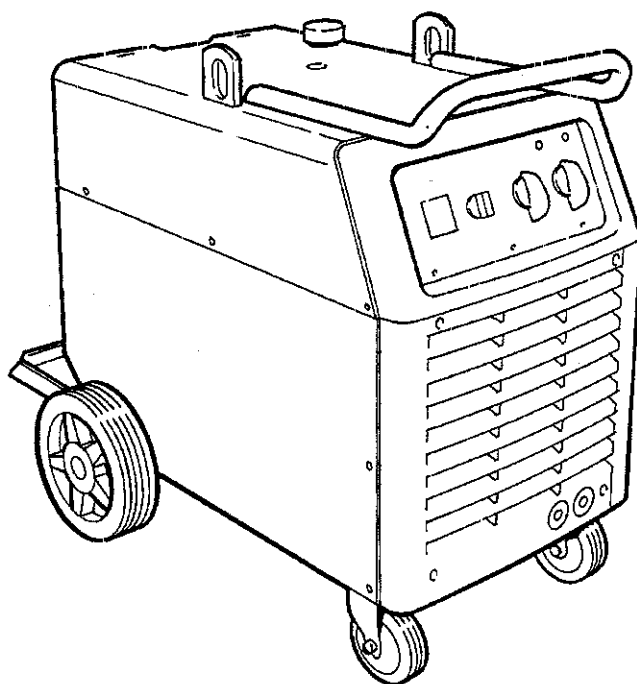


Transmig

333S / 403S / 403SW



0459 059 001 020101

TM 333S valid for serial No 005-xxx-xxxx
TM 403S / 403SW valid for serial No 645-xxx-xxxx



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DECLARATION OF CONFORMITY

Murex Welding Products Ltd.

Declare hereby that:

Murex Transmig 333S / 403S / 403SW Power Source

Part No.141 59 70 / 141 59 71 / 141 59 72

Manufactured after 1 st January 2002

- conform with the requirements of Council Directive 73/23/EEC, amended by Council Directive 93/68/EEC, relating to electrical equipment designed for use within certain voltage limits.
- conform with the requirements of Council Directive 89/336/EEC, amended by Council Directive 93/68/EEC, relating to electromagnetic compatibility.
- are manufactured in accordance with EN 60974-1 Safety Requirements for Arc Welding Equipment.
- are manufactured in accordance with EN 50199 Electromagnetic Compatibility for Arc Welding Equipment.

On behalf of Murex Welding Products Ltd.
Hertford Rd
Waltham Cross
Herts. EN8 7RP
England

.....
P.G Dodd
Managing Director
Esab Group (UK) Ltd
January 2002

Manufactured by Esab Welding Equipment AB.
S-695 81 Laxå Sweden



WARNING



ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS' HAZARD DATA.

ELECTRIC SHOCK - Can kill

- Install and earth the welding 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 keep fumes and gases 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 ear defenders 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!

MAINTENANCE

This welding equipment has been designed, manufactured and tested to the highest standards to ensure long and trouble free life. However, regular maintenance is an essential part of keeping the machine operating in a reliable and safe manner and your attention is drawn to any maintenance instructions that are contained in this manual.

In general all welding equipment should be thoroughly inspected, tested and serviced at least annually.

More frequent checking will be required when the equipment is heavily used.

Wear and tear, particularly in electro-mechanical and moving components, are gradual processes.

Caught in time, repair costs are small and the benefits in performance reliability and safety are significant.

Left alone they can put the equipment, and you, at risk.

Have this equipment regularly inspected and maintained by an approved service centre.

ELECTROMAGNETIC COMPATIBILITY

This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the users responsibility to take adequate precautions.

RISK OF TILTING

When moving the equipment on its wheels, the momentum should the wheels hit an obstruction (cable or scrap etc), could cause the machine to tilt.

When moving the equipment, do not pull on the torch.

Secure the equipment, especially if used on a sloping or uneven surface.

Ensure the feeder is prevented from suddenly swivelling to one side whilst moving or wheeling the machine.



SAFETY

In any arc welding or gouging operation, it is the responsibility of the user to observe certain safety rules to ensure his personal safety and to protect those working near him. Read all safety articles relevant to arc welding published by the WMA. Pay particular attention to any CAUTION or WARNING Notes included in this manual. CAUTION indicates possible equipment damage. WARNING indicates possible hazard to life.



WARNING



The ON/OFF switch on this equipment does not isolate the unit from the mains electrical supply. **AC POWER IS PRESENT ON THE ON/OFF SWITCH TERMINALS.**

The ON/OFF lamp is an indication that the supply is switched on and does not imply that the unit is isolated from the supply **BEFORE REMOVING THE COVERS FOR MAINTENANCE, ISOLATE THE UNIT FROM THE MAINS ELECTRICAL SUPPLY.**

1. Electrical

- Treat electricity with respect. Even the open circuit voltage of this equipment can be dangerous. Adjustments to the torch or replacement of torch parts should be undertaken with the mains supply isolated from the unit. If damaged torch cables or torch components are found, the unit must be disconnected from the mains and defective parts must be replaced using only Murex spare parts.
- Do not work on live circuits or cables. Disconnect the main power supply before checking the machine or performing any maintenance operation.
- Be sure the case of the welding machine is properly connected to a good electrical earth.
- Have the wiring for the welding machine installed by a qualified electrician. All connections must be made according to specifications in force and to general safety standards
- Do not stand in water or on damp floors while using an arc welder or cutter. Do not use in the rain.
- Do not operate with worn or poorly connected cables. Inspect all cables frequently for insulation failure, exposed wires and loose connections.
- Do not overload cables or continue to operate with overheating cables. Cables which are too small for the current carried will overheat, causing rapid deterioration of the insulation.
- Pay attention that live parts of the torch do not touch any metal which is connected to the earth cable. Fix an insulated hook to hang the torch on when it is not in use.

