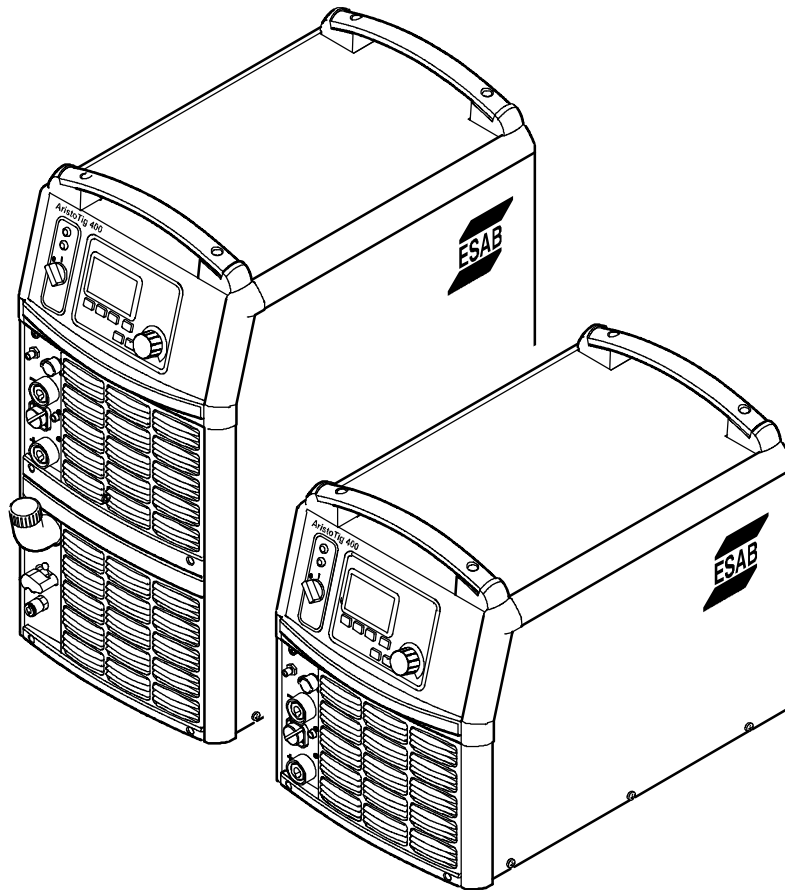


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# *Tig 4000i*

## *Aristo™*



**Instruction manual**

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## 1 DIRECTIVE

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### DECLARATION OF CONFORMITY

ESAB AB, Welding Equipment, SE-695 81 Laxå, Sweden, gives its unreserved guarantee that welding power source Tig 4000i, Tig 4000iw from serial number 620 (2006 w.20) are constructed and tested in compliance with the standard EN 60974-1/-2/-3 and EN 60974-10 in accordance with the requirements of directive (2006/95/EC) and (2004/108/EEC).

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Laxå 2007-03-13



Kent Eimbrodt  
Global Director  
Equipment and Automation

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## 2 SAFETY

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Users of ESAB welding equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of welding equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the welding equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the welding equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding
2. The operator must ensure that:
  - no unauthorized person is stationed within the working area of the equipment when it is started up.
  - no-one is unprotected when the arc is struck
3. The workplace must:
  - be suitable for the purpose
  - be free from drafts
4. Personal safety equipment
  - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
  - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. General precautions
  - Make sure the return cable is connected securely.
  - Work on high voltage equipment **may only be carried out by a qualified electrician.**
  - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
  - Lubrication and maintenance must **not** be carried out on the equipment during operation.



# WARNING



**ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS' HAZARD DATA.**

**ELECTRIC SHOCK - Can kill**

- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

**FUMES AND GASES - Can be dangerous to health**

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.

**ARC RAYS - Can injure eyes and burn skin.**

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

**FIRE HAZARD**

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

**NOISE - Excessive noise can damage hearing**

- Protect your ears. Use earmuffs or other hearing protection.
- Warn bystanders of the risk.

**MALFUNCTION - Call for expert assistance in the event of malfunction.**

**READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.**

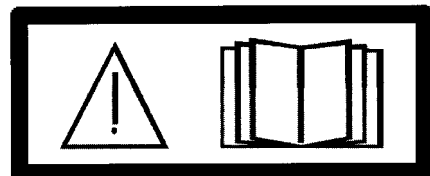
**PROTECT YOURSELF AND OTHERS!**

**ESAB can provide you with all necessary welding protection and accessories.**



**WARNING!**

Read and understand the instruction manual before installing or operating.

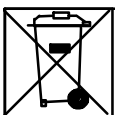


**WARNING!**

Do not use the power source for thawing frozen pipes.



**This product is solely intended for arc welding.**



**Do not dispose of electrical equipment together with normal waste!**

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative.

By applying this European Directive you will improve the environment and human health!

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## 3 INTRODUCTION

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The **Tig 4000i** is a TIG welding power source, which can also be used for MMA welding.

**NB:** These instructions describe an Tig 4000i with cooling unit.

**ESAB's accessories for the product can be found on page 23.**

### 3.1 Equipment

The Tig 4000i is delivered with 5m return cable, instructions for power source and one instruction for the control panel.

### 3.2 The control panel

The power source is supplied with one of the following control panels:

- **TA4 panel**



With a knob for adjusting the current. Other parameters are controlled by pushbuttons, with symbols in the display panel.

- **TA6 panel**



With a knob for adjusting the current. Other parameters are controlled by pushbuttons, with text in the display panel.

See the separate instructions for detailed descriptions of the control panels.

