




FIERCELY TESTED.  
**JOB SITE READY.**

**ROBUST**  
FEED



DIRT. DROPS. MUD. RAIN. GAME ON. YOU'RE A WELDER,  
AND YOU'RE NOT AFRAID TO GET YOUR HANDS DIRTY.  
YOU WORK IN THE TOUGHEST CONDITIONS, AND YOU  
NEED EQUIPMENT YOU CAN TAKE ANYWHERE. THAT'S  
WHY WE CREATED THE ROBUST FEED – OUR MOST  
DURABLE, ERGONOMIC, AND HIGH-PERFORMING  
WIRE FEEDER YET.

# ULTIMATE DURABILITY INSIDE AND OUT.

## EXTERNAL PROTECTION.

**Impact-proof** – Robust Feed's double-walled design with special impact zones is perfect for enduring daily use in tough conditions. Drop it, drag it, throw it around – Robust Feed can take it.

**Weather-proof** – Extreme elements are no problem for Robust Feed. It works in freezing cold temperatures, and it's the only portable wire feeder with an IP44 rating for superior protection against dirt, mud, splashes, and even heavy rain.

**Sun-proof** – Robust Feed will keep working in temperatures up to 130°F (55°C), and its bright front display is readable in even the sunniest conditions.



## INTERNAL PROTECTION.

**Shielded connections** – Superior protection for the interconnection cable and all connectors inside the housing helps prevent broken cables when moving around and creates the best strain-relief solution on the market.

**Shielded spools** – Robust Feed protects the filler metal inside the unit like no other feeder, and the offshore version includes a heat kit to keep the spool dry.

**Shielded electronics** – A dust-protected compartment protects the internal components even while the feeder is open, and special cable connections protect the feeder against short circuits in both the torch and the interconnection cables.



# RUGGED AND READY FOR ANYTHING.

## UNRIVALED PORTABILITY.

Robust Feed has three comfortable handles (all are crane certified) and two additional lifting points for best-in-class portability and maneuverability, making it easy to lift and carry through confined spaces and around obstacles. Rounded edges and special high-durability wear surfaces let you drag it anywhere without catching on other objects. The optional flat and vertical wheel kits and trolley integration allow for even greater mobility. And the new design can handle power source cables up to 300 feet long, so you'll always get to where you need to weld – in the shop or the field.



## UNMATCHED PERFORMANCE.

The new precisely crafted aluminum drive stand feeds solid wire up to 5/64 in. and cored up to 3/32 in. at speeds of 30–985 in./min. When changing the spool, you can feed the new wire without opening the drive stand. And when it comes to power, Robust Feed easily handles 550 A at 50% duty cycle, 500 A at 60%, and 400 A at 100%, enabling productivity that few other portable feeders can provide.



## UNBEATABLE USABILITY.

**Streamlined display** – Robust Feed's clear and bright front panel display contains only the most important settings, keeping the other settings well protected inside the housing.

**Easy-to-use controls** – Large, distinct knobs and push buttons make it easy to operate the unit – even while wearing thick welding gloves.

**Integrated gas flow** – Robust Feed comes with an integrated gas flow meter inside the unit (offshore version), allowing for quick gas flow adjustments.

**Onboard settings** – Seamlessly control all weld settings right from the wire feeder, no matter where your power source is located.

**Maintenance-friendly** – Robust Feed's design allows for quick access to the electronics and motor for easy service and repair, and the tool-less wire feeding system makes spool change outs quick and wire setup simple.

**Flexible performance** – Works in both vertical and horizontal alignment with the ability to rotate the display 90 degrees to adjust your viewing angle. The horizontal wheel kit gives the feeder a low, stable profile.



# ROBUST CC/CV SOLUTIONS.

## WARRIOR™ 400i, 500i, AND 750i WITH ROBUST FEED PRO.

Warrior is the reliable multi-process power source designed for heavy-duty productivity with up to 500 A of output. Paired with Robust Feed Pro, it's the most durable and dependable combination for heavy-duty MIG (GMAW) welding with stick (SMAW), TIG (GTAW), and gouging capabilities.

