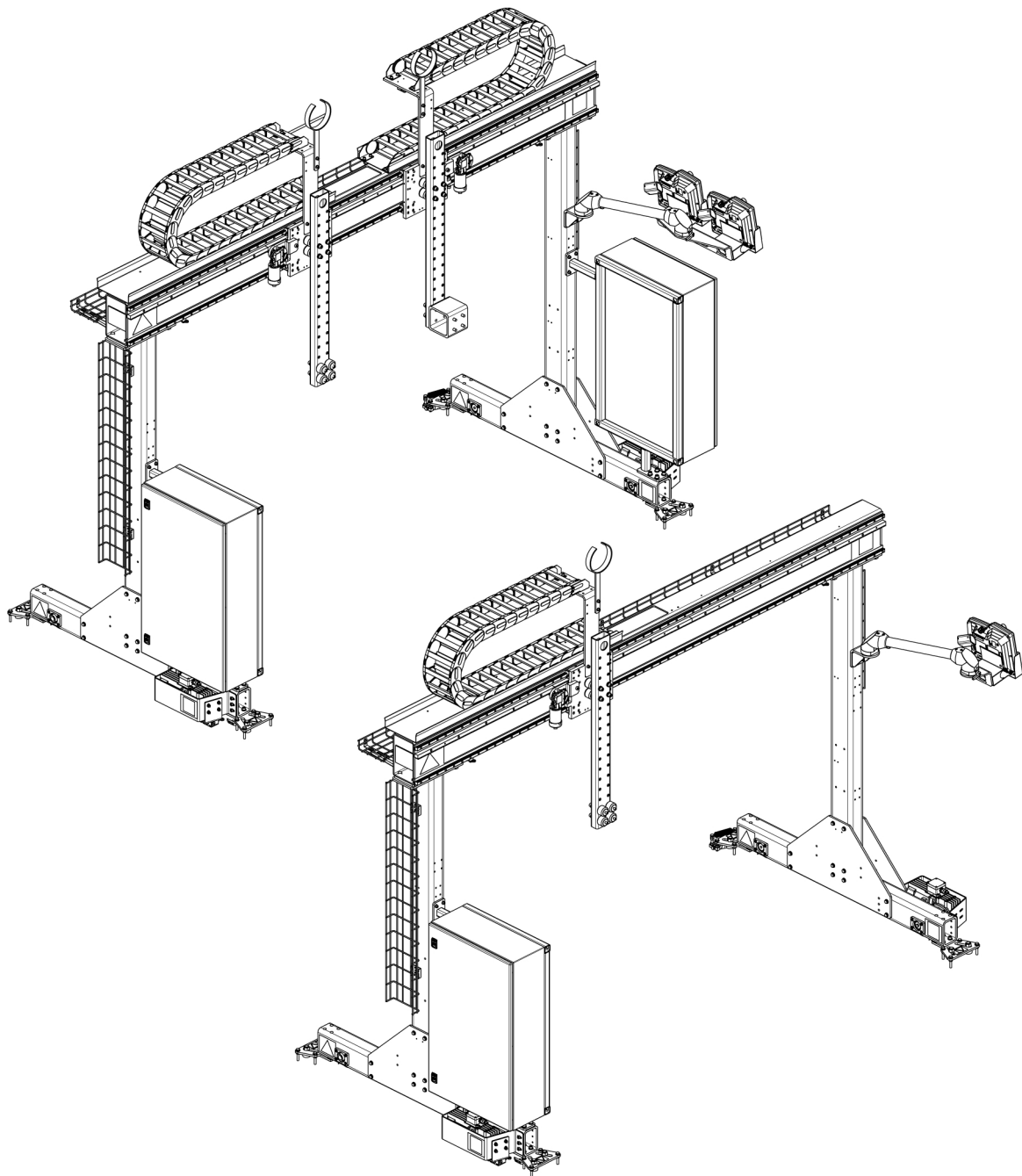


Mechtrac HD

Motor driven gantry



Spare parts list

Original instructions

Ordering no.	Product	Notes	Serial no.
0912 350 880	Mechtrac HD3	For dual boom carriages and welding heads (left and right)	LX426-xxxx-xxxx
0912 350 881	Mechtrac HD3	For single boom carriage and welding head (left)	LX426-xxxx-xxxx
0912 351 880	Mechtrac HD4	For dual boom carriages and welding heads (left and right)	LX426-xxxx-xxxx
0912 351 881	Mechtrac HD4	For single boom carriage and welding head (left)	LX426-xxxx-xxxx

Spare parts may be ordered through your nearest ESAB dealer, see esab.com. When ordering, please state product type, serial number, denominations and ordering numbers according to the spare parts list. This facilitates dispatch and ensures correct delivery.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