## 4 TECHNICAL DATA

	<b>Tig 4000i</b> not reconnectable
<b>Mains voltage</b>	400V, ± 10%, 3~ 50 Hz
<b>Primary current</b>	
I <sub>max</sub> TIG	29 A
I <sub>max</sub> MMA	38 A
<b>No-load power</b> in the energy-saving mode, 6,5 min. after welding	60 W
<b>Voltage/current range</b>	
TIG	8-60 V / 4-400 A
MMA	16 - 400 A
<b>Permissible load at TIG</b>	
35% duty cycle	400 A / 26 V
60 % duty cycle	320 A / 23 V
100% duty cycle	250 A / 20 V
<b>Permissible load at MMA</b>	
35% duty cycle	400 A / 36 V
60 % duty cycle	320 A / 33 V
100% duty cycle	250 A / 30 V
<b>Power factor</b> at maximum current	0,65
<b>Efficiency</b> at maximum current	85 %
<b>Open-circuit voltage</b>	78 - 90 V
<b>Operating temperature range</b>	-10 to + 40°C
<b>Transportation temperature</b>	-25 to +55°C
<b>Dimensions, lxbxh</b>	625 x 394 x 496
with cooling unit	625 x 394 x 776
<b>Continual sound pressure at no-load</b>	<70 db (A)
<b>Weight</b>	59 kg
with cooling unit	79 kg
<b>Insulation class</b>	H
<b>Enclosure class</b>	IP 23
<b>Application class</b>	S

<b>Cooling unit</b>	
Cooling power	2.0 kW at 40 °C temperature difference and flow 1.0 l/min
Coolant	50 % water / 50% mono-ethylen glycol
Liquid quantity	5.5 l
Maximum water flow	2.0 l/min
Maximum number of water-cooled welding guns/torches that may be connected	two MIG welding guns or one TIG torch and one MIG welding gun

**Duty cycle**

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld at a certain load without overloading.

The duty cycle is valid for 40 °C.

**Enclosure class**

The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP23** is designed for indoor and outdoor use.

**Application class**

The symbol **S** indicates that the power source is designed for use in areas with increased electrical hazard.

## 5 INSTALLATION

*The installation must be executed by a professional.*



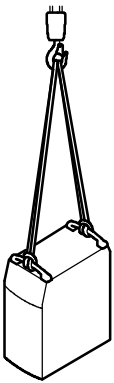
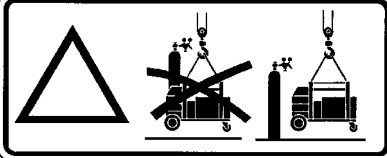

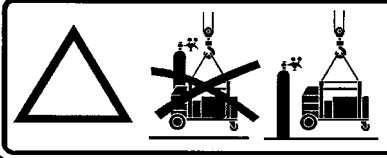
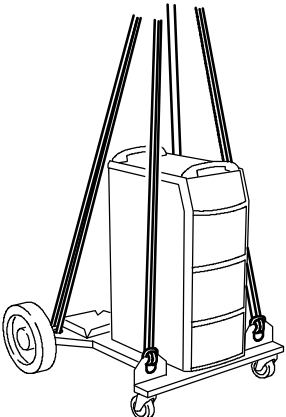
### WARNING!

This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.

### Note!

Connect the power source to the electricity mains with a network impedance of 0.200 ohm or lower. If the network impedance is higher, there is a risk of flicker in the illuminators.

### 5.1 Lifting instructions

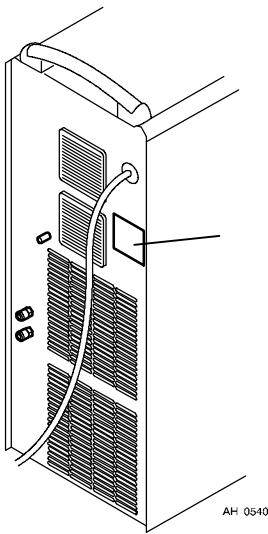
With power source	With trolley and power source	With trolley2 and power source
 <p style="text-align: right; font-size: small;">AHT 05e49</p>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;">  </div> 	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;">  </div> 

### 5.2 Placing

Position the welding power source such that its cooling air inlets and outlets are not obstructed.



### 5.3 Mains power supply



Check that the unit is connected to the correct mains power supply voltage, and that it is protected by the correct fuse sizes. A protective earth connection must be made, in accordance with regulations.

*Rating plate with supply connection data.*

#### Recommended fuse sizes and minimum cable areas

Tig 4000i	50 Hz
<b>Mains voltage</b>	400 V
<b>Mains cable area, mm<sup>2</sup></b>	4G4
<b>Phase current, I effective</b>	22 A
<b>Fuse</b>	
Anti-surge	25 A
Type C MCB	32 A