2. Ventilation

- Do not weld or cut on containers which have held combustible or flammable materials, or materials which give off flammable or toxic vapours when heated, without proper cleaning.
- Locate the welding/cutting operation far enough from any vapour-type degreaser using trichlorethylene or other chlorinated hydrocarbons as solvents. The ultraviolet light from the arc can decompose these vapours into toxic gases at a considerable distance from the arc, even though the concentration of the gases is low enough to be undetectable by smell
- Be sure to provide adequate ventilation for removal and dilution of fume and gases. Fume exhaust facilities near the arc, or a ventilated helmet should be used when cutting in confined spaces or on toxic material.

3. Glare

- Never look at the arc without wearing eye protection.
Always use the proper protective clothing, filter glasses, and gloves. Be careful to avoid exposed skin areas. Do not use cracked or defective helmets or shields.
- Never strike an arc when there is someone near who is not protected from the strong light of the arc
- Warn bystanders who are not aware of the dangers of ultraviolet light.

4. General

- Take care when lifting the unit.
- Ensure that cylinders are secured by chains.
- Locate the unit so that there is adequate air flow to the ventilation louvres.
- Always dress correctly to protect against glare, radiation and spatter.

5. Fire

- Ensure that the correct type of fire extinguisher is available in the welding area.
- Do not weld near flammable materials or liquids, in or near explosive atmospheres, or on pipes carrying explosive gases

6. Vehicle electrics

- When working on motor vehicles, remove the battery and any circuitry which may be damaged by the arc.
- Whilst welding be aware of the possibility of 'hidden wires' behind panels or bulkheads.



INTRODUCTION

Murex Transmig 333S, 403S & 403SW are industrial 3 phase flat characteristic power sources for MIG/MAG welding with solid or cored wires. They are normally used together with a Murex Transmatic wire feed unit for dip through spray transfer processes.

Transmig 403SW incorporates a MIG torch water cooling unit.

Specification Transmig 333S

Pt. No. 1415970

Standard delivery: Power source.

Mains cable 5 m (fitted). Includes: Handle, (fitted with 2 screws), gas cylinder shelf (fitted with 2 screws). Mounting post for wire feed unit.

Voltage	400-415V, 3~50/60 Hz
Permissible load at	
100 % duty cycle	195 A/24 V
60 % duty cycle	250 A/27 V
30 % duty cycle	320 A/30 V
Setting range (DC)	40A/16V-320A/30V
Open circuit voltage	16-40 V
Open circuit power	40 W
Efficiency	0,75
Power factor	0,94
Control voltage	42 V, 50/60 Hz
Dimensions l x w x h	770 x 560 x 640
Weight	110 kg
Enclosure class	IP 23
Application classification	S



Specification Transmig 333S / 403SW

Standard delivery: Pt. No. 1415971 / 1415972

Power source. (TM 403SW includes inbuilt torch water cooler).

Mains cable 5 m (fitted).

Includes:

Gas cylinder shelf (fitted with 2 screws).

Mounting post for wire feed unit.

Voltage	400-415V, 3-50/60 Hz
Permissible load at	
100 % duty cycle	280 A/28 V
60 % duty cycle	350 A/32 V
50 % duty cycle	380 A/33 V
Setting range (DC)	50A/17V-380A/33V
Open circuit voltage	17-45 V
Open circuit power	130 W 340 W / TM 403SW
Efficiency	0,75
Power factor	0,96
Control voltage	42 V, 50/60 Hz
Dimensions lwxhxh	800 x 640 x 835
Weight	143 kg 157 kg /TM 403SW
Enclosure class	IP 23
Application classification	S

TM 333S, 403S & 403SW comply with the requirements of EN 60974-1 or BS 638 pt 10.

Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld at a certain load without overloading the welding power source.

Enclosure class

The IP code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked IP 23 is designed for indoor and outdoor use.

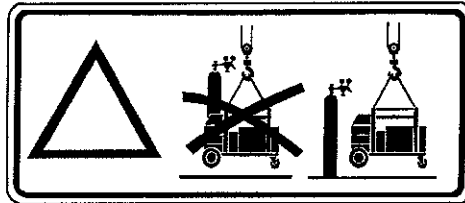
Application class

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

INSTALLATION

Lifting instructions

The power supply should be lifted by means of its lifting eye. The handle is only intended for pulling it along the ground.



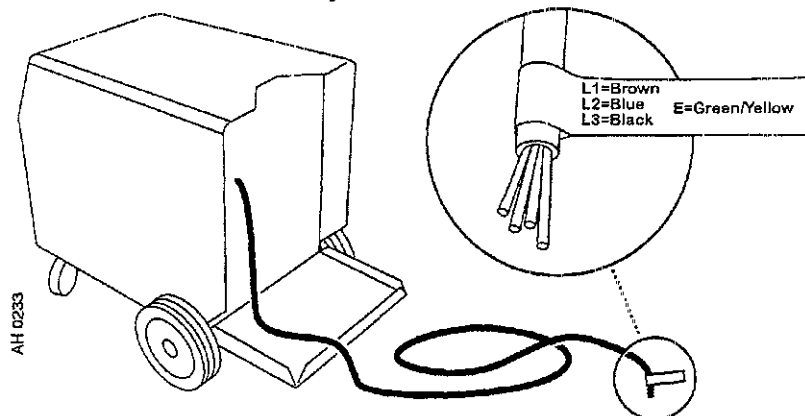
Important

- Electrical installation must be carried out by a qualified electrician.
- Site the unit so that ventilation grilles are clear of obstructions.
- Ensure all flammable materials are removed from the area.
- Ensure the gas cylinder retaining strap is installed when mounting the gas cylinder.
- The front panel on/off switch does not isolate the mains electrical supply.