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1 SPARE PARTS

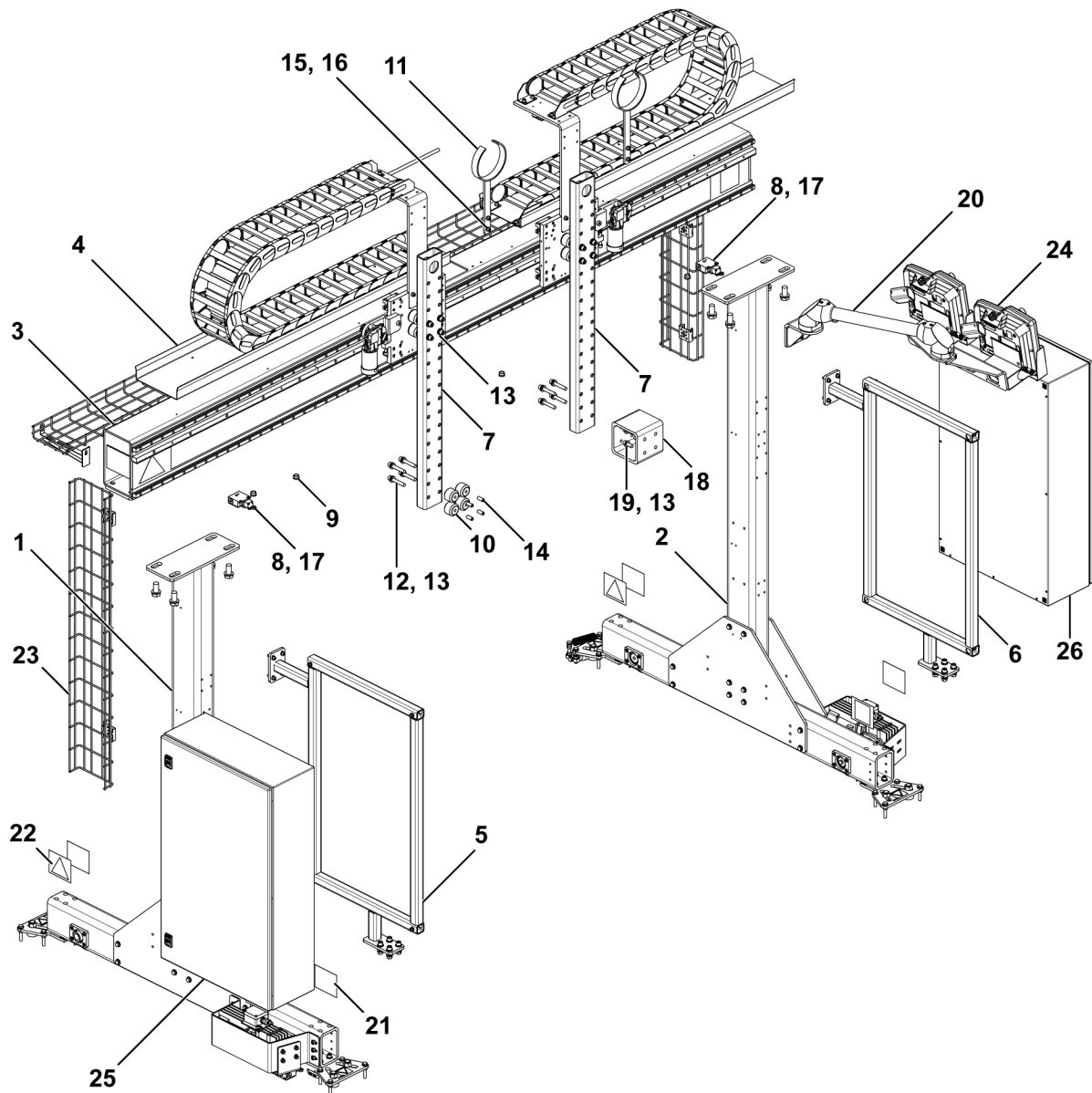
1.1 Mechtrac HD

1.1.1 Mechtrac HD3, Dual welding heads

Item	Qty	Ordering no.	Denomination	Notes
		0912 350 880	Mechtrac HD3, Dual welding heads	
1	1	0912 241 880	Drive-kit Mechtrac HD, Left	See Section 1.2.1 "Drive-kit Mechtrac HD, Left", page 12
2	1	0912 241 881	Drive-kit Mechtrac HD, Right	See Section 1.2.2 "Drive-kit Mechtrac HD, Right", page 14
3	1	0904 356 880	Boom, Size 3 m	See Section 1.3.1 "Boom, Size 3 m", page 16
4	1	0912 290 880	Sub assembly Boom carriage Left and Right	See Section 1.4.1 "Sub assembly Boom carriage, for 3 metres boom, Left and Right", page 18
5	1	0912 313 880	Bracket for cabinet B, Left	
6	1	0912 313 881	Bracket for cabinet B, Right	
7	2	0806 471 002	Arm for Mechtrac	
8	2	0191 072 102	Limit switch (CaB)	
9	4	0190 753 104	Bushing D15/20	
10	4	0278 300 180	Insulator (A6)	
11	2	0912 315 880	Cable support	
12	16		Allen screw 8.8, M12×70	
13	36		Washer TBRB steel, D24×13×4	
14	4		Stop screw M12×30 mm	
15	4		Allen screw 8.8, M8×20	
16	4		Washer TBRB steel D16/8.4X	
17	4		Allen screw 8.8, M5×12, steel	
18	1	0820 274 001	Distance	
19	4		Allen screw 8.8, M12×30	
20	1	0912 277 880	Support assembly EAC 30, For two panels	
21	4	0912 523 001	Direction symbol, 120×100 square symbol	
22	4	0912 523 002	Direction symbol, 120×100 triangle symbol	
23	1	0912 538 880	Cable management kit, Mechtrac HD3	
24	2	0911 492 880	EAC 30 Control panel	
25	1	0912 575 880	Control cabinet B1	

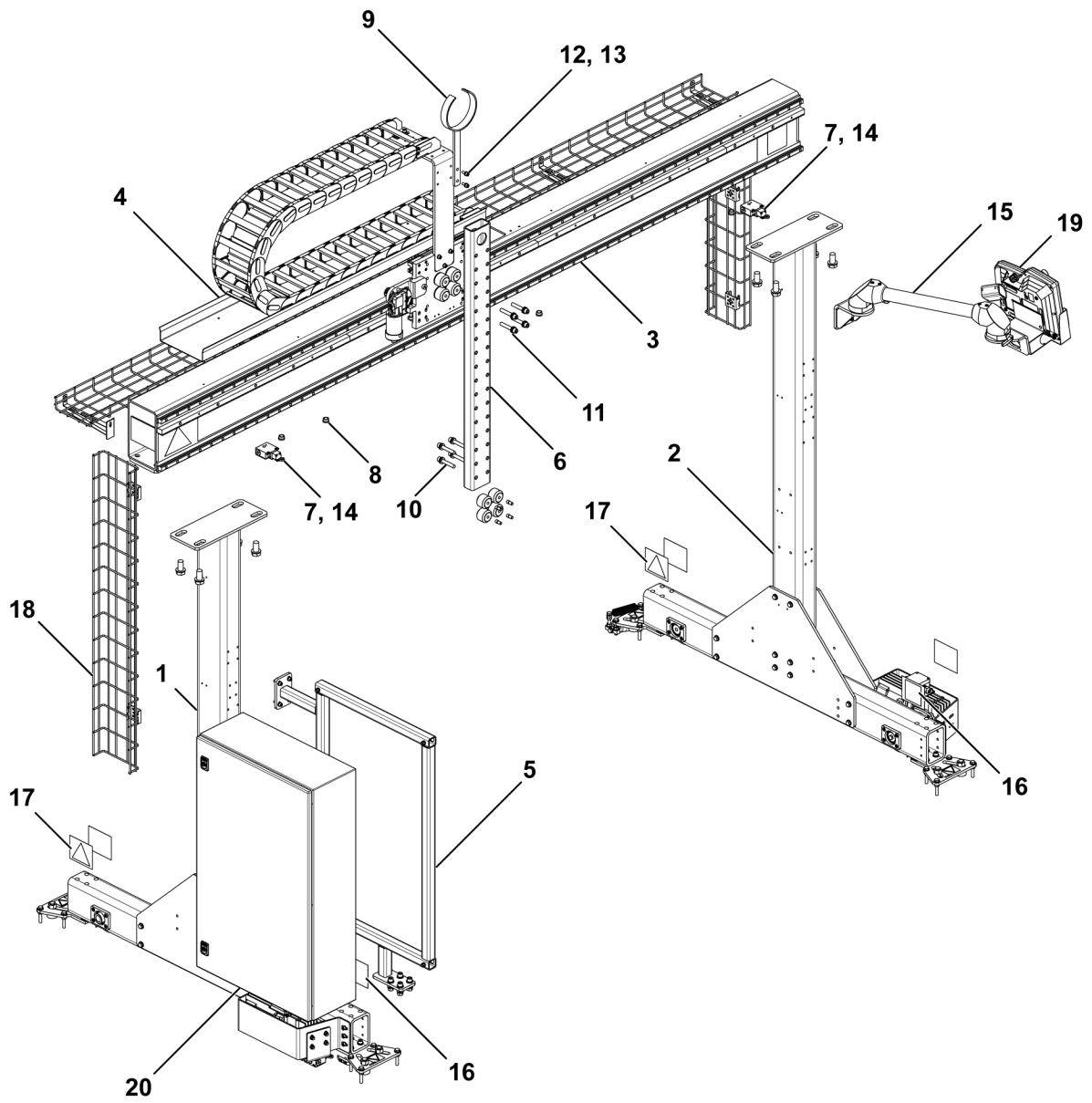
1 SPARE PARTS

Item	Qty	Ordering no.	Denomination	Notes
26	1	0912 575 881	Control cabinet B2	
27	1	0912 576 880	Cable set (for gantry with dual welding heads)	Not visible in graphic



