

CIGWELD

AN ESAB BRAND



100+
YEARS OF
WELDING
INNOVATION

COOLVENOM



COOLVENOM
4LTR

COOLVENOM
7LTR

OPERATING MANUAL

CIGWELD

AN ESAB BRAND

WE APPRECIATE YOUR BUSINESS!

Congratulations on your new CIGWELD product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network.

This Operating Manual has been designed to instruct you on the correct use and operation of your CIGWELD product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) while writing this manual. However errors do occur and we apologise if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

YOU ARE IN GOOD COMPANY!

The Brand of Choice for Contractors and Fabricators Worldwide.

CIGWELD is a Market Leading Brand of Arc Welding Products for ESAB. We are a mainline supplier to major welding industry sectors in the Asia Pacific and emerging global markets including; Manufacturing, Construction, Mining, Automotive, Engineering, Rural and DIY.

We distinguish ourselves from our competition through market-leading, dependable products that have stood the test of time. We pride ourselves on technical innovation, competitive prices, excellent delivery, superior customer service and technical support, together with excellence in sales and marketing expertise.

Above all, we are committed to develop technologically advanced products to achieve a safer working environment for industry operators.



100+
YEARS OF
WELDING
INNOVATION

**WARNING**

Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment. While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use. Disclaimer: The images and values depicted in this manual are for illustration purposes only and may vary to actual values.

**CIGWELD COOLVENOM
WATER COOLER
OPERATING MANUAL
NUMBER: 742055**

FOR:**P/N W4018240****P/N W4018270**

Published by:

**CIGWELD Pty Ltd****CIGWELD An ESAB Brand**

71 Gower Street, Preston VIC 3072 Australia

Customer Care:

Tel: 1300 654 674 | Intl Tel: +61 3 9474 7400

Email: support@cigweld.com.au

 | **CIGWELD.COM.AU**

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Publication Date: 01-06-2026

Revision Date:

**RECORD THE FOLLOWING
INFORMATION
FOR WARRANTY
PURPOSES:**

Where Purchased:

Purchase Date:

Equipment Serial #:

BE SURE THIS INFORMATION REACHES THE OPERATOR. YOU CAN GET EXTRA COPIES FOR FREE BY DOWNLOADING FROM THE CIGWELD WEBSITE.



CAUTION

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for arc welding and cutting equipment, we urge you to read our booklet, "Precautions and Safe Practices for Arc Welding, Cutting, and Gouging," Booklet 0-5407. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information. Be sure to read the Safety Precautions before installing or operating this equipment.

USER RESPONSIBILITY

This equipment will perform in conformity with the description thereof contained in this manual and accompanying labels and/or inserts when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Malfunctioning or poorly maintained equipment should not be used. Parts that are broken, missing, worn, distorted or contaminated should be replaced immediately. Should such repair or replacement become necessary, the manufacturer recommends that a telephone or written request for service advice be made to the Authorised Distributor from whom it was purchased.

This equipment or any of its parts should not be altered without the prior written approval of the manufacturer. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use, faulty maintenance, damage, improper repair or alteration by anyone other than the manufacturer or a service facility designated by the manufacturer.



READ AND UNDERSTAND THE OPERATING MANUAL BEFORE INSTALLING OR OPERATING. PROTECT YOURSELF AND OTHERS!

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DECLARATION OF CONFORMITY

According to AS/NZS 3820:2020, Essential Safety Requirements for Electrical Equipment Radiocommunications Labelling (Electromagnetic Compatibility) Notice 2017

TYPE OF EQUIPMENT

Arc welding water cooler

TYPE DESIGNATION

CoolVenom 4LTR with serial number from:
ZC621YYWW####

CoolVenom 7LTR with serial number from:
ZC622YYWW####

BRAND NAME OR TRADEMARK

CIGWELD

MANUFACTURER OR HIS AUTHORISED REPRESENTATIVE ESTABLISHED WITHIN THE EEA NAME, ADDRESS, AND TELEPHONE NO:

CIGWELD Pty Ltd 71 Gower Street
Preston, Victoria, Australia, 3072
Phone: +61 3 9474 7400;
cigweld.com.au

THE FOLLOWING HAS BEEN USED IN THE DESIGN:

AS 1674.2:2025	Safety in welding and allied processes, Part 2: Electrical
EN IEC 60974-2: 2019	Arc Welding Equipment, Part 2: Liquid cooling systems
AS/NZS 3760:2022	In-service safety inspection and testing of electrical equipment and RCDs
EN IEC 60974-10: 2021	Arc Welding Equipment, Part 10: EMC requirements

ADDITIONAL INFORMATION:

Restrictive use, Class A equipment, intended for use in location other than residential. This equipment is also in compliance with the essential requirements of EU Directives 2014/30/EU and 2014/35/EU.

BY SIGNING THIS DOCUMENT, THE UNDERSIGNED DECLARES AS MANUFACTURER, OR THE MANUFACTURER'S AUTHORISED REPRESENTATIVE, THAT THE EQUIPMENT IN QUESTION COMPLIES WITH THE SAFETY REQUIREMENTS STATED ABOVE.

PLACE/DATE

SIGNATURE

Preston
01-06-2026


Jarrod Brennan
General Manager

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SECTION 1: ARC WELDING SAFETY INSTRUCTIONS AND WARNINGS



WARNING

PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS KEEP AWAY UNTIL CONSULTING YOUR DOCTOR. DO NOT LOSE THESE INSTRUCTIONS. READ OPERATING/INSTRUCTION MANUAL BEFORE INSTALLING, OPERATING OR SERVICING THIS EQUIPMENT.

Welding products and welding processes can cause serious injury or death, or damage to other equipment or property, if the operator does not strictly observe all safety rules and take precautionary actions.

Safe practices have developed from past experience in the use of welding and cutting machinery/equipment. These practices must be learned through study and training before using this equipment. Some of these practices apply to equipment connected to power lines; other practices apply to engine driven equipment. Anyone not having extensive training in welding and cutting practices should not attempt to weld.

Safe practices are outlined in the Australian Standard AS 1674.2:2025 entitled: Safety in welding and allied processes Part 2: Electrical. This publication and other guides as to what you should learn before operating this equipment are listed at the end of these safety precautions.