Mains supply	Transmig 333S	Transmig 403S / 403SW
Voltage	400/415 V	400/415 V
Frequency	50/60 Hz	50/60 Hz
Input Current at 100% duty	9 A	16 A
60% duty	14 A	23 A
30% duty	20 A	
50% duty		27 A
Reconnected primary cable	4x2,5 mm ²	4x2,5 mm ²
Reconnected primary fuse, slow	16 A	20 A

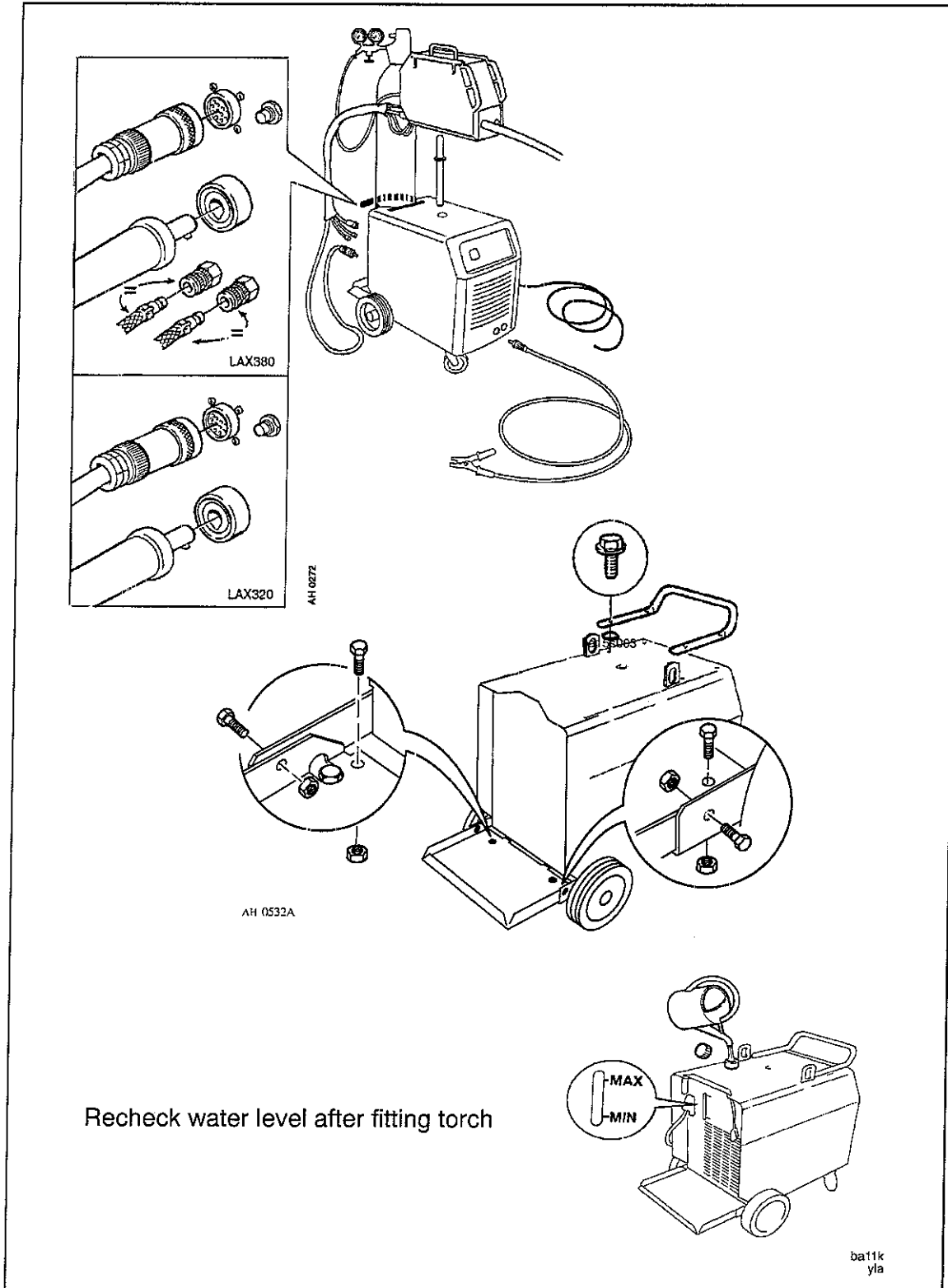
Note: Transmig 333S, 403S & 403SW are supplied with a fitted 5 m primary cable.

Primary connection



ba19d001

Assembly of components





OPERATION

Transmig 333S, 403S & 403SW utilise "switched" primary control providing 40 (4x10) welding voltage selections.

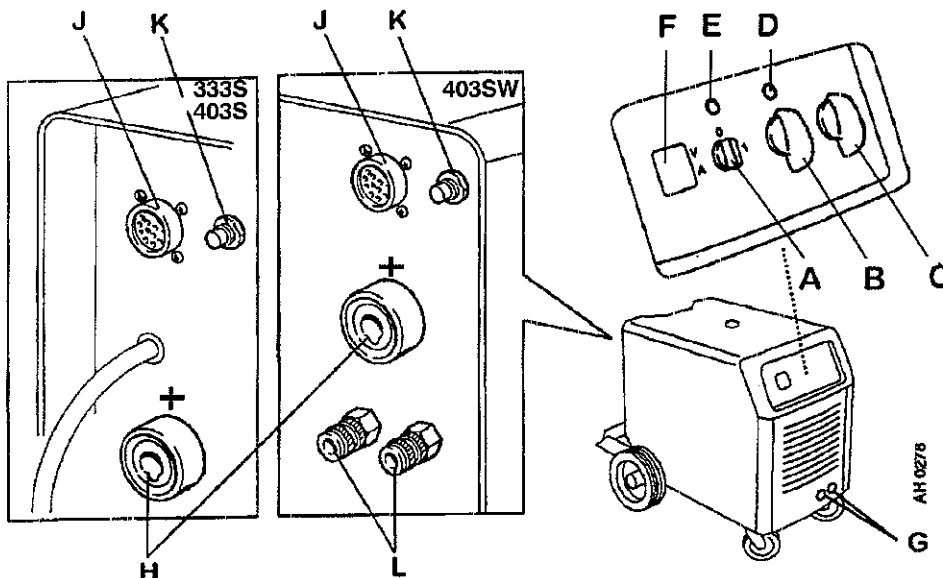
In addition 2 different inductance levels can be selected at the - ve welding outlets (normally the work connection) on the lower front panel.

The machines are fan cooled, 2 speed thermostatic on the 403S & 403SW models, and incorporate thermal overload protection.

If the machine is overheated the orange warning light will illuminate and welding output will stop.

In this event have the machine switched on with the fan running, resetting is automatic when the unit has cooled.