**NB:**

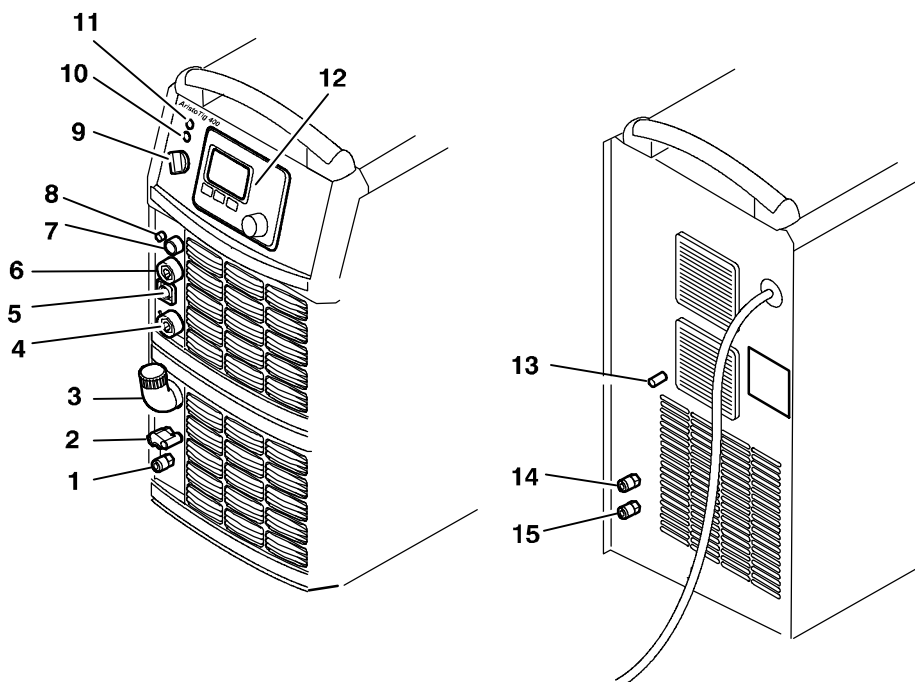
*The mains cable areas and fuse sizes as shown above are in accordance with Swedish regulations. They may not be applicable in other countries: make sure that the cable area and fuse sizes comply with the relevant national regulations.*

## 6 OPERATION

**General safety regulations for the handling of the equipment can be found on page 3. Read through before you start using the equipment!**

### 6.1 Connections and control devices

- |   |  |    |  |
|---|--|----|--|
| 1 | Connection for cooling water from the TIG torch - RED                | 9  | Main power supply switch, 0 / 1 / START                      |
| 2 | Connection with water lock for cooling water to the TIG torch - BLUE | 10 | White indicating lamp - Power supply ON                      |
| 3 | Cooling water filler   | 11 | Orange indicating lamp - Overheating                         |
| 4 | Connection for return cable (+)                                      | 12 | Control panel (see the respective instructions)              |
| 5 | Connection for remote control  | 13 | Connection for gas hose                                      |
| 6 | Connection for welding cable (-)                                     | 14 | Connection for cooling water. <i>Not used on this model.</i> |
| 7 | Connection for start signal from the welding torch                   | 15 | Connection for cooling water. <i>Not used on this model.</i> |
| 8 | Connection for gas to the TIG torch                                  |    |  |



### 6.2 Turning on the power source

Turn on the mains power by turning switch (9) to the "START" position. Release the switch, and it will return to the "1" position.

If the mains power supply should be interrupted while welding is in progress, and then be restored, the power source will remain de-energised until the switch is again turned manually to the "START" position.

Turn the unit off by turning the switch to the "0" position

Whether in the event of a loss of power supply or of turning the power source off in the normal manner, welding data will be stored so that it is available next time the unit is started.

### **6.3 Fan control**

The power source fans continue to run for 6,5 minutes after welding has stopped, and the unit switches to energy-saving mode. They start again when welding restarts.

The fans run at reduced speed for welding currents up to 144 A, and at full speed for higher currents.

### **6.4 Overheating protection**

The power source has two thermal overload trips which operate if the internal temperature becomes too high, interrupting the welding current and lighting the orange indicating lamp on the front of the unit. They reset automatically when the temperature has fallen.

### **6.5 Cooling unit**

#### **Water lock**

The cooling unit has a water lock that senses whether the cooling water hoses are connected.

The power source On/Off switch must be in the "0" position (Off) when connecting a water-cooled TIG torch.

If a water-cooled TIG torch is connected, the water pump starts automatically when the main On/Off switch is turned to "START" and/or when welding starts. After welding, the pump continues to run for 6,5 minutes, and then switches to the energy-saving mode.

#### **Function when welding**

To start welding, the welder presses the torch trigger switch. The power source energises the torch and starts wire feed and the cooling water pump.

To stop welding, the welder releases the torch trigger switch. The welding current is interrupted, but the cooling water pump continues to run for 6,5 minutes, after which the unit switches to energy-saving mode.

#### **Water flow guard**

The water flow guard interrupts the welding current in the event of loss of coolant, and displays an error message on the control panel. The water flow guard is an accessory.

### **6.6 Remote control unit**

Aristo machines with integral control panels should have program version 1.21 or higher, in order for the remote control to function correctly.

When the remote control unit is connected, the power source and wire feed unit are in remote control mode; the buttons and knobs are blocked. The functions can only be adjusted via the remote unit.

If the remote control unit is not to be used, the remote control unit must be disconnected from the power source / wire feed unit, as otherwise it will remain in remote control mode.

When carrying out TIG welding, the value for the pulse current can be changed with the remote control.

For more information about the operation of the remote control unit, see the relevant operating instructions for the control panel.

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## 7 MAINTENANCE

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Regular maintenance is important for safe, reliable operation.

Only personnel with the appropriate electrical skills (authorised electricians) may remove safety plates.

### **Note!**

*All guarantee undertakings from the supplier cease to apply if the customer himself attempts any work in the product during the guarantee period in order to rectify any faults.*

### 7.1 Daily

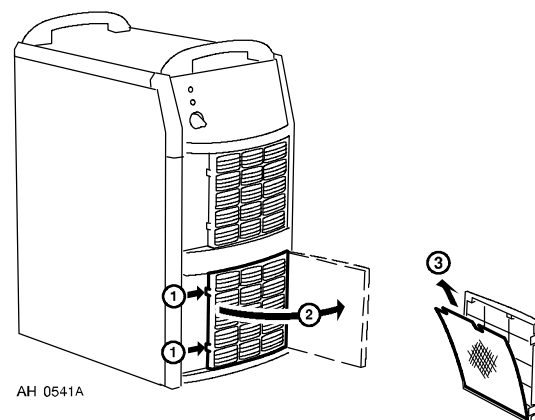
Carry out the following maintenance every day.

