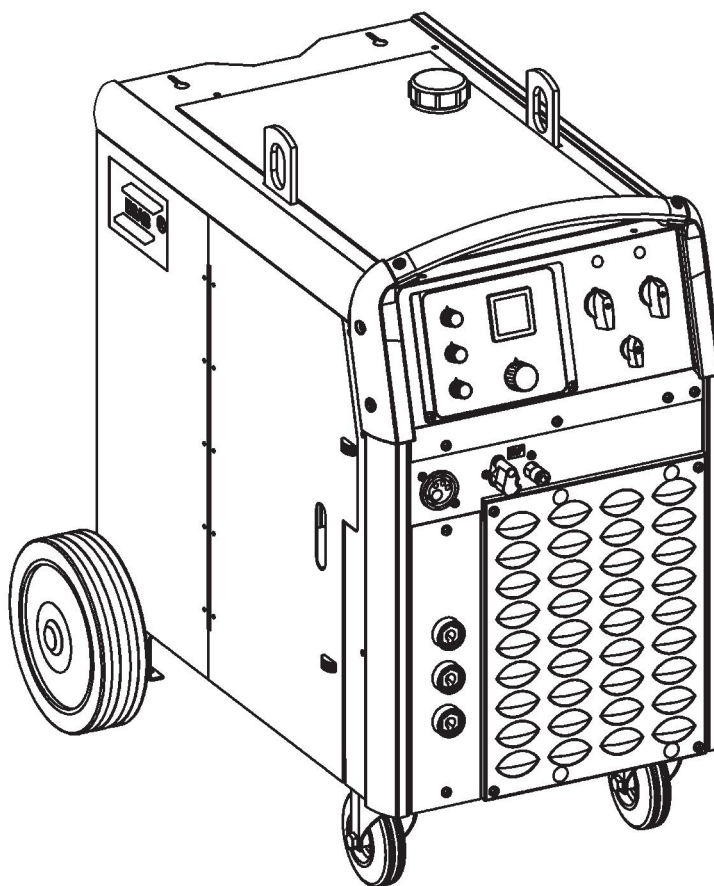


Origo™



Mig C420 PRO



Instruction manual



DECLARATION OF CONFORMITY

In Accordance with

The Low Voltage Directive 2006/95/EC of 12 December 2006, entering into force 16 January 2007

The EMC Directive 2004/108/EC of 15 December 2004, entering into force 20 July 2007

Type of equipment

Welding power sources for MIG/MAG welding

Brand name or trade mark

ESAB

Type designation etc.

Origo™ Mig C420 PRO Valid from serial number 627-xxx-xxxx (2006 w.27), 120-xxx-xxxx (2011 w.20)

Manufacturer or his authorised representative established within the EEA

Name, address, telephone No, telefax No:

OZAS-ESAB Sp. z o.o.

ul.A.Struga 10 , 45-073 Opole , Poland

Phone: +48 77 4019200, Fax: +48 77 4019201

The following harmonised standard in force within the EEA has been used in the design:

EN 60974-1, Arc welding equipment – Part 1: Welding power sources

EN 60974-5, Arc welding equipment – Part 5: Wire feeders

EN 60974-10, Arc welding equipment – Part 10: Electromagnetic compatibility (EMC) requirements

Additional information: Restrictive use, Class A equipment, intended for use in locations other than residential

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.

Place and Date
Opole , 2011-05-31

Signature

A handwritten signature in blue ink, appearing to read "Dariusz Brudkiewicz", is written over a horizontal line.

Dariusz Brudkiewicz
Clarification

Position
Managing Director
OZAS-ESAB Sp. z o.o.

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1 SAFETY

1.1 Meaning of symbols

As used throughout this manual: Means Attention! Be Alert!



DANGER!

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



WARNING!

Means potential hazards which could result in personal injury or loss of life.



CAUTION!

Means hazards which could result in minor personal injury.



WARNING!

Before use, read and understand the instruction manual and follow all labels, employer's safety practices and Safety Data Sheets (SDSs).



1.2 Safety precautions

Users of ESAB 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 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 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 equipment must be familiar with:
 - its operation
 - location of emergency stops
 - its function
 - relevant safety precautions
 - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
 - no unauthorised person is stationed within the working area of the equipment when it is started up
 - no-one is unprotected when the arc is struck or work is started with the equipment
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 and cutting.



ELECTRIC SHOCK - Can kill

- Install and ground the unit in accordance with instruction manual.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from work and ground.
- Ensure your working position is safe



ELECTRIC AND MAGNETIC FIELDS - Can be dangerous to health

- Welders having pacemakers should consult their physician before welding. EMF may interfere with some pacemakers.
- Exposure to EMF may have other health effects which are unknown.
- Welders should use the following procedures to minimize exposure to EMF:
 - Route the electrode and work cables together on the same side of your body. Secure them with tape when possible. Do not place your body between the torch and work cables. Never coil the torch or work cable around your body. Keep welding power source and cables as far away from your body as possible.
 - Connect the work cable to the workpiece as close as possible to the area being welded.



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.



NOISE - Excessive noise can damage hearing

Protect your ears. Use earmuffs or other hearing protection.

MOVING PARTS - Can cause injuries

- Keep all doors, panels and covers closed and securely in place. Have only qualified people remove covers for maintenance and troubleshooting as necessary. Reinstall panels or covers and close doors when service is finished and before starting engine.



- Stop engine before installing or connecting unit.
- Keep hands, hair, loose clothing and tools away from moving parts.

FIRE HAZARD

- Sparks (spatter) can cause fire. Make sure that there are no inflammable materials nearby.
- Do not use on closed containers.

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

PROTECT YOURSELF AND OTHERS!**CAUTION!**

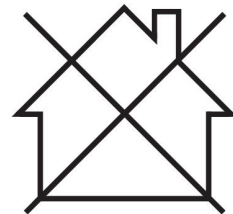
This product is solely intended for arc welding.

**WARNING!**

Do not use the power source for thawing frozen pipes.

**CAUTION!**

Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility of class A equipment in those locations, due to conducted as well as radiated disturbances.

**NOTE!****Dispose of electronic equipment at the recycling facility!**

In observance of European Directive 2012/19/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

As the person responsible for the equipment, it is your responsibility to obtain information on approved collection stations.