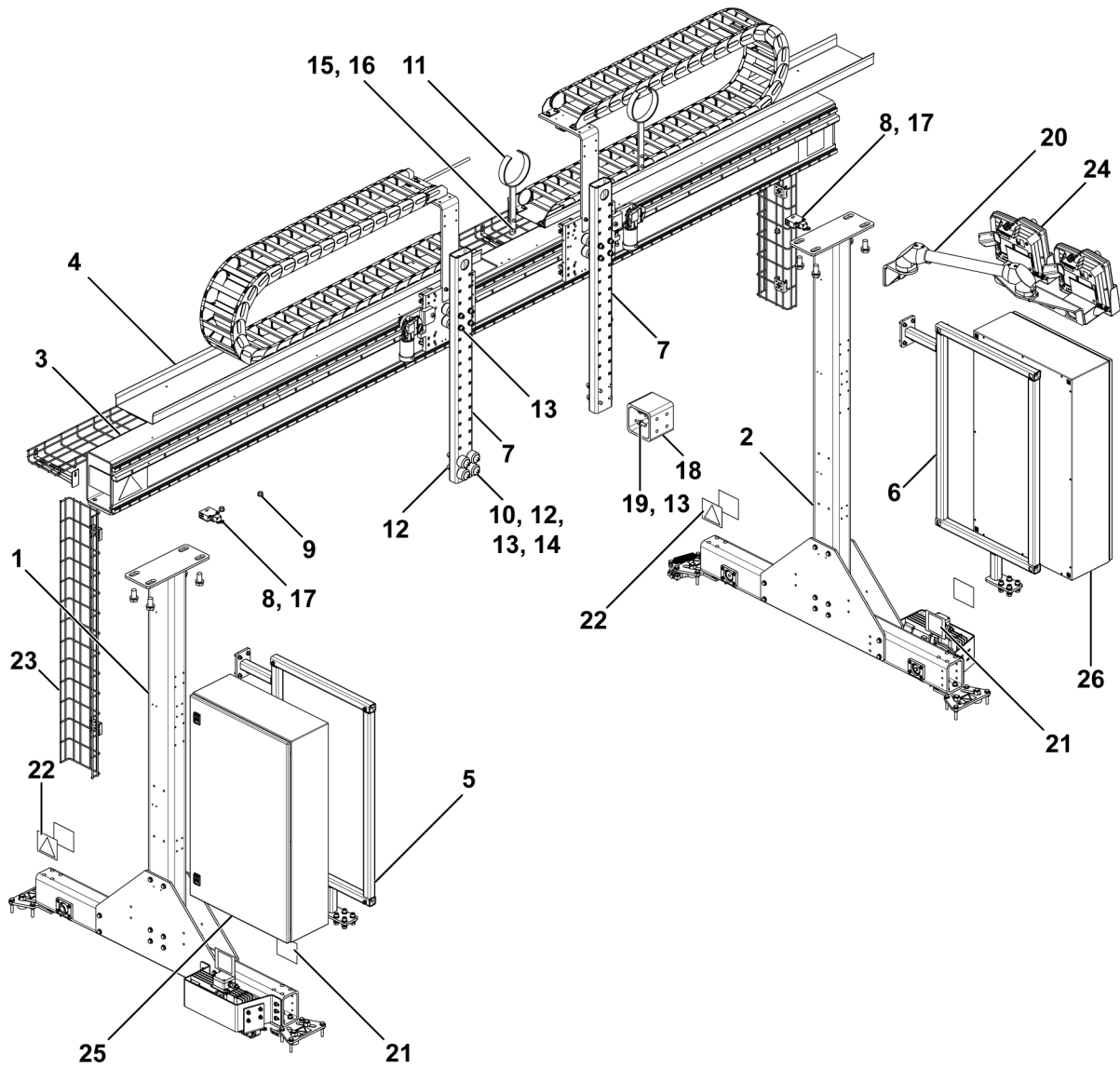
1.1.2 Mechtrac HD3, Single welding head

Item	Qty	Ordering no.	Denomination	Notes
		0912 350 881	Mechtrac HD3, Single welding head	
1	1	0912 241 880	Drive-kit Mechtrac HD, Left	See Section 1.2.1 "Drive-kit Mechtrac HD, Left", page 12
2	1	0912 241 881	Drive-kit Mechtrac HD, Right	See Section 1.2.2 "Drive-kit Mechtrac HD, Right", page 14
3	1	0904 356 880	Boom, Size 3 m	See Section 1.3.1 "Boom, Size 3 m", page 16
4	1	0912 290 881	Sub assembly Boom carriage Left	See Section 1.4.2 "Sub assembly Boom carriage, for 3 metres boom, Left", page 19
5	1	0912 313 880	Bracket for cabinet B, Left	
6	1	0806 471 002	Arm for Mechtrac	
7	2	0191 072 102	Limit switch (CaB)	
8	4	0190 753 104	Bushing D15/20	
9	1	0912 315 880	Cable support	
10	8		Allen screw 8.8, M12×70	
11	16		Washer TBRB steel, D24×13×4	
12	2		Allen screw 8.8, M8×20	
13	2		Washer TBRB steel D16/8.4X	
14	4		Allen screw 8.8, M5×12, steel	
15	1	0912 277 881	Support assembly EAC 30, For one panel	
16	4	0912 523 001	Direction symbol, 120×100 square symbol	
17	4	0912 523 002	Direction symbol, 120×100 triangle symbol	
18	1	0912 538 880	Cable management kit, Mechtrac HD3	
19	1	0911 492 880	EAC 30 Control panel	
20	1	0912 575 880	Control cabinet B1	
21	1	0912 576 881	Cable set (for gantry with single welding head)	Not visible in graphic



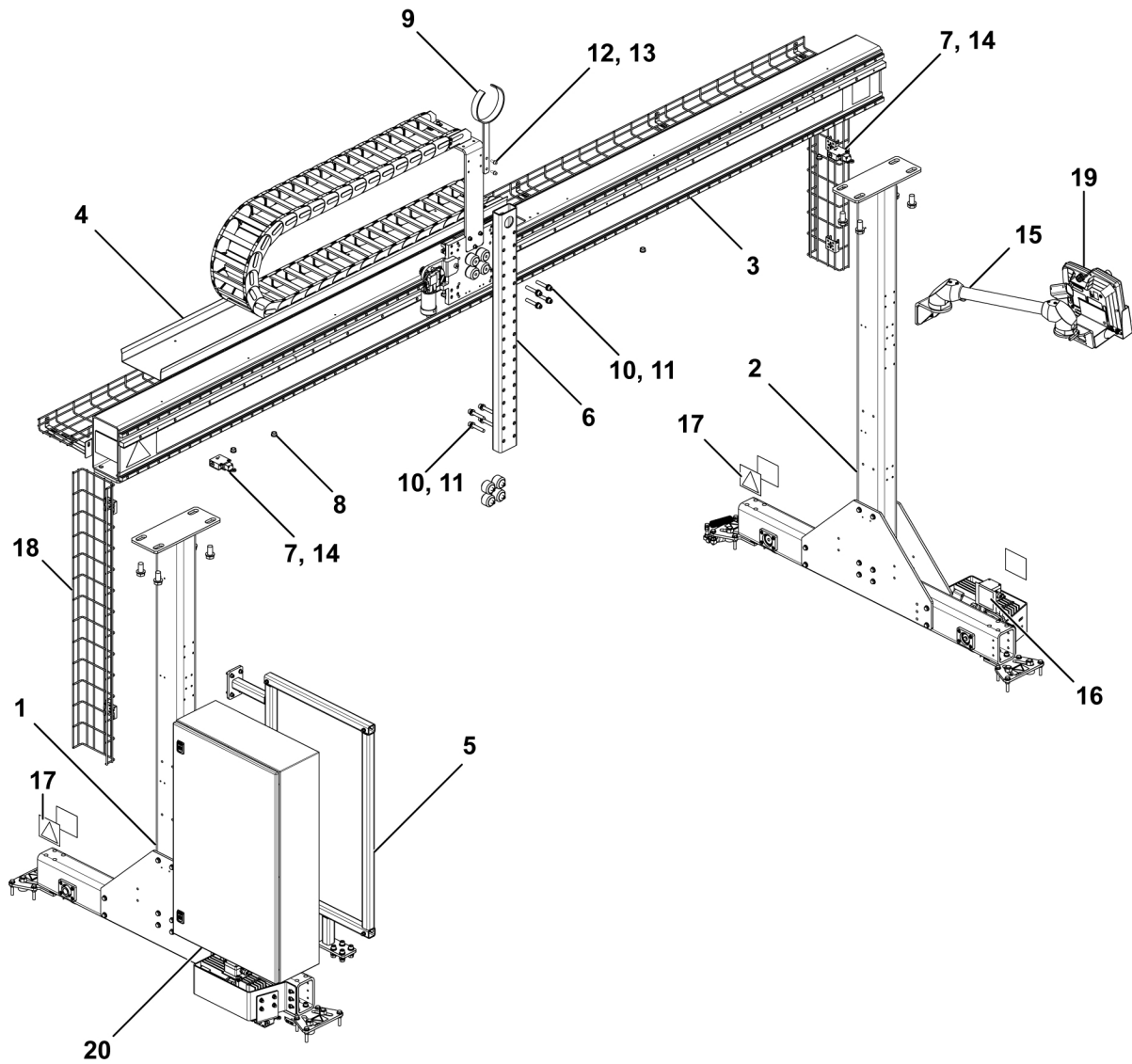
1.1.3 Mechtrac HD4, Dual welding heads

Item	Qty	Ordering no.	Denomination	Notes
		0912 351 880	Mechtrac HD4, Dual welding heads	
1	1	0912 241 880	Drive-kit Mechtrac HD, Left	See Section 1.2.1 "Drive-kit Mechtrac HD, Left", page 12
2	1	0912 241 881	Drive-kit Mechtrac HD, Right	See Section 1.2.2 "Drive-kit Mechtrac HD, Right", page 14
3	1	0904 356 881	Boom, Size 4 m	See Section 1.3.2 "Boom, Size 4 m", page 17
4	1	0912 290 883	Sub assembly Boom carriage Left and Right	See Section 1.4.3 "Sub assembly Boom carriage, for 4 metres boom, Left and Right", page 20
5	1	0912 313 880	Bracket for cabinet B, Left	
6	1	0912 313 881	Bracket for cabinet B, Right	
7	2	0806 471 002	Arm for Mechtrac	
8	2	0191 072 102	Limit switch (CaB)	
9	4	0190 753 104	Bushing D15/20	
10	4	0278 300 180	Insulator (A6)	
11	2	0912 315 880	Cable support	
12	16		Allen screw 8.8, M12×70	
13	36		Washer TBRB steel, D24×13×4	
14	4		Stop screw M12×30 mm	
15	4		Allen screw 8.8, M8×20	
16	4		Washer TBRB steel D16/8.4X	
17	4		Allen screw 8.8, M5×12, steel	
18	1	0820 274 001	Distance	
19	4		Allen screw 8.8, M12×30	
20	1	0912 277 880	Support assembly EAC 30, For two panels	
21	4	0912 523 001	Direction symbol, 120×100 square symbol	
22	4	0912 523 002	Direction symbol, 120×100 triangle symbol	
23	1	0912 538 881	Cable management kit, Mechtrac HD4	
24	2	0911 492 880	EAC 30 Control panel	
25	1	0912 575 880	Control cabinet B1	
26	1	0912 575 881	Control cabinet B2	
27	1	0912 576 880	Cable set (for gantry with dual welding heads)	Not visible in graphic