- A - Main switch On/Off
- B - Voltage selector 4-step Coarse
- C - Voltage selector 10-step Fine
- D - Indicator lamp thermal overload, lights up in case of overheating
- E - Mains on indicator lamp
- F - Digital meters (meters incorporate last reading hold feature)
- G - Inductance connection- Negative output
- H - Welding socket - Positive output
- J - Sleeve socket 23-pol. wire feed unit
- K - Circuit breaker 42 V AC-circuit
- L - Quick coupling water, (403 SW)





MAINTENANCE

- Regular maintenance is important for reliable and safe operation.

- **Daily**
 - Check all welding and electrical connections and cables for signs of deterioration
 - Check the gas supply, hoses and connectors
 - Check the water cooling unit (403SW only) and top up if necessary
 - Check the fan is operating normally

- **At least annually**
 - Disconnect the machine from the mains electrical supply
 - Remove the top and side covers
 - Blow out the inside of the unit with clean dry compressed air at low pressure
 - Check the security of all wiring, connections and components
 - Refit the covers

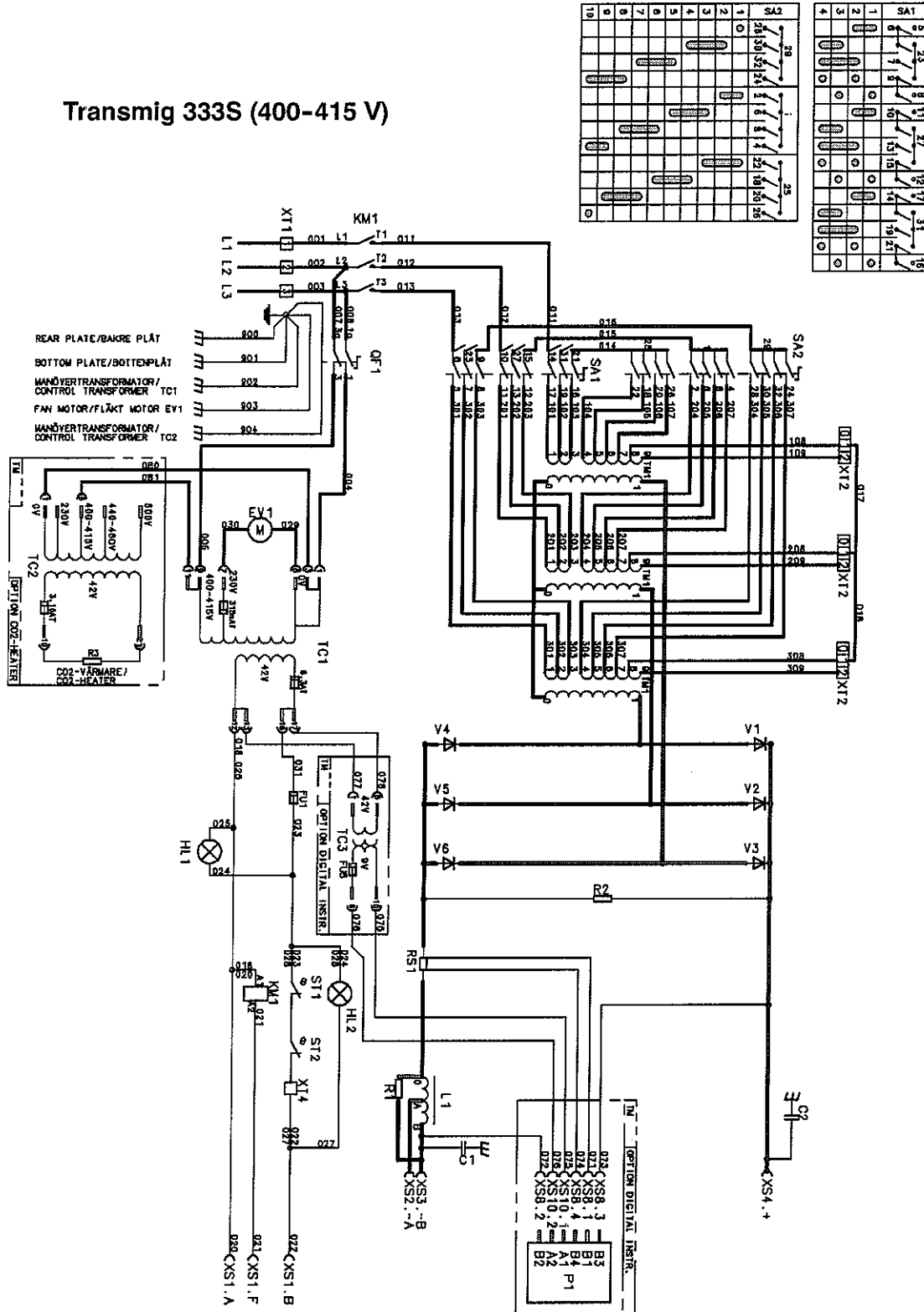
- **Annually**
 - Have an insulation and earth continuity test carried out by an approved service agent

ACCESSORIES

1415285	5m Interconnection to Transmatic feeder
1415286	10m Interconnection to Transmatic feeder
1415287	15m Interconnection to Transmatic feeder
1409320	3,5m Work return lead & clamp (50 mm ²)
1380438	CCC DINZ Plug 50/70
1414015	Water hose 6,6 m (2 required for 403SW)
334627	Primary cable 4x4 mm ² (per metre)
368541-005	Burndy plug 23 way (excl pins)
323945-004	Burndy pin (3 required)

Circuit Diagram

Transmig 333S (400-415 V)

