

GAS SUPPLEMENT

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

NO. W000273158 - W000273159



EDITION : EN
REVISION : M
DATE : 03 - 2025

Instructions for use

REF: 8695 5511

Original instructions

LINCOLN[®]
ELECTRIC

Thank for the trust you have expressed by purchasing this equipment, which will give you full satisfaction if you follow its instructions for use and maintenance.

Its design, component specifications and workmanship comply with applicable European directives.

Please refer to the enclosed CE declaration to identify the directives applicable to it.

The manufacturer will not be held responsible where items not recommended by themselves are associated with this product.

For your safety,there follows a non-restrictive list of recommendations or requirements, many of which appear in the employment code.

Finally we would ask you kindly to inform your supplier of any error which you may find in this instruction manual.

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INFORMATION

This technical literature is intended for the following machines or products:

- Auxiliary gas box
- Additional auxiliary gas



These instructions and the product covered by them refer to the applicable standards.



Please read these instructions carefully before installing, using or maintaining the machine. Keep these instructions in a safe place for future reference. These instructions must accompany the described machine or equipment if there is a change in ownership, up to the time of destruction.



Display and pressure gauge:

Measurement instruments or displays of voltage, intensity, speed, accuracy etc. are to be considered as indicators, whether they are analogue or digital.



For operating instructions, adjustments, troubleshooting and spare parts, please refer to the special instructions for safe operating and maintenance.

REVISIONS

REVISION : B DATE : 02/03

DESIGNATION	PAGE
Plasma RDM	10

REVISION : C DATE : 06/06

DESIGNATION	PAGE
To change logos	-

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REVISION : E DATE : 11/08

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Complete update + spareparts newoffer	-

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Gyrometer replacement	11

REVISION : G DATE : 04/11

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Add "Setting"	3

REVISION : H DATE : 04/11

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Spare parts	

REVISION : I DATE : 03/13

DESIGNATION	PAGE
Spare parts	

REVISION : J DATE : 07/03

DESIGNATION	PAGE
Update NERTAMATIC Plus	10 - 11

REVISION : K DATE : 05/18

DESIGNATION	PAGE
To change logos	


























REVISION : L DATE : 04/23

DESIGNATION	PAGE
Update Add «LINC-MASTER installation»	

REVISION : M DATE : 03/25

DESIGNATION	PAGE
Add "Reading"	1

MEANING OF SYMBOLS

	Reading the manual/instructions mandatory.		Indicates a hazard.
	Use of safety shoes mandatory.		Warning of an electrical risk or hazard.
	Use of auditory protection mandatory.		Warning of a risk or hazard due to an obstacle on the ground.
	Use of safety helmet mandatory.		Warning of a risk or hazard of falling, with a level difference.
	Use of safety gloves mandatory.		Warning of a risk or hazard due to suspended loads.
	Use of safety glasses mandatory.		Warning of a risk or hazard due to the presence of a hot surface.
	Use of safety visor mandatory.		Warning of a risk or hazard due to moving mechanical parts.
	Use of safety clothing mandatory.		Warning of a risk or hazard due to the closing movement of moving mechanical parts of a machine.
	Cleaning the working area mandatory.		Warning of a risk or hazard due to the presence of a laser radiation.
	Use of breathing protection mandatory.		Warning of a risk or hazard due to an obstacle at a height.
	Visual inspection required.		Warning of a risk or hazard due to the presence of a pointed part.
	Indicates a lubrication operation.		Wearers of pacemakers may not be admitted in the designated area.
	Requires maintenance action.		



W000273158

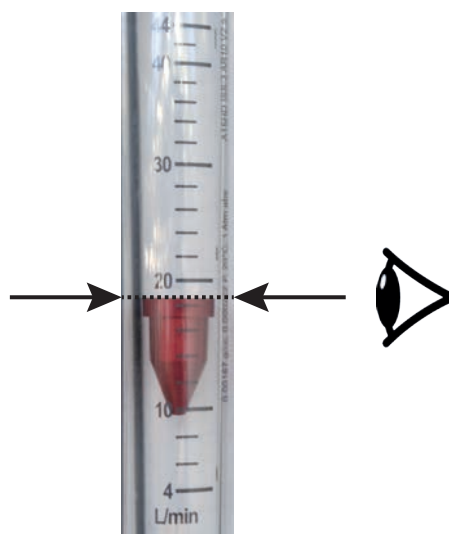
W000273159

The gas unit W000273158 can handle up to two flows of gas – torch annular, reverse or saddle gas. It includes a 4 - 40 l/min gyrometer as standard, plus a solenoid valve. As an option, it may be fitted with a second gas line W000273159, which also includes a gyrometer and a solenoid valve.