1.1.4 Mechtrac HD4, Single welding head

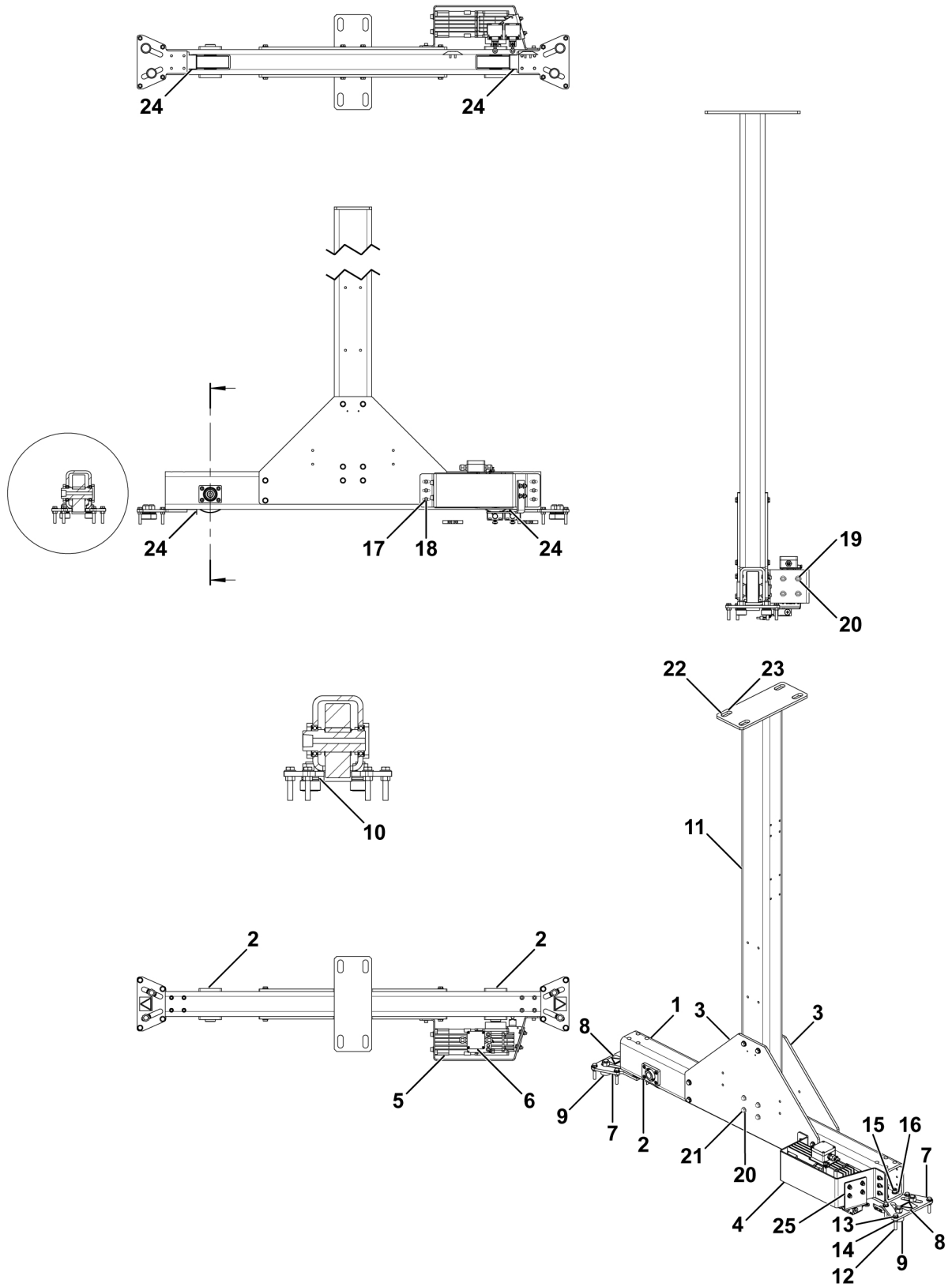
Item	Qty	Ordering no.	Denomination	Notes
		0912 351 881	Mechtrac HD4, Single welding head	
1	1	0912 241 880	Drive-kit Mechtrac HD, Left	See Section 1.2.1 "Drive-kit Mechtrac HD, Left", page 12
2	1	0912 241 881	Drive-kit Mechtrac HD, Right	See Section 1.2.2 "Drive-kit Mechtrac HD, Right", page 14
3	1	0904 356 881	Boom, Size 4 m	See Section 1.3.2 "Boom, Size 4 m", page 17
4	1	0912 290 884	Sub assembly Boom carriage Left, For boom length 4 m	See Section 1.4.4 "Sub assembly Boom carriage, for 4 metres boom, Left", page 21
5	1	0912 313 880	Bracket for cabinet B, Left	
6	1	0806 471 002	Arm for Mechtrac	
7	2	0191 072 102	Limit switch (CaB)	
8	4	0190 753 104	Bushing D15/20	
9	1	0912 315 880	Cable support	
10	8		Allen screw 8.8, M12×70	
11	16		Washer TBRB steel, D24×13×4	
12	2		Allen screw 8.8, M8×20	
13	2		Washer TBRB steel D16/8.4×3	
14	4		Allen screw 8.8, M5×12	
15	1	0912 277 881	Support assembly EAC 30, For one panel	
16	4	0912 523 001	Direction symbol, 120×100 square symbol	
17	4	0912 523 002	Direction symbol, 120×100 triangle symbol	
18	1	0912 538 881	Cable management kit, Mechtrac HD4	
19	1	0911 492 880	EAC 30 Control panel	
20	1	0912 575 880	Control cabinet B1	
21	1	0912 576 881	Cable set (for gantry with single welding head)	Not visible in graphic



1.2 Drive-kit Mechtrac HD

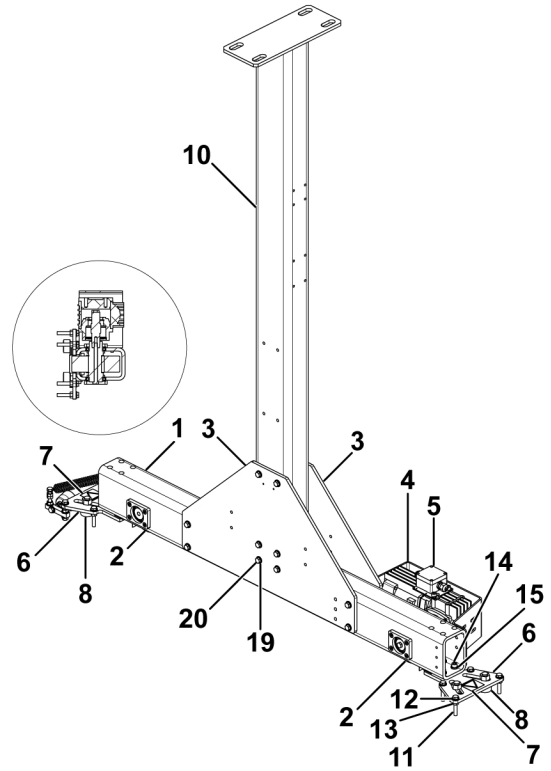
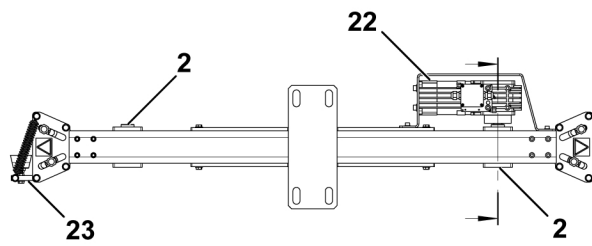
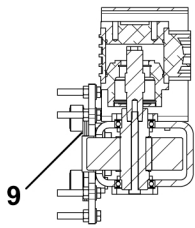
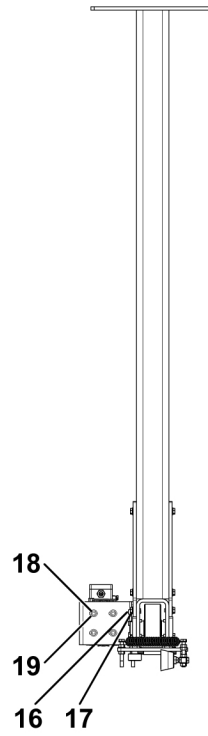
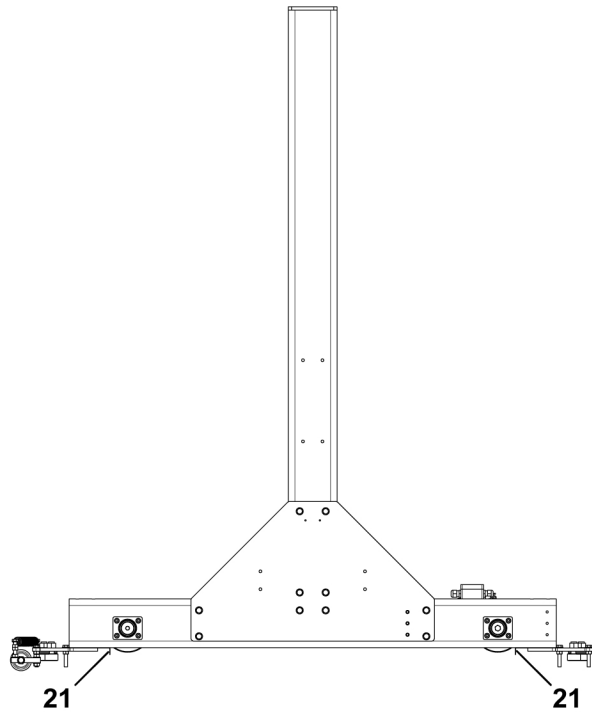
1.2.1 Drive-kit Mechtrac HD, Left