HAVE ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK PERFORMED ONLY BY QUALIFIED PEOPLE.

1.01 ARC WELDING HAZARDS



WARNING

ARC RAYS can burn eyes and skin; NOISE can damage hearing.

Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.

ARC RAYS AND NOISE

1. Use a Welding Helmet or Welding Faceshield fitted with a proper shade of filter (see ANSI Z49.1 and AS 1674 listed in Safety Standards) to protect your face and eyes when welding or watching the welding operation.
2. Wear approved safety glasses. Side shields recommended.
3. Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
4. Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.
5. Use approved ear plugs or ear muffs if noise level is high.
6. Never wear contact lenses while welding.



WARNING

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on.

In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

ELECTRIC SHOCK

1. Do not touch live electrical parts.
2. Wear dry, hole-free insulating gloves and body protection.
3. Insulate yourself from work and ground using dry insulating mats or covers.
4. Disconnect input power or stop engine before installing or servicing this equipment. Lock input power disconnect switch open, or remove line fuses so power cannot be turned on accidentally.
5. Properly install and ground this equipment according to its Operating Manual and national, state, and local codes.
6. Turn off all equipment when not in use. Disconnect power to equipment if it will be left unattended or out of service.
7. Use fully insulated electrode holders. Never dip holder in water to cool it or lay it down on the ground or the work surface. Do not touch holders connected to two welding machines at the same time or touch other people with the holder or electrode.
8. Do not use worn, damaged, undersized, or poorly spliced cables.
9. Do not wrap cables around your body.
10. Ground the workpiece to a good electrical (earth) ground.
11. Do not touch electrode while in contact with the work (ground) circuit.
12. Use only well-maintained equipment. Repair or replace damaged parts at once.
13. In confined spaces or damp locations, do not use a welder with AC output unless it is equipped with a voltage reducer. Use equipment with DC output.
14. Wear a safety harness to prevent falling if working above floor level.
15. Keep all panels and covers securely in place.

RECOMMENDED PROTECTIVE FILTERS FOR ELECTRIC WELDING

Description of process	Approximate range of welding current in amps	Minimum shade number of filter(s)
Manual Metal Arc Welding - covered electrodes (MMAW)	Less than or equal to 100	8
	100 to 200	10
	200 to 300	11
	300 to 400	12
	Greater than 400	13
Gas Metal Arc Welding (GMAW) (MIG) other than Aluminium and Stainless Steel	Less than or equal to 150	10
	150 to 250	11
	250 to 300	12
	300 to 400	13
	Greater than 400	14
Gas Metal Arc Welding (GMAW) (MIG) Aluminium and Stainless Steel	Less than or equal to 250	12
	250 to 350	13
Gas Tungsten Arc Welding (GTAW) (TIG)	Less than or equal to 100	10
	100 to 200	11
	200 to 250	12
	250 to 350	13
	Greater than 350	14
Flux-cored Arc Welding (FCAW) - with or without shielding gas	Less than or equal to 300	11
	300 to 400	12
	400 to 500	13
	Greater than 500	14
Air - Arc Gouging	Less than or equal to 400	12
Plasma - Arc Cutting	50 to 100	10
	100 to 400	12
	400 to 800	14
Plasma - Arc Spraying	—	15
Plasma - Arc Welding	Less than or equal to 20	8
	20 to 100	10
	100 to 400	12
	400 to 800	14
Submerged - Arc Welding	—	2(5)
Resistance Welding	—	Safety Spectacles or eye shield

Refer to standard AS/NZS 1338.1:2012 for comprehensive information regarding the above table.

FUMES AND GASES



WARNING

FUMES & GASES CAN BE HAZARDOUS TO YOUR HEALTH.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

1. Keep your head out of the fumes. Do not breathe the fumes.
2. If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
3. If ventilation is poor, use an approved air-supplied respirator.
4. Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metals, consumables, coatings, and cleaners.
5. Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.
6. Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
7. Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

WELDING



WARNING

WELDING CAN CAUSE FIRE OR EXPLOSION.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Protect yourself and others from flying sparks and hot metal.
2. Do not weld where flying sparks can strike flammable material.
3. Remove all flammables within 35ft (10.7m) of the welding arc. If this is not possible, tightly cover them with approved covers.
4. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
5. Watch for fire, and keep a fire extinguisher nearby.
6. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
7. Do not weld on closed containers such as tanks or drums.
8. Connect work cable to the work as close to the welding area as practical to prevent welding current from travelling long, possibly unknown paths and causing electric shock and fire hazards.
9. Do not use welder to thaw frozen pipes.
10. Remove stick electrode from holder or cut off welding wire at contact tip when not in use.

FLYING SPARKS AND HOT METAL



WARNING

FLYING SPARKS & HOT METAL CAN CAUSE INJURY.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Wear approved face shield or safety goggles. Side shields recommended.
2. Wear proper body protection to protect skin.

CYLINDERS



WARNING

CYLINDERS CAN EXPLODE IF DAMAGED.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

1. Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
2. Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
3. Keep cylinders away from any welding or other electrical circuits.
4. Never allow a welding electrode to touch any cylinder.
5. Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
6. Turn face away from valve outlet when opening cylinder valve.
7. Keep protective cap in place over valve except when cylinder is in use or connected for use.
8. Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

MOVING PARTS



WARNING

Moving parts can cause injury.

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Stop engine before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
5. Keep hands, hair, loose clothing, and tools away from moving parts.
6. Reinstall panels or guards and close doors when servicing is finished and before starting engine.



WARNING

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety code Sec. 25249.5 et seq.)



NOTE

Considerations About Welding and The Effects of Low Frequency Electric and Magnetic Fields.



WARNING

The procedures below are among those also normally recommended for pacemaker wearers. Consult your doctor for complete information.

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, Biological Effects of Power Frequency Electric & Magnetic Fields - Background Paper, OTA-BP-E-63 (Washington, DC: U.S. Government Printing Office, May 1989): "...there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields and interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about questions of possible risk or to offer clear science-based advice on strategies to minimize or avoid potential risks."

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cable around the body.
4. Keep welding power source and cables as far away from body as practical.

1.02 PRINCIPAL SAFETY STANDARDS

Safety in welding and allied processes Part 1: Fire Precautions, AS 1674.1:2025 from SAI Global Limited, www.saiglobal.com.