For further information contact the nearest ESAB dealer.



ESAB has an assortment of welding accessories and personal protection equipment for purchase. For ordering information contact your local ESAB dealer or visit us on our website.

2 INTRODUCTION

The **Mig C420 PRO** is a step-controlled compact welding power source incorporating wire feed mechanism intended for MIG/MAG welding with solid wires of steel, stainless steel or aluminium, and cored wires with or without shielding gas.

The Mig C420w PRO is equipped with a cooling liquid system for welding torches. The Mig C420 PRO is not equipped with a cooling system and can operate only with appropriate gas cooled torches.

The power units are fan-cooled and equipped with thermal overload protection.

The power sources can be fitted with a flow guard (Mig C420w PRO).

The power source comes in different variants, see "ORDERING NUMBERS" chapter.

ESAB accessories for the product can be found in the "ACCESSORIES" chapter of this manual.

2.1 Equipment

The power source is supplied with:

- Welding torch PSF 405/410w - 4.5 m
- Return cable 5 m with return clamp
- Shelf for gas cylinder
- Instruction manual

3 TECHNICAL DATA

Mig C420 PRO	
Voltage	400 - 415 V, 3~ 50 Hz
Permissible load	
at 100% duty cycle	315 A/30 V
at 60% duty cycle	400 A/34 V
at 50% duty cycle	420 A/35 V
Setting range (DC)	50 A/16.5 V - 420 A/35 V
Open circuit voltage	14 - 47 V
Open circuit power	520 W
with cooling unit	730 W
Efficiency	77%
Power factor	0.92
Control voltage	42 V, 50/60 Hz
Wire feed speed	1.9 - 25.0 m/min
Burnback time	0 - 0.5 s
Creep start	OFF / ON
2/4 stroke	2 / 4
Welding torch connection	EURO
Max diameter of wire bobbin	300 mm
Wire dimension range	0.6 - 1.6 mm
Dimensions LxWxH	935 x 640 x 800 mm
Weight	215 kg
with cooling unit	230 kg
Operating temperature	-10 to +40 °C
Transportation temperature	-20 to +55 °C
Enclosure class	IP 23
Application class	S
Cooling unit (100 % duty cycle)	
P _{1l} /min	1200 W at 25 °C
p _{max}	3.5 bar
Coolant	ESAB's ready mixed coolant
Coolant quantity	5.5 l

Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld or cut at a certain load without overloading. The duty cycle is valid for 40 °C / 104 °F, or below.

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 intended for indoor and outdoor use.

Application class

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

4 INSTALLATION

The installation must be carried out by a professional.

**NOTE!**

Connect the power source to the electricity mains with a network impedance of 0.268 W or lower. If the network impedance is higher, there is a risk of flicker in the illuminators.

**CAUTION!**

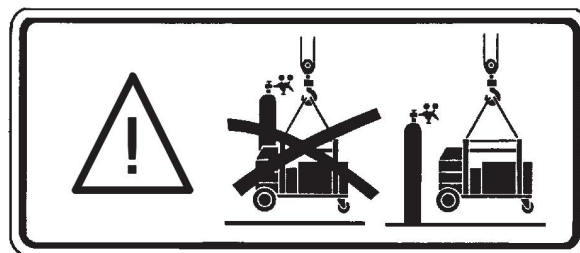
This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.

4.1 Location

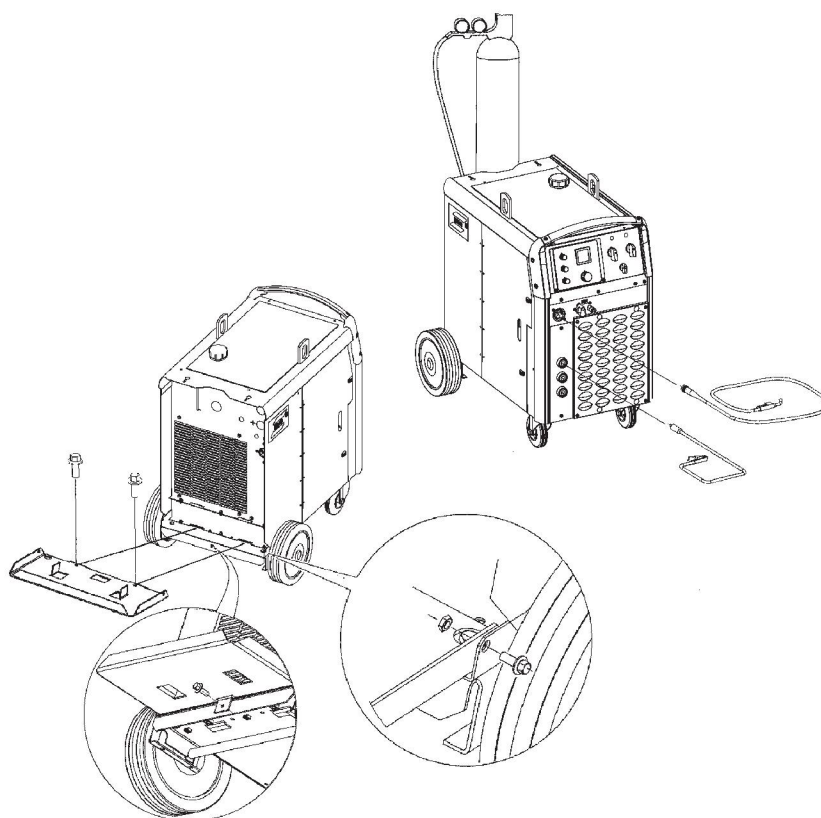
Position the welding power in source such a way that its cooling air inlets and outlets are not obstructed.

**WARNING!**

Straps must be used when lifting the power source. The handle is only intended for pulling it.