Warrior 750i ARCAIR is the ideal solution for ultimate gouging capabilities. It features optimized performance for ½ in. electrodes and an 850 A maximum output. With the ability to work on 750 A at 100% duty cycle, Warrior 750i can be also used with Robust Feed Pro for any mechanized MIG or heavy-duty hardfacing applications.

**Inverter technology** – Warrior delivers the outstanding portability, arc performance, and energy savings you expect from an inverter.

**High duty cycle** – Warrior is capable of 400 A, 500 A, or 820 A output at 60% duty cycle for long welding runs across a variety of applications.

**Durable and rugged** – Warrior has a sturdy design with thick metal side panels, double bent sides, and large feet that provide clearance, making it fit for use in tough indoor and outdoor environments.

**Portable** – Warrior has ergonomic handles that are rated and marked for crane lifting, providing easy logistics. Warrior 750i's feet also provide a safe lifting area for moving with a forklift.

**Easy to use** – A clear and intuitive user interface with glove-friendly knobs makes setting adjustments quick and easy.

**Wide input voltage range** – Warrior runs on flexible power supplies to support regional requirements.



WARRIOR™ 500i AND  
ROBUST FEED PRO

WARRIOR™ 750i ARCAIR  
AND ROBUST FEED PRO

# ROBUST PULSE SOLUTIONS.

## ARISTO® 500ix WITH ROBUST FEED PULSE OR ROBUST FEED U6.

Aristo 500ix is a portable heavy industrial pulse power source with a rugged and reliable mechanical design. Together with Robust Feed Pulse or Robust Feed U6, this is the ultimate portable and durable combination for advanced heavy-duty pulsed welding applications.

**Advanced pulse functionality** – Aristo's control panel allows for precise adjustment of welding parameters to reduce heat input and minimize spatter.

**Automated weld optimization** – With preprogrammed synergic lines for a wide variety of steel, stainless, and aluminum wires, Aristo automatically adjusts welding parameters based on user input to ensure weld quality.

**Rugged and portable** – Aristo 500ix shares the sturdy, reliable design from Warrior, making it ideal for use both in the shop and out in the field. It also features ergonomic handles that are rated and marked for mechanized lifting to provide easy logistics.

**Multi-process from the point of weld** – Aristo 500ix's multi-process capabilities, including stick and gouging, can be operated from the wire feeder. This eliminates the need for additional welding cables and allows the operator to control all settings, even if far away from the power source.

**Easy to use** – The clear and intuitive user interface has glove-friendly knobs for easy adjustments, including QSet™ technology for automatic short arc parameter setup.

**Wide input voltage range** – Aristo 500ix runs on many types of power supplies, giving it the flexibility to support regional requirements.