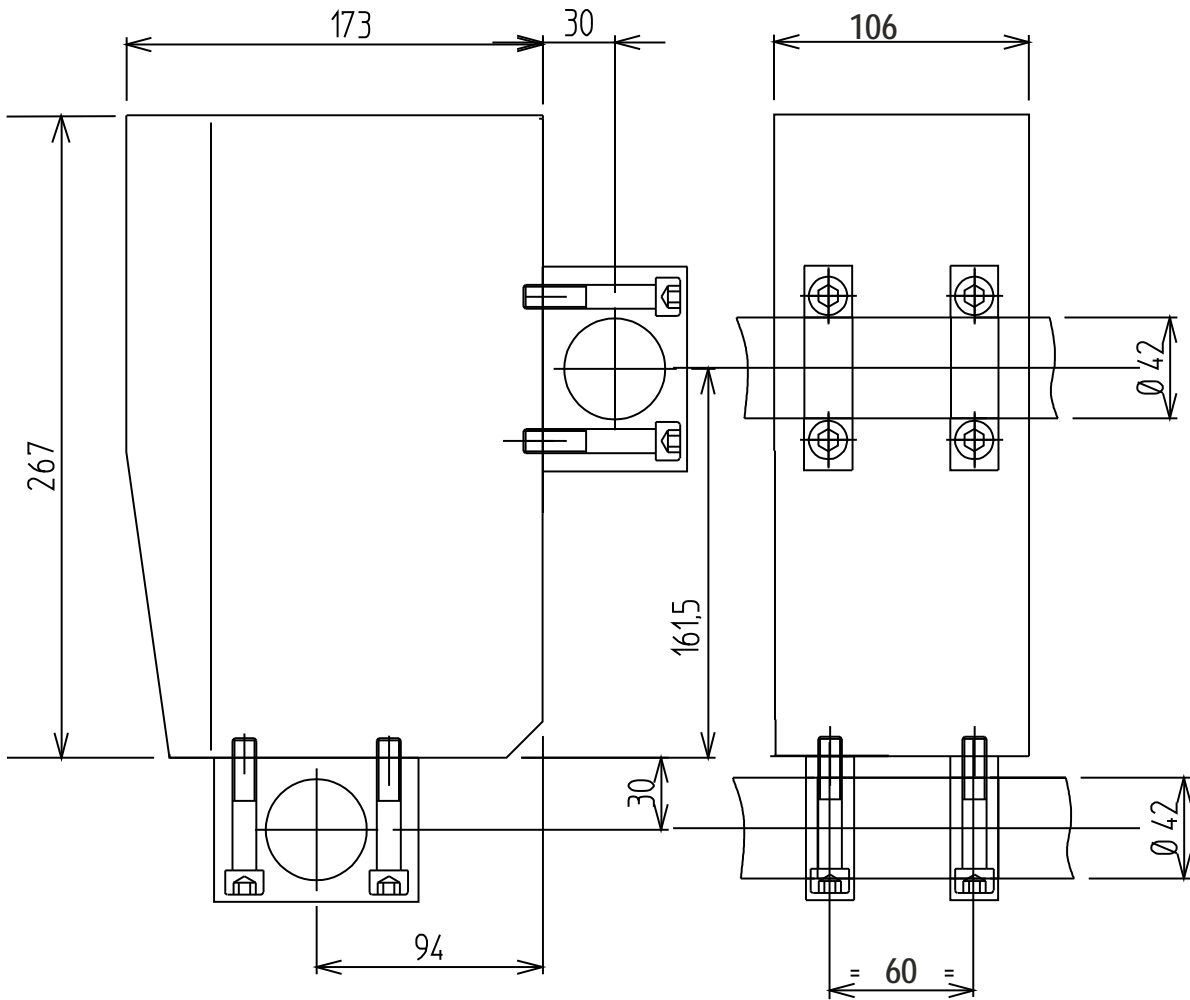
Setting :

- 3 bar → 4 - 30 l/mn

Reading is done from the top of the float.



B - ASSEMBLY



Fix the support rings to the front or lower side of the unit (take the same side as the console).

Fix the unit to the support tube next to the console.

C - CONFIGURATION

Select the desired type of assembly, depending on the welding installation.

The basic unit is supplied with a set of plates **D4 D5** to be put in place depending on the case of use (see following pages).



To assemble the various plates or install the optional second flow meter :

- Remove the front and back **D1 D2** after removing nuts **D3**
- Put in the selected plates **D4 and D5**
- Put back the front and back and the nuts.

Connect the gas cylinder to the rear of the kit (gas inlet).

< 45 psi
< 3 bar



Connect the pipes from the **BRT** kit to the gas outlets.