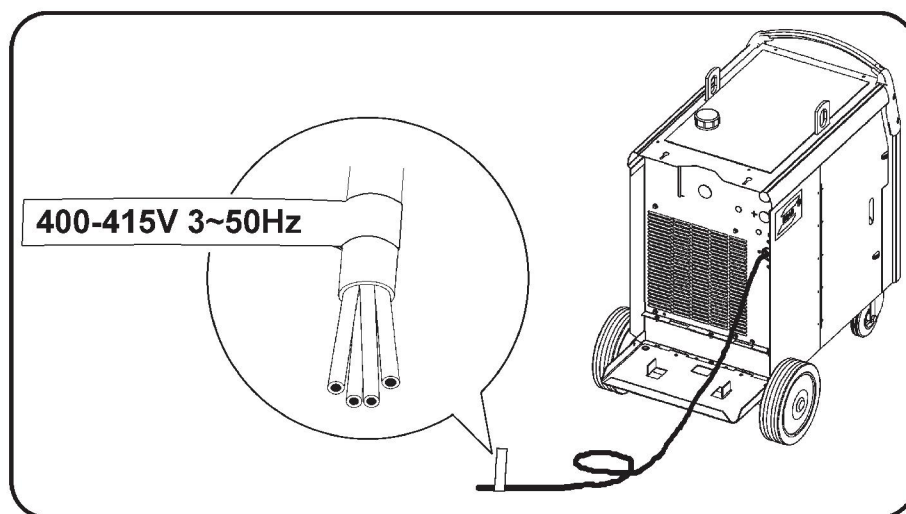
4.2 Assembly of components



**WARNING!**

During transport, the rear wheels of the power source are in their forward position. Before use, place the wheels in their rear position.

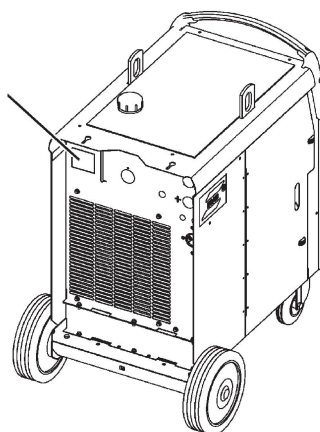
4.3 Electrical installation



4.4 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 size. A protective earth connection must be made, in accordance with regulations.

Rating plate with supply connection data



Recommended fuse sizes and minimum cable areas

Mig C420 PRO	3~ 50 Hz
Voltage V	400 - 415
Current A	
at 100% duty cycle	19
at 60% duty cycle	27
at 50% duty cycle	30
Cable area mm²	4 x 4
Fuse, slow A	25



NOTE!

The mains cable areas and fuse sizes as shown above are in accordance with Swedish regulations. For other regions, supply cables must be suitable for the application and meet local and national regulations.

5 OPERATION

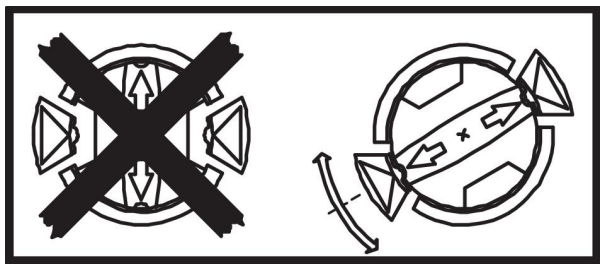
General safety regulations for handling the equipment can be found in the "SAFETY" chapter of this manual. Read it through before you start using the equipment!

**WARNING!**

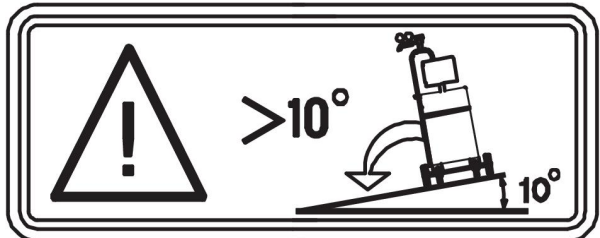
Rotating parts can cause injury, take great care.

**WARNING!**

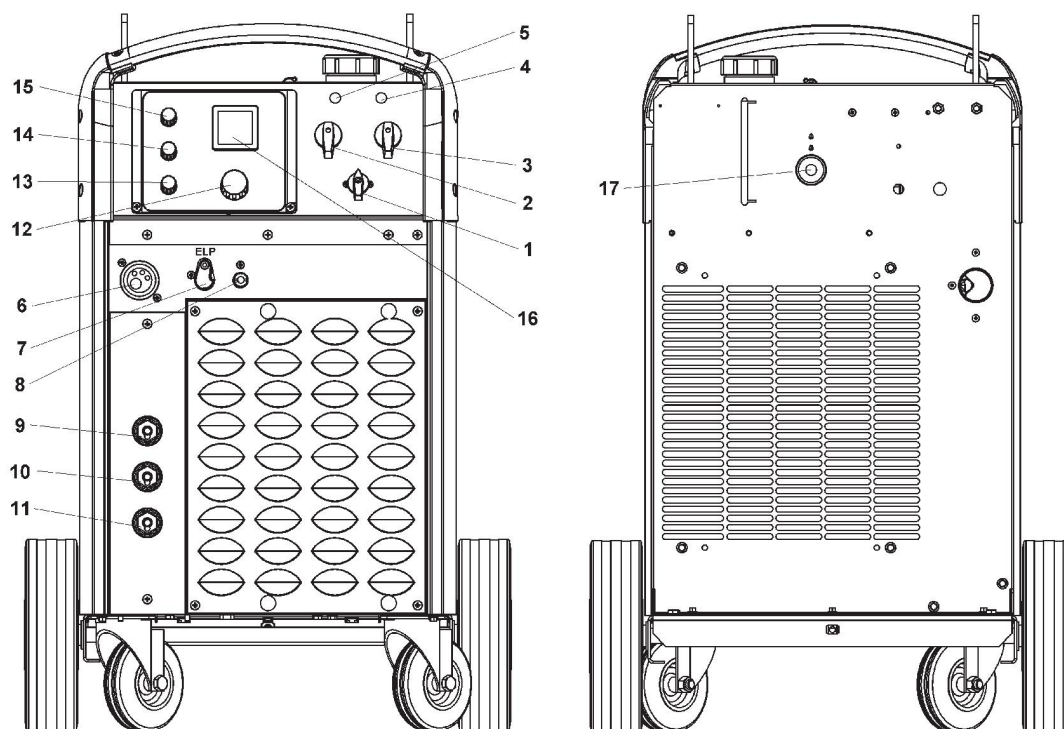
To prevent the reel from sliding off the hub: Lock the reel in place by turning the red knob as shown on the warning label attached next to the hub.

**WARNING!**

Secure the equipment - particularly if the ground is uneven or sloping.