Safety in welding and allied processes Part 2: Electrical, AS 1674.2:2025 from SAI Global Limited, www.saiglobal.com.

Filters for eye protectors - Filters for protection against radiation generated in welding and allied operations AS/NZS 1338.1:2012 from SAI Global Limited, www.saiglobal.com.

Welding Processes, Code of Practice, JULY 2020 - Safe Work Australia. This document provides "Practical guidance on how to manage health and safety risks associated with welding". **The latest version is available free of charge at: <https://www.safeworkaustralia.gov.au/doc/model-code-practice-welding-processes>.**

Other International Standards and Codes of Practice

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices for Occupation and Educational Eye and Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

SECTION 2: INTRODUCTION

2.01 HOW TO USE THIS MANUAL

This Operating Manual only applies to the Part Numbers listed on page 3. To ensure safe operation, read the entire manual, including the chapter on safety instructions and warnings.

Throughout this manual, the words WARNING, CAUTION, and NOTE may appear. Pay particular attention to the information provided under these headings. These special annotations are easily recognized as follows:



NOTE

An operation, procedure, or background information which requires additional emphasis or is helpful in efficient operation of the system.



CAUTION

A procedure which, if not properly followed, may cause damage to the equipment.



WARNING

An operation, procedure, or background information which requires additional emphasis or is helpful in efficient operation of the system.



ELECTRICAL WARNING

Gives information regarding possible electrical shock injury. Warnings will be enclosed in a box such as this.



DANGER

Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

Additional copies of this manual may be purchased by contacting CIGWELD at the address and phone number for your location listed in the inside back cover of this manual. Include the Operating Manual number and equipment identification numbers.

Electronic copies of this manual can also be downloaded at no charge in Acrobat PDF format by going to the CIGWELD web site listed below and clicking on the Literature Library link:

cigweld.com.au

2.02 EQUIPMENT IDENTIFICATION

The units identification number (specification or part number), model, and serial number are located on the Data Plate which is fixed to the bottom of the welding machine. In some cases, the Data Plate may be attached to the rear panel. Equipment which does not have a control panel such as cable assemblies are identified only by the specification or part number printed on the shipping container. Record these numbers on the bottom of page 3 for future reference.

2.03 RECEIPT OF EQUIPMENT

When you receive the equipment, check it against the invoice to confirm it is complete and inspect the equipment for possible damage due to shipping. If there is any damage, notify the carrier immediately to file a claim. Furnish complete information concerning damage claims or shipping errors to the location listed on the back cover of this manual. Include all equipment identification numbers, as described above, along with a full description of the parts in error.

Move the equipment to the installation site before unboxing the unit. Use care to avoid damaging the equipment when using knives, breaker bars, hammers, etc, to unbox the machine and its accessories.

2.04 DESCRIPTION

Introducing the **CoolVenom 4LTR** and **CoolVenom 7LTR** – 4 and 7 litre welding water coolers designed for the **BlueVenom SiC** range. The CoolVenom 4LTR and CoolVenom 7LTR are perfect for lengthy welding runs, mitigating heat and extending the life of your water-cooled TIG torches and MIG guns.

Utilizing a massive 150mm fan and 22 advanced steel tube radiators, the CoolVenom 4LTR and 7LTR provide fast and effective heat dissipation. Simply mount and screw in place the Power Source to the top of the Water Cooler for a strong and stable setup. The CoolVenom 4LTR is designed to work with the **BlueVenom XF250 AC/DC** and **BlueVenom XF320 AC/DC**, while the CoolVenom 7LTR is designed for the **BlueVenom XF250⁶**.

The **CoolVenom 7LTR** features an intuitive **4" Full Colour LCD** display, providing all the information you need from the 1 screen. See the status of the water pump, cooling fan, water level, and temperature of the inlet and outlets at a glance. No more second guessing, know the exact temperature and cool your torch before it can overheat.

2.05 USER RESPONSIBILITY

This equipment will perform safely and reliably when installed, operated and maintained in accordance with the instructions herewith. Periodic checks are recommended as defective or poorly maintained equipment should not be used. Broken, missing, severely worn, distorted or contaminated parts should be replaced immediately. Should a repair or replacement become necessary, it is recommended that the Authorised Distributor from whom the equipment was purchased, be contacted for service advice. The owner or user of this equipment shall have the responsibility for any malfunction which results from improper use, damage, faulty maintenance or repair/alteration by other than CIGWELD or an accredited service provider.



NOTE

Refer to the complete Warranty Schedule at the back of the manual.

2.06 WHAT'S IN THE BOX

CoolVenom 4LTR (Part No. W4018240)

- CoolVenom 4LTR Water Cooler
- CoolVenom Interconnection lead
- 4x Mounting Plates
- Operation manual

CoolVenom 7LTR (Part No. W4018270)

- CoolVenom 7LTR Water Cooler
- CoolVenom Interconnection lead
- 4x Mounting Plates
- Operation manual

2.07 TRANSPORTING METHODS



WARNING

FALLING EQUIPMENT can cause serious personal injury and equipment damage.

- Use handcart or similar device of adequate capacity.
- If using a forklift vehicle, place and secure unit on a proper skid before transporting.

2.08 SPECIFICATIONS

DESCRIPTION	COOLVENOM 4LTR
Packaged Part Number	W4018240
Water Cooler Dimensions	(L) 590mm x (W) 190mm x (H) 240mm
Water Cooler Weight (empty)	9.1kg
Standards	EN IEC 60974-2:2019 EN IEC 60974-10:2021
Nominal Supply Voltage	230 - 400 VAC \pm 10%
Nominal Supply Frequency	50/60Hz
Maximum Input Current (I _{1max})	1.0 Amps
Reservoir Volume	4L
Cooling Power	1.2kW @ 1L/min
Maximum Pressure	0.25Mpa
Maximum Flow Rate	10L/min
Maximum Lead Length	25m
Protection Class	IP23S

Table 2-2: Specifications

DESCRIPTION	COOLVENOM 7LTR
Packaged Part Number	W4018270
Water Cooler Dimensions	(L) 750mm x (W) 260mm x (H) 290mm
Water Cooler Weight (empty)	12.9kg
Standards	EN IEC 60974-2:2019 EN IEC 60974-10:2021
Nominal Supply Voltage	230 - 400 VAC \pm 10%
Nominal Supply Frequency	50/60Hz
Maximum Input Current (I _{1max})	1.0 Amps
Reservoir Volume	7L
Cooling Power	1.2kW @ 1L/min
Maximum Pressure	0.25Mpa
Maximum Flow Rate	10L/min
Maximum Lead Length	25m
Protection Class	IP23S

Table 2-3: Specifications

NOTE 1: Due to variations that can occur in manufactured products, claimed performance, voltages, ratings, all capacities, measurements, dimensions and weights quoted are approximate only. Achievable capacities and ratings in use and operation will depend upon correct installation, use, applications, maintenance and service.