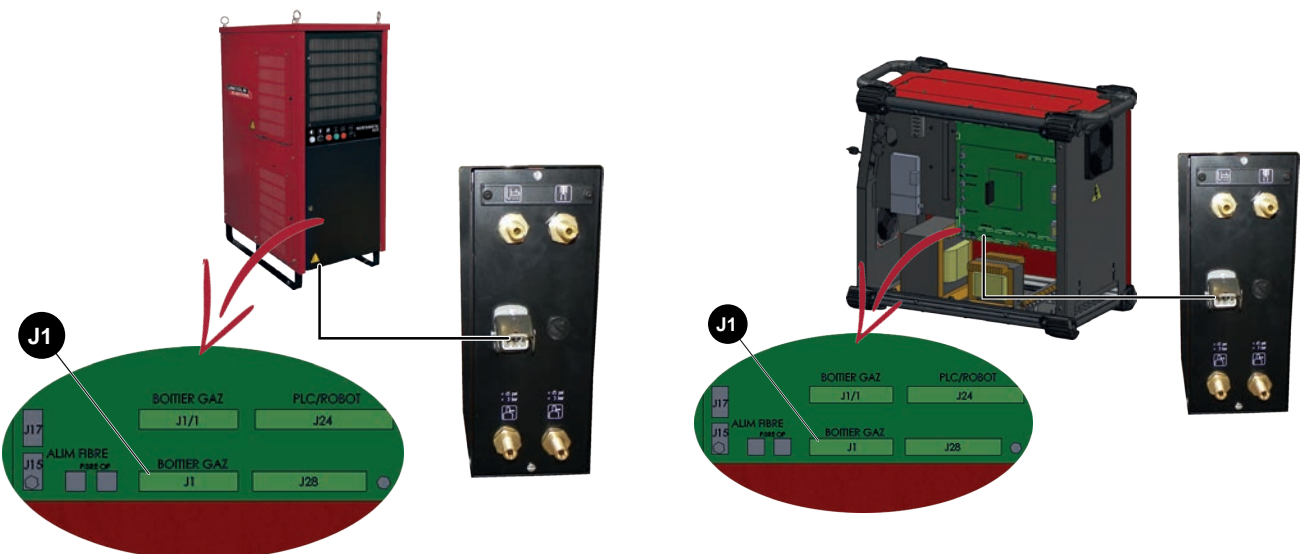
Please refer to the document :

- 86955510: **NERTAMATIC 450 Plus** installation
- 86955520: **LINC-MASTER** installation

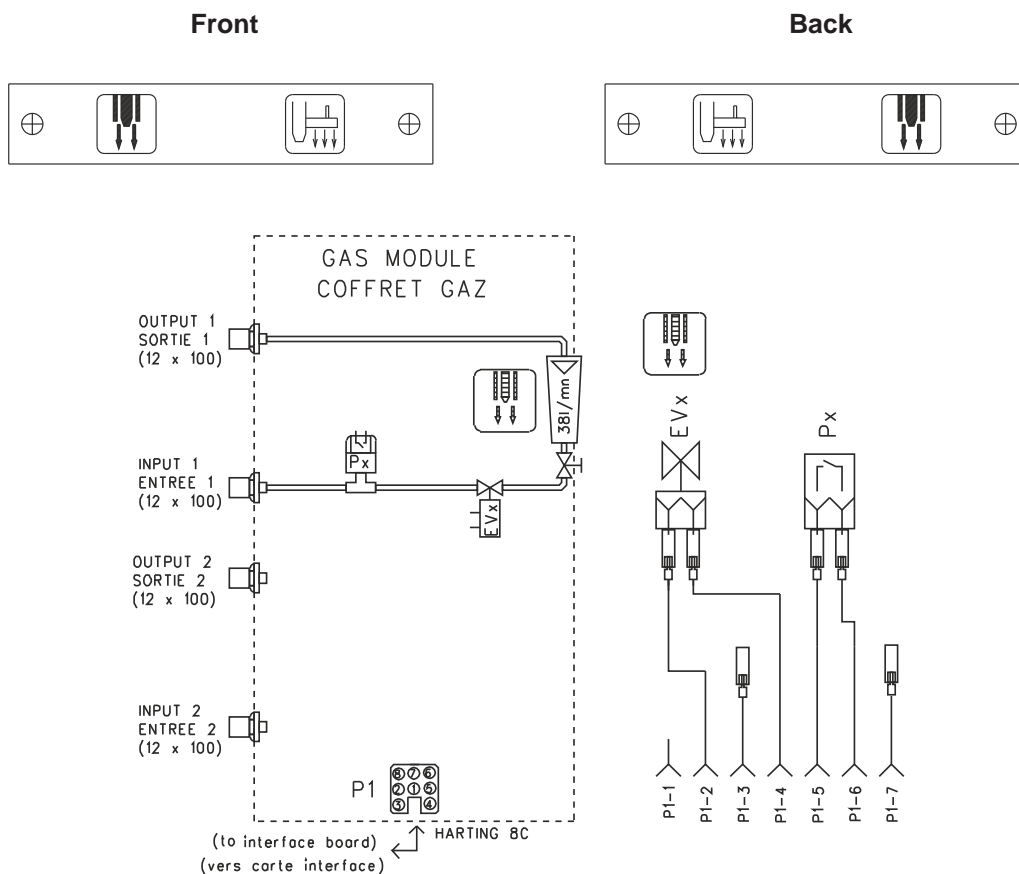
Connect the Harting connector to **P1**. Connect the other end to **J1** of the interface board.