5.1 Connection and control devices



- | | |
|---|--|
| 1. Mains supply switch | 10. Connection for return cable (-), medium inductance |
| 2. Switch, coarse control | 11. Connection for return cable (-), low inductance |
| 3. Switch, precise control | 12. Knob for wire speed setting |
| 4. Indicator lamp, power supply ON | 13. Knob for selecting 2/4-stroke control mode |
| 5. Orange indicating lamp, overheating and loss of coolant* | 14. Knob for selecting - creep start - ON/OFF |
| 6. EURO - connector (for welding torch) | 15. Knob for burn-back time setting |
| 7. Connection for cooling water to the welding torch (Blue - with ELP** switch) | 16. Digital instrument - V / A |
| 8. Connection for cooling water from the welding torch (Red) | 17. Water flow guard (option, see "ACCESSORIES" chapter) |
| 9. Connection for return cable (-), high inductance | |

* Indicating loss of coolant, only when water flow guard is used, see "Water flow guard" section.

** ELP = ESAB Logic Pump, see "Water connection" section.

5.2 Start

When switched on, indicator lamps [4,5] are on for 2 seconds. Normally, if the power source is not overheated, it should start to work in idle mode, which is indicated by blinking of the supply ON lamp. The fan and the coolant pump are stopped. The fan starts at the first start of welding. The coolant pump starts at the same moment, if it is switched on with ELP switch on the water outlet [7].

5.3 Overheating protection

The power source has 2-step control of fan speed and overheating protection. If temperature crosses the threshold point, the fan starts to run with increased speed. If the internal

temperature becomes too high, the welding is interrupted and disabled. This state is indicated by permanent lighting of the orange indicating lamp on the front of the unit. It resets automatically when the temperature falls down.

5.4 Water connection

The Mig C420w PRO has a sensor ELP, ESAB Logic Pump, which senses whether the water hoses of the welding torch are connected. When a water-cooled welding torch is connected, the water pump is active.

It is recommended to switch the power source off by means of the mains switch ON/OFF [1] for connecting the cooling water hoses to/from the Mig C420w PRO.

5.5 Water flow guard

The power sources with cooling unit (Mig C420w PRO) can be fitted with a water flow guard (option - see "ACCESSORIES" chapter).

The water flow guard interrupts and disables welding in event of loss of coolant. This state is indicated by the orange indicating lamp on the front of the power source flashing. If there is a lack of coolant flow, after 1 min the pump is switched off and locked in this state. The pump restarts from that state along with start of welding.

5.6 Idle mode

The power source has an idle mode. The fan is switched off 5 min after the end of the last welding, or after 5 min of work with decreased speed without welding. The pump is switched off 3 min after the last welding. When both fan and pump are switched off the power supply lamp [4] on the front panel flashes.

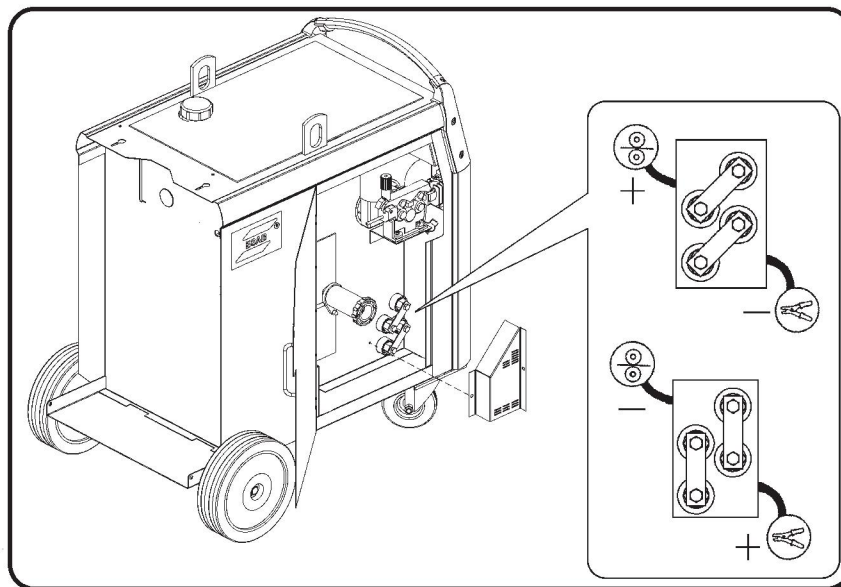
5.7 Mig C420w PRO / Mig C420 PRO

The Mig C420w PRO / Mig C420 PRO is equipped with a standard control unit. The welder can manually select and adjust all welding parameters.

- Wire speed (1.9 - 25 m/min) is set with knob [12].
- The stroke control (2/4 stroke) is selected with switch [13].
- Creep start i.e. start with 50% wire speed is toggled ON/OFF with switch [14].
- Burn back time is set with knob [15].

Mig C420w PRO / Mig C420 PRO can be fitted with a digital instrument that displays current and voltage. It incorporates a hold function (see "ACCESSORIES" chapter).

5.8 Polarity change



The power source is delivered with the welding wire connected to the plus pole. Some wires, e.g. self shielded cored wires, are recommended for welding with negative polarity. Negative polarity means that the wire is connected to the minus pole and the return cable to the plus pole.

Check the recommended polarity for the welding wire you want to use.

5.9 Wire feed pressure

Start by making sure that the wire moves smoothly through the wire guide. Then set the pressure of the wire feeder's pressure rollers. It is important that the pressure is not too great.

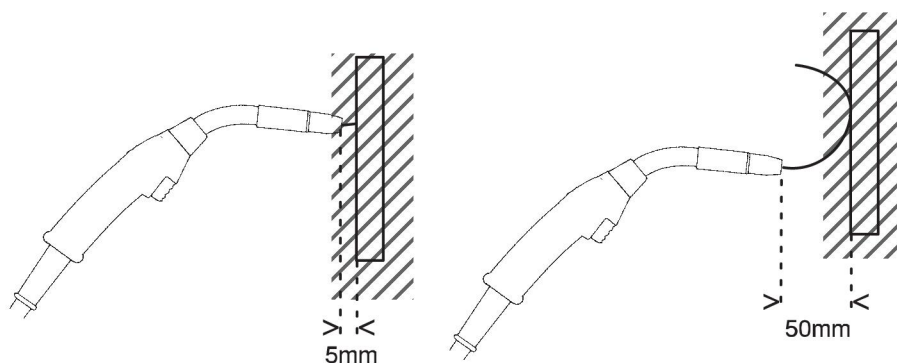


Fig 1

Fig 2

To check that the feed pressure is set correctly, you can feed out the wire against an insulated object, e.g. a piece of wood.

