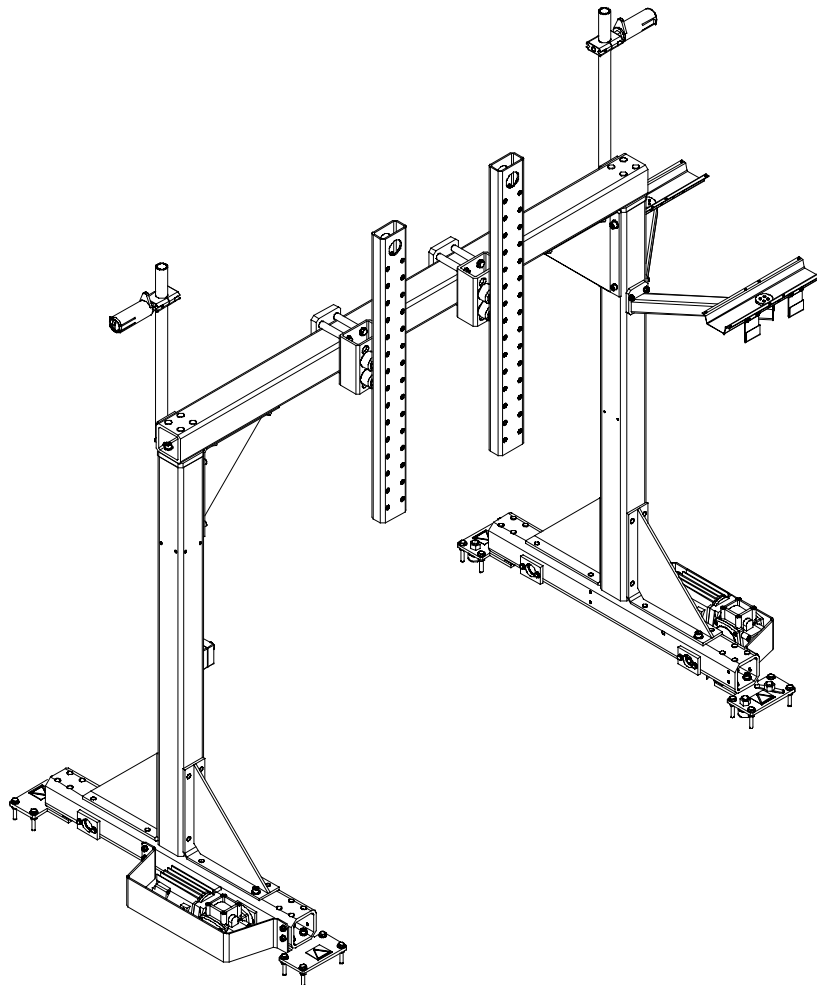




# ***MechTrac 1730/ 2100/ 2500/ 3000***



**Instruction manual**

ENGLISH ..... 4

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## DECLARATION OF CONFORMITY

according to the Machinery Directive 2006/42/EC, according to the EMC Directive 2004/108/EC

## FÖRSÄKRAN OM ÖVERENSSTÄMMELSE

enligt Maskindirektivet 2006/42/EG, enligt EMC-Direktivet 2004/108/EG

**Type of equipment** Materialslag

Welding Automat

**Brand name or trade mark** Fabrikatnamn eller varumärke

ESAB

**Type designation etc.** Typbeteckning etc.

MechTrac 1730/2100/2500/3000, from Serial number 644 (2006 week 44)

**Manufacturer or his authorised representative established within the EEA**

**Name, address, telephone No, telefax No:** Tillverkarens namn, adress, telefon, telefax:

ESAB AB, Welding Equipment

Esabvägen, SE-695 81 LAXÅ, Sweden

Phone: +46 584 81 000, Fax: +46 584 411 924

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

Följande harmoniserande standarder har använts i konstruktionen:

EN 60204-1, Safety of machinery – Electrical equipment of machines – Part 1: General requirements

EN 12100-1, Safety of machinery – Part 1: Basic terminology, methodology

EN 12100-2, Safety of machinery – Part 2: Technical principles

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

**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.**

Genom att underteckna detta dokument försäkras undertecknad såsom tillverkare, eller tillverkarens representant inom EES, att angiven materiel uppfyller säkerhetskraven angivna ovan.