NERTAMATIC 450 Plus installation

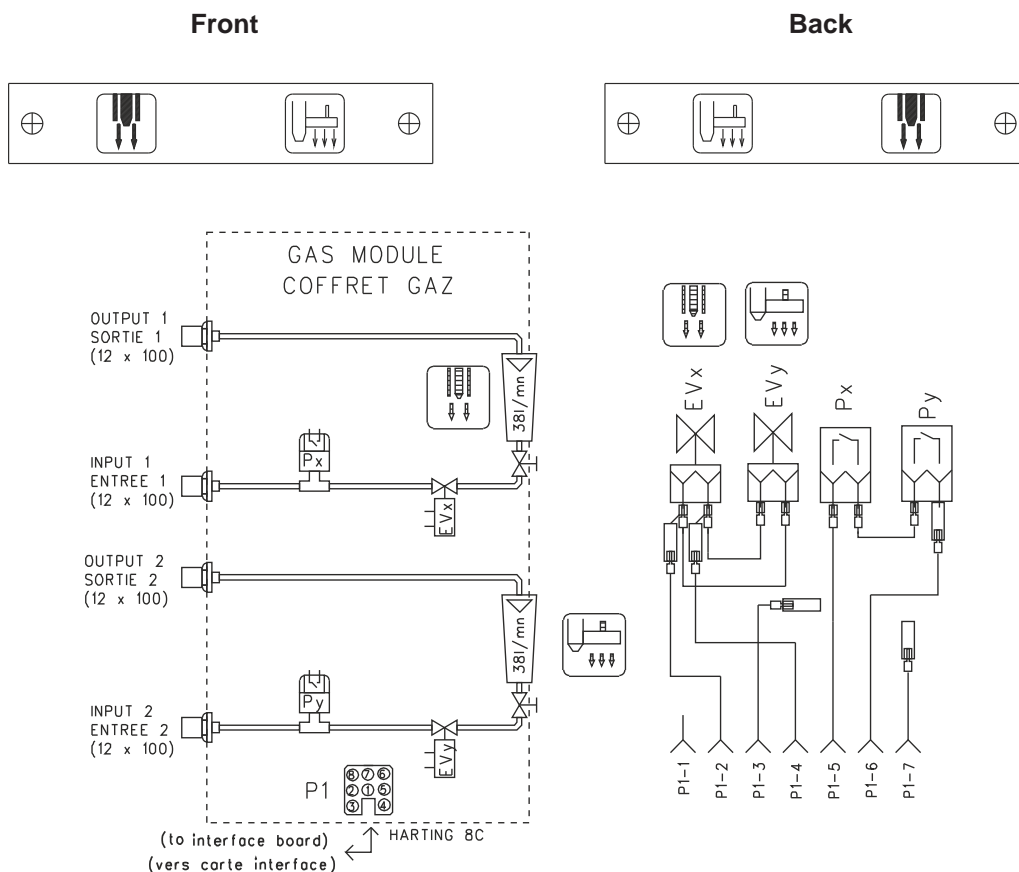
LINC-MASTER installation



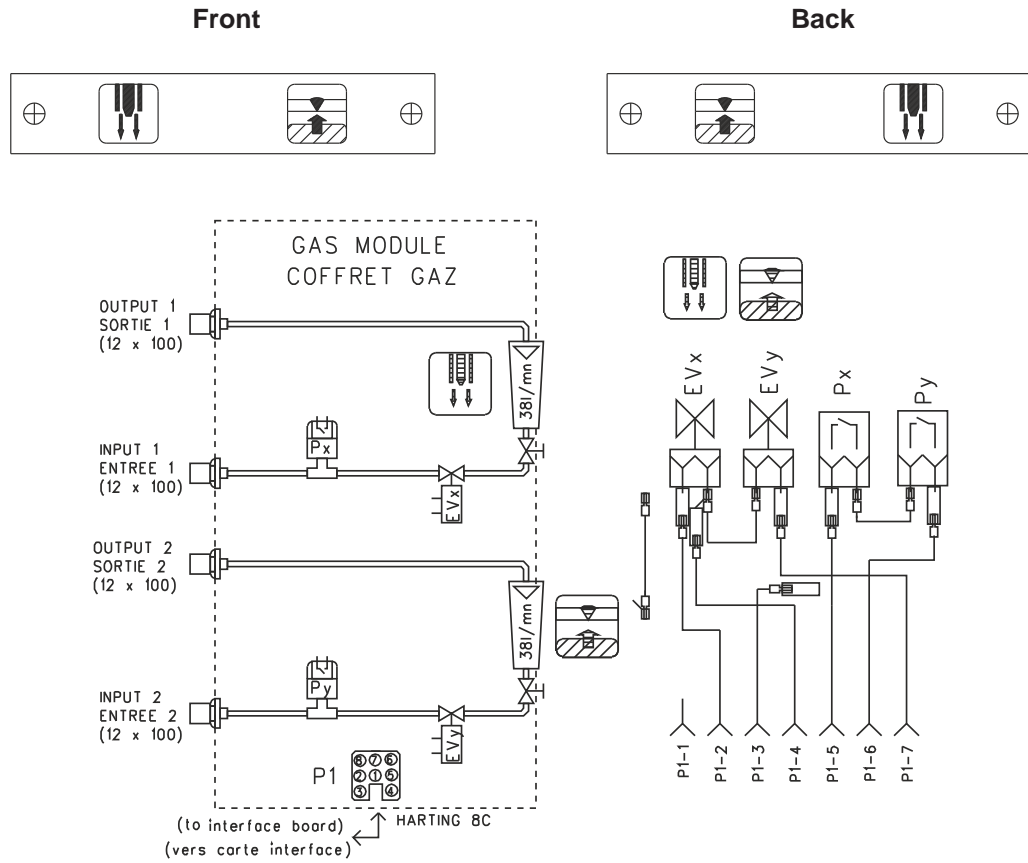
1 - TIG welding only



2 - TIG welding with saddle gas

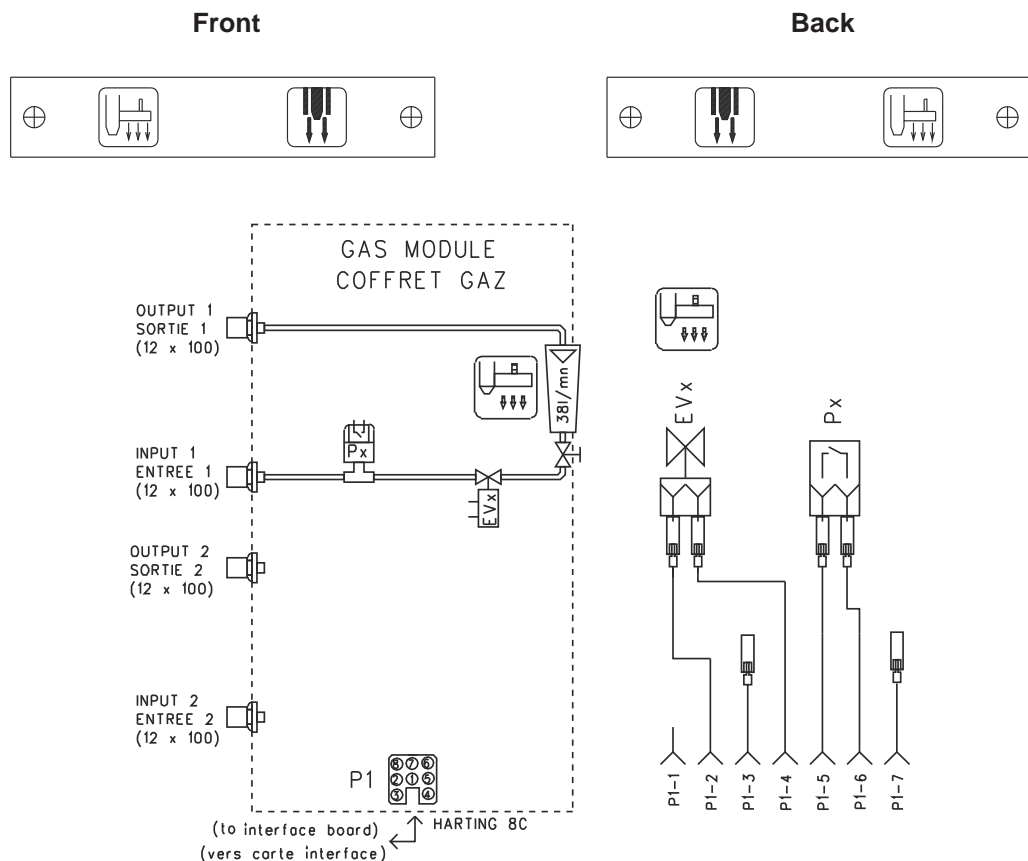


3 - TIG welding with reverse gas



4 - Saddle gas only

