

DuraDrive® 4 - 48 Wire Feeder

- Modular panels for easy function and feature upgradability
- Heavy duty compact wire feed motor
- Two speed ranges - offers wider application range; 50-700 or 150-800 ipm
- Quick release “No Tools” feed roll system
- Driven upper and lower feed rolls for positive feed force and maximum wire grip
- All control circuits incorporated on one solid-state printed circuit board, mounted for easy access and removal
- Slow run-in switch sets the wire feed speed to 1/2 the preset until the arc is struck for smoother arc starting
- Jog switch for wire inching without energizing the power source contactor
- Anti-stick wire burnback control for precise adjustment of amount of wire burnback after wire feed stops, to eliminate freezing of wire in weld pool
- Low voltage circuit (12V) for gun trigger switch, to assure operator safety
- NAS (Bayonet) gun adaptor factory installed
- Heavy Duty 48 millimeter feed rolls, ideal for heavy wire applications

Ordering Information

DuraDrive 4-48 Basic.....	0558001910
DuraDrive 4-48 Basic w/6ft. Control Cable	*0558002770
DuraDrive 4-48 Basic Boom Mount Feeder	0558002497
DuraDrive 4-48 Basic w/Digital Display	0558002280
<i>Single Weld Schedule with Digital Display. Field upgradable to Dual Schedule with addition of kit 0558002278.</i>	
DuraDrive 4-48 Pulse	0558006556
<i>PulseMig, Dual Weld Schedule with Digital Display</i>	

DuraDrive 4-48 Basic, Ready-to-Weld Packages for Ring Terminal Cables

(use with ESAB 353, 453, 460, 653)

DuraDrive 4-48 Basic, GM-400 x 12 ft. R33 Pkg	0558003268
DuraDrive 4-48 Basic, GM-400 x 15 ft. R33 Pkg	0558003269

for Quick Connect Cables

(use with ESAB 350 mpi, SVI- 450)

DuraDrive 4-48 Basic, GM-400 x 12 ft. R33 Pkg	0558003272
DuraDrive 4-48 Basic, GM-400 x 15 ft. R33 Pkg	0558003273

Ready-to-Weld packages include: Wire Feeder, 8 ft. control cable, gas hose regulator/flowmeter, GunMaster 400 Torch Ready-to-Weld .052-1/16, 15 ft. work cable and 15 ft. welding power cable. Order drive roll kits from next page.

Instruction Manual.....	F15-636
Sales Literature.....	(12-01-2006) ARC-23115



Options & Accessories

Single Schedule/Digital Display Panel	0558002277
Dual Schedule Panel	0558001913
Dual Schedule/Digital Display Panel	0558001912
Dual Sched./Digital Display/Pulse Panel	0558002496
Pre-Postflow/Spot/Trigger/Lock Kit	0558001914
Hanging Bail	0558003047
Handle Kit	0558002356
Outlet Adaptor Tweco #5	0558002212
Marathon Pack Inlet Guide	0558002519
Requires Quick Connect Adaptor.....	899F50
Counterbalance Mini-Boom.....	0458705881
Counterbalance Mini-Boom for 60lb. Coils	0458705882
Spool Cover	0558002357
Control Cable, 6ft.	30686
Control Cable, 8ft.	0558002358
Control Cable, 30ft.	30780
Control Cable, 60ft.	30781
ST16/21 Outlet Adaptor.....	0588000995
Water Kit.....	37801
NAS Tweco #4 to Euro Adaptor.....	0558002622

Gunmaster Trigger Leads,

Trigger Lead, GunMaster 250	0558001815
Trigger Lead, GunMaster 400.....	2075216

Specifications

Input Power Required.....	42V, 50/60Hz 1ph
Wire Feed Range	
Low Range	50-700 in/min (1.2-18 m/min)
Hi Range	150-800 in/min (3.8-20.5 m/min)
Wire Sizes	
Hard (V-Groove)035 - 1/16 in.(.9-1.6mm)
Tubular (Knurled).....	.035 - 1/8 in.(.9-3.2mm)
Soft (U-Groove)035 - 3/32 in.(.9-2.4mm)
Dimensions	
Length	23 in.(584mm)
Width	14.5 in.(368mm)
Height.....	16.5 in.(419mm)
Weight	53 lbs.(24 kg)

Optional Panels

Single Schedule Panel w/ Digital Display 0558002277
 The Digital Single Schedule panel has all the capability of the Basic panel with the addition of a digital display for Wire Feed Speed and output Voltage. This panel may be field upgraded to Dual Schedule by adding the Dual Schedule Upgrade Kit 0558002278.