Date / Datum  
Laxå 2010-02-05

Signature / Underskrift

Kent Eimbrodt

Clarification

Position / Befattning  
Global Director  
Equipment and Automation

<b>1 SAFETY</b> .....	<b>5</b>
1.1 General .....	5
1.2 Markings on the equipment .....	7
<b>2 INTRODUCTION</b> .....	<b>8</b>
2.1 General .....	8
2.2 Technical data .....	8
<b>3 INSTALLATION</b> .....	<b>9</b>
3.1 General .....	9
3.2 Assembly/ Disassembly .....	9
3.3 External emergency stop .....	10
3.4 Emergency stop circuit .....	10
<b>4 OPERATION AND MAINTENANCE</b> .....	<b>11</b>
4.1 General .....	11
4.2 Emergency Stop .....	12
<b>5 ACCESSORIES</b> .....	<b>13</b>
5.1 A2 GMAW (Gas Metal Arc Welding) .....	13
5.2 A2 SAW (Submerged Arc Welding) .....	13
<b>6 ORDERING OF SPARE PARTS</b> .....	<b>13</b>
<b>DIMENSION DRAWING</b> .....	<b>14</b>
<b>DIAGRAM</b> .....	<b>16</b>
<b>SPARE PARTS LIST</b> .....	<b>21</b>

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# 1 SAFETY

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## 1.1 General

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 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
3. The workplace must:
  - be suitable for the purpose
  - be free from draughts
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.**

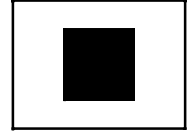
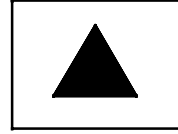
**READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.**

**PROTECT YOURSELF AND OTHERS!**

## 1.2 Markings on the equipment

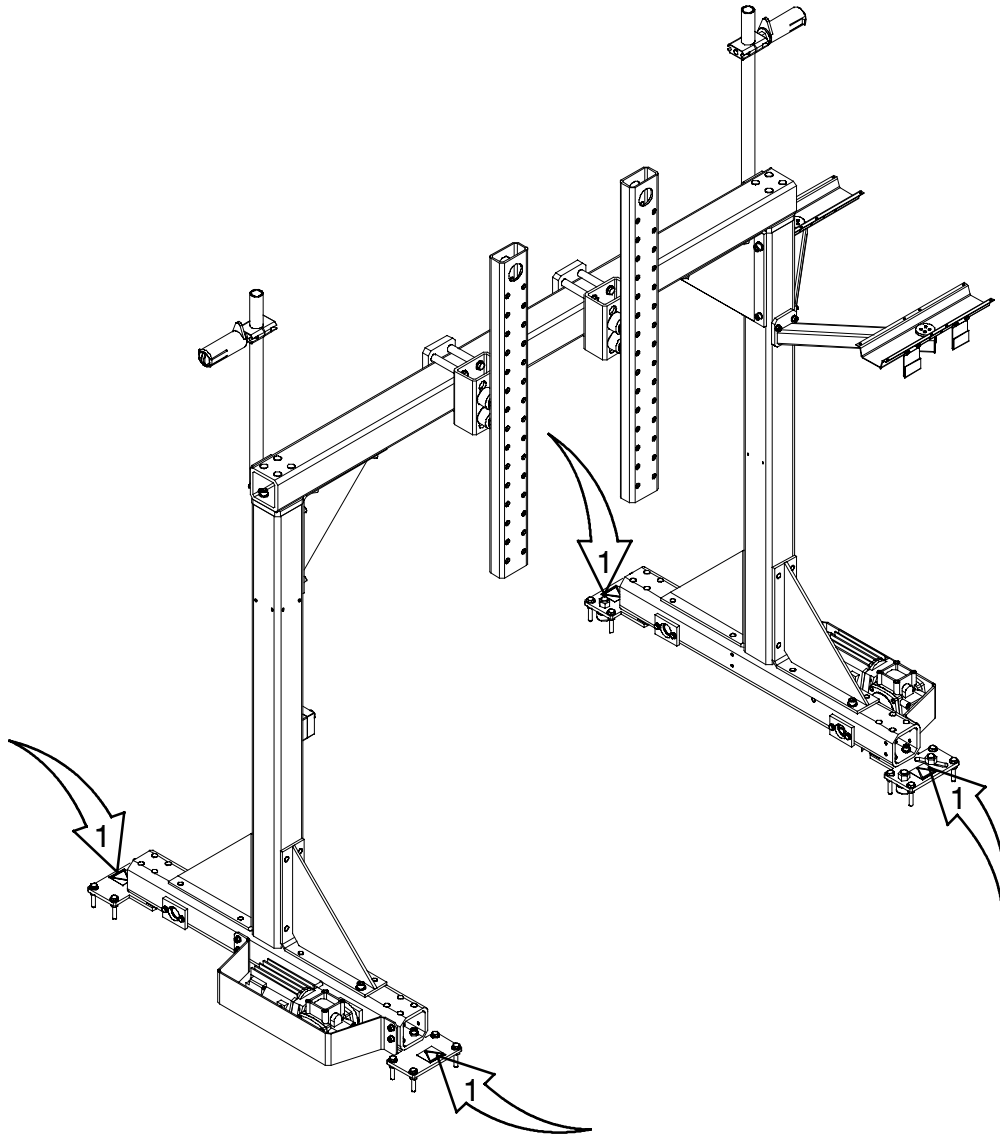
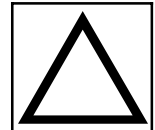
### Travel motion