Item	Qty	Ordering no.	Denomination	Notes
		0912 241 880	Drive-kit Mechtrac HD, Left	
1	1	0912 240 001	Beam for carriage	
2	2	0912 270 880	Wheel kit Ø148	
3	2	0912 244 001	Side support	
4	1	0912 284 001	Motor cover	
5	1	0147 018 902	VEC motor, Co L 4000 rpm, 672:1, 42 V	
6	1	0449 498 880	Junction box complete, A6	
7	2	0912 267 001	Holder for guide rollers	
8	2	0443 514 001	Warning sign (wire straight) A6	
9	4	0806 475 001	Roller Mechtrac	
10	16		Washer BRB D34/19×3	
11	1	0912 242 880	Beam, Mechtrac HD	
12	8		Screw 6K, Steel, Galvanised, M10×60	
13	8		Washer BRB D22/10.5×2	
14	8		Nut 6K, Steel, 8.8, M10	
15	8		Allen Screw M10×25 mm	
16	8		Washer TBRB, Steel	
17	6		Allen Screw, Steel, 8.8, M8×20	
18	6		Washer BRB D16/8.4×1.5	
19	4		Allen Screw, Steel, 8.8, 10×20	
20	24		Washer BRB D22/10.5×2	
21	20		Screw, M6S, 10×25	
22	8		Screw, M6S, 20×40	
23	8		Washer BRB D36/21×3	
24	2	0806 476 002	Scraper Mechtrac	
25	1	0912 308 880	Rail limit switch assembly	



1.2.2 Drive-kit Mechtrac HD, Right

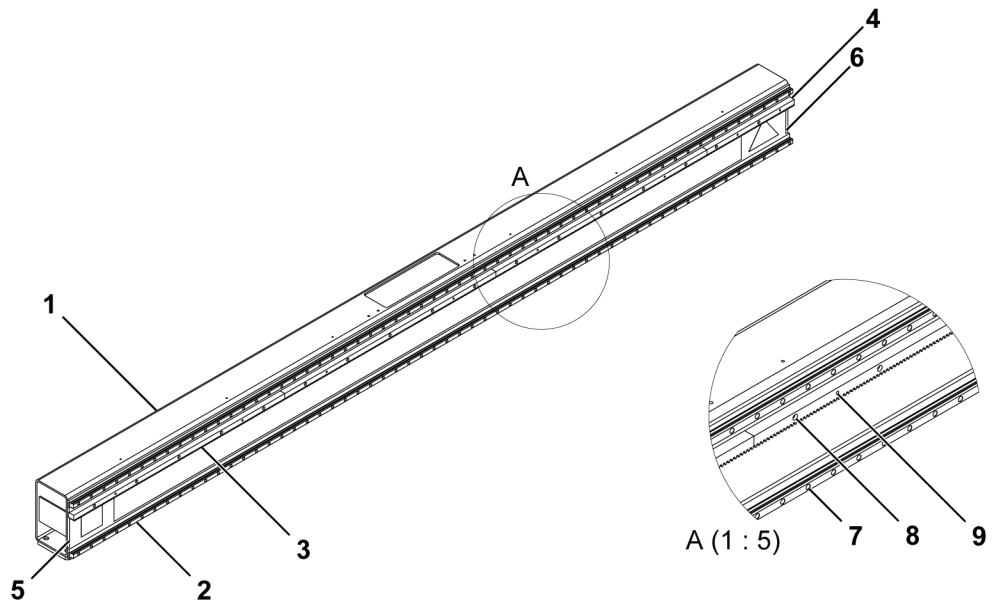
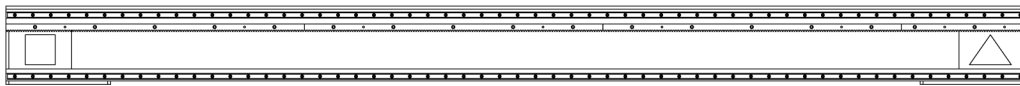
Item	Qty	Ordering no.	Denomination	Notes
		0912 241 881	Drive-kit Mechtrac HD, Right	
1	1	0912 240 001	Beam for carriage	
2	2	0912 270 880	Wheel kit Ø148	
3	2	0912 244 001	Side support	
4	1	0912 284 001	Motor cover	
5	1	0449 498 880	Junction box complete, A6	
6	2	0912 267 001	Holder for guide rollers	
7	2	0443 514 001	Warning sign (wire straight) A6	
8	4	0806 475 001	Roller Mechtrac	
9	16		Washer BRB D34/19×3	
10	1	0912 242 880	Beam, Mechtrac HD	
11	8		Screw 6K, Steel, Galvanised, M10×60	
12	8		Washer BRB D22/10.5×2	
13	8		Nut 6K, Steel, 8.8, M10	
14	8		Allen Screw M10×25 mm	
15	8		Washer TBRB, Steel	
16	6		Allen Screw, Steel, 8.8, M8×20	
17	6		Washer BRB D16/8.4×1.5	
18	4		Allen Screw, Steel, 8.8, 10×20	
19	24		Washer BRB D22/10.5×2	
20	20		Screw, M6S, 10×25	
21	2	0806 476 002	Scraper Mechtrac	
22	1	0147 018 892	VEC motor, Co R 4000 rpm, 672:1, 42 V	
23	1	0912 269 881	Brush kit	



1.3 Boom

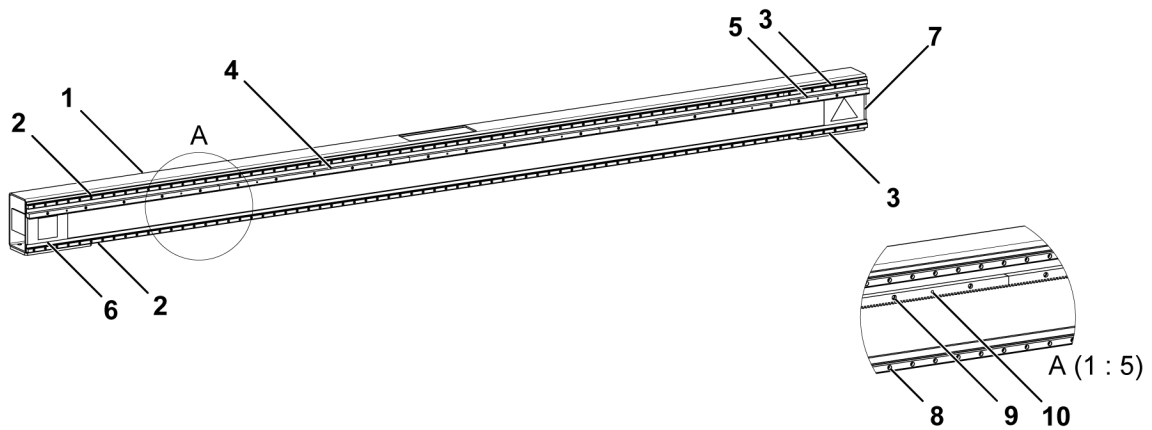
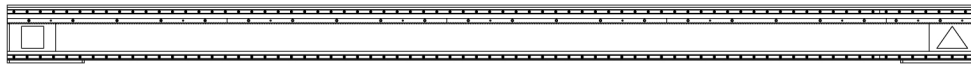
1.3.1 Boom, Size 3 m