☛ second box if the assembly includes TIG + reverse gas + saddle gas

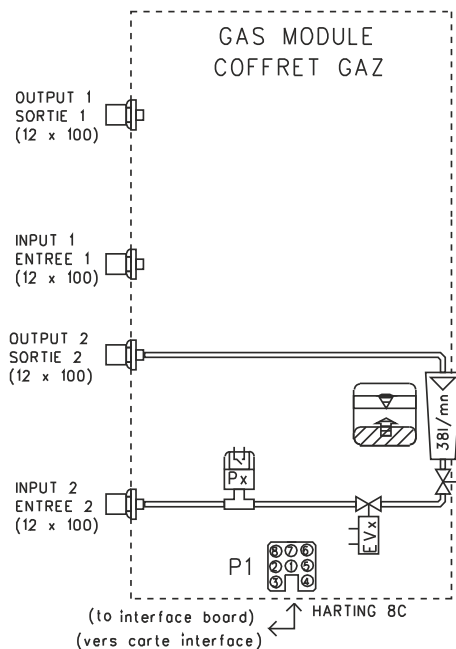


5 - Reverse gas only

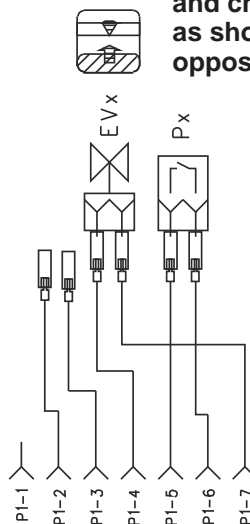
Front



Back



Note: in this case, fit the flow meter to the right and change the wiring as shown in the diagram opposite