**ROBUST  
FEED PULSE**

**ARISTO® 500ix AND  
ROBUST FEED U6**

# ROBUST FEED SELECTION GUIDE.



**ROBUST  
FEED PRO**

**ROBUST  
FEED PULSE**

**ROBUST  
FEED U6**

SPECIFICATIONS	ROBUST FEED PRO	ROBUST FEED PULSE AND ROBUST FEED U6
Input Voltage	42 VAC	42 VAC
Welding Output	550 A @ 50% 500 A @ 60% 400 A @ 100%	630 A @ 35% 500 A @ 60% 400 A @ 100%
Wire Dimensions		
Mild Steel	.023–5/64 in. (0.6–2.0 mm)	.023–1/16 in. (0.6–1.6 mm)
Stainless Steel	.023–1/6 in. (0.6–1.6 mm)	.023–1/16 in. (0.6–1.6 mm)
Cored Wire	.040–3/32 in. (0.9–2.4 mm)	.031–5/64 in. (0.8–2.0 mm)
Aluminum	.040–1/6 in. (0.9–1.6 mm)	.031–1/16 in. (0.8–1.6 mm)
Wire Feed Speed	30–985 in./min. (0.8–25.0 m/min.)	30–985 in./min. (0.8–25.0 m/min.)
Wire Spool Capacity	45 lb (20 kg)	45 lb (20 kg)
Max Spool Diameter	12 in. (300 mm)	12 in. (300 mm)
Operating Temperatures	-4°F to +131°F (-20°C to +55°C)	-4°F to +131°F (-20°C to +55°C)
Protection Class	IP44	IP44
Certification Mark (standards)	CE, CSA	CE, CSA
Dimensions (L x W x H)	23.5 in. x 9.8 in. x 16.9 in. (595 mm x 250 mm x 430 mm)	23.5 in. x 9.8 in. x 16.9 in. (595 mm x 250 mm x 430 mm)
Weight	37.1 lb (16.8 kg)	37.1 lb (16.7 kg)

FUNCTION/FEATURE	ROBUST FEED PRO	ROBUST FEED PULSE + ARISTO 500ix	ROBUST FEED U6 + ARISTO 500ix
MIG CV	x	x	x
MIG Pulse		x	x
Synergic Lines		S, SS, Al - <b>93 lines</b>	S, SS, Al - <b>92 lines</b>
Stick	At power source	Stick controls and outlet on wire feeder *	Stick controls and outlet on wire feeder *
ACAG			Gouging controls and outlet on wire feeder *
Live TIG	x		
Gouging	x		
Gas Flow Meter	Depending on variant	x *	x *
Heat Kit	Depending on variant		
2T/4T	x	x	x
Hot Start		x	x
Creep Start	x	x	x
Crater Fill	x	x	x
Burnback	Auto (solid/cored wire switch)	x	x
SCT		x	x
Amperage Setting		x	x
Gas Pre- and Post-flow Setting		x	x
Qset		x	x
Memory Setting		3	10
Spot Welding Time			x
Setting Limits			x
Code Lock			x

\* Depending on variant



**ROBUST  
FEED PRO**



**ROBUST  
FEED PULSE**



**ROBUST  
FEED U6**

# ROBUST FEED SPECIFICATIONS AND ORDERING INFORMATION.

POWER SOURCE MODEL	WARRIOR 400i MV	WARRIOR 500i	WARRIOR 750i ARCAIR	ARISTO 500ix
Mains Input	220 - 460 V, 3ph, ±10%, 50/60 Hz	380 - 575 V ±10%, 3ph, 50/60 Hz	380 - 575 V ±10%, 3ph, 50/60 Hz	380 - 575 V ±10%, 3ph, 50/60 Hz
Fuse Slow	25 A	32 A	63 A	32 A
Generator Minimum Rated Power (AVR)	40 kW	40 kW	75 kW	40 kW
Permissible Load Air Arc Gouging MIG / Stick / TIG 35% Duty Cycle 60% Duty Cycle 100% Duty Cycle	– 400 A 300 A	– 500 A 400 A	850 A 820 A 750 A	– 500 A 400 A
Efficiency at Max Current MIG (GMAW)	87%	90%	91%	90%
Power Factor Max Current MIG (GMAW)	0.95	0.87	0.91	0.91
Energy Save Mode	50 W	40 W	34 W	28 W
Open Circuit Voltage	56 VDC	84 VDC	94 VDC	84 VDC
Operating Temperature	14 to 104 °F (-10 °C to +40 °C)	14 to 104 °F (-10 °C to +40 °C)	14 to 104 °F (-10 °C to +40 °C)	-4 to 131 °F (-20 °C to +40 °C)
Dimensions (L x W x H)	28.1 x 12.8 x 18.5 in. (712 x 325 x 470 mm)	28.1 x 12.8 x 18.5 in. (712 x 325 x 470 mm)	33.5 x 16.4 x 25 in. (850 x 415 x 637 mm)	28.1 x 12.8 x 18.5 in. (712 x 325 x 470 mm)
Weight	134 lbs (61 kg)	116 lbs (53 kg)	232 lbs (105 kg)	116 lbs (53 kg)
Enclosure Class	IP23	IP23	IP23	IP23
Certification Mark	CSA	CSA	CSA	CSA

