

# Robust Feed Pulse/U6

Portable and rugged wire feeders for pulse applications



*Robust Feed Pulse*

*Robust Feed U6*

The Robust Feed, with its ergonomic, robust and enclosed design, is the ideal partner whenever portability and durability are key. These new pulse welding wire feeders are equipped with a new precision wire drive system perfect for demanding applications. Additional features include an MMA outlet and integrated flow meter.

Robust Feed Pulse control functions are easy to find, set and fine-tune, while the Robust Feed U6 offers additional functionality including parameter limits and parameter lock for better repeatability. Both units offers synergic lines to address a wide variety of steel, aluminium and stainless steel wires.

## Industry

- Industrial and General Fabrication
- Structural Steel Fabrication
- Steel Erectors
- Marine and Offshore
- Transportation
- Railcars
- Mobile Equipment
- Tank and Vessel Fabrication
- Pressure Vessels
- Energy

- Fully portable feeder offering the benefits of pulse - reducing weld spatter and post weld clean up, controlling bead appearance and profile, increased speed for position welding and more depending on the application
- Durable, drop-proof housing that withstands demanding applications
- Great portability with ergonomic handles, 5 lifting points and safe for crane lifting handles
- Weatherproof, enclosed design that withstands rain from all directions and inside heater ensures the filler metal is kept dry
- Protected cable connectors and sturdy strain relief for interconnection cable reduces maintenance
- Works as great in the field as in workshops, on a trolley, with or without wheel kit, and other options and accessories

Visit [esab.com](http://esab.com) for more information.



*Internal LED lights and intergrated storage for wear parts in lid*



*Wheel Kit and Torch Strain Relief works with feeder horizontal or vertical*

## Specifications

Input Voltage	42 VAC
Welding Output	630 A @ 35% 500 A @ 60% 400 A @ 100%
Wire Dimensions Mild Steel Stainless Steel Cored Wire Aluminium	0.6–2.0 mm (0.023–5/64 in.) 0.6–1.6 mm (0.023–1/16 in.) 0.8–2.4 mm (0.031–3/32 in.) 0.8–1.6 mm (0.031–1/16 in.)
Wire Feed Speed	0.8 – 25.0 m/min
Wire Spool Capacity	20 kg
Max Spool Diameter	300 mm
Operating Temperature	-20° to +55 °C
Protection Class	IP44
Certification Mark (Standards)	CE
Dimensions L x W x H	595 x 250 x 430 mm
Weight	16.7 kg

## Panel Functions

	<b>Robust Feed Pulse + Aristo 500ix</b>	<b>Robust Feed U6 + Aristo 500ix</b>
MIG CV	x	x
MIG Pulse	x	x
Synergic Lines	Steel, Stainless Steel, Aluminium 93 lines	Steel, Stainless Steel, Aluminium 92 lines
MMA	MMA controls and outlet on wire feeder *	MMA controls and outlet on wire feeder *
Gouging		Gouging controls and outlet on wire feeder *
Gas Flow Meter	x *	x *
Heat Kit	x *	x *
2T/4T	x	x
Hot Start	x	x
Creep Start	x	x
Crater Fill	x	x
Burnback	x	x
SCT	x	x
Amperage Setting	x	x
Gas Pre- and Post-flow Setting	x	x
Qset	x	x
Memory Settings	3	10
Spot Welding Time		x
Setting Limits		x
Code Lock		x

\* Depending on variant

<b>Ordering Information</b>	
Robust Feed Pulse Water-cooled Euro	0445800894
Robust Feed Pulse (incl. gas flow meter, heater, MMA outlet) Water-cooled Euro	0445800891
Robust Feed Pulse (incl.push-pull, ELP, gas flow meter, heater, MMA outlet) Water-cooled Euro *	0445800892
Robust Feed U6 Water-cooled Euro	0445800897
Robust Feed U6 (incl. gas flow meter, heater, MMA outlet) Water-cooled Euro	0445800887
Robust Feed U6 (incl. push-pull, ELP, gas flow meter, heater, MMA outlet) Water-cooled Euro *	0445800888

*ELP feature needed for use with legacy equipment for example Cool 1.*

*MTA1 CAN, AT1 CAN and other digital remote controls can be used on packages ending in 891, 894, 887, and 897.*

*M1, AT1 and other analogue remote controls can be used on packages ending in 892 and 888.*

*\* Robust Feed Pulse/U6 with push-pull has support for remote control and mechanisation with Miggytrac/Railtrac.*