When you hold the torch approx. 5 mm from the piece of wood (fig. 1) the feed rollers should slip.

If you hold the torch approx. 50 mm from the piece of wood, the wire should be fed out and bend (fig. 2).

5.10 Replacing and inserting wire

- Open the side panel.
- Disconnect the pressure sensor by folding it backwards, the pressure rollers slide up.

- Straighten out 10-20 cm of new wire. File off any burrs and sharp edges from the end of the wire before inserting it into the wire feed unit.
- Make sure that the wire goes properly into the feed roller track and into the outlet nozzle and the wire guide.
- Secure the pressure sensor.
- Close the side panel.

6 MAINTENANCE



NOTE!

Regular maintenance is important for safe and reliable operation.



CAUTION!

Only those persons who have appropriate electrical knowledge (authorized personnel) may remove the safety plates.



CAUTION!

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

6.1 Inspection and cleaning

Power source

Check regularly that the power source is free from dirt.

The power source should be regularly blown clean using dry compressed air at reduced pressure, see "CLEANING" chapter. This should be done more frequently in dirty environments.

Otherwise the air inlet/outlet may become blocked and cause overheating. To avoid this you can use an airfilter.

The airfilter is an accessory. Order number can be found in the "ACCESSORIES" chapter.

Welding torch

The welding torch's wear parts should be cleaned and replaced at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean regularly and clean the contact tip.

The brake hub

The hub is adjusted when delivered, if readjustment is required, follow the instructions below. Adjust the brake hub so that wire is slightly slack when wire feed stops.

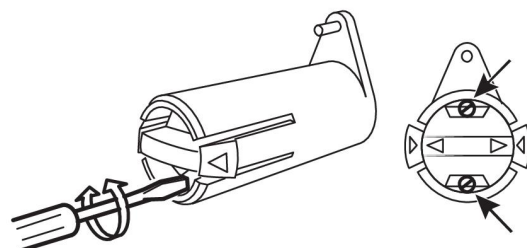
- **Adjusting the braking torque:**

- Turn the red handle to the locked position.
- Insert a screwdriver into the springs in the hub.

Turn the springs clockwise to reduce the braking torque.

Turn the springs counter-clockwise to increase the braking torque.

Note: Make sure you turn both springs the same amount.



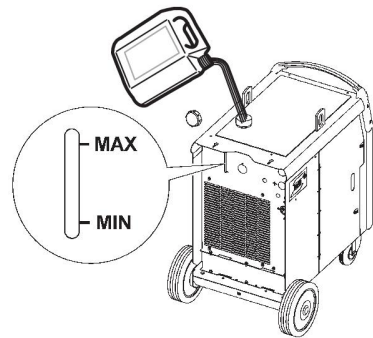
6.2 Topping up the coolant

ESAB's ready mixed coolant is recommended for use.

See accessories in the "ACCESSORIES" chapter.

**NOTE!**

Coolant must be topped up if connecting a Push-Pull welding torch that is 6 meters in length or longer. When adjusting the water level by topping up, the coolant hose does not need to be disconnected.

**CAUTION!**

The coolant must be handled as chemical waste.

7 TROUBLESHOOTING

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

Type of fault	Actions
No arc	• Check that the mains power supply switch is turned on. • Check that the welding current supply and return cables are correctly connected. • Check that correct current value is set.
Welding current is interrupted during welding	• Check whether the thermal overload trip has operated (indicated by the orange lamp on the front). • Check the main power supply fuses.
Thermal overload trips operate frequently	• Check to see whether the air filters are clogged. • Make sure that you are not exceeding the rated data for the power source (i.e. that the unit is not being overloaded).
Poor welding performance	• Check that the welding current supply and return cables are correctly connected. • Check that the correct current value is set. • Check that the correct welding wires are being used. • Check the main power supply fuses. • Check the wire feed unit - that proper rolls are applied and properly set the pressure of the wire feeder's pressure rollers.