NOTE 2: CIGWELD reserves the right to change product performance and specifications without notice.

2.09 OPTIONAL ACCESSORIES

We recommend genuine CIGWELD products. The biggest range and best quality with guaranteed performance.

PART NUMBER	DESCRIPTION
0465720002	MIG/TIG Torch Coolant 10L
W7007750	CoolVenom Interconnection Lead
W1400254	BlueVenom XF250 ⁶ SiC
W1300250	BlueVenom XF250 AC/DC SiC
W1300320	BlueVenom XF320 AC/DC SiC
W4020018	NEXARC DGX 24W, 3m BZ24 Water Cooled MIG Gun with 4 Button Digital Control
W4020019	NEXARC DGX 24W, 4m BZ24 Water Cooled MIG Gun with 4 Button Digital Control
W4020020	NEXARC DGX 24W, 5m BZ24 Water Cooled MIG Gun with 4 Button Digital Control
W4020009	NEXARC DGX 501W OLED, 3m BZ501 Water Cooled MIG Gun with 3 Button Digital Control and OLED Display
W4020010	NEXARC DGX 501W OLED, 4m BZ501 Water Cooled MIG Gun with 3 Button Digital Control and OLED Display
W4020011	NEXARC DGX 501W OLED, 5m BZ501 Water Cooled MIG Gun with 3 Button Digital Control and OLED Display
W52TL4E30	MIG Gun TW4 Flame 3m Water Cooled
W52TL4E50	MIG Gun TW4 Flame 5m Water Cooled
W4022017	DIMEX ELITE 18, 4m TIG Torch with Remote Control, Water Cooled
W4022018	DIMEX ELITE 18, 8m TIG Torch with Remote Control, Water Cooled
W4022021	DIMEX ELITE 18F, 8m Flex Head TIG Torch with Remote Control, Water Cooled
W3000250	BlueVenom FeedX4 Wire Feeder
W4000200	FeedX4 Interconnection Lead, 5m Water Cooled
W4000201	FeedX4 Interconnection Lead, 10m Water Cooled
W4000202	FeedX4 Interconnection Lead, 15m Water Cooled

Table 2-4: Accessories

SECTION 3: INSTALLATION

3.01 ENVIRONMENT

These units are designed for use in environments with increased hazard of electric shock.

- A.** Examples of environments with increased hazard of electric shock are:
- 1.** In locations in which freedom of movement is restricted, so that the operator is forced to perform the work in a cramped (kneeling, sitting or lying) position with physical contact with conductive parts.
 - 2.** In locations which are fully or partially limited by conductive elements, and in which there is a high risk of unavoidable or accidental contact by the operator.
- B.** Environments with increased hazard of electric shock do not include places where electrically conductive parts in the near vicinity of the operator, which can cause increased hazard, have been insulated.

3.02 LOCATION

Be sure to locate the welder and water cooler according to the following guidelines:

- A.** In areas, free from moisture and dust.
- B.** Ambient temperature between -10°C to 40°C.
- C.** In areas, free from oil, steam and corrosive gases.
- D.** In areas, not subjected to abnormal vibration or shock.
- E.** In areas, not exposed to direct sunlight or rain.
- F.** Place at a distance of 300mm or more from walls or similar that could restrict natural air flow for cooling.

3.03 MAINS SUPPLY VOLTAGE REQUIREMENTS

The Mains Supply Voltage should be within $\pm 15\%$ of the rated Mains Supply Voltage. If actual Mains Supply Voltage is outside this range internal components may fail.

Refer to Specifications on page 15 for Supply Voltage information.

The Welding Power Source and Water Cooler must be:

- Correctly installed, if necessary, by a qualified electrician.
- Correctly earthed (electrically) in accordance with local regulations.



WARNING

Any electrical work must be carried out by a qualified Electrical Tradesperson.

3.04 ELECTROMAGNETIC COMPATIBILITY



WARNING

Extra precautions for Electromagnetic Compatibility may be required when this Water Cooler is used in a domestic situation.

A. INSTALLATION AND USE - USERS RESPONSIBILITY

The user is responsible for installing and using the welding equipment according to the manufacturer's instructions. If electromagnetic disturbances are detected then it shall be the responsibility of the user of the welding equipment to resolve the situation with the technical assistance of the manufacturer. In some cases this remedial action may be as simple as earthing the welding circuit. In other cases it could involve constructing an electromagnetic screen enclosing the Welding Power Source and the work, complete with associated input filters. In all cases, electromagnetic disturbances shall be reduced to the point where they are no longer troublesome.

B. ASSESSMENT OF AREA

Before installing welding equipment, the user shall make an assessment of potential electromagnetic problems in the surrounding area. The following shall be taken into account

1. Other supply cables, control cables, signalling and telephone cables; above, below and adjacent to the welding equipment.
2. Radio and television transmitters and receivers.
3. Computer and other control equipment.
4. Safety critical equipment, e.g. guarding of industrial equipment.
5. The health of people around, e.g. the use of pacemakers and hearing aids.
6. Equipment used for calibration and measurement.
7. The time of day that welding or other activities are to be carried out.
8. The immunity of other equipment in the environment: the user shall ensure that other equipment being used in the environment is compatible: this may require additional protection measures.

The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

C. METHODS OF REDUCING ELECTROMAGNETIC EMISSIONS

1. Mains Supply

Welding equipment should be connected to the mains supply according to the manufacturer's recommendations. If interference occurs, it may be necessary to take additional precautions such as filtering of the mains supply. Consideration should be given to shielding the supply cable of permanently installed welding equipment in metallic conduit or equivalent. Shielding should be electrically continuous throughout its length. The shielding should be connected to the Welding Power Source so that good electrical contact is maintained between the conduit and the Welding Power Source enclosure.