ORDERING INFORMATION										
Wire Feeder	Ordering Number	Water Cooling	Gas Flow Meter & Heater	Stick Outlet	Push-Pull	Mechanized MIG	ELP <sup>3</sup>	Remote Outlet	Power Source Options	Ordering Number
Robust Feed Pro	0445800885		X					Optional outlet (power source and wire feeder <sup>1</sup> )	Warrior 400i MV CC/CV	0465885880
									Warrior 500i CC/CV, 460V	0465350881
									Warrior 500i CC/CV, 575V	0465350887
									Warrior 750i CC/CV	0445555881
Robust Feed Pulse	0445800893	X	X	X	X	X	X	X (Wire feeder <sup>2</sup> )	Aristo 500ix	0446200881
									Aristo 4004i WC	0445301881
Robust Feed U6	0445800895		X	X	X	X	X	X (Wire feeder <sup>2</sup> )	Aristo 5000i	0459230884
		X	X	X	X	X	X	X (Wire feeder <sup>1</sup> )	Aristo U500iw	0445400886

1. Available remotes: M1, AT1, and others. 2. Available remotes: MTA1 CAN, AT1 CAN, and others. 3. ELP feature needed for use with legacy equipment (for example, COOL 1).

OPTIONS AND ACCESSORIES		
Product	Accessories	Ordering Number
Robust Feed	Robust Feed Wheel Kit	0446081880
	Torch Strain Relief	0446082880
	Liquid Cooling Kit (to upgrade gas-cooled feeders)	0446123880
	Quick Connector Marathon Pac™	F102440880
Warrior 400i MV CC/CV Warrior 500i CC/CV Aristo 500ix	Tweco 5 connector including front plate	0446120884
	4-Wheel Trolley with Swivel Post for Wire Feeder, Torch Holder, Cable Holders	0349313450
	Guide Pin Extension Kit (needed with trolley when wire feeder is equipped with wheel kit)	0465508880
	Wheel Kit for Power Source	0465416880
	COOL 2 Cooling Unit (Warrior 400i/500i, Aristo 500ix)	0465427880
Warrior 750i CC/CV	Warrior 750i Trolley (air-cooled)	0446398880
	Warrior 750i Trolley (water-cooled)	0446270880
	COOL 2 Stand-Alone (for Warrior 750i)	0465427881
	Adapter Cable from OKC to LUG (to connect interconnection cable sets to Warrior 750i)	0446507880

## Easy 2 Step Ready To Weld Package Selection:

### Step 1: Select Basic Package

### Step 2: Select Interconnection Length

ORDERING INFORMATION	POWER SOURCE ONLY		BASIC PACKAGE*
Warrior 500i CC/CV, 3 ph, 460 V pre-set		0465350881	0558102697
Warrior 500i CC/CV, 3 ph, 575 V pre-set		0465350887	0561000189
Warrior 400i MV CC/CV, 3 ph, 220-460 V		0465885880	0558102696
Warrior 750i Arcair, 380-575 V, CSA		0445555881	0558102739
Aristo 500ix, 380-575 V	0446200881	w/ Robust Feed Pulse	0558102737
		w/ Robust Feed U6	0558102716
		w/ Robust Feed U6 water	0558102738

\* Basic Package Includes: Power Source with ground lead and clamp; Robust Feed™; 10401833 Tweco® Spray Master V450 MIG Gun 15 ft 1/16; 0781-3634 - ESS32-150-580 EDGE 2.0 Regulator; 0349313450 (0446398880 for Warrior 750) Cart - 4 wheel, single cylinder; Water cooled package includes: 0465427880 Cool 2 unit and Spray Master MIG Gun is substituted with 10441179 - FUSION PRO 450 W/C 15 ft, Euro.