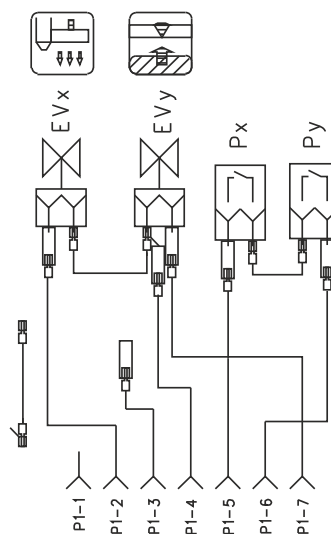
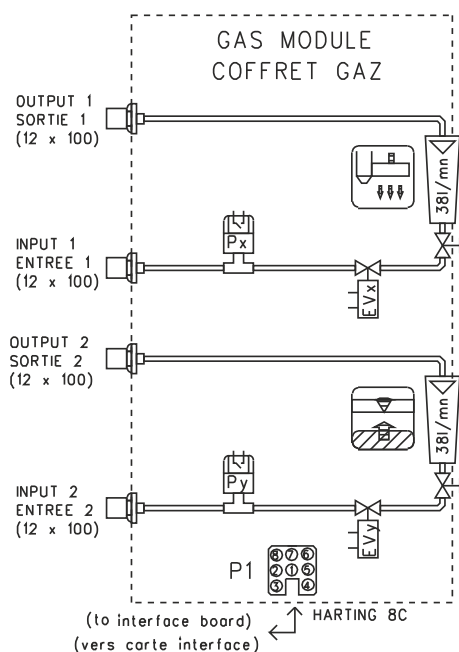
6 - Saddle gas and reverse gas