- Check that all cables and connections are fault free. Tighten if necessary and replace any defective parts.
- Check the water level and water flow, top up with coolant if necessary.

### 7.2 If necessary

- Regularly check that the power source is not clogged with dirt. Clogged or blocked air inlets and outlets result in overheating

- Clean the dust filter
  - Remove the fan grille with the dust filter (1).
  - Swing out the grille (2).
  - Release the dust filter (3).
  - Blow the filter clean with compressed air (reduced pressure).
  - Replace the filter with the finer mesh on the side against the grille (2) (out from the power source).
  - Replace the fan grille with the dust filter.

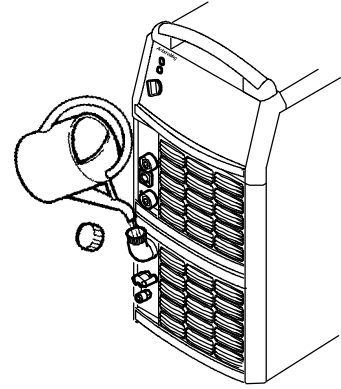


**GB**

- Top up with coolant

ESAB's ready mixed coolant is recommended for use.  
See accessories on page [23](#).

- Top up with coolant until it covers half the inlet pipe.



### **CAUTION!**

The coolant must be handled as chemical waste.

## **7.3 Every year**

Carry out the following maintenance at least once a year.

- Clean off any dirt and dust. Blow the power source clean with dry compressed air (reduced pressure).
- Change the coolant and clean the hoses and water reservoir with clean water.
- Check seals, cables and connections. Tighten if necessary and replace any defective parts.

## **8 FAULT TRACING**

*Try these recommended checks and inspections before sending for an authorised service technician.*

<b>Type of fault</b>	<b>Action</b>
No arc	<ul style="list-style-type: none"> <li>• Check that the mains power supply switch is turned on.</li> <li>• Check that the welding current supply and return cables are correctly connected.</li> <li>• Check that the correct current value is set.</li> </ul>
Welding current is interrupted during welding	<ul style="list-style-type: none"> <li>• Check whether the thermal overload trips have operated (indicated by the orange lamp on the front panel).</li> <li>• Check the main power supply fuses.</li> </ul>
The thermal overload trips operate frequently.	<ul style="list-style-type: none"> <li>• Check to see whether the air filters are clogged.</li> <li>• Make sure that you are not exceeding the rated data for the power source (i.e. that the unit is not being overloaded).</li> </ul>
Poor welding performance.	<ul style="list-style-type: none"> <li>• Check that the welding current supply and return cables are correctly connected.</li> <li>• Check that the correct current value is set.</li> <li>• Check that the correct electrodes are being used.</li> <li>• Check the main power supply fuses.</li> </ul>

## **9 ORDERING OF SPARE PARTS**

*Repair and electrical work should be performed by an authorized ESAB serviceman. Use only ESAB original spare and wear parts.*

**Tig 4000i is designed and tested in accordance with the international and European standards IEC/EN 60974-1, /-2, /-3 and EN 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.**

Spare parts may be ordered through your nearest ESAB dealer, see the last page of this publication.

