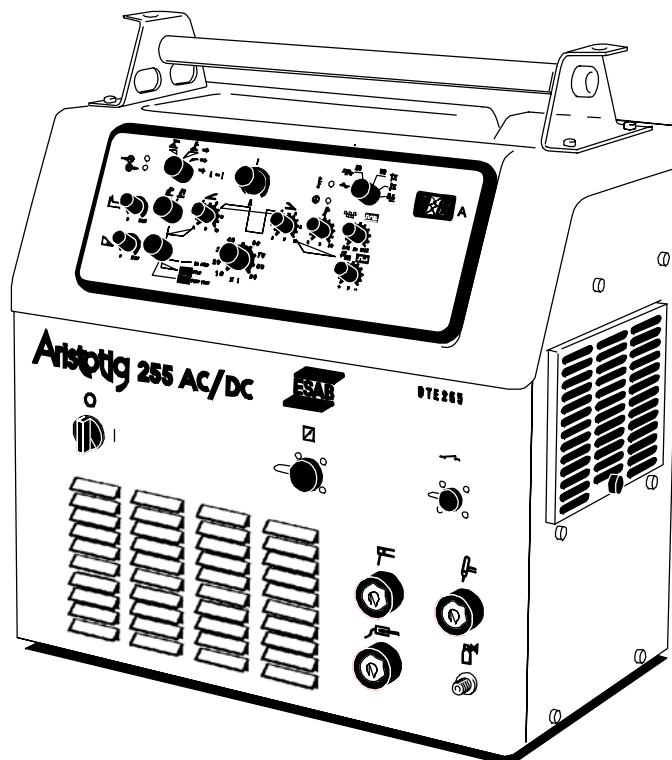


Spare parts list



Valid for serial no. 810-xxx-xxxx, 844-xxx-xxxx, 934-xxx-xxxx, 948-xxx-xxxx, 246-xxx-xxxx

