/green
512
To PE Gnd

Pump data



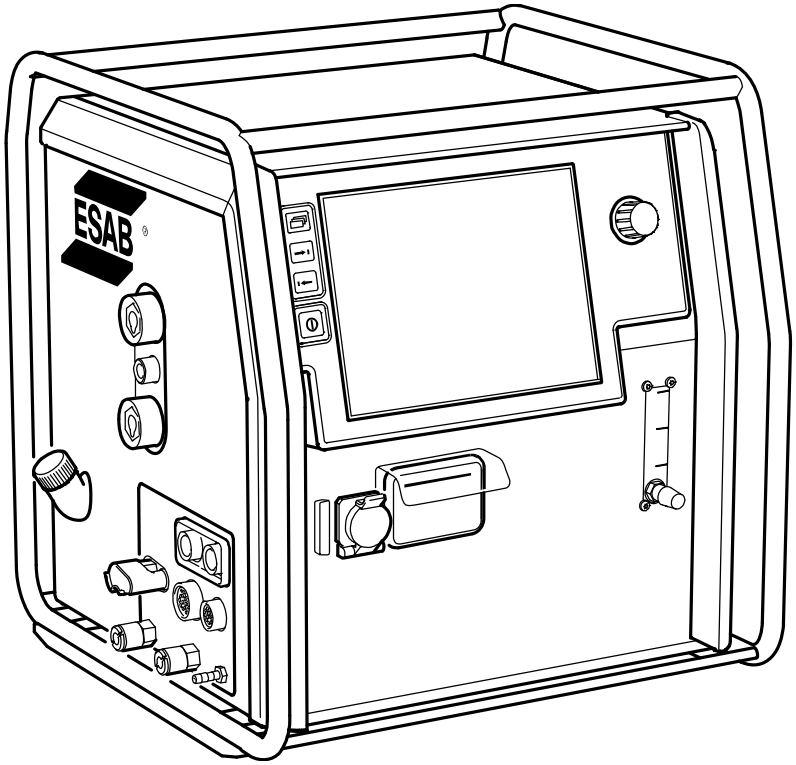
P = Pump pressure
Q = Flow rate

Cooling caracteristic



P = Power
tö = Flow rate

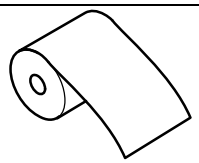
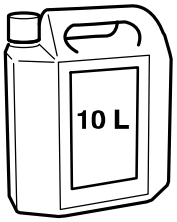
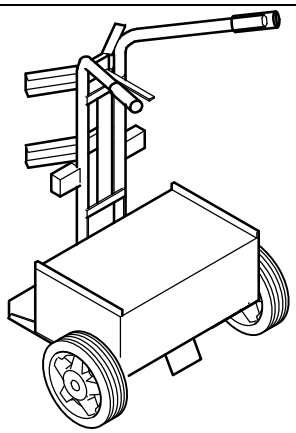
Ordering number



