

Warrior™ Feed 304

Simple functionality, multi-process wire feeder



The Warrior Feed 304 is an economical wire feeder that brings you the same benefits as its partner Warrior 400i MV and 500i power supplies; simple functionality, rugged durability, and outstanding performance.

Sturdy design with galvanized metal casing for use in tough environments. Electronically controlled feeding gives accurate and stable arc. The 4-roll feeder mechanism with grooves in both feed roll and pressure roll gives stable feeding and low wear on the wire, all to avoid operational disturbance.

- New drive motor offers more torque for improved arc starts, more consistent speed and less noise
- Redesigned 4 roll drive stand mechanism with improved feed rolls, provides positive feeding performance and reduced wire shavings
- Sun-friendly display, volt and amp meter
- Easy-to-use controls (remote voltage, gas purge, inch wire, WFS) trigger lock, and slow run-in make configuration easy
- Short Circuit Termination (SCT) technology sharpens the wire at the end of each weld to promote better arc starts
- Spool cover and lifting handle standard

Industry

- General Industrial Fabrication
- Energy
- Windtowers
- Transportation
- Railcars
- Mining
- Mobile Machinery
- Steel Industry
- Ship/Barge Building
- Offshore Oil

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Warrior Feed 304 shown with Warrior 500i

Warrior™ Feed 304

Specifications	
Supply voltage	42 VAC
Supply frequency	50/60 Hz
Power requirement	252 VA
Wire feed speed	32 – 1000 ipm (0.8 – 25.4 m/min)
Wire spool capacity	44 lbs. (18 kg)
Maximum spool diameter	12 in. or 17 in.* (305 mm or 432 mm*)
Wire Dimensions:	
Mild steel	.023 – 1/16 in. (0.6 – 1.6 mm)
Stainless steel	.023 – 1/16 in. (0.6 – 1.6 mm)
Aluminum	.040 – 1/16 in. (1.0 – 1.6 mm)
Cored wire	.035 – 1/16 in. (0.9 – 1.6 mm)
Operating temperature	14 – 104°F (-10 – 40°C)
Dimensions L x W x H	27.1 x 10.8 X 16.1 in. (690 x 275 x 420 mm)
Weight	33 lbs. (15 kg)
Standards	CE, CSA
Enclosure class	IP23

*Requires trolley 0460565880 and stabilizer kit 0461310880.

Ordering Information	
Description	Part Number
Warrior Feed 304 Air-Cooled	0465250880
Warrior Feed 304w Water-Cooled	0465250881
Warrior Feed 304, ST-16/21 Compatible	0588002048

Options & Accessories	
Description	Part Number
Wheel kit, Warrior feeder	0458707880
Strain relief for welding gun	0457341881
Strain relief for connection cables	0459234880
Lifting eye	0458706880
Adapter for spool diameter 17 in. (440 mm)	0459233880
Coil adapter	34323
Adapter for 11 lbs. (5 kg) spool	0455410001
Guide pin extension kit, feeder	0465508880
Turning piece for Aristo Feed/Origo Feed Marathon Pac versions	0458703880
Quick connector Marathon Pac	899F50
Inlet guide for Marathon Pac/adapter (use with 899F50)	0558002354
MiniBoom Counterbalance Device	0458705880
Trolley 4-wheel stabilizer kit for counterbalance device	0460946880
Spool cover, steel	0459431880
Remote outlet kit feeder, 23p	0465451880
Remote control M1	0459491895

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Options & Accessories

Description	Part Number
Remote interconnection cable M1 16.4 ft. (5 m)	0459553880
Remote Adapter Kit Miggytrac/Railtrac	0465451881
Victor EDGE ESS3-40-580 Ar Single-Stage Regulator/Flowmeter	0781-5120
Female gas hose quick-connector	0365803002
Tweco Spray Master V250 MIG Gun (Euro), up to .045 in. (1.2 mm), 15 ft. (4.6 m)	1023-1288
Tweco Spray Master V350 MIG Gun (Tweco), up to 1/16 in. (1.6 mm), 15 ft. (4.6 m)	1036-1756
Tweco Spray Master V450 MIG Gun (Euro), up to 1/16 in. (1.6 mm), 15 ft. (4.6 m)	1040-1850









Interconnection Cables

Description	Part Number
Interconnection Cables - 70mm ² , Air-Cooled, 6.5 ft. (2 m)	0459836880
Interconnection Cables - 70mm ² , Air-Cooled, 16.4 ft. (5 m)	0459836881
Interconnection Cables - 70mm ² , Air-Cooled, 32.8 ft. (10 m)	0459836882
Interconnection Cables - 70mm ² , Air-Cooled, 49.2 ft. (15 m)	0459836883
Interconnection Cables - 70mm ² , Air-Cooled, 82 ft. (25 m)	0459836884
Interconnection Cables - 70mm ² , Air-Cooled, 114.8 ft. (35 m)	0459836885
Interconnection Cables - 70mm ² , Water-Cooled, 6.5 ft. (2 m)	0459836890
Interconnection Cables - 70mm ² , Water-Cooled, 16.4 ft. (5 m)	0459836891
Interconnection Cables - 70mm ² , Water-Cooled, 32.8 ft. (10 m)	0459836892
Interconnection Cables - 70mm ² , Water-Cooled, 49.2 ft. (15 m)	0459836893
Interconnection Cables - 70mm ² , Water-Cooled, 82 ft. (25 m)	0459836894
Interconnection Cables - 70mm ² , Water-Cooled, 114.8 ft. (35 m)	0459836895

*Air-cooled connection sets include shielding gas hose, welding current cable, control cable protective sheath. All fittings included.