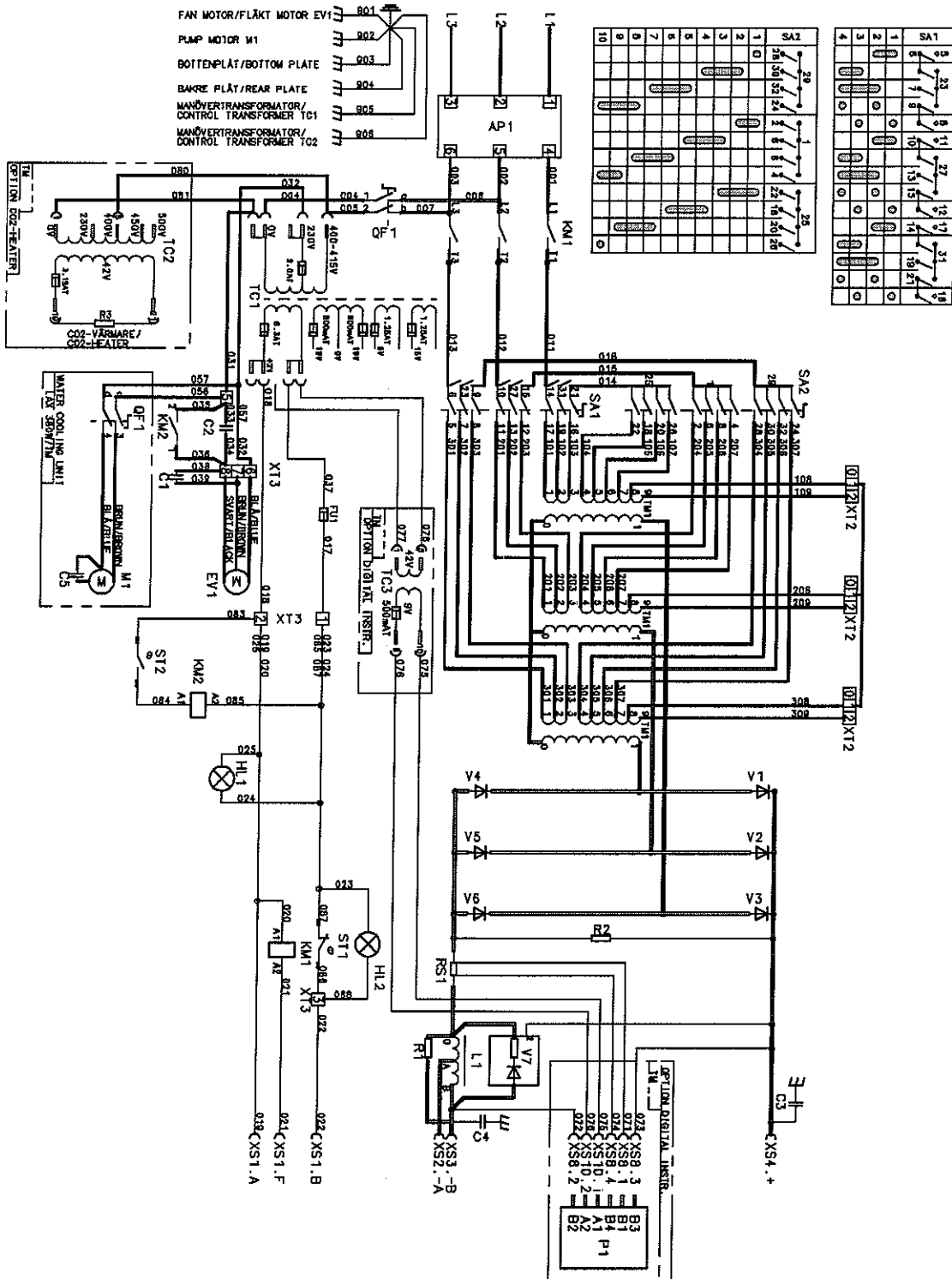


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Circuit Diagram

Transmig 403S/403SW (400-415V)



Spare parts Transmig 333S

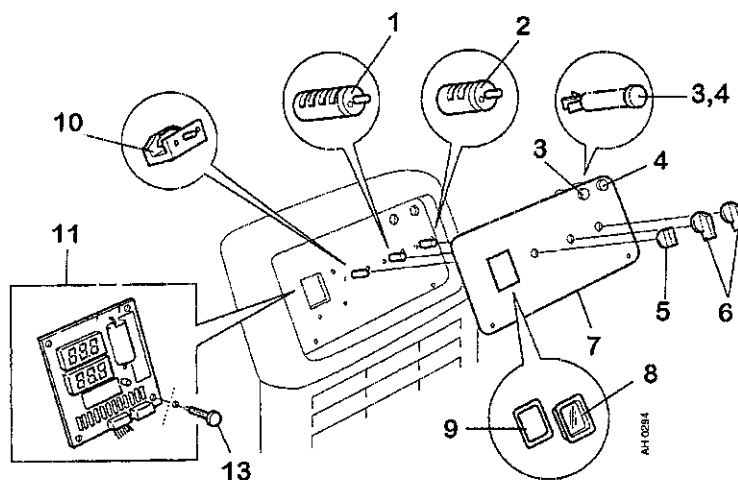
Ordering numbers for Transmig 253 welding rectifiers

Ordering no.	Denomination	Notes
1415970	TM 333s	400-415 V 3 ~ 50/60 Hz

Spare parts list

Spare parts can be ordered through the nearest Murex distributor.