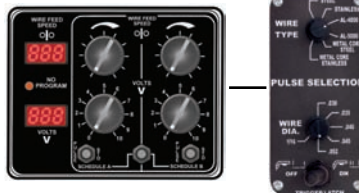
Dual Schedule Panel Basic..... 0558001913
 The Basic Dual Schedule panel allows for the adjustment of two independent welding schedules (Wire Speed and VOLTS) for power sources with remote voltage capability. The operator can switch between either schedule while welding by simply double clicking the gun trigger in rapid fashion.



Dual Schedule Panel w/ Digital Display 0558001912
 The Digital Dual Schedule panel has all the capability of the Basic Dual Schedule panel with the addition of a digital display for Wire Feed Speed and output Voltage. The operator can switch between either welding schedule while welding by simply double clicking the gun trigger in rapid fashion.



Dual Schedule Pulse Kit w/ Digital Display 0558002496
 The Digital Dual Schedule Pulse panel adds Pulse Mig welding capability to the DuraDrive feeder line. Two welding schedules can be set on the panel in either the standard (CV) or Pulse-Mig process modes. This kit can be used with the ESAB 350 mpi, SVI-450i and MultiPower 460 (non-pulse version) power sources.



Pre-PostFlow/Spot/Trigger Lock Panel..... 0558001914
 This easy-to-install kit permits the operator to set times for spot welding (0-10 secs.), gas preflow (0-5 secs.), and gas postflow (0-7.5 secs.). This panel also includes a trigger latch feature, which allows the welder to make long welds without having to "hold" the trigger.



Table 1. Drive Roll & Guide Tube Selection

Use for: DuraDrive 4-48

Wire Diameter	Type	Kit P/N	Drive Roll	Qty	Center Guide	Qty	Outlet Guide	Qty	Inlet Guide	Qty
.035 in. (0.9 mm)	V-Solid	0558003125	0558002237	4	0558002223	1	0558002215	1	0558002347	1
.045 in. (1.2 mm)	V-Solid	0558003126	0558002238	4	0558002223	1	0558002215	1	0558002347	1
.052 in. (1.4 mm)	V-Solid	0558003126	0558002238	4	0558002223	1	0558002216	1	0558002347	1
1/16 in. (1.6 mm)	V-Solid	0558003128	0558002240	4	0558002224	1	0558002216	1	0558002347	1
.035 in. (0.9 mm)	K-Cored	0558003115	0558002227	4	0558002223	1	0558002215	1	0558002347	1
.045 in. (1.2 mm)	K-Cored	0558003116	0558002228	4	0558002223	1	0558002215	1	0558002347	1
.052 in. (1.4 mm)	K-Cored	0558003117	0558002229	4	0558002224	1	0558002216	1	0558002347	1
1/16 in. (1.6 mm)	K-Cored	0558003118	0558002230	4	0558002224	1	0558002216	1	0558002347	1
5/64 in. (2.0 mm)	K-Cored	0558003119	0558002231	4	0558002225	1	0558002217	1	0558002347	1
3/32 in. (2.4 mm)	K-Cored	0558003120	0558002232	4	0558002225	1	0558002217	1	0558002347	1
7/64 in. (2.8 mm)	K-Cored	0558003121	0558002233	4	0558002226	1	0558002217	1	0558002347	1
1/8 in. (3.2 mm)	K-Cored	0558003122	0558002234	4	0558002226	1	0558002218	1	0558002347	1
.035 in. (0.9 mm)	U-Soft	0558003130	0558002244	4	0558002307	1	0558002219	1	0558002347	1
3/64 in. (1.2 mm)	U-Soft	0558003131	0558002245	4	0558002308	1	0558002220	1	0558002347	1
1/16 in. (1.6 mm)	U-Soft	0558003132	0558002247	4	0558002308	1	0558002220	1	0558002347	1
3/32 in. (2.4 mm)	U-Soft	0558003133	0558002248	4	0558002310	1	0558002222	1	0558002347	1