2. Maintenance of Welding Equipment

The welding equipment should be routinely maintained according to the manufacturer's recommendations.

All access and service doors and covers should be closed and properly fastened when the welding equipment is in operation. The welding equipment should not be modified in any way except for those changes and adjustments covered in the manufacturer's instructions. In particular, the spark gaps of arc striking and stabilising devices should be adjusted and maintained according to the manufacturer's recommendations.

3. Welding Cables

The welding cables should be kept as short as possible and should be positioned close together, running at or close to the floor level.

4. Equipotential Bonding

Bonding of all metallic components in the welding installation and adjacent to it should be considered. However Metallic components bonded to the work piece will increase the risk that the operator could receive a shock by touching the metallic components and the electrode at the same time. The operator should be insulated from all such bonded metallic components.

5. Earthing of the Workpiece

Where the workpiece is not bonded to earth for electrical safety, nor connected to earth because of its size and position, e.g. ship's hull or building steelwork, a connection bonding the workpiece to earth may reduce emissions in some, but not all instances. Care should be taken to prevent the earthing of the workpiece increasing the risk of injury to users, or damage to other electrical equipment. Where necessary, the connection of the workpiece to earth should be made by direct connection to the workpiece, but in some countries where direct connection is not permitted, the bonding should be achieved by suitable capacitance, selected according to national regulations.

6. Screening and Shielding

Selective screening and shielding of other cables and equipment in the surrounding area may alleviate problems of interference. Screening the entire welding installation may be considered for special applications.

3.05 INSTALLATION TO THE POWER SOURCE

Screw two mounting brackets to the top of the Water Cooler as shown in Figure 3-1. Repeat this process, screwing the remaining two mounting brackets to the base of the Welding Power Source.

Place the Welding Power Source on top of the Water Cooler, ensuring the Water Cooler's brackets sit inside the Power Source brackets. Ensure the front and back panels of the Water Cooler sit flush with the Power Source, align the holes and screw the brackets together.



Figure 3-1: CoolVenom Mounting Bracket

To power the Water Cooler, attach the interconnection lead to the 14 pin receptacles found on the Water Cooler and Power Source. To make the connection, align the keyway, insert the plug, and rotate the threaded collar fully clockwise

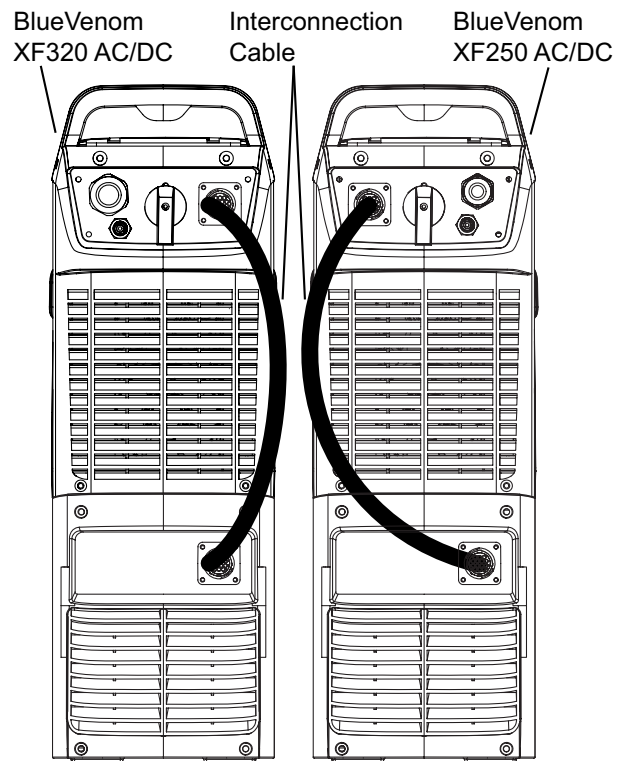


Figure 3-2: CoolVenom 4LTR Installation

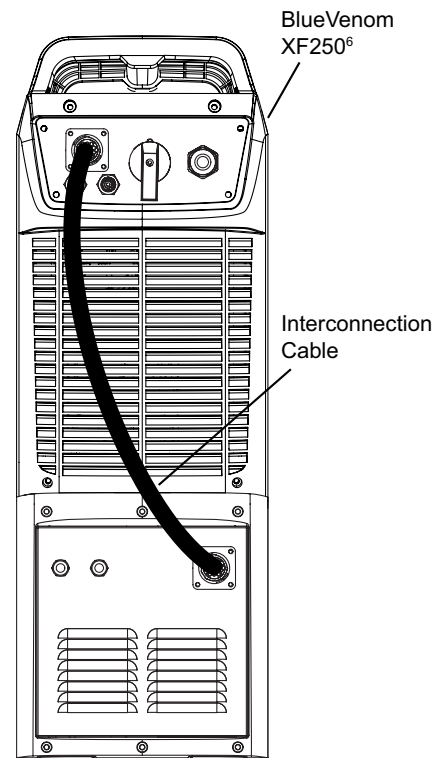


Figure 3-3: CoolVenom 7LTR Installation

SECTION 4: OPERATION

4.01 OVERVIEW

Conventional operating procedures apply when using the Water Cooler:

- Water Cooler is to be placed on a level floor, do not exceed a maximum angle of 15 degrees.
- Do not exceed the Gun's/Torch's maximum water inlet temperature.
- Use the appropriate coolant for the connected Gun/Torch.
- Antifreeze may be necessary if the surrounding temperature is below 5°C
- Check the water reservoir regularly for sediment and drain if necessary.



Figure 4-1: CoolVenom 4LTR and 7LTR

4.02 COOLVENOM 4LTR FEATURES



Figure 4-2: CoolVenom 4LTR Features

- 1 Mounting Bracket
- 2 Inlet Connection (RED)
- 3 Reservoir Inlet
- 4 Water Level Window
- 5 Outlet Connection (BLUE)
- 6 Interconnection Socket 14 Pin

1 MOUNTING BRACKET

Brackets are used to mount the Welding Power Source to the Water Cooler. Refer to Section 3.05 on how to mount the Power Source to the Water Cooler.