use with the RDM kit

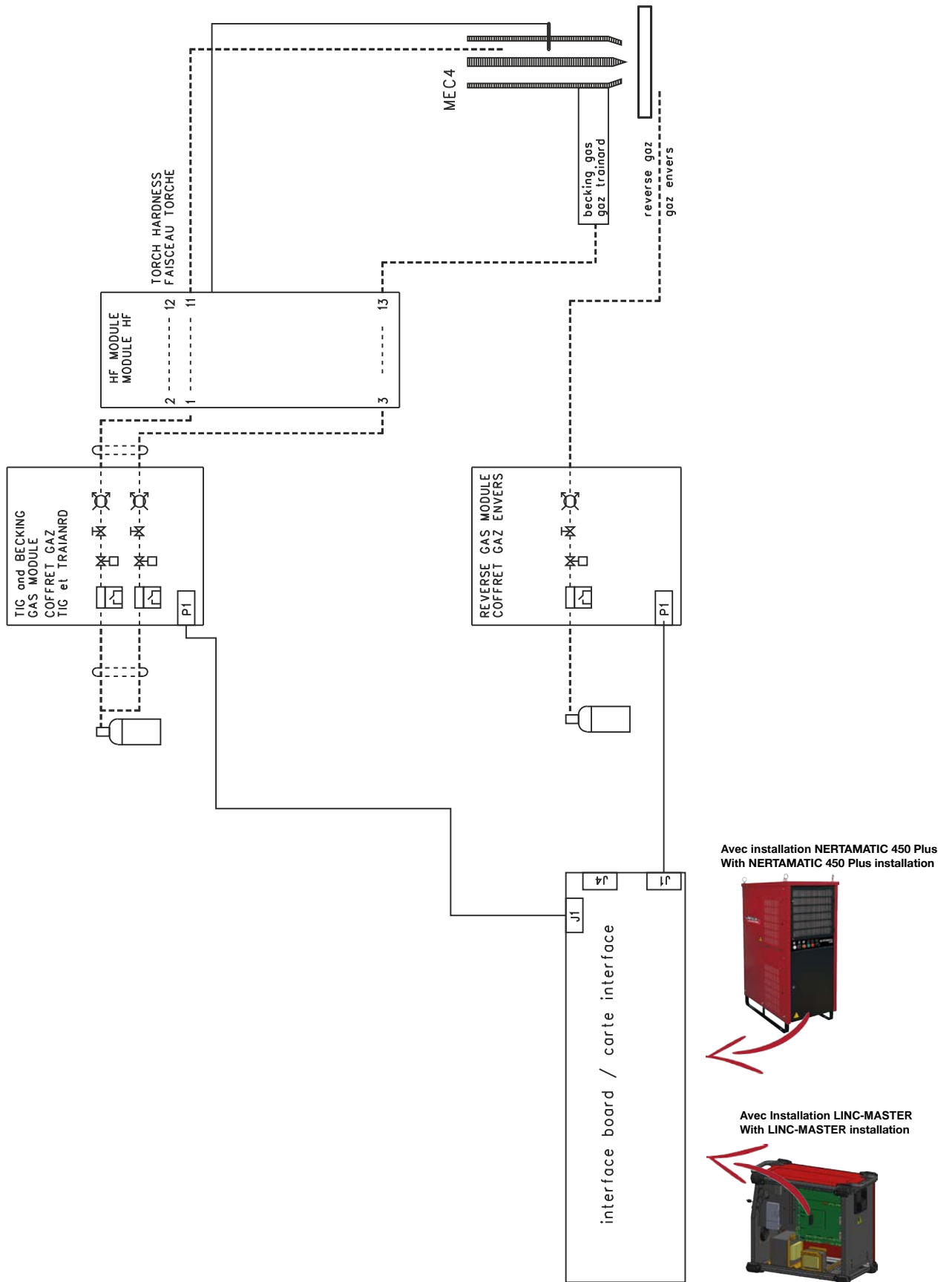
Front

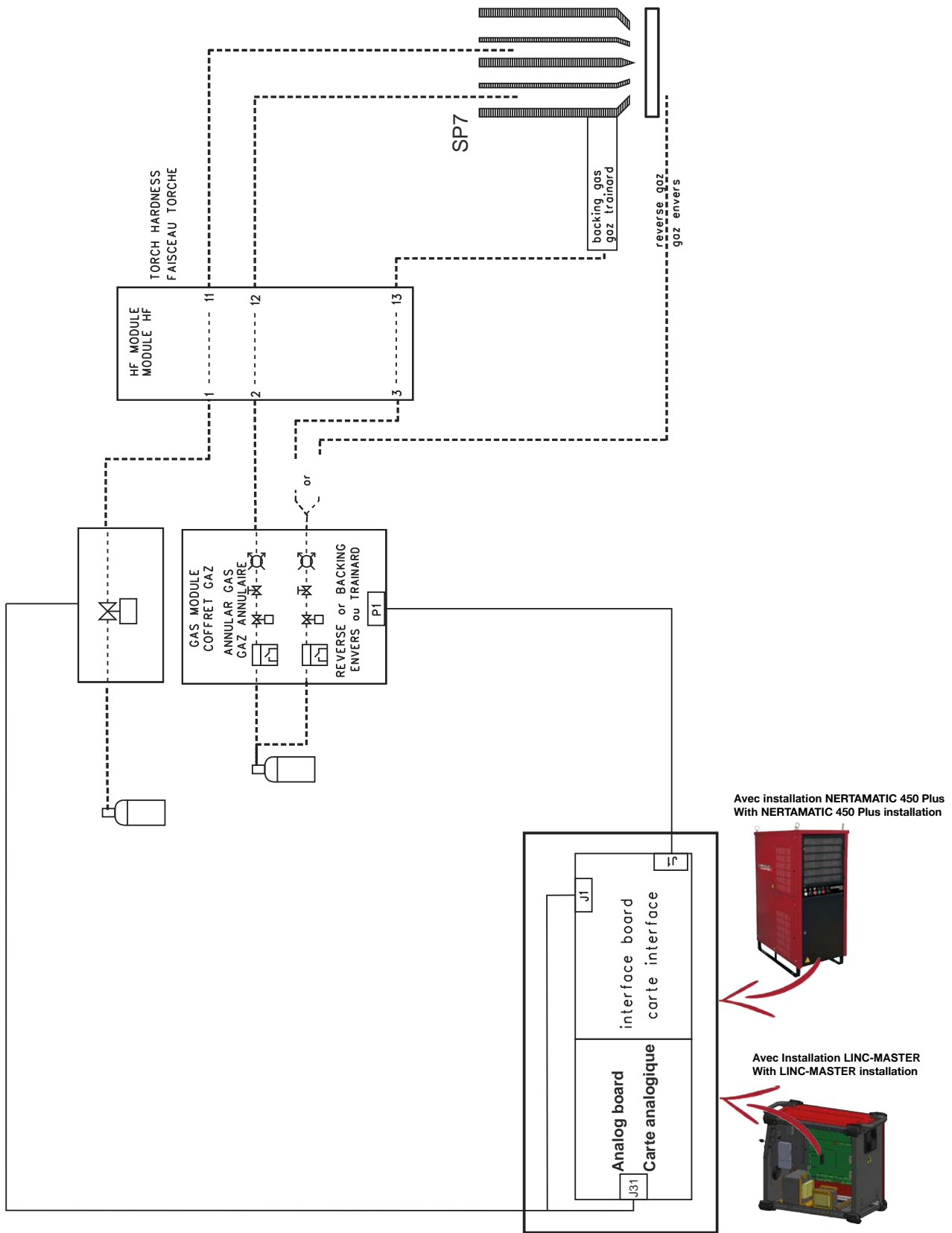


Back



1 - TIG only





1 - Spare parts

Ordering procedure:

Almost all the parts of a machine or installation are referenced in the photographs and sketches.