8 ORDERING SPARE PARTS



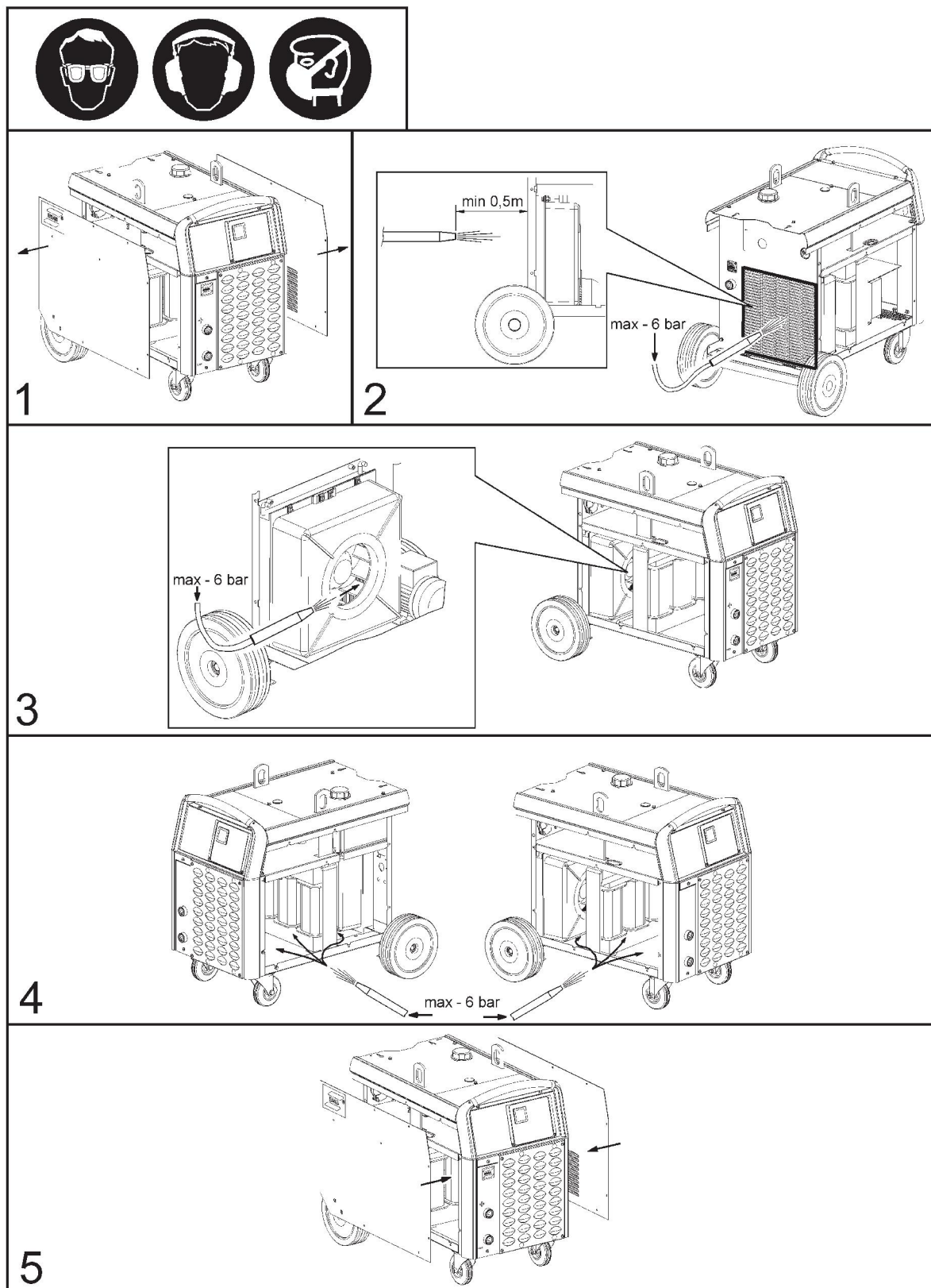
CAUTION!

Repair and electrical work should be performed by an authorised ESAB service technician. Use only ESAB original spare and wear parts.

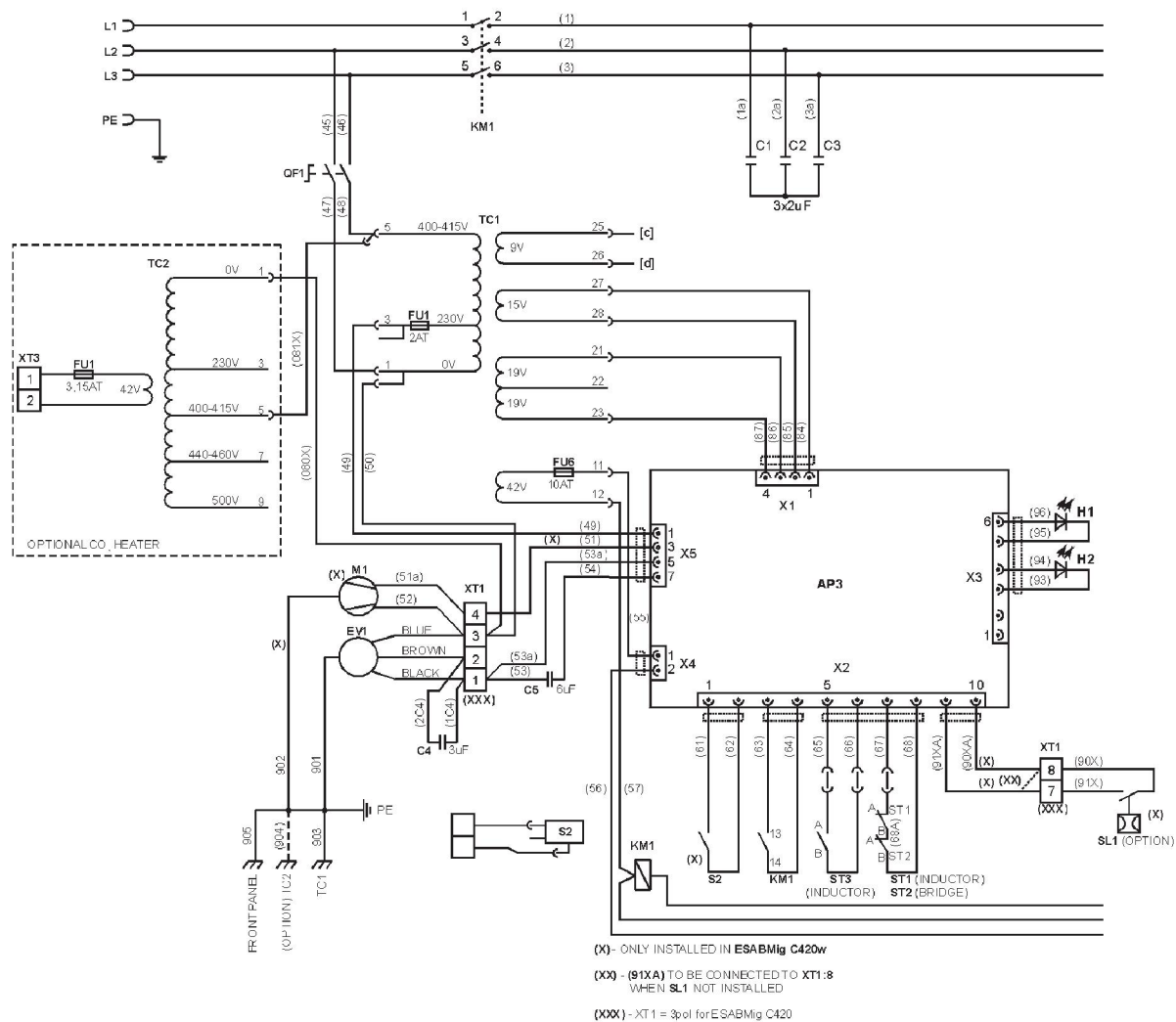
Mig C420 PRO is designed and tested in accordance with the international and European standards EN 60974-1, EN 60974-5 and EN 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see the back cover of this document. When ordering, please state product type, serial number, designation and spare part number in accordance with the spare parts list. This facilitates dispatch and ensures correct delivery.