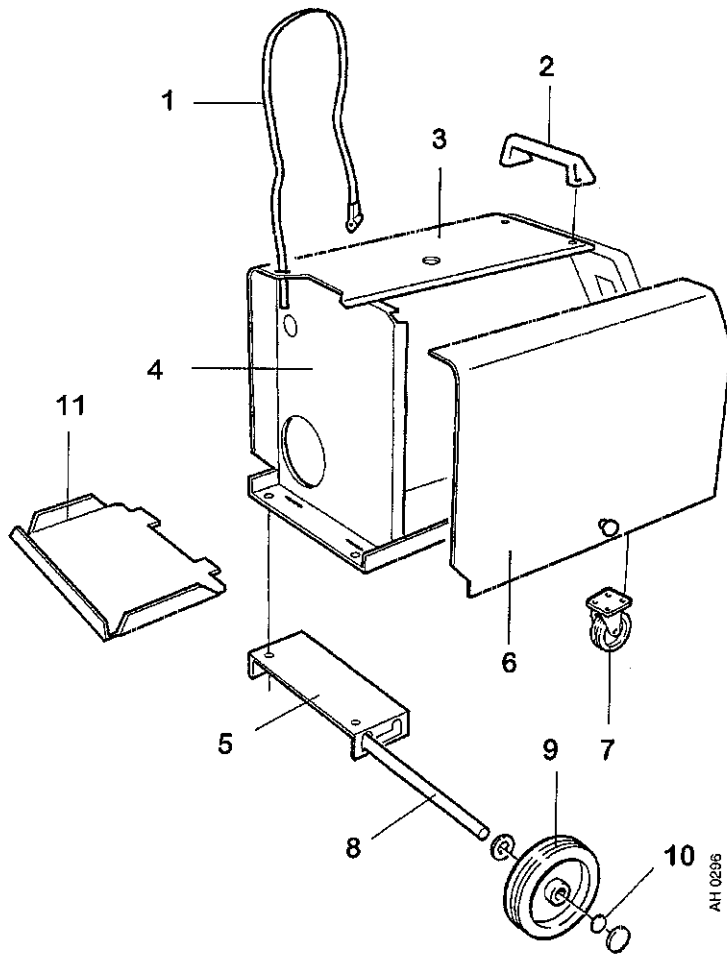
Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0193 942 001	Switch	4 step, item 6 is included
2	1	0193 945 001	Switch	10 step, item 6 is included
3	1	0369 733 002	Indicating lamp	48 VAC, orange
4	1	0369 733 007	Indicating lamp	42 VAC, white
5	1	0366 296 002	Knob	
6	2		Knob	Included in items 1 and 2
7	1	0455 610 002	Panel with text	
8	1	0455 174 001	Seal	
9	1	0455 172 001	Protection glass	
10	1	0366 295 002	Switch	
11	1	0486 317 880	Circuit board	For digital instrument ,
13	3	0455 226 010	Spacer	For circuit board



ba19s001



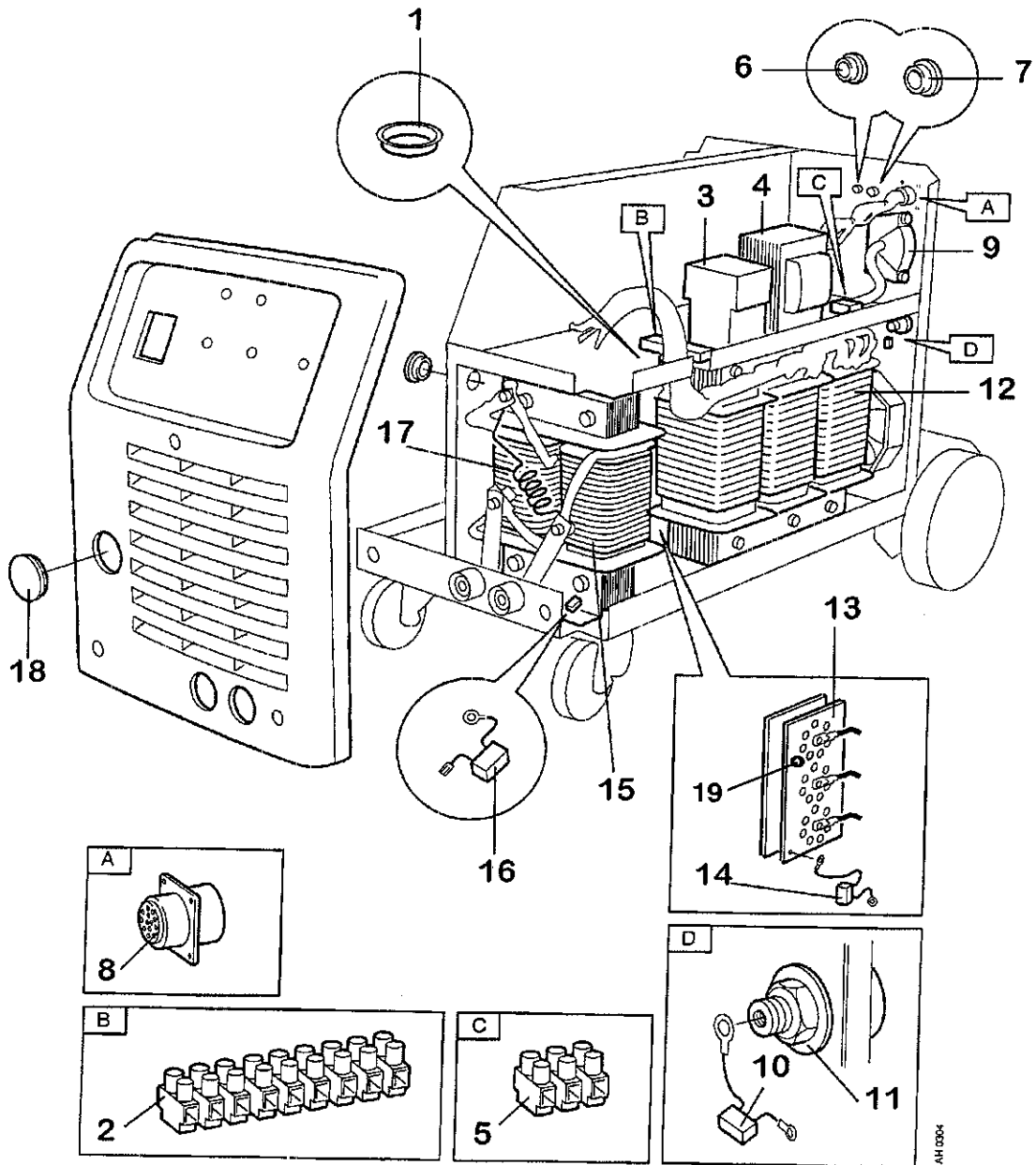
Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0368 265 002	Securing strap	
2	1	0455 833 002	Handle	
3	1	0456 026 001	Cover with text	
4	1	0455 474 001	Rear panel	
5	1	0455 814 001	Clamp	
6	1	0456 025 001	Side panel with txt	
7	2	0455 467 001	Castor wheel	∅ 100mm h=125mm
8	1	0469 516 003	Shaft	
9	2	0455 457 001	Wheel	∅ 200mm
10	2	0192 859 126	Locking washer	
11	1	0469 684 001	Shelf	