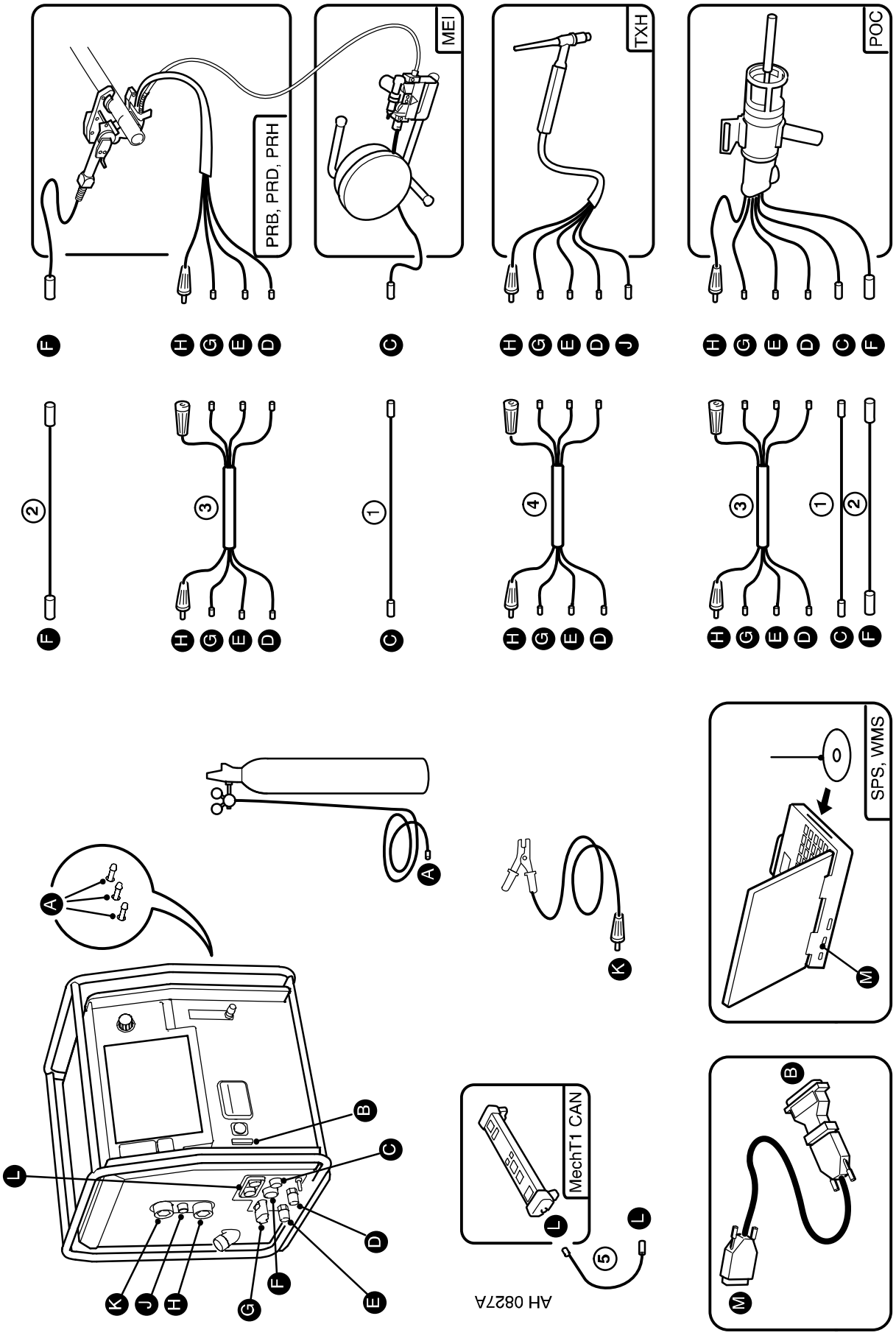
Ordering no.	Denomination	Type
0444 700 880	Welding power source	Aristo™ MechTig C2002i, WO100
0459 839 009	Spare parts list	Aristo™ MechTig C2002i, WO100
0444 536	Instruction manual	Control panel WO100

Instruction manuals and the spare parts list are available on the Internet at **www.esab.com**

Accessories

	**Thermal paper**	0444 529 002
	**Coolant** (ready mixed) 50 % water and 50% monoethylene glycol (10 l) . . .	0007 810 012
	**Carriage**	0301 100 880

Product	Ordering number
Tube welding tool PRB	
17-49 watercooled	0443 750 882
33-90 watercooled	0443 760 882
60-170 watercooled	0443 770 882
17-49 aircooled	0443 750 883
33-90 aircooled	0443 760 883
60-170 aircooled	0443 770 883
Tube welding tool PRD	
160 (for meltwelding with floating head)	0444 151 880
160 with wire feeder	0444 151 881
Tube welding tool PRH	
3-12 enclosed	0444 300 880
3-38 enclosed	0444 301 880
6-76 enclosed	0444 302 880
Tube welding tool POC 12-60 with wire feed unit	0443 930 880
TIG hand torch TXH 400W (4 m OKC)	0460 014 840
Wire feed unit MEI 10	
for PRB 17-49	0444 211 880
for PRB 33-90	0444 212 880
for PRB 60-170	0444 213 880
Wire feed unit MEI 21	0443 830 880
Remote control unit MechT1 CAN	0460 181 880
⑤ **Remote cable** CAN 4 pole - 12 pole,	
5 m	0459 554 880
10 m	0459 554 881
15 m	0459 554 882
25 m	0459 554 883
0.25 m	0459 554 884
Documentation system	
Welddoc™ WMS 40000	0457 410 880
SPS 4000	0457 410 881
Opto cable, 15 m	0457 072 881
Opto cable, 2 m	0457 072 882
Return cable 4,5 m, 25 mm^2	0156 743 909
Extension cable	
① for wire feed unit and CAN 42 V, 10 m	0456 904 880
② for rotation, 10 m	0456 906 880
Extension set	
③ for current, water and gas, 8 m	0456 905 880
④ for current, water, gas and torch contact, 8 m	0466 705 881


PRB, PRD, PRH
MEI
TXH
POC
SPS, WMS
MechT1 CAN
AH 0827A

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