Item	Qty	Ordering no.	Denomination	Notes
		0904 356 880	Boom, Size 3 m	
1	1	0904 355 880	Boom size 3 m for Gantrac 300	
2	2	0825 513 408	Guide rail MSA 20R L=3400	
3	3	0433 596 002	Gear rod L=1000 M2.5	
4	1	0433 596 001	Gear rod L=500 M2.5	
5	1	0443 631 001	Information sign, 210×148, foil	
6	1	0443 631 009	Information sign, 210×148, foil	
7	228		Allen screw, D140, M5×20	
8	22		Allen screw, Steel 8.8, M6×30	
9	10	0211 101 129	Cylinder pin, D 6×40	



1.3.2 Boom, Size 4 m

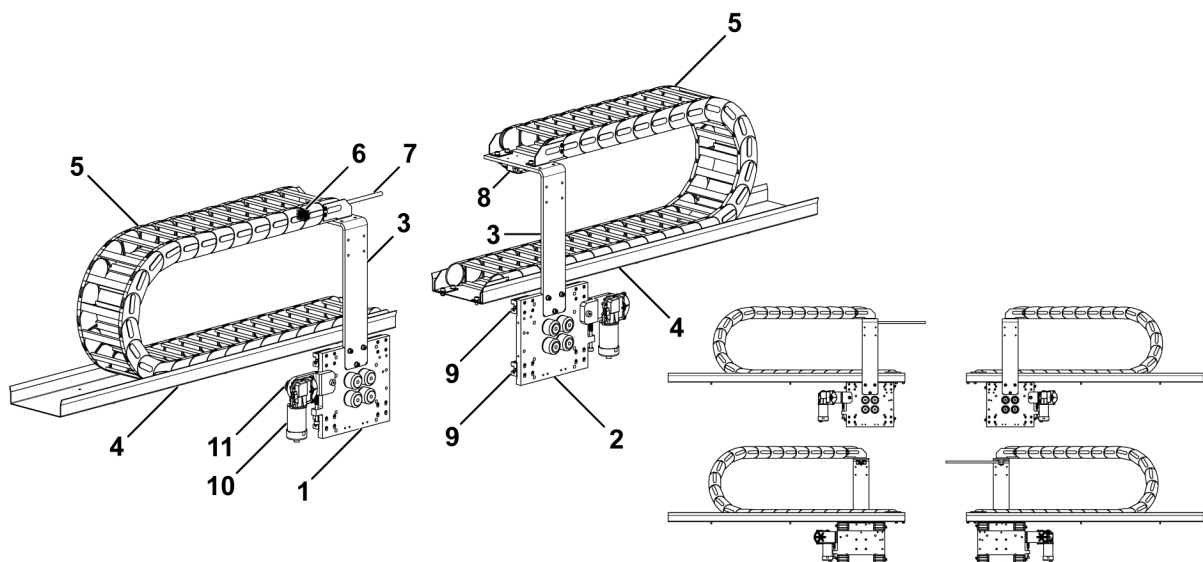
Item	Qty	Ordering no.	Denomination	Notes
		0904 356 881	Boom, Size 4 m	
1	1	0904 355 881	Boom size 4 m for Gantrac 300	
2	2	0825 513 401	Guide rail MSA 20R L=3960	
3	2	0825 513 402	Guide rail MSA 20R L=440	
4	4	0433 596 002	Gear rod L=1000 M2.5	
5	1	0433 596 001	Gear rod L=500 M2.5	
6	1	0443 631 001	Information sign, 210×148, foil	
7	1	0443 631 009	Information sign, 210×148, foil	
8	146		Allen screw, Steel 8.8, M5×20	
9	22		Allen screw, Steel 8.8, M6×30	
10	10	0211 101 129	Cylinder pin, D 6×40	



1.4 Sub assembly Boom carriage

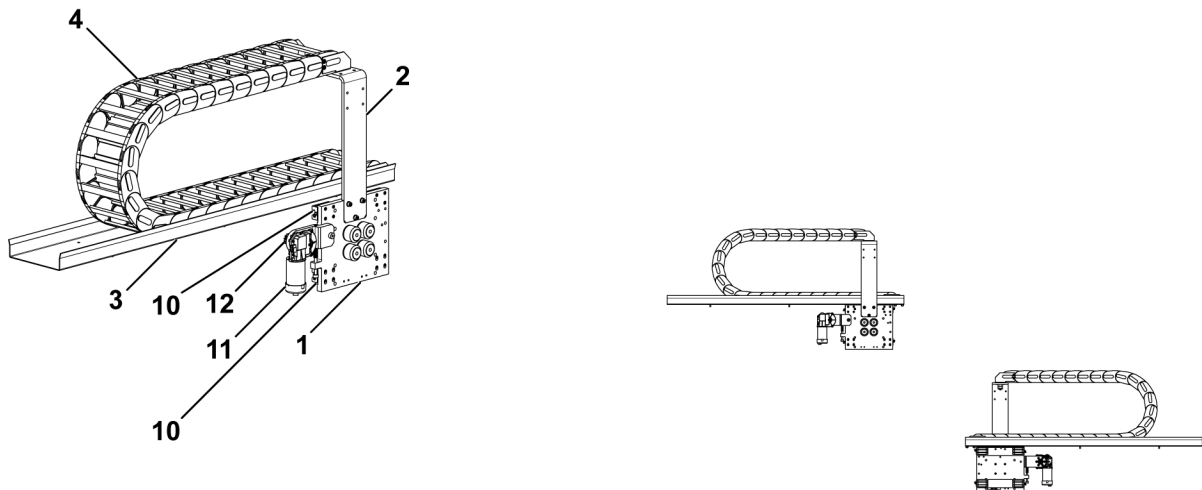
1.4.1 Sub assembly Boom carriage, for 3 metres boom, Left and Right

Item	Qty	Ordering no.	Denomination	Notes
		0912 290 880	Sub assembly Boom carriage, for 3 metres boom, Left and Right	
1	1	0912 291 880	Boom carriage, Left	
2	1	0912 291 881	Boom carriage, Right	
3	2	0904 366 001	Bracket for cable chain	
4	2	0801 093 003	Cable chain chute, Length: 1500	
5	2	0800 692 305	Cable tow chain, Length: 2240	
6	1	0191 498 104	Clamp Ø12, aluminium	
7	1	0190 395 197	Steel pipe SMS 2353, D 12/8	
8	1	0191 072 102	Limit switch (CaB)	
9	8	0825 514 002	Carriage MSA20S	
10	2	0910 974 002	Motor with gear box, KSV 4030-801, 24 V encoder	
11	2	0912 288 001	Gear wheel, M=2.5, Z=12	
12	22		Washer BRB D16/8.4×1.5	
13	6		Allen screw, Steel, 8.8, M8×20	
14	16		Allen screw, Steel, 8.8, M8×16 mm	
15	4		Nut 6K, Steel, M8	
16	6		Screw MRT, M6×16	
17	2		Allen screw, Steel, 8.8, M6×40	
18	2		Allen screw, Steel, 8.8, M5×12	



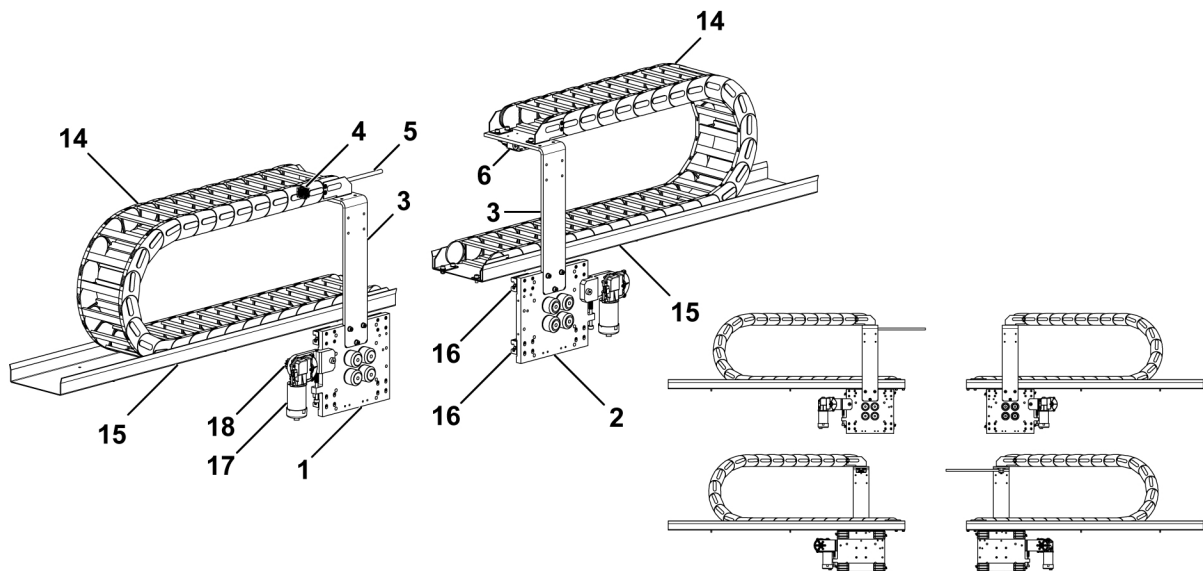
1.4.2 Sub assembly Boom carriage, for 3 metres boom, Left