*Water-cooled connection sets include the same as air-cooled sets plus additional coolant in and out hoses. All fittings included.

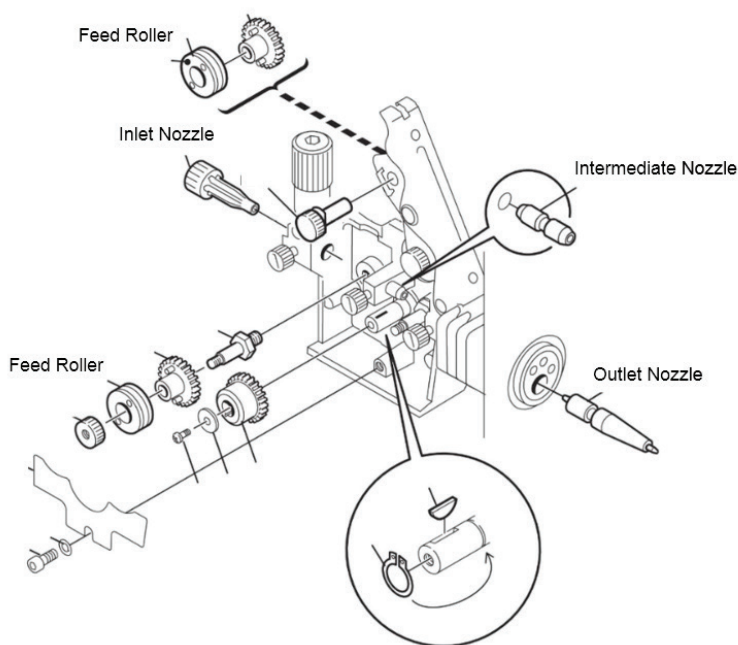
Warrior Feed Functions

2-Stroke	With 2-stroke, the gas pre-flow (if used) starts when the welding torch trigger switch is pressed. The welding process then starts. Releasing the trigger switch stops welding entirely and starts gas post-flow (if selected).	
4-Stroke	With 4-stroke, the gas pre-flow starts when the welding trigger torch switch is depressed and the wire feed starts when it is released. The welding process continues until the switch is pressed in again, the wire feed then stops and when the switch is released, the gas post-flow starts (if selected).	
Wire Selection Cored Wire	A constant burnback time is selected when the trigger is released, to adjust to welding with cored wire. This prevents the wire from sticking to the work or burning back to contact tip.	
Wire Selection Solid Wire	Short Circuit Termination (SCT) function is a new way to end/terminate the weld. SCT uses a small short circuit to reduce the size of the end of the wire. This helps with crater oxidation. It also gives the advantage of preparing the wire for a good start without clipping the end of the wire.	
Creep Start Slow Run-In	Creep start feeds out the wire at slower WFS than the preset WFS until it makes electrical contact with the work-piece. This provides better starts.	
Wire Inching	Wire inching is used when feeding wire without applying a welding voltage. This feature is used to replace pulling the torch trigger, which wastes gas and energy.	
Gas Purging	Gas purging is used when measuring the gas flow or to flush any air or moisture from the gas hoses before welding starts. Gas purging takes place for as long as the button is held depressed and takes place without voltage or wire feed starting.	
Wire Feed Speed	This sets the required feed speed of the filler wire in inch/minute or m/minute.	

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Interconnection Cables

Description	Part Number
Feed Roller V Groove for Fe/SS/C .023-.030 in. (0.6-0.8 mm)	0459052001
Feed Roller V Groove for Fe/SS/C .030-.035 in. (0.8-0.9 mm)	0459052002
Feed Roller V Groove for Fe/SS/C .035-.040 in. (0.9-1.0 mm)	0459052003
Feed Roller V Groove for Fe/SS/C .052-1/16 in. (1.4-1.6 mm)	0459052013
Feed Roller V-K Groove for C .035-.045 in. (0.9-1.2 mm)	0458825001
Feed Roller V-K Groove for C .045-.052 in. (1.2-1.4 mm)	0458825002
Feed Roller V-K Groove for C 1/16 in. (1.6 mm)	0458825003
Feed Roller U Groove for Al .030-.040 in. (0.8-1.0 mm)	0458824001
Feed Roller U Groove for Al .040 in. (1.0 mm)	0458824002
Feed Roller U Groove for Al .045-1/16 in. (1.2-1.6 mm)	0458824003
Inlet Nozzle Ø 2 mm for Fe/SS/AlC .023-1/16 in. (0.6-1.6 mm)	0156602001
Inlet Nozzle Ø 3 mm for Fe/SS/AlC .023-1/16 in. (0.6-1.6 mm)	0455049001
Intermediate Nozzle for Fe/SS/C .023-1/16 in. (0.6-1.6 mm)	0455072002
Intermediate Nozzle for Al .030-1/16 in. (0.8-1.6 mm)	0456615001
Outlet Nozzle for Fe/SS/C .023-1/16 in. (0.6-1.6 mm)	0469837880
Outlet Nozzle for Al .030-1/16 in. (0.8-1.6 mm)	0469837881



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