These markings are placed on the gantry. Indicate the travel direction.



### Risk of getting pinched

This marking is placed on the support (1) of the gantry.



---

## **2 INTRODUCTION**

---

### **2.1 General**

MechTrac is a motor driven gantry for use together with ESAB's A2 welding equipment and power sources (LAF/TAF).

The control of the travel motor takes place over the PEK control unit where the desired speed can be set.

For more information regarding the PEK see instruction manual 0460 948 xxx, 0460 949 xxx, 0459 839 036.

### **2.2 Technical data**

<b>Travel speed :</b>	0.2 - 2.0 m/min
<b>Maximum load :</b>	220 kg
<b>Standard rail length :</b>	3 m

Equivalent continuous A-weighted noise pressure is below 70 dB (A).



## **3 INSTALLATION**

### **3.1 General**

***The installation must be executed by a professional.***

Read the separate instruction manuals supplied with the different modules that are to be fitted on the gantry.

For installation of :

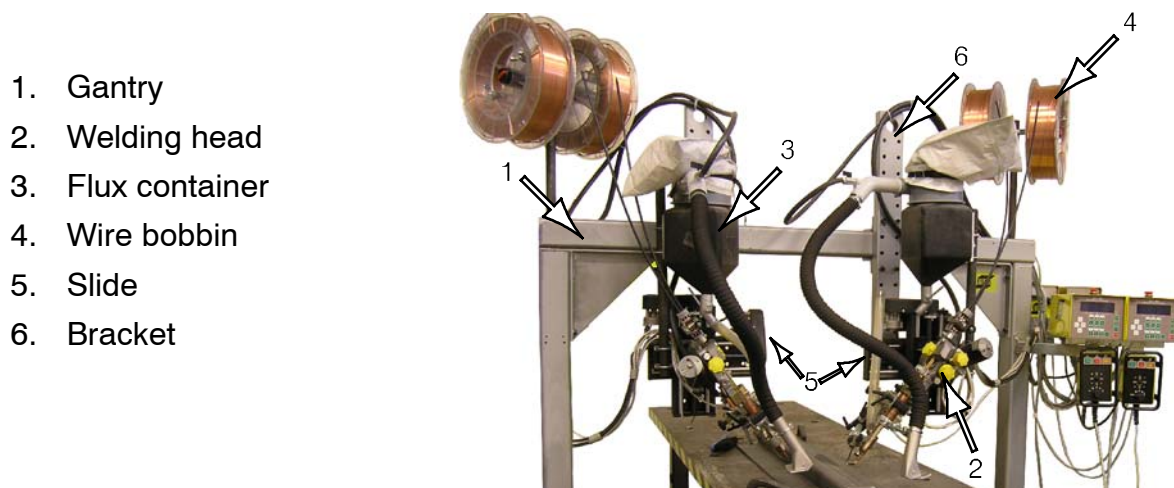
- welding head A2SFE1/ A2 SGE1 see instruction manual 0456 552 xxx
- welding head A2SF J1/ A2SF J1 Twin/ A2SG J1/ A2SG J1 4WD see instruction manual 0449 175 xxx
- welding power source LAF 631 see instruction manual 0449 501 xxx
- welding power source LAF 1001/ 1000M see instruction manual 0449 503 xxx
- welding power source TAF 801 see instruction manual 0449 509 xxx

#### **Voltage supply**

- Disconnect the voltage supply before starting the installation!

### **3.2 Assembly/ Disassembly**

The picture below shows an example of how to attach an A2 welding head, flux container, wire bobbin and slide to the gantry.