Ordering number

0301 035 880 DTE 255 with central connection for the TIG torch

0301 035 881 DTE 255 with OKC connection for the TIG torch

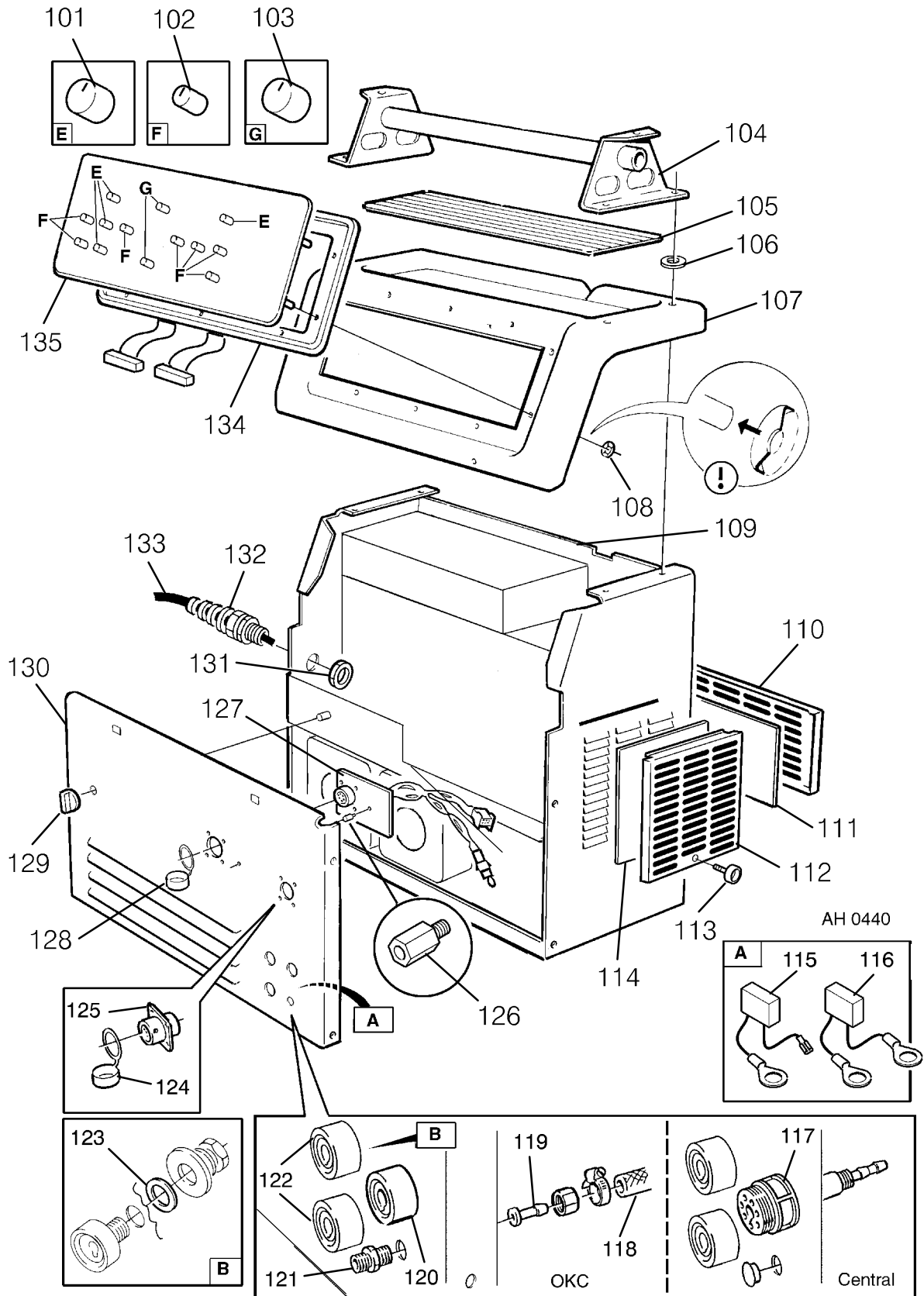
Spare parts are to be ordered through the nearest ESAB agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

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

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
101	4	0192 296 104	Knob		
102	7	0191 508 102	Knob		
103	2	0192 296 102	Knob		
104	1	0468 543 882	Handle		
105	1	0468 529 001	Rubber mat		
106	4	0365 534 001	Sealing washer		
107	1	0301 015 001	Cover	When the cover is replaced, items 108 and 134 must also be replaced	
108	10	0192 859 006	Locking washer	Must be pressed with 50 kg pressure when fitted.	
109	1	0301 021 001	Rear plate		
110	1	0301 028 001	Grill		
111	1	0301 054 001	Filter		
112	1	0301 027 001	Grill		
113	3	0441 819 001	Screw		
114	1	0301 053 001	Filter		
115	1	0457 817 881	Capacitor	47 nF, 275 V AC, with cable lugs	C06
116	1	0457 817 880	Capacitor	47 nF, 1000 V AC, with cable lugs	C07
117	1	0367 258 880	Central connection	For machines with central TIG connection	XS12
118		0190 209 114	Hose	To be ordered per metre	
119	1	0252 103 501	Hose nipple	For machines with OKC TIG connection	