ba19s00



Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0192 041 139	Grommet	
2	1	0193 655 012	Terminal	12-pole
3	1	0193 923 001	Contacteur	400-415 V mains voltage
4	1	0455 633 001	Transformer	255 VA
5	1	0162 781 002	Terminal	3-pole
6	1	0192 230 110	Cover	ø 20mm
7	1	0368 544 005	Sleeve socket	23-pole
8		0323 945 003	Sleeve	
9	1	0469 950 880	Cable inlet	
10	1	0467 911 881	Capacitor	with cable lugs
11	3	0160 362 881	Terminal	OKC 50
12	1	0455 618 880	Transformer	Complete, 400-415 V
13	1	0455 815 881	Diode bridge	Complete
14	1	0469 380 881	Capacitor	
15	1	0455 328 880	Inductor	
16	1	0467 911 881	Capacitor	
17	1	0466 479 002	Resistor	
18	1	0192 230 117	Cover plug	ø 50 mm
19	1	0321 229 004	Thermal cutout	Opens at 120° C
		0192 058 101	Thermal compound	For fitting of the thermal cutout



AH 0304

ba19s006



Spare parts Transmig 403S /403SW

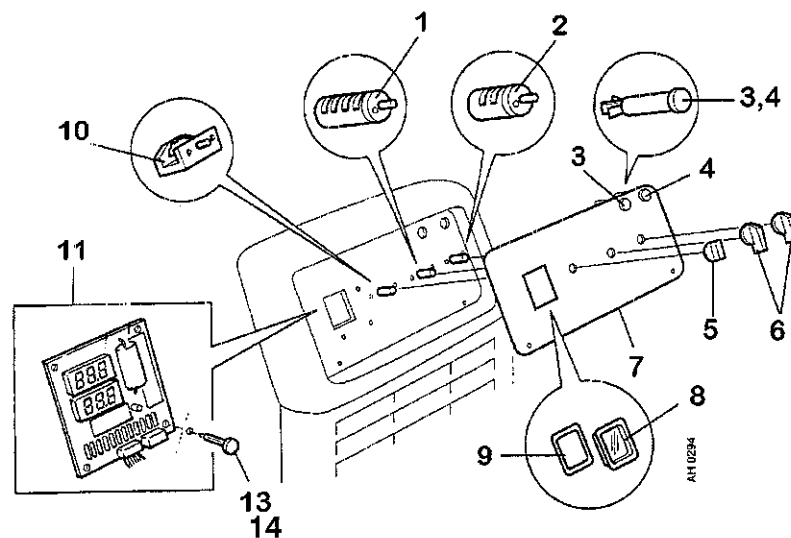
Ordering numbers for Transmig 353 /353W welding rectifiers

Ordering no.	Denomination	Notes
1415971	TM 403S	400-415 V 3~ 50/60 Hz
1415972	TM 403SW	400-415 V 3~ 50/60 Hz

Spare parts list

Spare parts can be ordered through the nearest Murex distributor.

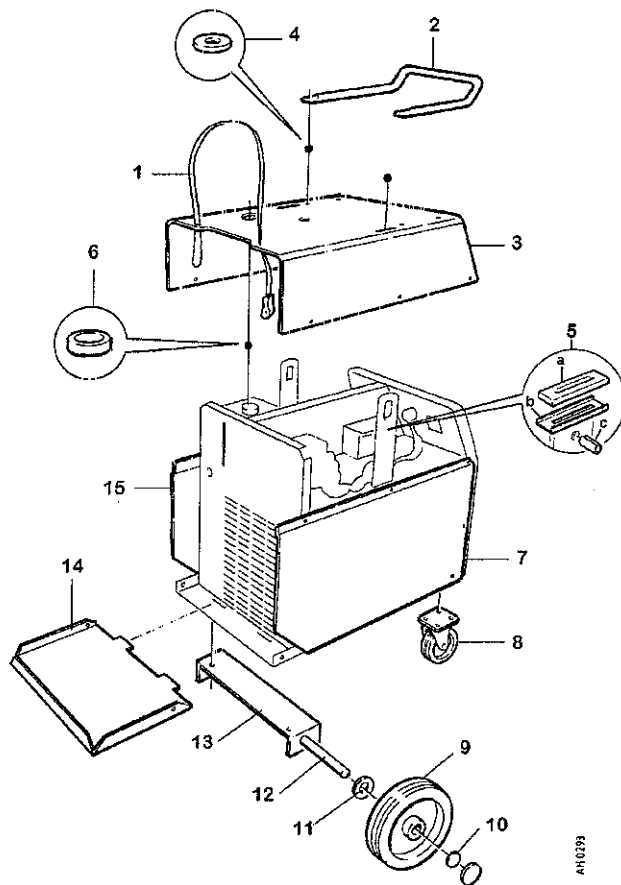
Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0193 942 001	Switch	4 step, item 6 is included
2	1	0193 945 001	Switch	10 step, item 6 is included
3	1	0369 733 007	Indicating lamp	42 VAC, white
4	1	0369 733 002	Indicating lamp	48 VAC, orange
5	1	0366 296 001	Knob	
6	2		Knob	Included in items 1 and 2
7	1	0455 877 003	Panel with text	
8	1	0455 174 001	Seal	
9	1	0455 172 001	Protection glass	
10	1	0366 295 002	Switch	
11	1	0486 317 880	Digital instrument	
13	2	0455 226 010	Spacer	For circuit board
14	1	0455 226 004	Spacer	For circuit board