Item	Qty	Ordering no.	Denomination	Notes
		0912 290 881	Sub assembly Boom carriage, for 3 metres boom, Left	
1	1	0912 291 880	Boom carriage, Left	
2	1	0904 366 001	Bracket for cable chain	
3	1	0801 093 003	Cable chain chute, Length: 1500	
4	1	0800 692 305	Cable tow chain, Length: 2240	
5	11		Washer BRB D16/8.4×1.5, 8.4X16 STL HB-20	
6	3		Allen screw, Steel, 8.8, M8×20	
7	8		Allen screw, Steel, 8.8, M8×16	
8	2		Nut 6K, Steel, M8	
9	3		Screw MRT, M6×16, Steel 8.8 FZB	
10	4	0825 514 002	Carriage MSA20S	
11	2	0910 974 002	Motor with gear box, KSV 4030-801, 24 V encoder	
12	2	0912 288 001	Gear wheel, M=2.5, Z=12	



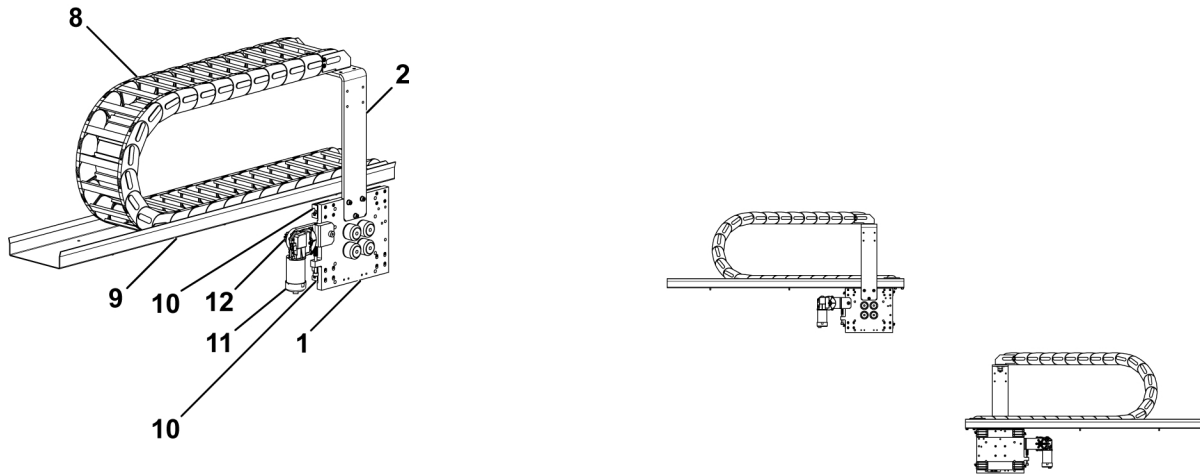
1.4.3 Sub assembly Boom carriage, for 4 metres boom, Left and Right

Item	Qty	Ordering no.	Denomination	Notes
		0912 290 883	Sub assembly Boom carriage, for 4 metres boom, Left and Right	
1	1	0912 291 880	Boom carriage, Left	
2	1	0912 291 881	Boom carriage, Right	
3	2	0904 366 001	Bracket for cable chain	
4	1	0191 498 104	Clamp Ø12, aluminium	
5	1	0190 395 197	Steel pipe SMS 2353, D 12/8	
6	1	0191 072 102	Limit switch (CaB)	
7	22		Washer BRB D16/8.4×1.5, 8.4X16 STL HB-20	
8	6		Allen screw, Steel, 8.8, M8×20	
9	16		Allen screw, Steel, 8.8, M8×16 mm	
10	4		Nut 6K, Steel, M8	
11	8		Screw MRT, M6×16, Steel 8.8 FZB	
12	2		Allen screw, Steel, 8.8, M6×40, STL 8.8 F	
13	2		Allen screw, Steel, 8.8, M5×12	
14	2	0800 692 307	Cable tow chain, Length: 2800, Horizontal montage	
15	2	0801 093 001	Cable chain chute, Length: 2000	
16	8	0825 514 002	Carriage MSA20S	
17	2	0910 974 002	Motor with gear box, KSV 4030-801, 24 V encoder	
18	2	0912 288 001	Gear wheel, M=2.5, Z=12	



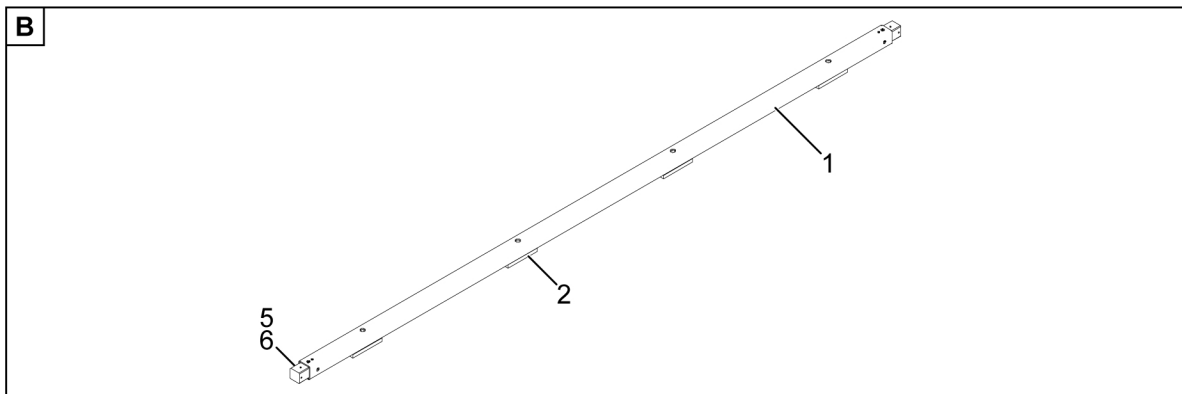
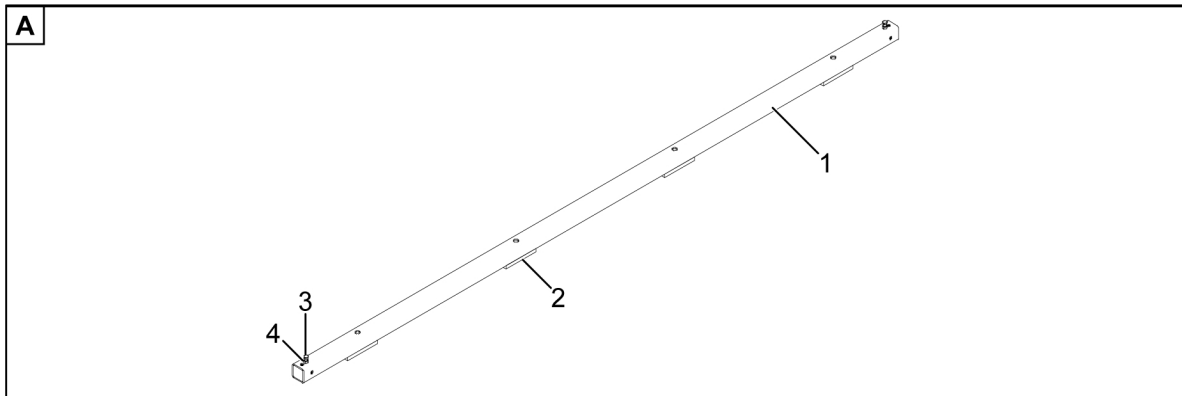
1.4.4 Sub assembly Boom carriage, for 4 metres boom, Left