120	1	0156 868 880	OKC-TIG	For machines with OKC TIG connection	XS12
121	1	0156 867 001	Gas outlet bushing	For machines with OKC TIG connection	
122	2	0160 362 881	OKC		XS13, XS14
123	2	0466 325 001	Gasket	For machines with central TIG connection	
	3	0466 325 001	Gasket	For machines with OKC TIG connection	
124	1	0457 626 001	Cap		
125	1	0538 500 902	Connector socket	For machines with OKC TIG connection	XS15
126	1	0394 516 005	Spacer		
127	1	0486 634 880	Circuit board	With connector	AP06
	2	0193 260 150	Connector	2-pole	XA, XD
	1	0193 260 153	Connector	5-pole	XC
128	1	0366 285 001	Cap		
129	1	0366 296 003	Knob		
130	1	0301 049 001	Front plate		
131	1	0212 602 202	Nut		
132	1	0193 307 105	Cable clamp	Cable inlet	
133	1	0467 696 886	Mains cable		
-	2	0194 034 002	Ferrite ring core	To be fitted close to the mains cable inlet	L04
134	1	0468 304 001	Rubber seal		
135	1	0301 069 883	Panel complete	Front panel, circuit board AP05, 13 knobs (items 101, 102 and 103) and 12 locking washers (item 108) are included. When replacing item 135, item 134 must also be replaced. NOTE: This panel does only fit in machines having processor board AP04 with part no. 0486 770 880. If the machine has a processor board with part no. 0486 665 880, this must also be replaced.	AP05
	1	0193 260 160	Connector	12-pole	XA