CLEANING



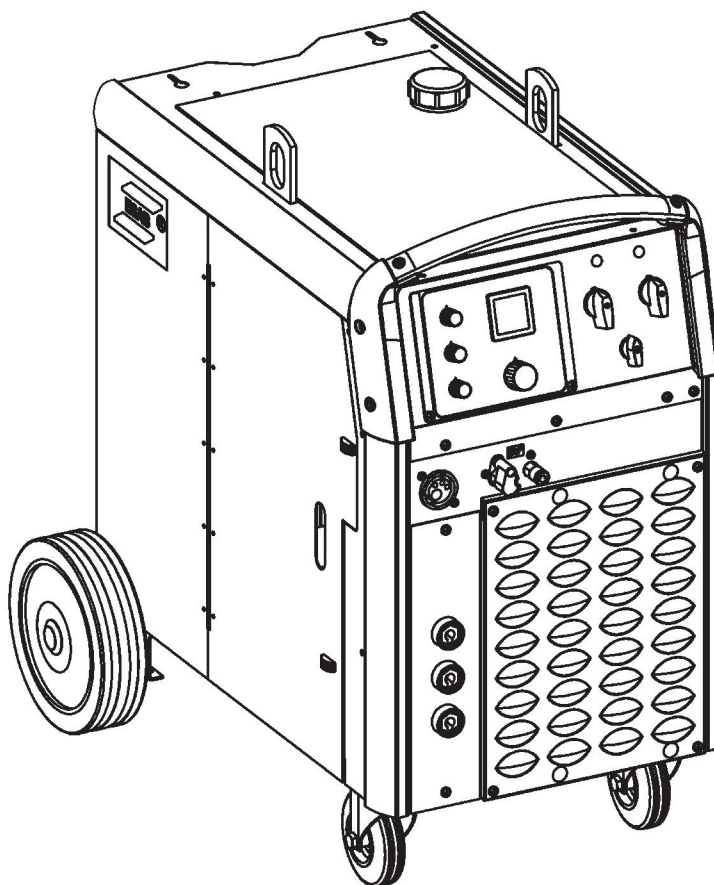
DIAGRAM



QF3	1-2	3-4	5-6	7-8	9-10	11-12	13-14	15-16	17-18	19-20	21-22	23-24	25-26	27-28
1	●	●												
2			●	●										
3					●	●								
4							●	●						
5								●	●					
6									●	●				
7										●	●			

QF2	1-2	3-4	5-6	7-8	9-10	11-12	13-14	15-16	17-18	19-20	21-22	23-24	25-26	27-28	29-30
1	●	●	●												
2				●	●										
3						●	●								
4								●	●						
5									●	●					

ORDERING NUMBERS



Ordering no.	Type	Notes
0349 312 580	Origo™ Mig C420 PRO	400–415V 3~ 50Hz, with digital instrument
0349 312 590	Origo™ Mig C420w PRO	400–415V 3~ 50Hz; with water cooler and digital instrument
0349 300 538	Origo™ Mig C420 PRO	Spare parts list