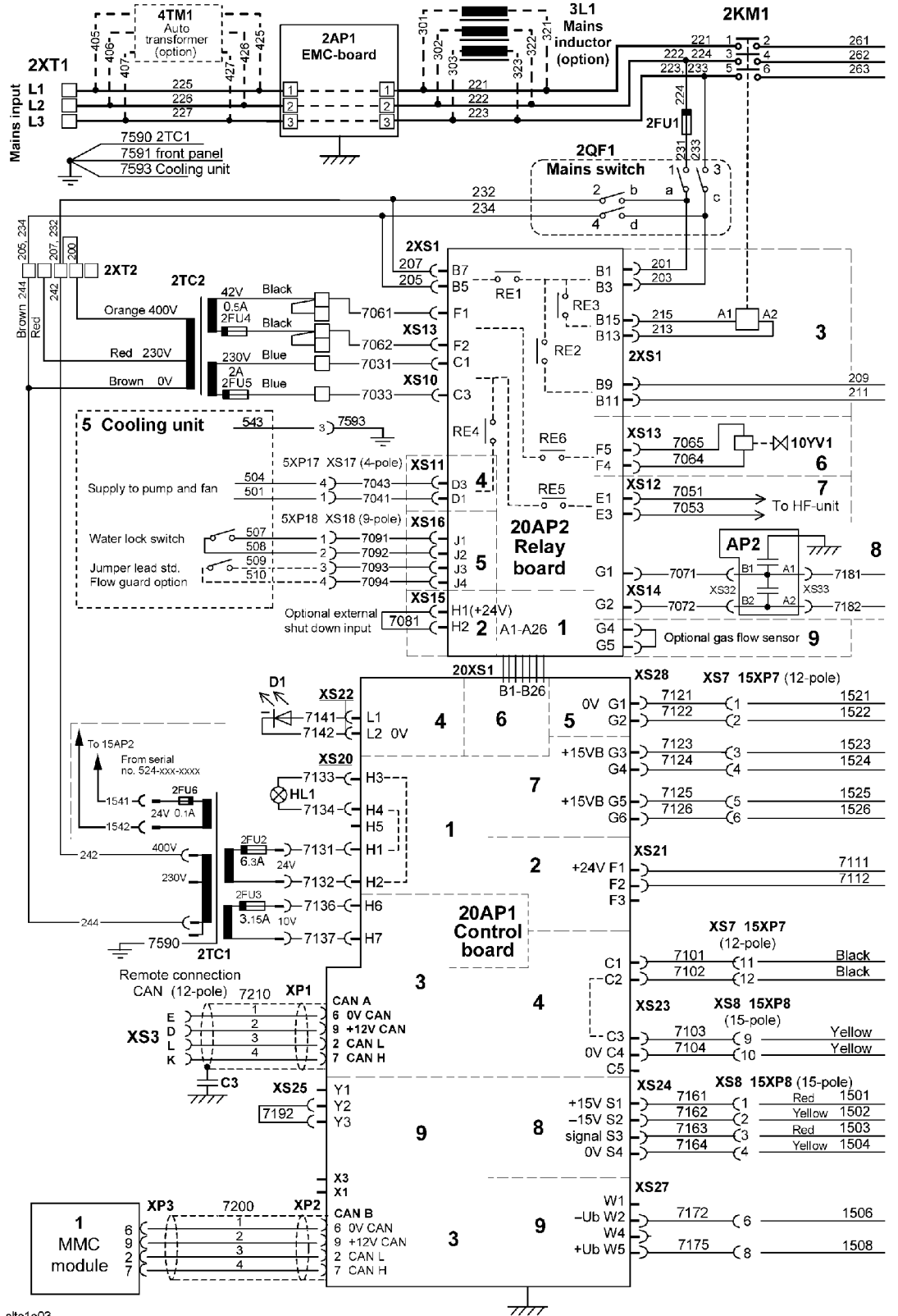




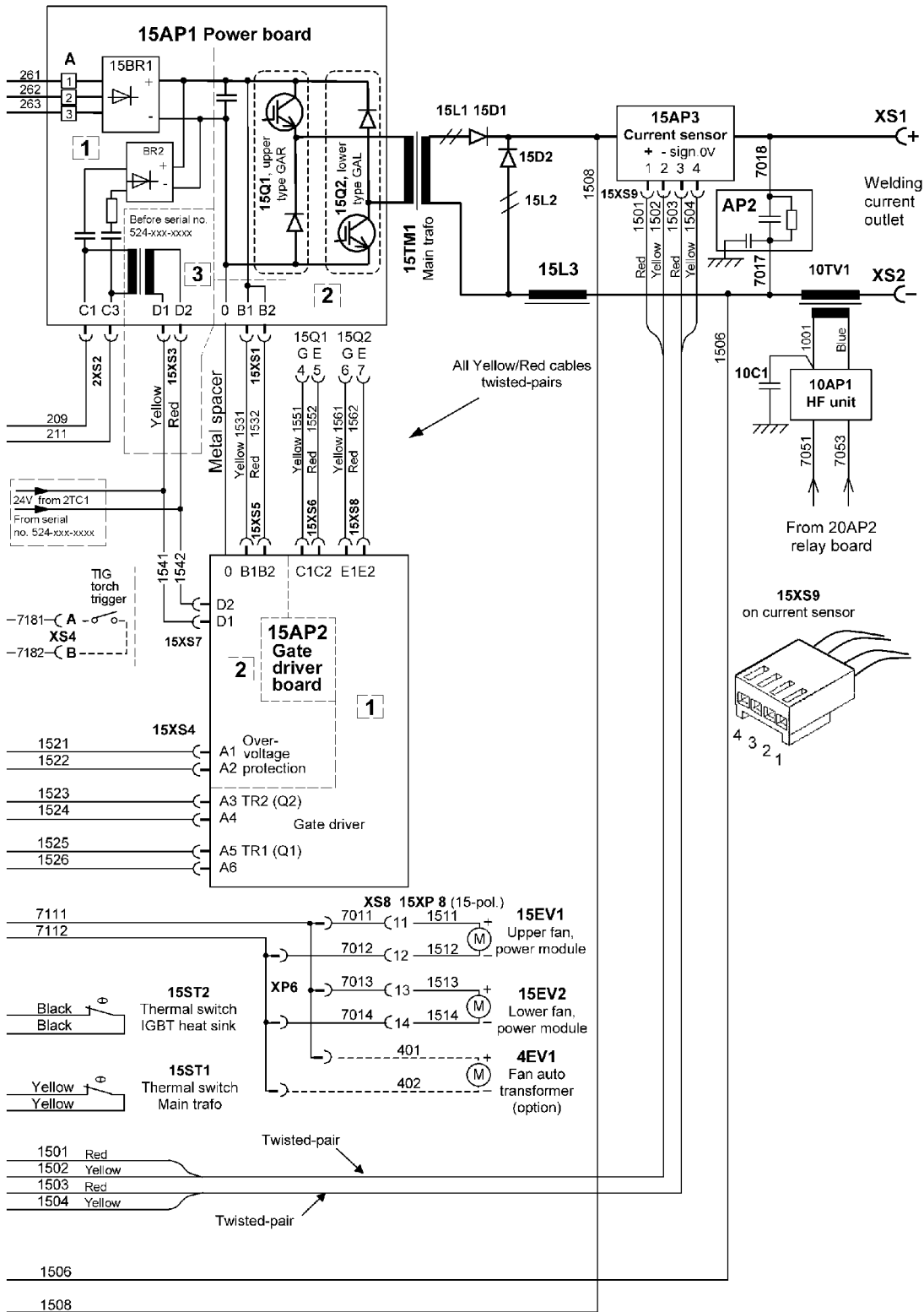




# Diagram

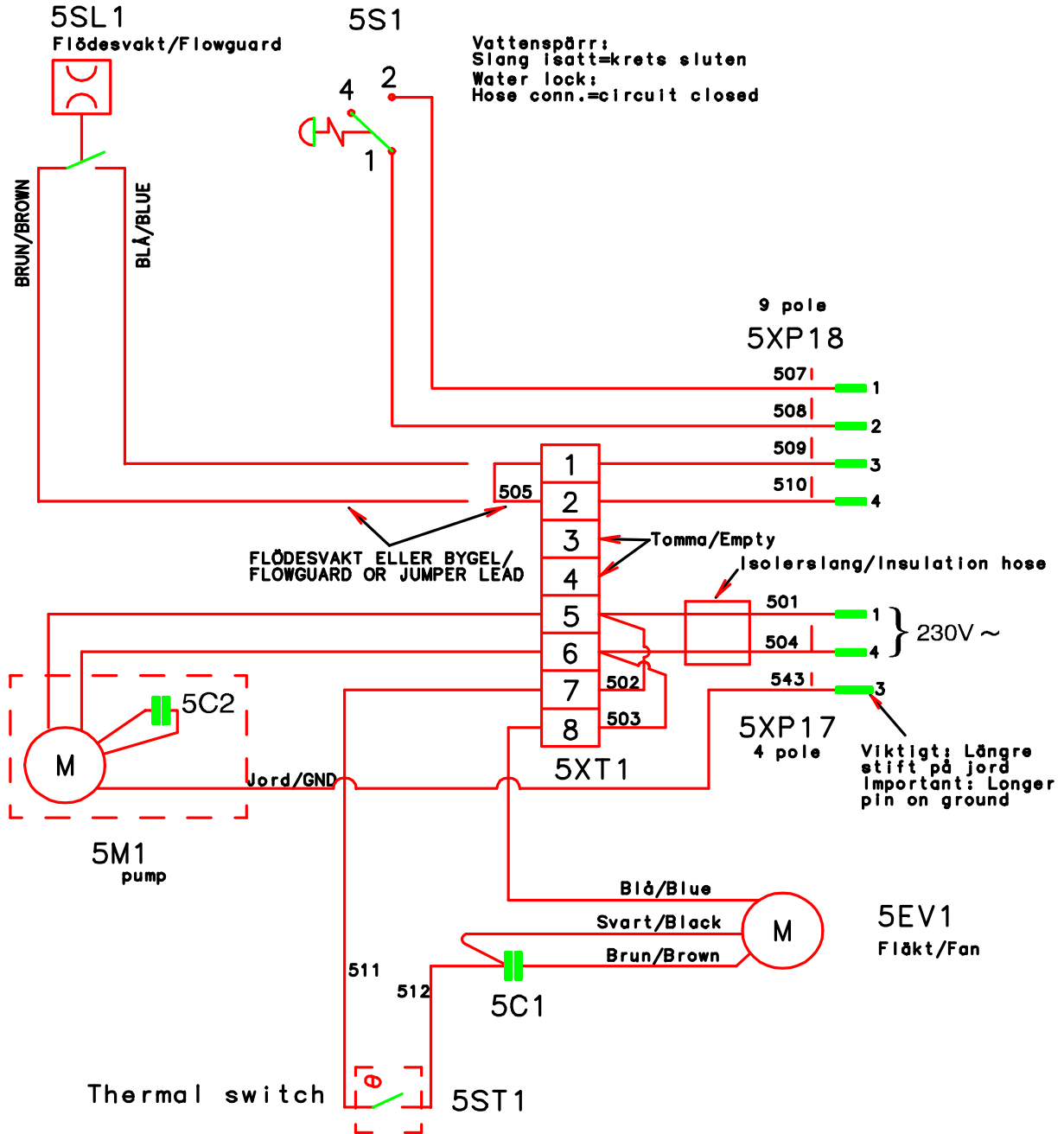