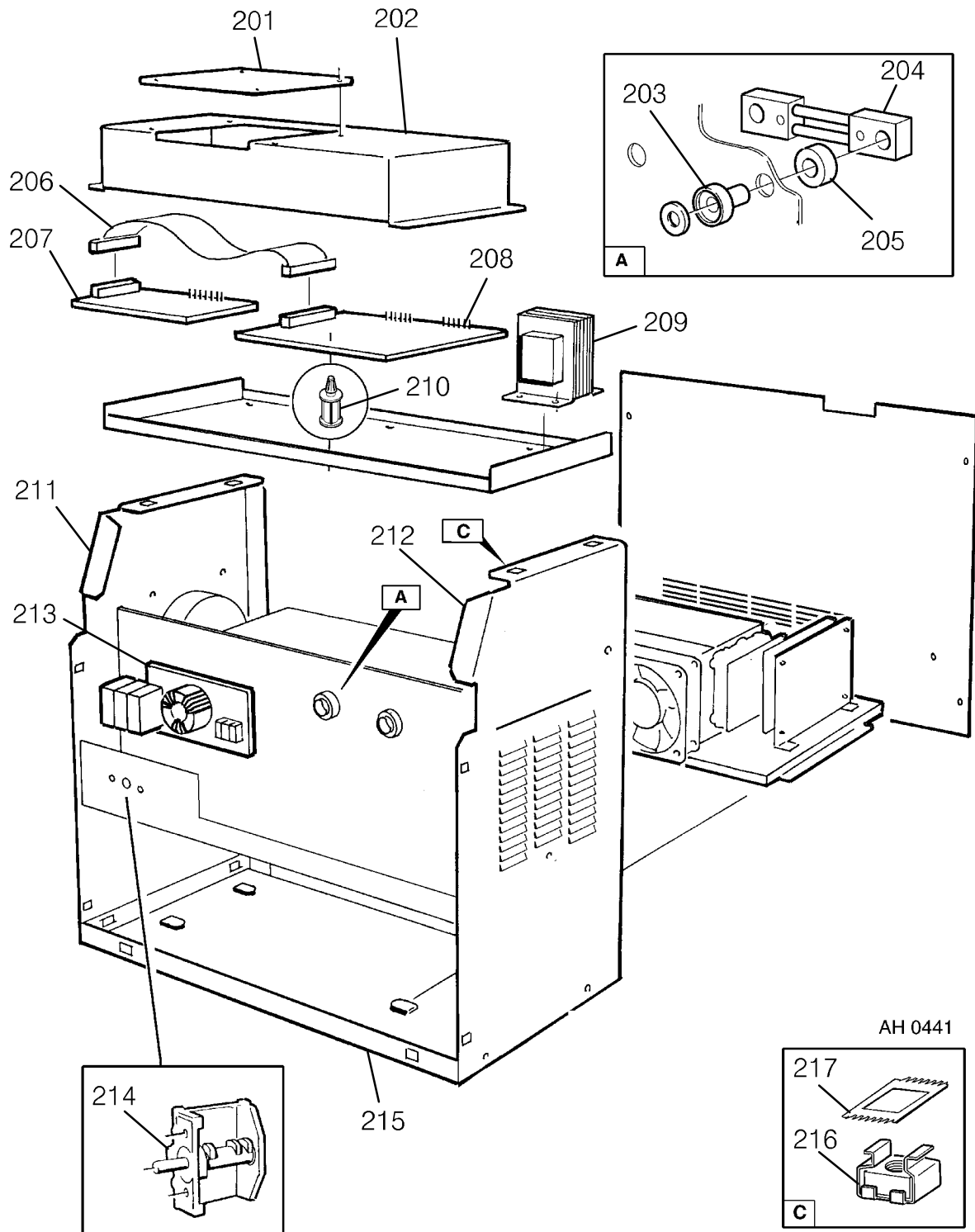
DTE 255



C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
201	1		Cover	Replaced by item 202	
202	1	0301 075 001	Screening box	New design with built-in cover, fits to all machines	
203	2	0162 414 001	Insulating tube		
204	1	0301 041 001	Shunt	250 A / 60 mV	RS01
205	2	0163 139 001	Bushing		
206	1	0193 700 401	Ribbon cable	Connectors AP01:XD and AP04:X1/XA are included	
207	1	0486 770 880	Circuit board	Replacing circuit board 0486 665 880, fits in all machines	AP04
	1	0193 260 153	Connector	5-pole	X4/XD
	1	0193 260 155	Connector	7-pole	X9/XB
208	1	0486 810 880	Circuit board	Replacing circuit board 0486 657 880	AP01
	1	0193 260 151	Connector	3-pole	XA
	1	0193 260 158	Connector	10-pole	XB
	1	0193 494 003	Ferrite ring core		L05
	3	0193 260 150	Connector	2-pole	XE, XF, XG
	1	0193 260 153	Connector	5-pole	XI
	2	0193 260 152	Connector	4-pole	XK, XL
209	1	0301 006 001	Control transformer		TC01
210	10	0192 790 103	Spacer		
211	1	0301 016 001	Side panel (left)		
212	1	0301 017 001	Side panel (right)		
213	1	0486 577 880	Circuit board	EMC filter	AP08
214	1	0366 295 004	Switch		QF01
215	1	0301 033 001	Base plate		
216	4	0192 562 105	Cage nut	M6	
217	4	0320 029 002	Ground stud		