2 INLET CONNECTION (RED)

The RED inlet connects to the RED outlet from a compatible TIG Torch. This returns heated water from the TIG Torch to the Water Cooler. Refer to Section 4.04 for more details.

3 RESERVOIR INLET

The Reservoir Inlet is used to fill the reservoir with coolant. Ensure the welding Power Source is powered off before filling the reservoir and that the water level does not exceed the maximum level. Refer to Section 4.05 for more details.

4 WATER LEVEL WINDOW

The Water Level Window gives a quick indication of the amount of water left in the reservoir. Ensure the water level is between the Minimum and Maximum levels as indicated next to the Water Level Window. Operation with the water level below the minimum may result in poor cooling performance and damage the machine.

5 OUTLET CONNECTION (BLUE)

The BLUE outlet connects to the BLUE inlet on a compatible TIG Torch. This passes cooled water from the Water Cooler to the TIG Torch. Refer to Section 4.04 for more details.

6 INTERCONNECTION SOCKET 14 PIN

The 14 pin receptacle is used to connect the Water Cooler to the welding Power Source. To make the connection, align the keyway, insert the plug, and rotate the threaded collar fully clockwise.

4.03 COOLVENOM 7LTR FEATURES

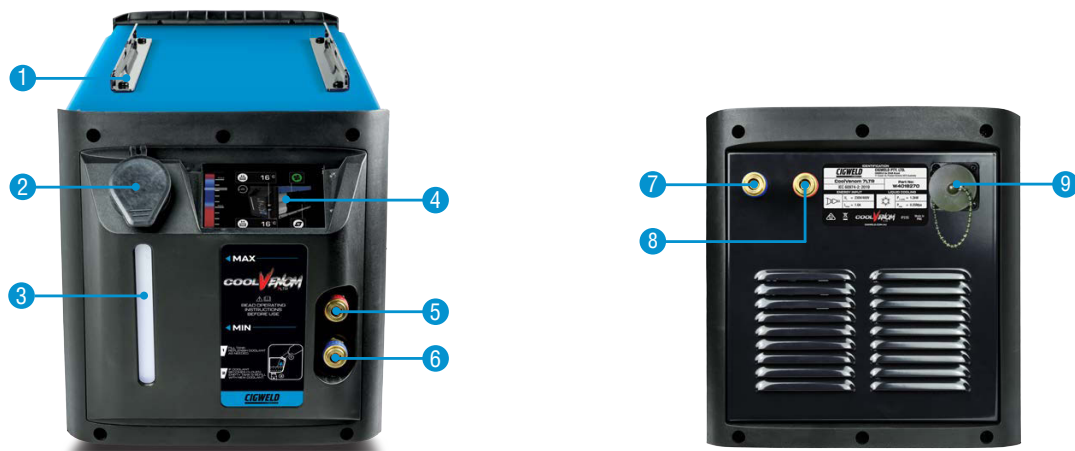


Figure 4-3: COOLVENOM 7LTR Features

- 1 Mounting Bracket
- 2 Reservoir Inlet
- 3 Water Level Window
- 4 LCD Display
- 5 Front Inlet Connection (RED)
- 6 Front Outlet Connection (BLUE)
- 7 Rear Outlet Connection (BLUE)
- 8 Rear Inlet Connection (RED)
- 9 Interconnection Socket 14 Pin

1 MOUNTING BRACKET

Brackets are used to mount the Welding Power Source to the Water Cooler. Refer to Section 3.05 on how to mount the Power Source to the Water Cooler.

2 RESERVOIR INLET

The Reservoir Inlet is used to fill the reservoir with coolant. Ensure the welding Power Source is powered off before filling the reservoir and that the water level does not exceed the maximum level. Refer to Section 4.05 for more details.

3 WATER LEVEL WINDOW

The Water Level Window gives a quick indication of the amount of water left in the reservoir. Ensure the water level is between the Minimum and Maximum levels as indicated next to the Water Level Window. Operation with the water level below the minimum may result in poor cooling performance and damage the machine.

4 LCD DISPLAY

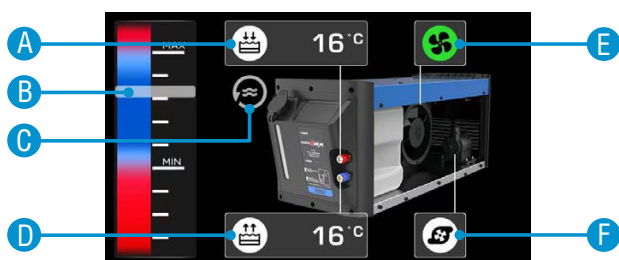


Figure 4-4: LCD Display

The LCD Display shows the status of the Water Cooler in real-time

A. Inlet Water Temperature

Displays temperature of the incoming coolant returning from the Gun/Torch, measured in degrees Celsius.

B. Water Level Indicator

Indicates the current water level inside the reservoir, including the minimum and maximum allowable levels.

C. Outlet Water Temperature

Displays the temperature of the outgoing coolant from the Water Cooler, measured in degrees Celsius.

D. Overheat Indicator

This icon illuminates when the coolant temperature is too high. Stop welding, wait for the icon to disappear and the temperature to lower before resuming. Failure to do so may engage the thermal cutoff protection, disabling the pump to protect the Water Cooler from overheating.

E. Cooling Fan Status

Displays the status of the cooling fan, illuminating when active. The cooling fan blows air over the internal radiator to dissipate heat from the coolant.

F. Water Pump Status

Displays the status of the water pump, illuminating when active. When active, coolant is pumped through the connected Gun/Torch and Water Cooler.

5 FRONT INLET CONNECTION (RED)

The front RED inlet connects to the RED outlet from a compatible Torch/Gun. This returns heated water from the Torch/Gun to the Water Cooler. Refer to Section 4.04 for more details.

6 FRONT OUTLET CONNECTION (BLUE)

The front BLUE outlet connects to the BLUE inlet on a compatible Torch/Gun. This passes cooled water from the Water Cooler to the Torch/Gun. Refer to Section 4.04 for more details.

7 REAR OUTLET CONNECTION (BLUE)

The rear BLUE outlet connects to the BLUE inlet on a compatible Torch/Gun or external Wire Feeder. This passes cooled water from the Water Cooler to the Torch/Gun or Wire Feeder. Refer to Section 4.04 for more details.