<b>Options &amp; Accessories</b>	
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Robust Feed Wheel Kit	0446081880
Torch Strain Relief	0446082880
Trolley (Robust Feed/Warrior Feed/Aristo Feed)	0349313450
Trolley Retrofit Kit Robust Feed †	0349313100
Guide Pin Extension Kit **	0465508880
Liquid Cooling Kit (to upgrade gas-cooled feeders)	0446123880
Quick Connector Marathon Pac™	F102440880

*† To fit Robust Feed on existing Warrior Trolley 0465510880*

*\*\* Extension Kit required when Wire Feeder Wheel Kit is used in combination with Trolley.*

<b>Torches</b>			
	<b>3 m</b>	<b>4 m</b>	<b>5 m</b>
PSF 415, with Euro Connection	0700025040	0700025041	0700025042
PSF 515, with Euro Connection	0700025050	0700025051	0700025052
PSF 420W, with Euro Connection	0700025060	0700025061	0700025062
PSF 520W, with Euro Connection*	0700025070	0700025071	0700025072

*\* With dual-circuit cooling system for less heat, better wire feedability and fewer production stops to change wear parts.*

<b>Interconnection Cables</b>		
	<b>Gas-Cooled</b>	<b>Water-Cooled</b>
Interconnection Cables - 70mm <sup>2</sup> , 2.0m, incl. strain relief	0446255880	0446255890
Interconnection Cables - 70mm <sup>2</sup> , 5.0m, incl. strain relief	0446255881	0446255891
Interconnection Cables - 70mm <sup>2</sup> , 10.0m, incl. strain relief	0446255882	0446255892
Interconnection Cables - 70mm <sup>2</sup> , 15.0m, incl. strain relief	0446255883	0446255893
Interconnection Cables - 70mm <sup>2</sup> , 20.0m, incl. strain relief	0446255884	0446255894
Interconnection Cables - 70mm <sup>2</sup> , 25.0m, incl. strain relief	0446255885	0446255895
Interconnection Cables - 70mm <sup>2</sup> , 35.0m, incl. strain relief	0446255886	0446255896
Interconnection Strain Relief Kit Aristo **	0446050881	

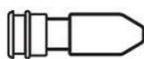
*\*\* To upgrade existing Aristo interconnection cable sets to fit with Robust Feed*

## Wear & Spare Parts

Feed Roller V Groove for Fe/SS/C 0.6-0.8 mm	0445850001
Feed Roller V Groove for Fe/SS/C 0.8-0.9/1.0 mm	0445850002
Feed Roller V Groove for Fe/SS/C 0.9/1.0-0.9/1.0 mm	0445850003
Feed Roller V Groove for Fe/SS/C 0.9/1.0-1.2 mm *	0445850004
Feed Roller V Groove for Fe/SS/C 1.2-1.2 mm	0445850005
Feed Roller V Groove for Fe/SS/C 1.4-1.6 mm	0445850006
Feed Roller V Groove for Fe/SS/C 2.0 mm	0445850007
Feed Roller V-K Groove for C 0.9/1.0-1.2 mm	0445850030
Feed Roller V-K Groove for C 1.2-1.2 mm	0445850031
Feed Roller V-K Groove for C 1.2-1.4 mm	0445850032
Feed Roller V-K Groove for C 1.6-1.6 mm	0445850033
Feed Roller V-K Groove for C 2.0-2.0 mm	0445850035
Feed Roller V-K Groove for C 2.4-2.4 mm	0445850036
Feed Roller U Groove for Al 0.8-1.0mm	0445850050
Feed Roller U Groove for Al 1.0-1.2mm	0445850051
Feed Roller U Groove for Al 1.2-1.6mm	0445850052
Inlet Wire Guide Ø 2 mm for Fe/SS/Al/C 0.6-1.6mm	0445822001
Inlet Wire Guide Ø 3 mm for Fe/C 1.8-2.4 mm	0445822002
Middle Wire Guide for Fe/SS/C 0.6-1.6 mm	0446080882
Middle Wire Guide for Fe/C 1.8-2.4 mm	0446080883
Middle Wire Guide for Al 0.8-1.6 mm	0446080881
Outlet Wire Guide for Fe/SS/C 0.6-1.6 mm	0445830881
Outlet Wire Guide for Fe/C 1.8-2.4 mm	0445830882
Outlet Wire Guide for Al 0.8-1.6 mm	0445830885

*Fe = Mild Steel; SS = Stainless Steel, Al = Aluminium, C = Cored Wire \* Included in delivery.  
For complete list of wear and spare parts please see separate manual.*

*Inlet Wire Guide*



*Middle Wire Guide*



*Outlet Wire Guide*



*Dual Groove Feed Roller*



*V Groove*



*V-K Groove*



*U-Groove*



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