DTE 255

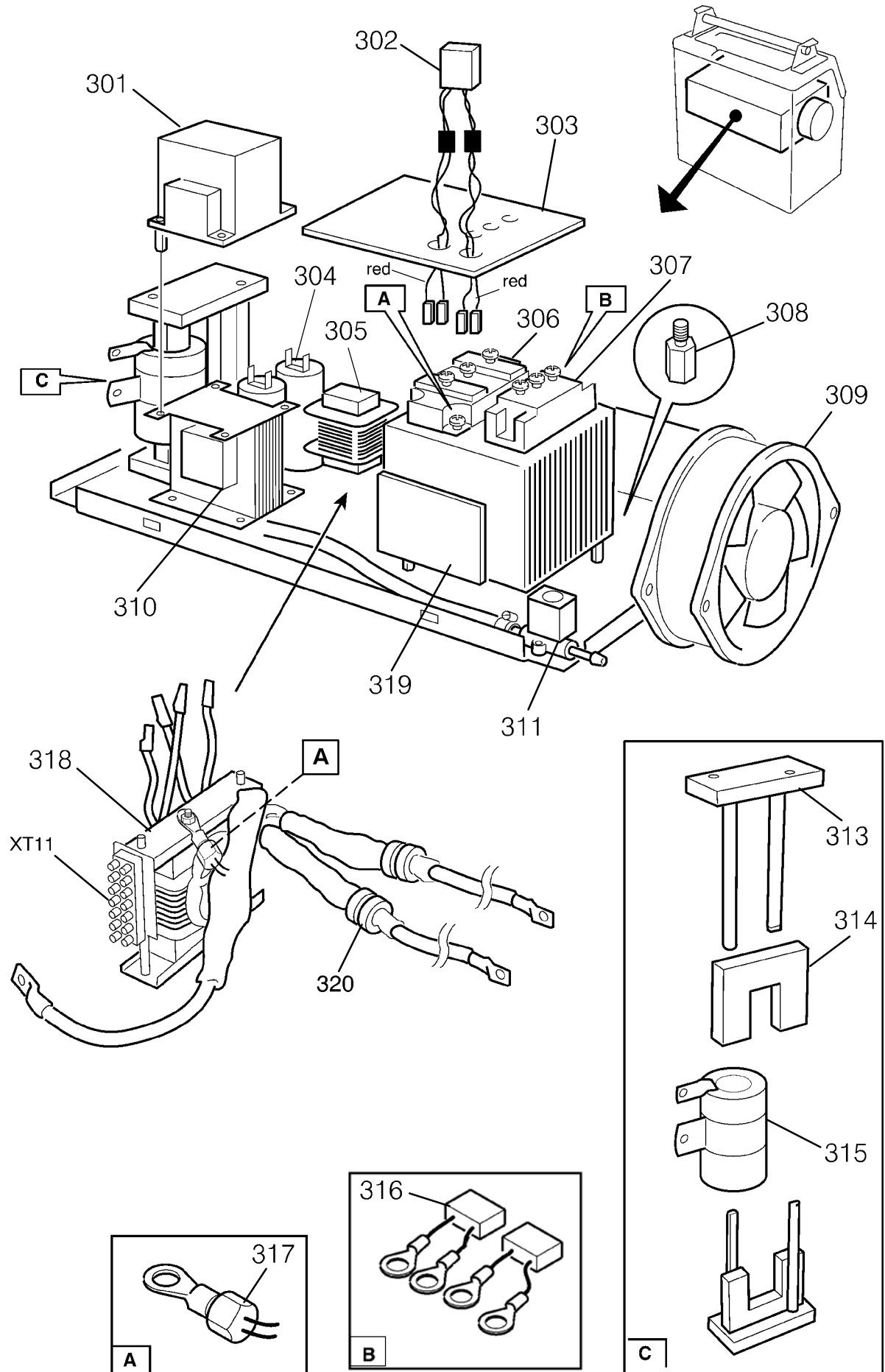


C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
301	1	0367 268 001	HF unit		AP13
302	1	0486 603 880	IGBT connection	Safety circuit boards with connectors	AP11, AP12
303	1	0486 613 880	Circuit board	IGBT	AP02
	4	0193 260 150	Connector	2-pole	XA, XB, XE, XF
304	2	0191 085 208	Capacitor	10 μ F, 450 V AC	C04, C05
305	1	0365 591 882	Primary inductor		L01
306	1	0194 073 001	IGBT module		Q5
		0192 058 101	Thermal compound	For fitting of Q01 - Q04, Q05 and V07	
307	1		Diode module	See item 350	V07
308	4	0394 516 031	Spacer screw		
309	1	0466 109 001	Fan	230 V AC	EV01
310	1	0301 026 880	Secondary inductor		L02
311	1	0193 054 002	Solenoid valve	42 V AC	YV01
313	2	0467 755 001	Attachment		
314	2	0466 895 001	Ferrite core		
315	1	0457 841 880	HF coil		TV01
316	2	0320 805 887	Capacitor	0.01 μ F, 1000 V	C10, C11
317	2	0194 050 001	PTC resistor	Thermal sensor	ST01, ST03
318	1	0301 007 880	Main transformer	Item 320 is included	TM01
319	1	0486 607 880	Circuit board	Mains rectifier	AP03
	1	0193 260 153	Connector	5-pole	XB
320	4	0193 494 004	Ferrite ring cores	Included in TM01	L03