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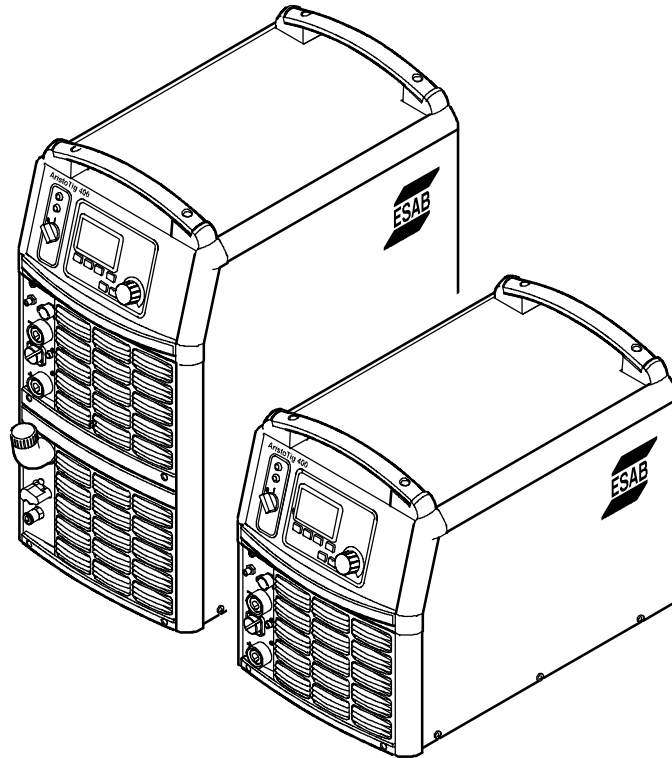
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# Cooling unit