8 REAR INLET CONNECTION (RED)

The rear RED inlet connects to the RED outlet connection from a compatible Torch/Gun or external Wire Feeder. This returns heated water from the Torch/Gun or Wire Feeder to the Water Cooler. Refer to Section 4.04 for more details.

9 INTERCONNECTION SOCKET 14 PIN

The 14 pin receptacle is used to connect the compatible water cooler to the welding Power Source. To make the connection, align the keyway, insert the plug, and rotate the threaded collar fully clockwise.

4.04 INLET/OUTLET CONNECTION

Refer to the following diagrams on how to connect the cooling tubes between the inlets and outlets for the CoolVenom 4LTR and CoolVenom 7LTR. Incorrect connection between inlets and outlets may result in poor performance, damaging the Water Cooler and connected Gun/Torch.

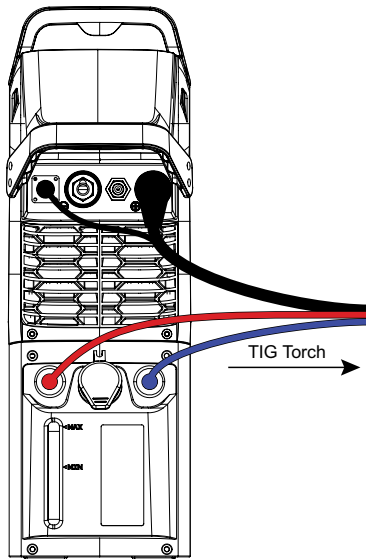


Figure 4-5: CoolVenom 4LTR Connections

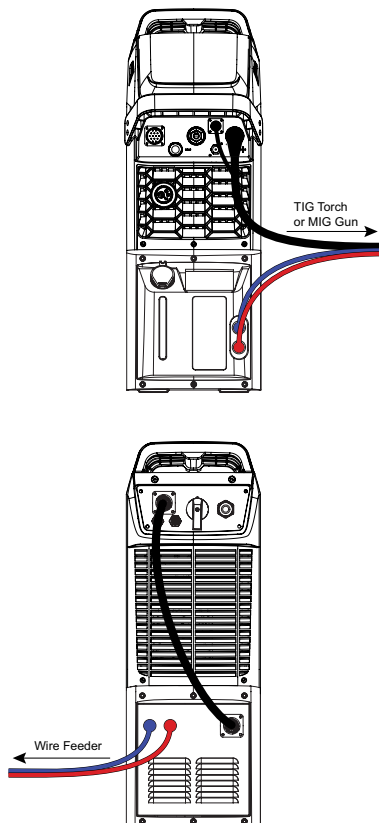
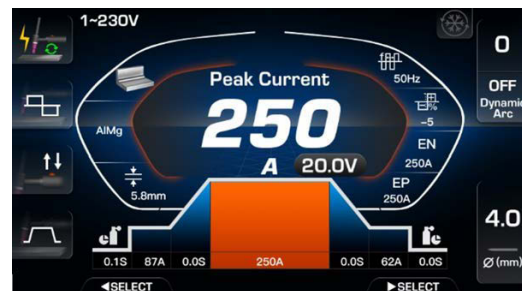


Figure 4-6: CoolVenom 7LTR Connections

4.05 SETUP PROCEDURE

1. With all cooling leads connected, ensure the welding Power Source is powered off and connect the 14 pin interconnection cable between the Power Source and Water Cooler (Refer to Figure 4-#).
2. Remove the Reservoir Inlet cap and pour coolant into the reservoir, making sure not to exceed the maximum water level.
3. Power on the welding Power Source and enable water cooling.

a. BlueVenom XF250/XF320 SiC



While in a TIG welding mode, navigate to the Water Cool icon at the top right of the LCD display using the Menu Button. With the icon highlighted, rotate the Control Knob and press to enable water cooling.

b. BlueVenom XF250⁶ SiC



While in either a MIG or TIG welding mode, press the Water Cool Button on the control panel to enable water cooling.

4. After enabling water cooling on the welding Power Source, the Water Cooler will begin to pump the coolant. As the coolant is pumped through the system the water level on the reservoir will begin to drop. Disable the water-cooling function before the minimum water level is reached; failure to do so may result in air being pumped through the cooling system, damaging the pump and the connected Gun/Torch.
5. Repeat steps 1-4, adding coolant to the reservoir until the water level no longer drops. It is recommended to let the coolant pump through the system for several minutes. This is to remove any trapped air bubbles that may have formed over time.

SECTION 5: ROUTINE SERVICE AND TROUBLESHOOTING

5.01 ROUTINE MAINTENANCE & INSPECTION



ELECTRICAL WARNING

There are extremely dangerous voltage and power levels present inside this product. Do not attempt to open or repair unless you are a qualified electrical tradesperson. Disconnect the Water Cooler from the Welding Power Source before disassembling.

Welding and Water Cooling equipment should be regularly checked by a qualified electrical tradesperson to ensure that:

- The main earth wire of the electrical installation is intact.
- The power point for the Welding Power Source is effectively earthed and of adequate current rating.
- Plugs and cord extension sockets are correctly wired.
- Flexible cord is of the 3-core tough rubber or plastic sheathed type of adequate rating, correctly connected and in good condition.
- Welding terminals are shrouded to prevent inadvertent contact or short circuit.
- The frame of the Welding Power Source and Water Cooler are effectively earthed.
- Welding leads and electrode holder are in good condition.

- The Welding Power Source and Water Cooler are clean internally, especially from metal filing, slag, and loose material. If any parts are damaged for any reason, replacement is recommended.
- Water pump fixtures are sealed and in good condition.
- Electrical components are clean and do not show signs of water damage.

5.02 CLEANING THE WATER COOLER

To clean the Water Cooler, use a vacuum cleaner to remove any accumulated dirt, metal filings, slag and loose material. Keep surfaces clean as accumulated foreign material may reduce the welders output welding current.



CAUTION

Do not use compressed air to clean the Water Cooler. Compressed air can force metal particles to lodge between live electrical parts and earthed metal parts within the Water Cooler. This may result in arcing between these parts and their eventual failure.