NOTE: Power Sources, Basic Packages and Ready to Weld Combinations require the customer to supply input power cables. Suggested cable is 4C 8Awg input cable. Robust Feed comes standard with .035/.045 drive rolls.

INTERCONNECTION CABLES	6.5 ft. (2.0 m)	16.5 ft. (5.0 m)	49.2 ft. (15.0 m)	82 ft. (25.0 m)	115 ft. (35.0 m)
<b>Robust Feed Pro (Warrior)</b>					
70 mm², Gas-Cooled	0446160880	0446160881	0446160883	0446160884	0446160885
95 mm², Gas-Cooled*	0446160980	0446160981	0446160983	0446160984	0446160985
95 mm², Liquid-Cooled*	0446160990	0446160991	0446160993	0446160994	0446160995
<b>Robust Feed Pulse and U6 (Aristo)</b>					
70 mm², Gas-Cooled**	0446255880	0446255881	0446255883	0446255885	
70 mm², Liquid-Cooled**	0446255890	0446255891	0446255893	0446255895	

\* Interconnection set recommended when using the Warrior 750i.

\*\* When using Aristo 5000i/5000iW you must order adapter cable 0446089880.

INTERCONNECTION STRAIN RELIEF KITS		AIR-COOLED MIG TORCHES	12 FT. (3.7 m)	15 FT. (4.5 m)	25 FT. (7.6 m)
Robust Feed Pro for Warrior*	0446050880	Spray Master™ 350 A	1036-1613	1036-1615	1036-1725
Robust Feed Pulse/U6 for Aristo**	0446050881	Spray Master 450 A	1040-1051	1040-1052	1040-1058

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

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

FEED ROLLER SPARE PARTS						
V Groove for Fe/SS/Cored	Wire Diameters					
Groove / Side 1	.030	.035	.035	.045	.052	5/64
Groove / Side 2	.035	.035	.045	.045	1/16	5/64
GIN	0445850002	0445850003	0445850004	0445850005	0445850006	0445850007
V-K Groove for Cored Wire	Wire Diameters					
Groove / Side 1	.035	.045	.045	1/16	5/64	.052
Groove / Side 2	.045	.045	.052	1/16	5/64	.052
GIN	0445850030	0445850031	0445850032	0445850033	0445850035	0445850036
U Groove for Aluminum Wire	Wire Diameters					
Groove / Side 1	.030	.035	.045			
Groove / Side 2	.035	.045	1/16			
GIN	0445850050	0445850051	0445850052			

WIRE GUIDE SPARE PARTS	INLET NOZZLE	MIDDLE NOZZLE	OUTLET NOZZLE
Outlet Wire Guide for Fe/SS/Cored .023 - 1/16" (0.6 - 1.6 mm)	0445822001	0446080882	0445830883
Outlet Wire Guide for Fe/Cored .072 - 3/32" (1.8 - 2.4 mm)	0445822002	0446080883	0445830884
Outlet Wire Guide for Aluminum .031 - 1/16" (0.8 - 1.6 mm)	0445822001	0446080881	0445830886

**Get the feeder that keeps on feeding.** Contact your ESAB distributor to order a Robust Feed package today, [and visit esab.com/robust](http://esab.com/robust) to learn more.

# UNRIVALED SERVICE AND SUPPORT.

Robust Feed, like every ESAB machine, is backed by our commitment to superior customer service and support. Our skilled customer service department is prepared to quickly answer any questions, address problems, and help with maintenance and upgrading of machines.

For more information on Robust Feed, visit [esab.com/robust](http://esab.com/robust).

## 3-YEAR WARRANTY.

ESAB's industry-leading service and support means that if customers do need help, they'll be protected by the most comprehensive warranty in the business.



## 100% SATISFACTION GUARANTEE.

If there's anything you're not completely satisfied with in your first 100 days with your new Robust Feed, ESAB will make it right, even if it means giving you your money back.

It's all part of our Iron Clad Pledge to our customers.



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