ba19s001



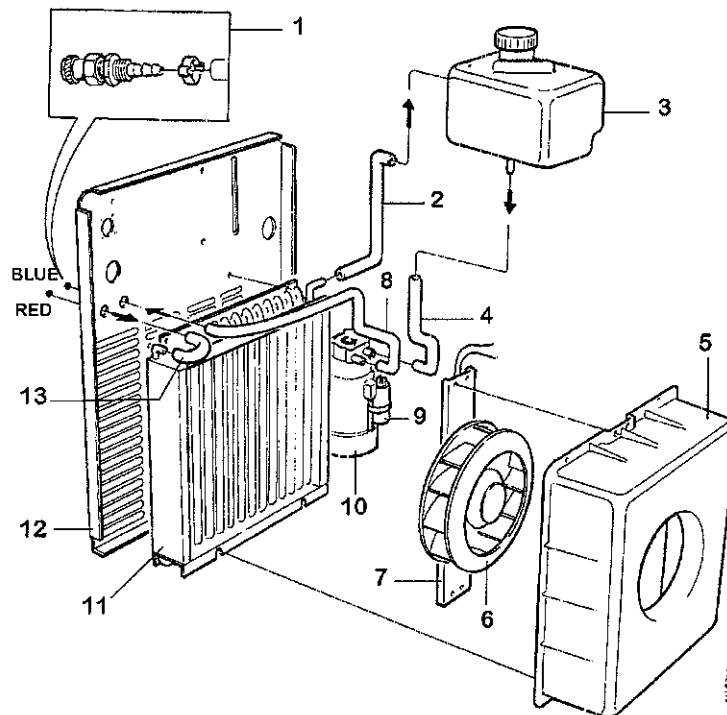
Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0368 265 002	Securing strap	
2	1	0469 868 002	Handle	
3	1	0469 681 002	Cover	
4	4	0366 481 002	Seal	
5a	2	0468 797 001	Seal	
5b	2	0468 796 001	Support plate	
5c	2	0211 103 005	Roll pin	
6	1	0366 481 003	Seal	
7	1	0456 811 001	Side panel with text	Left
8	2	0469 873 001	Castor wheel	∅ 125mm h=150mm
9	2	0469 872 001	Wheel	∅ 250mm
10	2	0192 859 126	Locking washer	
11	2	0215 100 037	Washer	
12	1	0469 516 002	Shaft	
13	1	0469 685 001	Clamp	
14	1	0469 684 001	Shelf	
15	1	0456 023 001	Side panel with text	Right



AH0293



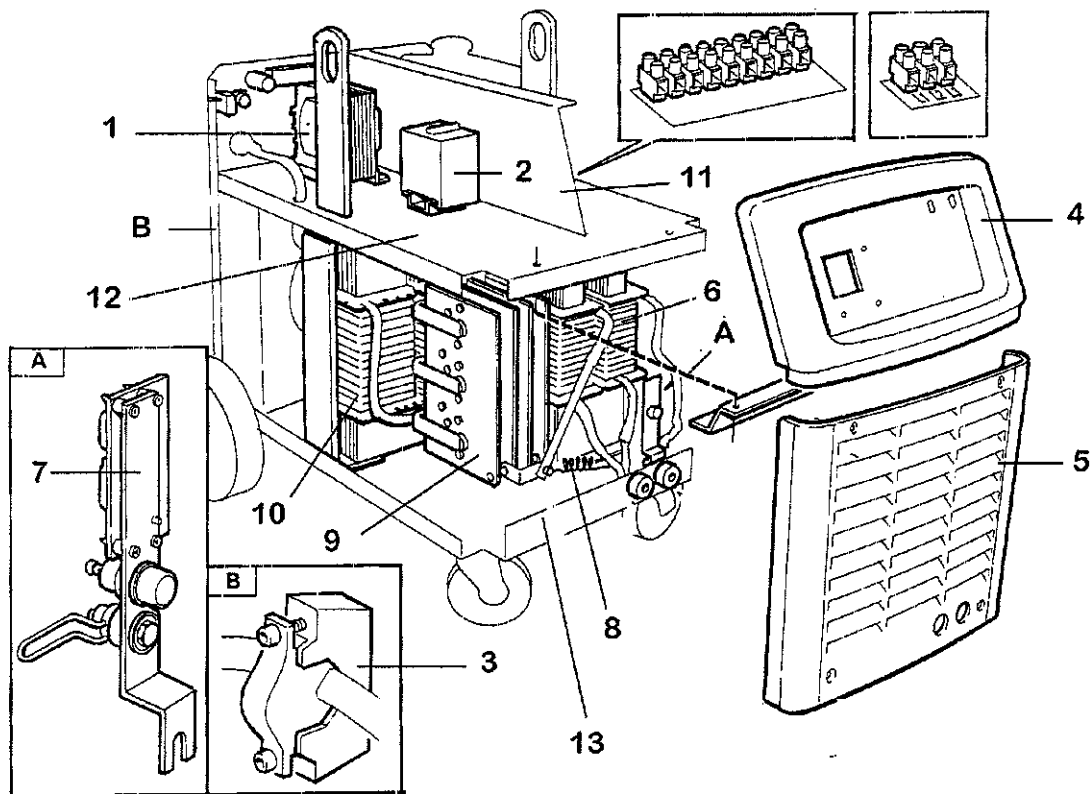
Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0365 803 008	Quick connector	Female, red
1	1	0365 803 009	Quick connector	Female, blue
2	1	0455 162 001	Hose	
3	1	0469 689 001	Water tank	
4	1	0455 164 001	Hose	
5	1	0469 893 001	Fan housing	
6	1	0369 827 001	Fan	
7	1	0455 165 001	Attachment	
8	1	0455 163 001	Hose	
9	1	0191 085 206	Capacitor	5 μ F 400 V
10	1	0469 692 001	Pump	1A 0.2kW 230V 50Hz,
11	1	0469 688 001	Cooler	
12	1	0469 677 001	Rear panel with text	
13	1	0455 161 001	Hose	



ba19s003

Item no.	Qty	Ordering no.	Denomination	Notes
1	1	0469 882 001	Control transformer	400-415 V (replacing 0455 628 001)
2	1	0193 923 001	Contactor	400-415 V
3	1	0469 950 880	Cable inlet	
4	1	0469 704 002	Front panel	
5	1	0469 703 002	Front grill	
6	1	0455 627 880	Inductor	
7	1	0367 070 881	Inductor short-circuiter	
8	1	0466 479 001	Resistor	
9	1	0455 488 880	Diode bridge	
10	1	0455 498 881	Transformer	400-415 V
11	1	0469 678 001	Centre plate	
12	1	0455 830 001	Intermediate plate	
13	1	0469 672 001	Base plate	

0486364880 EMC FILTER (API)



ba19s004