Technical documentation is available on the Internet at: www.esab.com

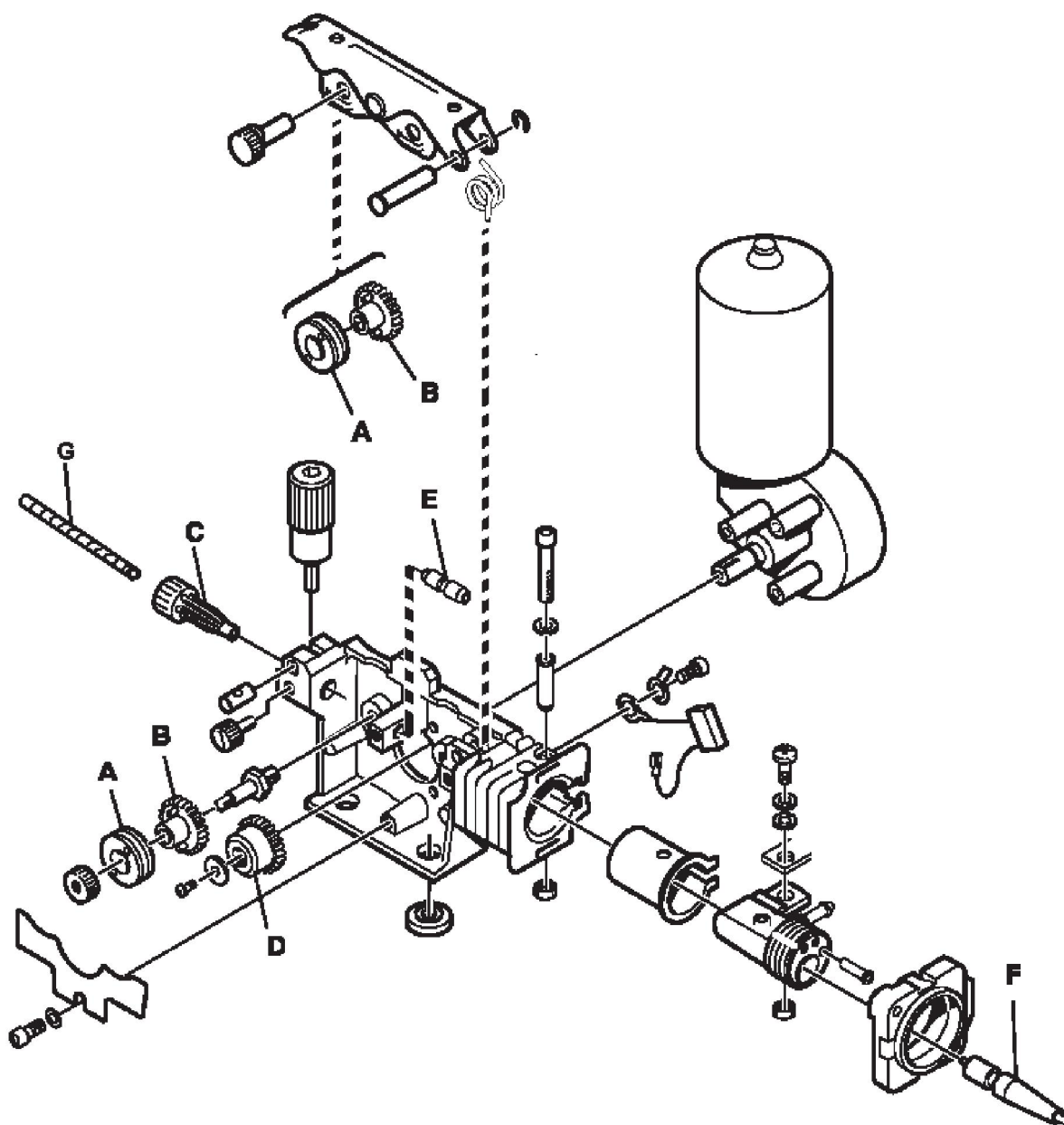
WEAR PARTS

Item	Denomination	Ordering no.	Notes
A	Feed / pressure roller	0459 052 001	Ø 0.6 & 0.8 mm; Fe, Ss & cored wire; V-groove
		0459 052 002	Ø 0.8 & 1.0 mm; Fe, Ss & cored wire; V-groove
		0459 052 003	Ø 0.9/1.0 & 1.2 mm; Fe, Ss & cored wire; V-groove
		0459 052 013	Ø 1.4 & 1.6 mm; Fe, Ss & cored wire; V-groove
		0458 825 001	Ø 0.9/1.0 & 1.2 mm; Cored wire; V-groove; knurled
		0458 825 002	Ø 1.2 & 1.4 mm; Cored wire; V-groove; knurled
		0458 825 003	Ø 1.6 & 2.0 mm; Cored wire; V-groove; knurled
		0458 824 001	Ø 0.8 & 0.9/1.0 mm; Al wire; U-groove
		0458 824 003	Ø 1.2 & 1.6 mm; Al wire; U-groove
B	Gear adapter	0459 441 880	Replacing 0455 053 880
C	Inlet nozzle	0455 049 001	
D	Drive gear	0459 440 001	Replacing 0455 052 001
E	Intermediate nozzle	0455 072 002	Fe, Ss & cored wire
		0456 615 001	Al wire
F	Outlet nozzle	0469 837 880	Ø 2.0 mm steel for 0.6-1.6 mm Fe, Ss & cored wire
		0469 837 881	Ø 2.0 mm plastic for 0.8-1.6 mm Al wire
G	Liner	0349 303 018	Fe, Ss & cored wire
		0455 894 001	Al wire

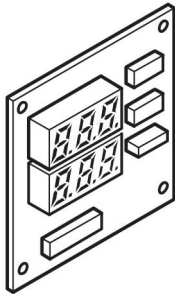
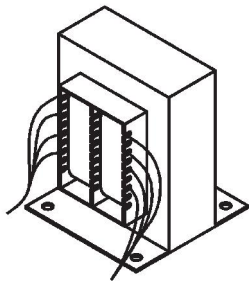
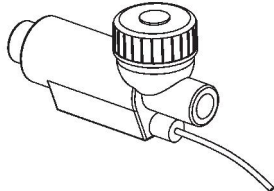
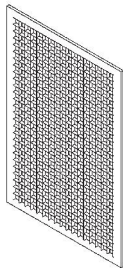
The rollers are marked with wire dimension in mm, some are also marked with inch.

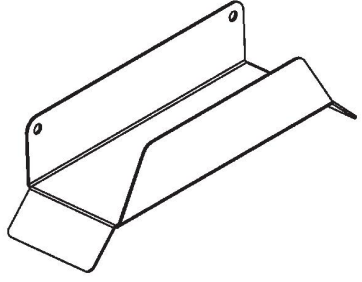
Welding with aluminium wires

In order to weld with aluminium wires, proper rollers, nozzles and liners for aluminium wires MUST be used. It is recommended to use 3 m long welding torch for aluminium wires, equipped with appropriate wear parts.



ACCESSORIES

0349 302 451	Digital meter	
0349 302 250	Transformer kit for CO₂ heater	
0349 302 251	Water flow guard	
0465 720 002	ESAB ready mixed coolant (10 l / 2.64 gal) Use of any other cooling liquid than the prescribed one might damage the equipment. In case of such damage, all warranty undertakings from ESAB cease to apply.	
0349 302 252	Filter	

0349 303 362	Cable holder	
0349 308 337	Push-Pull connection kit	
0700 200 015 0700 200 016	Push-Pull welding torches: MXH 400w PP - 6.0 m MXH 400w PP - 10.0 m	

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.
Heist-op-den-Berg
Tel: +32 15 25 79 30
Fax: +32 15 25 79 44

BULGARIA

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

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

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

FRANCE

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

GERMANY

ESAB Welding & Cutting GmbH
Langenfeld
Tel: +49 2173 3945-0
Fax: +49 2173 3945-218

HUNGARY

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

ITALY

ESAB Saldatura S.p.A.
Bareggio (Mi)
Tel: +39 02 97 96 8.1
Fax: +39 02 97 96 87 01

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. z o.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

ROMANIA

ESAB Romania Trading SRL
Bucharest
Tel: +40 316 900 600
Fax: +40 316 900 601

RUSSIA

LLC ESAB
Moscow
Tel: +7 (495) 663 20 08
Fax: +7 (495) 663 20 09

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.
San Fernando 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 Europe GmbH
Baar
Tel: +41 1 741 25 25
Fax: +41 1 740 30 55

UKRAINE

ESAB Ukraine LLC
Kiev
Tel: +38 (044) 501 23 24
Fax: +38 (044) 575 21 88

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 0220
Fax: +1 905 670 4879

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 4411
Fax: +1 843 664 5748

Asia/Pacific

AUSTRALIA

ESAB South Pacific
Archerfield BC QLD 4108
Tel: +61 1300 372 228
Fax: +61 7 3711 2328

CHINA

Shanghai ESAB A/P
Shanghai
Tel: +86 21 2326 3000
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 45 670 7073
Fax: +81 45 670 7001

MALAYSIA

ESAB (Malaysia) Snd Bhd
USJ
Tel: +603 8023 7835
Fax: +603 8023 0225

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

Africa

EGYPT

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

SOUTH AFRICA

ESAB Africa Welding & Cutting
Ltd
Durbanvill 7570 - Cape Town
Tel: +27 (0)21 975 8924

Distributors

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

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