## Tig 4000i

### Ordering number



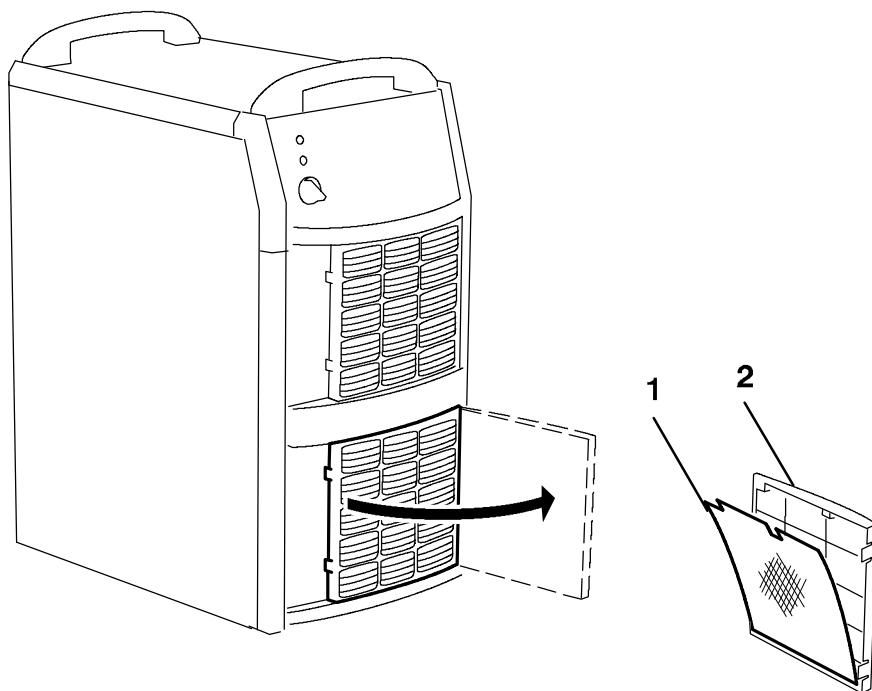
Ordering no.	Denomination	Type	Notes
0458 630 880	Welding power source	Aristo™ Tig 4000i, TA4	with cooling unit
0458 630 881	Welding power source	Aristo™ Tig 4000i, TA4	
0458 630 884	Welding power source	Aristo™ Tig 4000i, TA6	with cooling unit
0458 630 885	Welding power source	Aristo™ Tig 4000i, TA6	
0458 640 990	Spare part list	Aristo™ Tig 4000i	
0458 819 xxx	Instruction manual	Aristo™ TA4	
0458 855 xxx	Instruction manual	Aristo™ TA6	

Instruction manuals and the spare parts list are available on the Internet at [www.esab.com](http://www.esab.com)

## Tig 4000i

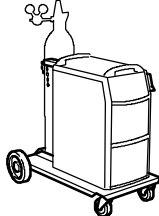
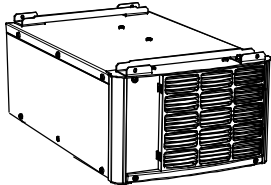





### Spare parts list

Item	Ordering no.	Denomination
1	0458 398 001	Filter
2	0458 383 001	Front grill

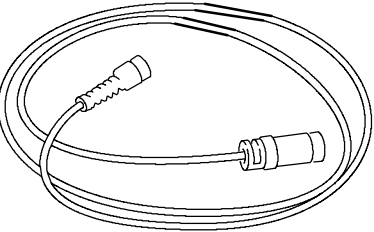

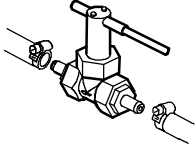
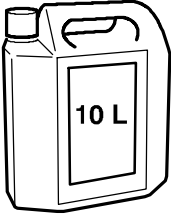


# Tig 4000i

## Accessories

	<p><b>Trolley</b> ..... 0458 530 881</p>
	<p><b>Autotransformer TUA2</b> ..... 0459 145 880</p>
	<p><b>Remote control adapter RA12</b> 12 pole .... 0459 491 910 For analogue remote controls to CAN based equipment.</p>
	<p><b>Remote control unit MTA1 CAN</b> ..... 0459 491 880 MIG/MAG: wire feed speed and voltage MMA: current and arc force TIG: current, pulse and background current</p>
	<p><b>Remote control unit M1 10Prog CAN</b> ..... 0459 491 882 Choice of one of 10 programs MIG/MAG: voltage deviation TIG and MMA: current deviation</p>
	<p><b>Remote control unit AT1 CAN</b> ..... 0459 491 883 MMA and TIG: current</p>
	<p><b>Remote control unit AT1 CF CAN</b> ..... 0459 491 884 MMA and TIG: rough and fine setting of current.</p>

**Tig 4000i**

	<p><b>Remote cable CAN 4 pole - 12 pole</b></p> <p>5 m ..... 0459 544 880</p> <p>10 m ..... 0459 554 881</p> <p>15 m ..... 0459 554 882</p> <p>25 m ..... 0459 554 883</p> <p>0.25 m ..... 0459 554 884</p>
	<p><b>Return cable 5 m 70 mm<sup>2</sup></b> ..... 0700 006 895</p>
	<p><b>Water flow guard 0.7 l/min</b> ..... 0456 855 880</p>
	<p><b>Coolant</b> (Ready mixed) 50% water and 50% mono-ethylene glycol (10 l) ..... 0194 230 002</p>