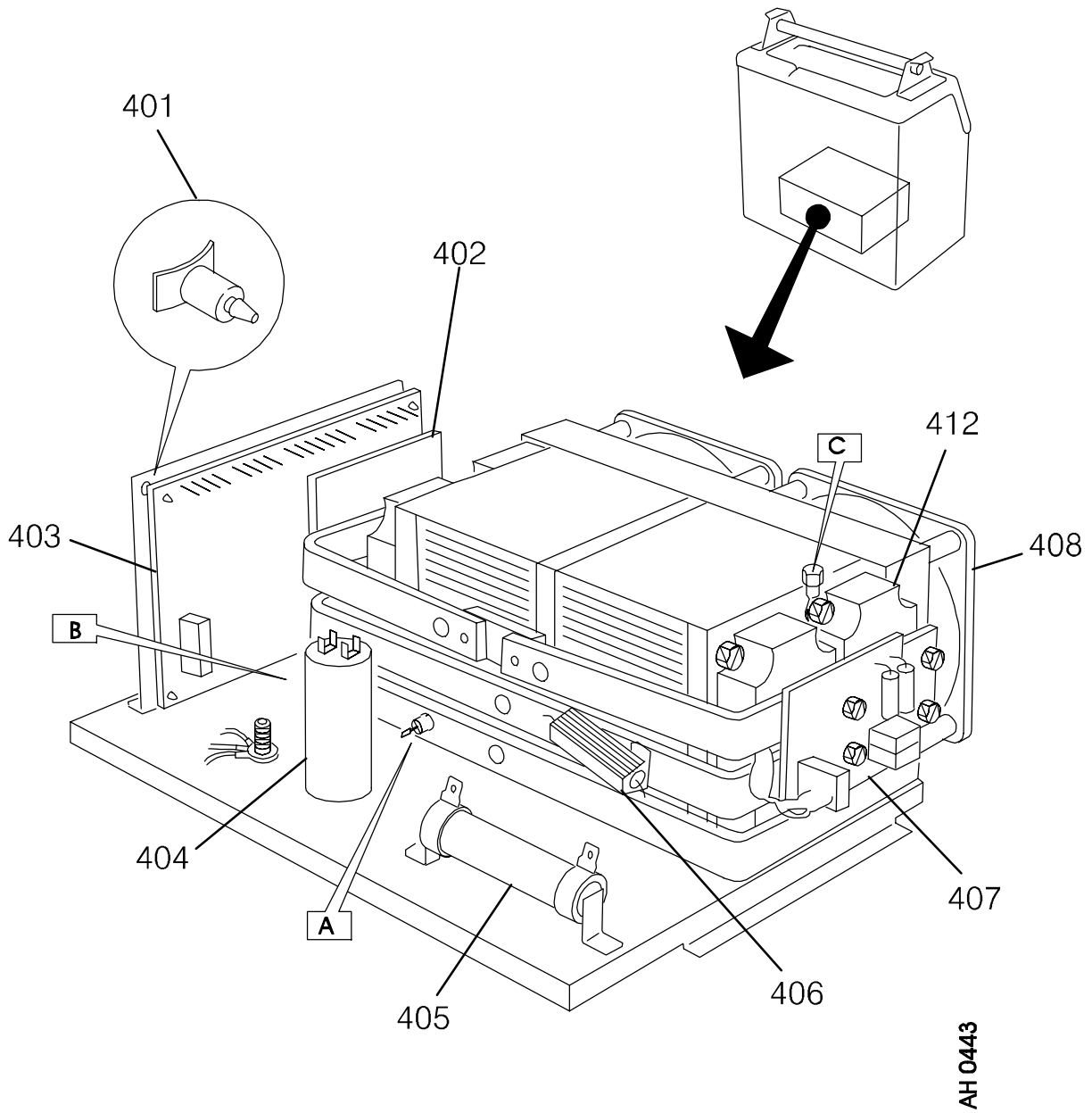
SPARE PARTS SET

Item	Ordering no.	Denomination	Notes
350	0458 920 882	Diode module set	Includes item 307 diode module, thermal compound, roller and mounting instruction.
-	0458 910 002	Roller handle	For the roller in the spare parts set above.