Item	Qty	Ordering no.	Denomination	Notes
		0912 290 884	Sub assembly Boom carriage, for 4 metres boom, Left	
1	1	0912 291 880	Boom carriage, Left	
2	1	0904 366 001	Bracket for cable chain	
3	11		Washer BRB D16/8.4×1.5	
4	3		Allen screw, Steel, 8.8, M8×20	
5	8		Allen screw, Steel, 8.8, M8×16 mm	
6	2		Nut 6K, Steel, M8	
7	4		Screw MRT, M6×16	
8	1	0800 692 307	Cable tow chain, Length: 2800	
9	1	0801 093 001	Cable chain chute, Length: 2000	
10	4	0825 514 002	Carriage MSA20S	
11	2	0910 974 002	Motor with gear box, KSV 4030-801, 24 V encoder	
12	2	0912 288 001	Gear wheel, M=2.5, Z=12	

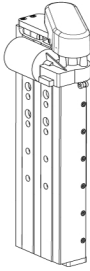



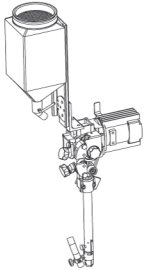


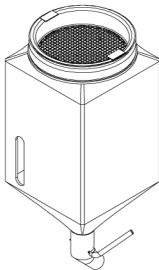
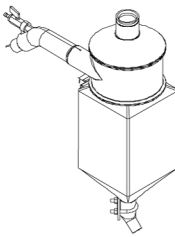

1.5 Rail

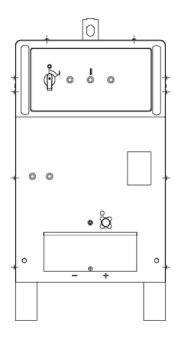
Item	Qty	Ordering no.	Denomination	Notes
A	–	0806 707 880	Rail (Basic)	
1	2	0806 700 001	Rail	
2	8	0806 701 001	Base plate	
3	2	0212 101 608	Screw, M10×40	
4	2	0212 601 110	Nut, M10	
B	–	0806 707 881	Rail (Extension)	
1	2	0806 700 001	Rail	
2	8	0806 701 001	Base plate	
5	2	0806 703 001	Inner plate	
6	12	0190 684 638	Screw, M16×90	



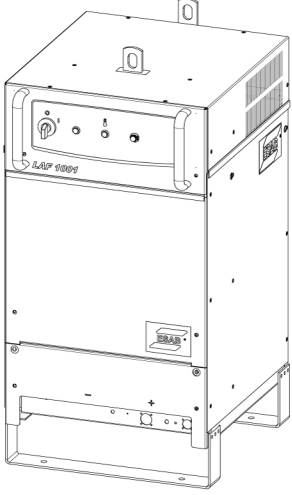
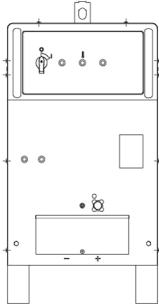
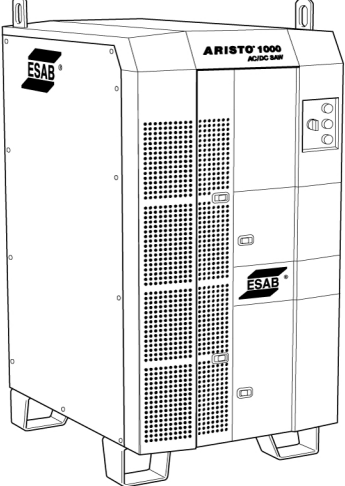
2 ACCESSORIES

Welding head modules:		
0334 333 883 0334 333 884 0334 333 885	Motorised slides: 240 mm 300 mm 420 mm	
0278 300 180	Insulator	
0334 170 880 0671 171 580	Manual round slides: Manual round slide, without handwheel Manual round slide, with handwheel	 
0912 360 880 0912 360 881 0912 360 882 0912 360 883 0912 360 884 0912 361 880 0912 361 881 0912 361 882 0912 361 883 0912 361 884	Feed units: SAW Twin wire right-hand assembled, Gear ratio 115:1 SAW Single wire right-hand assembled, Gear ratio 115:1, 4000 rpm SAW Single wire right-hand assembled, Gear ratio 74:1, 4000 rpm SAW Single wire right-hand assembled, Gear ratio 156:1, 4000 rpm SAW Single wire right-hand assembled, Gear ratio 74:1, 8000 rpm SAW Twin wire left-hand assembled, Gear ratio 115:1 SAW Single wire left-hand assembled, Gear ratio 115:1, 4000 rpm SAW Single wire left-hand assembled, Gear ratio 74:1, 4000 rpm SAW Single wire left-hand assembled, Gear ratio 156:1, 4000 rpm SAW Single wire left-hand assembled, Gear ratio 74:1, 8000 rpm	

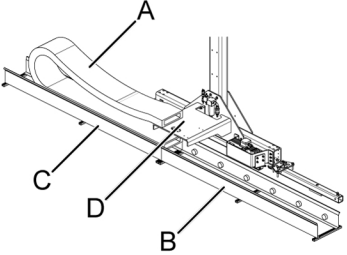
0147 649 881	Flux hopper 10 l	
0912 522 880 0912 522 881 0912 522 882 0912 522 883	OPC super Mechtrac HD units: Dual OPC super kit Single OPC super kit Dual OPC super kit without flux inlet Single OPC super kit without flux inlet	
0912 730 880	Mechanical option for flux suction OPC (Order 2 pieces when using dual welding heads.)	
0912 577 880	Electrical option for flux suction OPC (Option 30 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 577 881	Flux down (Option 40 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0333 225 882	Mechanical option for TPC with heater	
0912 577 889	Electrical option for TPC with heater (option 220 according to electrical diagram)	
0333 225 884	Mechanical option for TPC with low-level sensor	
0912 577 890	Electrical option for TPC with low-level sensor (option 230 according to electrical diagram)	
0333 225 886	Mechanical option for TPC with heater and low-level sensor	
0417 142 900	Mechanical option for GMH (Order 2 pieces when using dual welding heads.)	
0912 577 882	Electrical option for GMH (Option 60 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0810 904 881	Mechanical option for inductive sensor (Order 2 pieces when using dual welding heads.)	
0912 577 883	Electrical option for inductive sensor (Option 62 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	

0912 435 880	Mechanical option for gas (Order 2 pieces when using dual welding heads.)	
0912 577 884	Electrical option for gas (Option 70 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 728 880	Mechanical option for flow sensor (Order 2 pieces when using dual welding heads.)	
0912 577 885	Electrical option for flow sensor (Option 72 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 577 886	Shift transversal welding (Option 80 according to electrical diagram)	
0912 577 888	Camera system (Option 190 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 733 880	Mounting kit for camera system (Order 2 pieces when using dual welding heads.)	
0822 640 880	Bracket with slide cross (Order 2 pieces when using dual welding heads.)	
0912 577 891	ICE (Option 251 according to electrical diagram) (Order 2 pieces when using dual welding heads.)	
0912 577 892	WeldCloud: (Option 280 according to electrical diagram) Dual	
0912 578 892	Single	
0460 512 880	LAF 631 Welding power source	

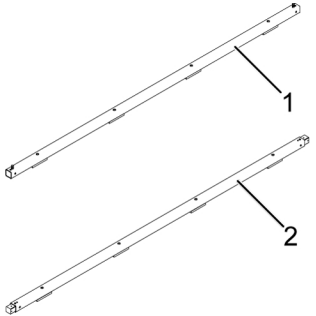
2 ACCESSORIES

0460 513 880	LAF 1001 Welding power source	
0460 513 881	LAF 1001M Welding power source	
0460 514 880	LAF 1251 Welding power source	
0460 514 881	LAF 1251M Welding power source	
0462 100 880	Aristo 1000 AC/DC SAW Welding power source	

2 ACCESSORIES

0417 981 005	Floor cable chain (A) For 5 m travel	
0417 981 010	For 10 m travel	
0417 981 015	For 15 m travel	
0417 981 020	For 20 m travel	
0417 981 025	For 25 m travel	
0417 981 030	For 30 m travel	
0417 981 035	For 35 m travel	
0417 981 040	For 40 m travel	
0417 981 045	For 45 m travel	
0417 981 050	For 50 m travel	
0417 981 101	Guide groove with rollers (B)	
0417 981 102	Guide groove without rollers (C)	
0912 352 880	Attachment for cable chain (D)	
0413 768 xxx *)	Welding cable (W20, W120, W220, W320)	
0413 768 xxx *)	Return cable (W18, W218)	
0820 129 8xx *)	Reference cable (W19, W219)	
0912 582 8xx *)	Control cable set (W15, W16, W215, W216) (consisting of cables 0460 910 98x and 0802 803 028)	

*) "x" Denotes total length of each cable type,
Order two cable sets when using dual welding heads.

0806 707 880	Rail (Basic) (1)	
0806 707 881	Rail (Extension) (2)	



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ESAB AB, Lindholmsallén 9, Box 8004, 402 77 Gothenburg, Sweden, Phone +46 (0) 31 50 90 00

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