# ESAB subsidiaries and representative offices

## Europe

### AUSTRIA

ESAB Ges.m.b.H  
Vienna-Liesing  
Tel: +43 1 888 25 11  
Fax: +43 1 888 25 11 85

### BELGIUM

S.A. ESAB N.V.  
Brussels  
Tel: +32 2 745 11 00  
Fax: +32 2 745 11 28

### THE CZECH REPUBLIC

ESAB VAMBERK s.r.o.  
Vamberk  
Tel: +420 2 819 40 885  
Fax: +420 2 819 40 120

### DENMARK

Aktieselskabet ESAB  
Herlev  
Tel: +45 36 30 01 11  
Fax: +45 36 30 40 03

### FINLAND

ESAB Oy  
Helsinki  
Tel: +358 9 547 761  
Fax: +358 9 547 77 71

### FRANCE

ESAB France S.A.  
Cergy Pontoise  
Tel: +33 1 30 75 55 00  
Fax: +33 1 30 75 55 24

### GERMANY

ESAB GmbH  
Solingen  
Tel: +49 212 298 0  
Fax: +49 212 298 218

### GREAT BRITAIN

ESAB Group (UK) Ltd  
Waltham Cross  
Tel: +44 1992 76 85 15  
Fax: +44 1992 71 58 03

ESAB Automation Ltd  
Andover  
Tel: +44 1264 33 22 33  
Fax: +44 1264 33 20 74

### HUNGARY

ESAB Kft  
Budapest  
Tel: +36 1 20 44 182  
Fax: +36 1 20 44 186

### ITALY

ESAB Saldatura S.p.A.  
Mesero (Mi)  
Tel: +39 02 97 96 81  
Fax: +39 02 97 28 91 81

### THE NETHERLANDS

ESAB Nederland B.V.  
Amersfoort  
Tel: +31 33 422 35 55  
Fax: +31 33 422 35 44

## NORWAY

AS ESAB  
Larvik  
Tel: +47 33 12 10 00  
Fax: +47 33 11 52 03

## POLAND

ESAB Sp.zo.o.  
Katowice  
Tel: +48 32 351 11 00  
Fax: +48 32 351 11 20

## PORTUGAL

ESAB Lda  
Lisbon  
Tel: +351 8 310 960  
Fax: +351 1 859 1277

## SLOVAKIA

ESAB Slovakia s.r.o.  
Bratislava  
Tel: +421 7 44 88 24 26  
Fax: +421 7 44 88 87 41

## SPAIN

ESAB Ibérica S.A.  
Alcalá de Henares (MADRID)  
Tel: +34 91 878 3600  
Fax: +34 91 802 3461

## SWEDEN

ESAB Sverige AB  
Gothenburg  
Tel: +46 31 50 95 00  
Fax: +46 31 50 92 22

ESAB international AB  
Gothenburg  
Tel: +46 31 50 90 00  
Fax: +46 31 50 93 60

## SWITZERLAND

ESAB AG  
Dietikon  
Tel: +41 1 741 25 25  
Fax: +41 1 740 30 55

## North and South America

### ARGENTINA

CONARCO  
Buenos Aires  
Tel: +54 11 4 753 4039  
Fax: +54 11 4 753 6313

### BRAZIL

ESAB S.A.  
Contagem-MG  
Tel: +55 31 2191 4333  
Fax: +55 31 2191 4440

### CANADA

ESAB Group Canada Inc.  
Mississauga, Ontario  
Tel: +1 905 670 02 20  
Fax: +1 905 670 48 79

### MEXICO

ESAB Mexico S.A.  
Monterrey  
Tel: +52 8 350 5959  
Fax: +52 8 350 7554

### USA

ESAB Welding & Cutting Products  
Florence, SC  
Tel: +1 843 669 44 11  
Fax: +1 843 664 57 48

## Asia/Pacific

### CHINA

Shanghai ESAB A/P  
Shanghai  
Tel: +86 21 5308 9922  
Fax: +86 21 6566 6622

### INDIA

ESAB India Ltd  
Calcutta  
Tel: +91 33 478 45 17  
Fax: +91 33 468 18 80

### INDONESIA

P.T. ESABindo Pratama  
Jakarta  
Tel: +62 21 460 0188  
Fax: +62 21 461 2929

### JAPAN

ESAB Japan  
Tokyo  
Tel: +81 3 5296 7371  
Fax: +81 3 5296 8080

### MALAYSIA

ESAB (Malaysia) Snd Bhd  
Selangor  
Tel: +60 3 8027 9869  
Fax: +60 3 8027 4754

### SINGAPORE

ESAB Asia/Pacific Pte Ltd  
Singapore  
Tel: +65 6861 43 22  
Fax: +65 6861 31 95

### SOUTH KOREA

ESAB SeAH Corporation  
Kyungnam  
Tel: +82 55 269 8170  
Fax: +82 55 289 8864

### UNITED ARAB EMIRATES

ESAB Middle East FZE  
Dubai  
Tel: +971 4 887 21 11  
Fax: +971 4 887 22 63

## Representative offices

### BULGARIA

ESAB Representative Office  
Sofia  
Tel/Fax: +359 2 974 42 88

### EGYPT

ESAB Egypt  
Dokki-Cairo  
Tel: +20 2 390 96 69  
Fax: +20 2 393 32 13

### ROMANIA

ESAB Representative Office  
Bucharest  
Tel/Fax: +40 1 322 36 74

### RUSSIA

LLC ESAB  
Moscow  
Tel: +7 095 543 9281  
Fax: +7 095 543 9280

### LLC ESAB

St Petersburg  
Tel: +7 812 336 7080  
Fax: +7 812 336 7060

## Distributors

*For addresses and phone numbers to our distributors in other countries, please visit our home page*

[www.esab.com](http://www.esab.com)



ESAB AB  
SE-695 81 LAXÅ  
SWEDEN  
Phone +46 584 81 000



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