5.03 REPLACING THE COOLANT

Before emptying the coolant reservoir, ensure all hosing is disconnected from the Water Cooler. It is recommended to replace the coolant once a month to prevent sediment buildup.

CoolVenom 4LTR:

Remove the interconnection lead and dismount the Welding Power Source from the Water Cooler. Ready a large open container and open the Reservoir Inlet cap. Carefully tip the Water Cooler, pouring the contents of the reservoir into the container.

CoolVenom 7LTR:

Place a large open container underneath the Water Cooler, then unscrew the drainage cap on the underside of the Water Cooler (Figure 5-1) to drain the reservoir. Once emptied, screw the drainage cap back in place.

Reconnect any disconnected leads and follow the setup procedure found in Section 4.05. It may be necessary to replace the coolant a second time, as sediment may have been stuck in the hosing during the initial drainage.



Figure 5-1: CoolVenom 7LTR Drain

5.04 TROUBLESHOOTING



ELECTRICAL WARNING

There are extremely dangerous voltage and power levels present inside this product. Do not attempt to open or repair unless you are a qualified electrical tradesperson and you have had training in power measurements and troubleshooting techniques.

Before troubleshooting, ensure the Water Cooler is disconnected from the Welding Power Source. If major complex subassemblies are faulty, then the Water Cooler must be returned to an Accredited CIGWELD Service Agent for repair.

The basic level of troubleshooting is that which can be performed without special equipment or knowledge.

FAULT	CAUSE	REMEDY
Water pump not running	A. No power	A. Check the interconnection cable for any damage and ensure the 14-pin connector is clean of any dirt and debris. If the issue persists, contact an accredited CIGWELD Service Provider.
	B. Over-heating	B. If the water temperature rises too high the thermal protection will engage, switching off the water pump. This serves to protect the Water Cooler components from any over-heating damage. The Water Cooler will automatically resume once the temperature has reached a safe operating level. If the problem persists, check front and rear panel air louvres are clean and not blocked by any dirt or obstacles. If damaged, they should be replaced by an accredited CIGWELD Service Provider.
	C. Scale in pump	C. Check that the fan is running. If the fan is not running it may be faulty and need replacing. Contact an accredited CIGWELD Service Provider. C. If distilled water is not used, limescale may build up over time. Use an appropriate descaler to remove any limescale throughout the water-cooling system.
	D. Motor failure	D. Contact an accredited CIGWELD Service Provider for repair or replacement.
Water not circulating and pump running	A. Air in hose	A. To remove a trapped pocket of air: <ol style="list-style-type: none"> 1. Disconnect the blue return line coming from the torch and place the end into a bucket. 2. Turn on the water cooler and continue to refill the reservoir as necessary. 3. It may be necessary to gently squeeze the hosing and elevate the torch to help remove any trapped air bubbles. 4. Once the flow of water remains steady with no sputtering, turn off the Water Cooler and reconnect the blue return line.
	B. No water	B. Check that the reservoir's water level is above the minimum threshold.
	C. Hose clogged	C. Check the hosing for any solid debris and remove.

SECTION 6: WARRANTY

CIGWELD

AN ESAB BRAND

LIMITED WARRANTY TERMS

LIMITED WARRANTY: CIGWELD Pty Ltd, An ESAB Brand, hereafter, "CIGWELD" warrants to customers of its Authorised distributors hereafter "Purchaser" that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the CIGWELD products as stated below, CIGWELD shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with CIGWELD's specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at CIGWELD's sole option, of any components or parts of the product determined by CIGWELD to be defective.

CIGWELD MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.

LIMITATION OF LIABILITY: CIGWELD SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE FOR SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES, SUCH AS, BUT NOT LIMITED TO, LOST PROFITS AND BUSINESS INTERRUPTION.

The remedies of the Purchaser set forth herein are exclusive and the liability of CIGWELD with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by CIGWELD whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of CIGWELD is Authorised to change this warranty in any way or grant any other warranty.

PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN CIGWELD'S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY CIGWELD PRODUCT. PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-Authorised PERSONS.

The warranty is effective for the time stated below beginning on the date that the Authorised distributor delivers the products to the Purchaser. Not with standing the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date CIGWELD delivered the product to the Authorised distributor.

Any claim under this warranty must be made within the warranty period which commences on the date of purchase of the product. To make a claim under the warranty, take the product (with proof of purchase from a CIGWELD Accredited Seller) to the store where you purchased the product or contact CIGWELD Customer Care 1300 654 674 for advice on your nearest Service Provider. CIGWELD reserves the right to request documented evidence of date of purchase. CIGWELD or our Accredited Distributor must be notified in writing of its claim within seven (7) days of becoming aware of the basis thereof, and at its own expense returning the goods which are the subject of the claim to CIGWELD or nominated Accredited Distributor/Accredited Service Provider

This warranty is given.

CIGWELD Pty Ltd A.B.N. 56007226815

71 Gower Street, Preston Victoria, Australia, 3072

Phone: 1300 654 674

Email: support@cigweld.com

Website: cigweld.com.au

This warranty is provided in addition to other rights and remedies you have under law: Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Please note that the information detailed in this statement supersedes any prior published data produced by CIGWELD.

WARRANTY SCHEDULE - COOLVENOM WATER COOLER

WARRANTY	WARRANTY PERIOD (PARTS AND LABOUR)
CoolVenom Water Cooler	5 Years
ACCESSORIES	WARRANTY PERIOD
CoolVenom Interconnection Lead	3 Months

CIGWELD LIMITED WARRANTY DOES NOT APPLY TO;

- Obsolete goods sold at auction, second-hand goods and prototype goods.
- Consumable Parts for MIG, Plasma welding, Plasma cutting and Oxy fuel torches, O-rings, fuses, filters or other parts that fail due to normal wear.

Notes:

- * No employee, agent, or representative of CIGWELD is Authorised to change this warranty in any way or grant any other warranty, and CIGWELD shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfilment of CIGWELD's obligations to purchaser with respect to the product.
- * This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in CIGWELD's sole judgment, impaired the safety or performance of any CIGWELD product and if the unit is altered or serviced by an unauthorised CIGWELD Service Provider. Purchaser's rights under this warranty are void if the product is sold to purchaser by unAuthorised persons.

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