The descriptive tables contain three types of item:

- items normally held in stock: ✓
- items not held in stock: ✗
- items upon request: no reference

(For such parts, please complete the list of parts page and send us a copy. In the Order column, state the number of parts required and indicate the type and number of your equipment.)

For items referenced in the photographs or sketches but not included in the tables, please send us a copy of the relevant page and highlight the relevant reference.

Example:

Ref.	Part no	Stock	Order	Description
E1	W000XXXXXX	✓		Machine interface board
G2	W000XXXXXX	✗		Flow meter
A3	P9357XXXX			Printed front plates

✓	normally held in stock.
✗	not in stock upon request.

- While ordering parts, please indicate the quantity and note the number of your machine in the box above.

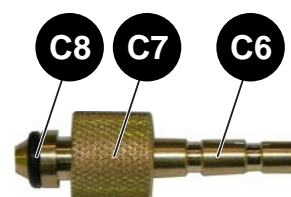
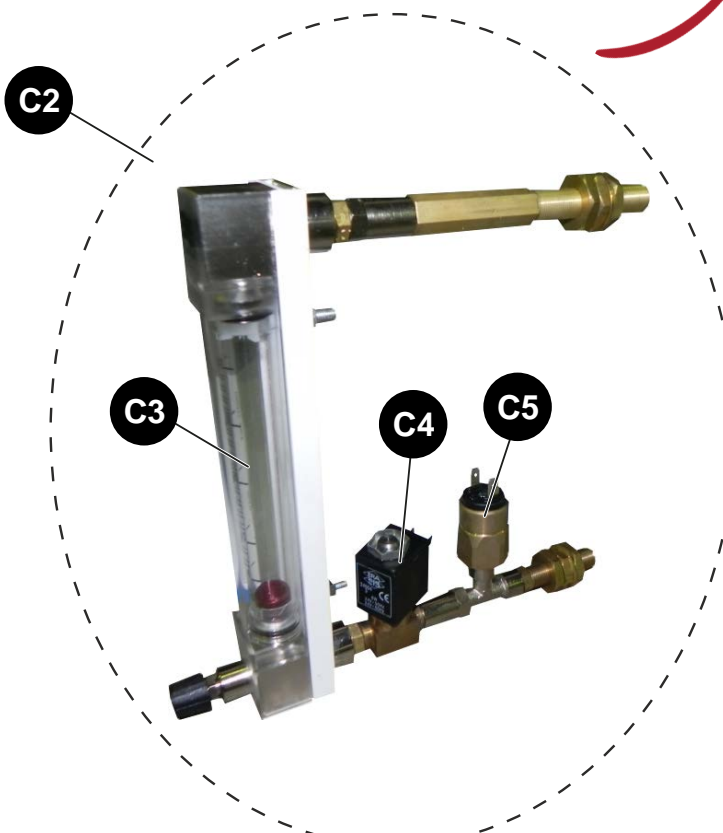
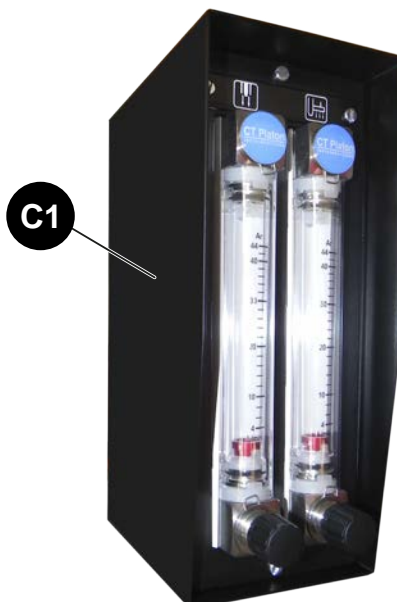
Type <input style="width: 100px;" type="text"/> Matricule <input style="width: 100px;" type="text"/>	TYPE :
	Number :

Old version :
(up to No.00467LD366)

New version :
(from No. 00468LD366)

Replace the unit with the new version:


- W000273158 for one gas
- W000273158 + W000273159 for two gases



✓	normally held in stock.
✗	not in stock upon request.

Ref.	Part no	Stock	Order	Description
C1	W000273158	✓		Complete unit
C2	W000273159	✓		Second gas supplement
C3	W000352160	✓		Gyrometer only
C4	W000147385	✓		2/2NC 24V50Hz 0-10b 1/8G Solenoid valve
C5	W000352161	✓		0 - 10 bars Pressure sensor
C6	W000352152	✓		Olive
C7	S33760211	✓		Argon nut
C8	W000147372	✓		O-ring seal

- While ordering parts, please indicate the quantity and note the number of your machine in the box above.

 Type <input type="text"/> Matricule <input type="text"/>	→	TYPE :
	→	Number :