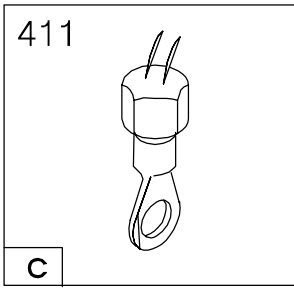
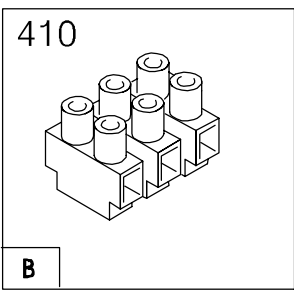
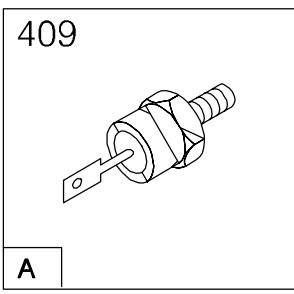


C = component designation in the circuit diagram

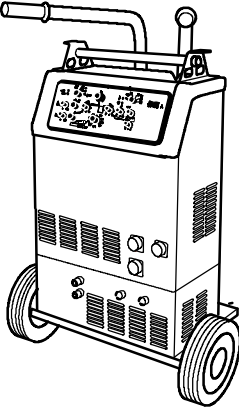
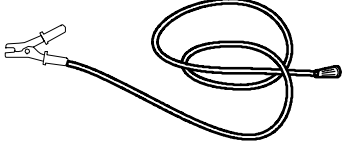
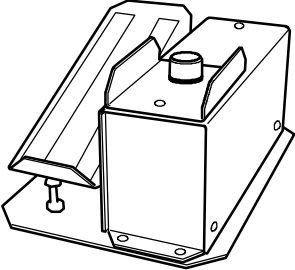
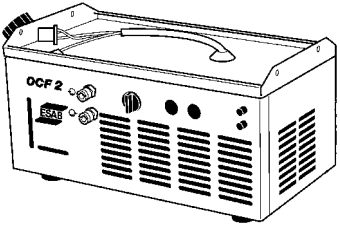
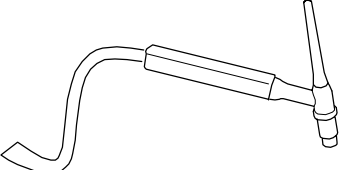
Item	Qty	Ordering no.	Denomination	Notes	C
401	6	0455 226 004	Spacer		
402	1	0486 622 880	Circuit board		AP09
	2	0193 260 153	Connector	5-pole	XA, XB
	1	0193 260 155	Connector	7-pole	XC
403	1	0486 829 880	Circuit board	Replacing circuit board 0486 648 880	AP07
	1	0193 260 158	Connector	10-pole	XA
	1	0193 260 067	Connector	8-pole	XB
	1	0193 260 153	Connector	5-pole	XC
	1	0193 260 159	Connector	12-pole	XD
404	1	0191 085 208	Capacitor	10 μ F, 450 V AC	C09
405	1	0349 061 004	Resistor	120 Ω , 80 W	R03
406	1	0192 579 206	Resistor	1 Ω , 50 W	R05
407	1	0486 628 880	Circuit board		AP10
	1	0193 260 153	Connector	5-pole	XA, XB
408	2	0365 539 001	Fan	230 V AC	EV02, EV03
409	1	0194 065 001	Diode		V05
410	1	0193 045 011	Terminal block		XT23
411	1	0194 050 001	PTC resistor	Thermal sensor	ST02
412	4	0194 083 001	IGBT module		Q01 - Q04
		0192 058 101	Thermal compound	For fitting of Q01 - Q04, Q05 and V07	



AH 0443



Accessories

	<p>Trolley (with room for gas bottle) 0301 100 880</p>
	<p>Return cable 0369 857 888</p>
	<p>Foot control FS 002 0349 090 886</p>
	<p>Cooling unit OCF 2D 0457 216 881</p>
	<p>TIG torches HW 26 R, 4 m with OKC connection 0588 000 738 HW 26 R, 4 m with central connection 0588 000 740 HW 20, 4 m with OKC connection 0588 000 744 HW 20, 4 m with central connection 0588 000 746</p>