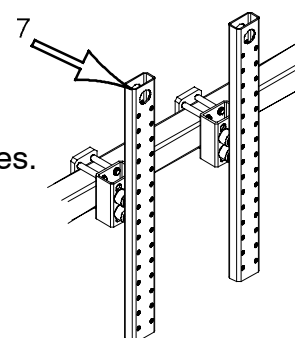
1. Gantry
2. Welding head
3. Flux container
4. Wire bobbin
5. Slide
6. Bracket

Make sure all the comprised modules are properly fastened. Loose parts falling off can involve danger and even unbalance when lifting.

Note that the maximum weight allowed on the gantry is 220 kg.

When necessary use a lifting strap for lifting the different modules.

Use a lifting device when dismantling the bracket. The lifting device is to be mounted in the holes (7) on top of the bracket.





### **3.3 External emergency stop**

For connection of the emergency stop placed on the gantry leg see the diagram on page 16.

### **3.4 Emergency stop circuit**

For connection of the emergency stop circuit between the PEK and the welding power source (LAF/TAF) see diagram on page 16.

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## 4 OPERATION AND MAINTENANCE

---

### 4.1 General



**Caution:**

*Have you read and understood the safety information ?  
You must not operate the machine before then !*

***General safety regulations for the handling of the equipment can be found on page 5. Read through before you start using the equipment!***

**Note:**

*All warranty undertakings given by the supplier cease to apply if the customer attempts to rectify any faults on the machine during the warranty period.*

**Voltage supply**

- Disconnect the voltage supply before carrying out any maintenance work!

For operation and maintenance, see the respective manual for PEK, A2 welding equipment and power sources (LAF/TAF).

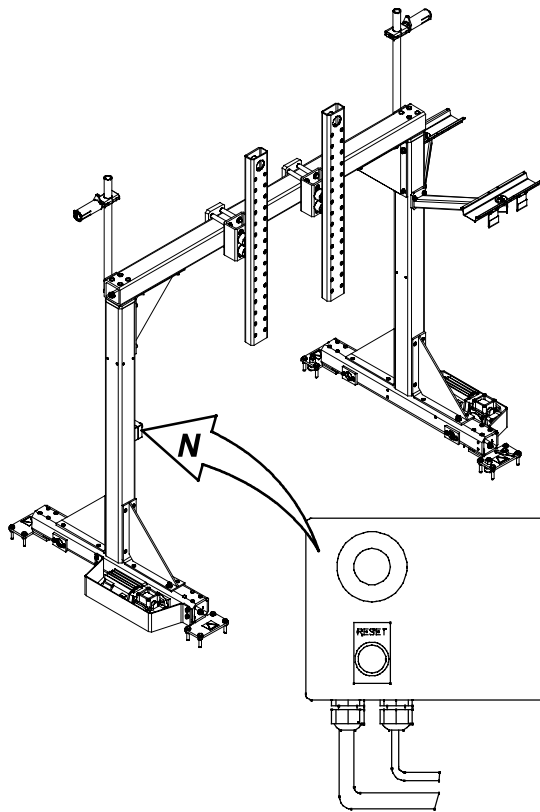
## 4.2 Emergency Stop

MechTrac is provided with an emergency stops (**N**).

### Resetting After Emergency Stop:

1. Find and eliminate the cause of the emergency stop.
2. Pull out the emergency stop button
3. Press "**Reset**".

**N.B.** An emergency stop must not be reset until the cause for the abnormal function or signal has been defined and remedied.



### Test and Check of Emergency Stop



*The function of all emergency and safety devices is to be checked regularly, at least once every month, as well as after any work has been carried out on the machine.*

### **N.B.**

Any abnormal function or signal must be defined and remedied before the welding column and boom unit is put into operation.

---

**5 ACCESSORIES**

---

**5.1 A2 GMAW (Gas Metal Arc Welding)**

Cooling unit OCE 2H .....	0414 191 881
Gas hose .....	0190 270 102
Water hose .....	0190 315 104

**5.2 A2 SAW (Submerged Arc Welding)**

Conversion kit Twin .....	0413 541 882
Conversion kit A2 SAW→ MIG/MAG .....	0461 248 880
Plastic wire reel .....	0153 872 880
Steel wire reel .....	0416 492 880
Flux recovery unit A6 OPC .....	0148 140 880
Air hose .....	0190 343 102
Flux funnel .....	0145 221 881
Air drying unit A6 CRE 30 .....	0443 570 880
Pilot lamp .....	0153 143 886
Laser lamp .....	0457 788 880

---

**6 ORDERING OF SPARE PARTS**

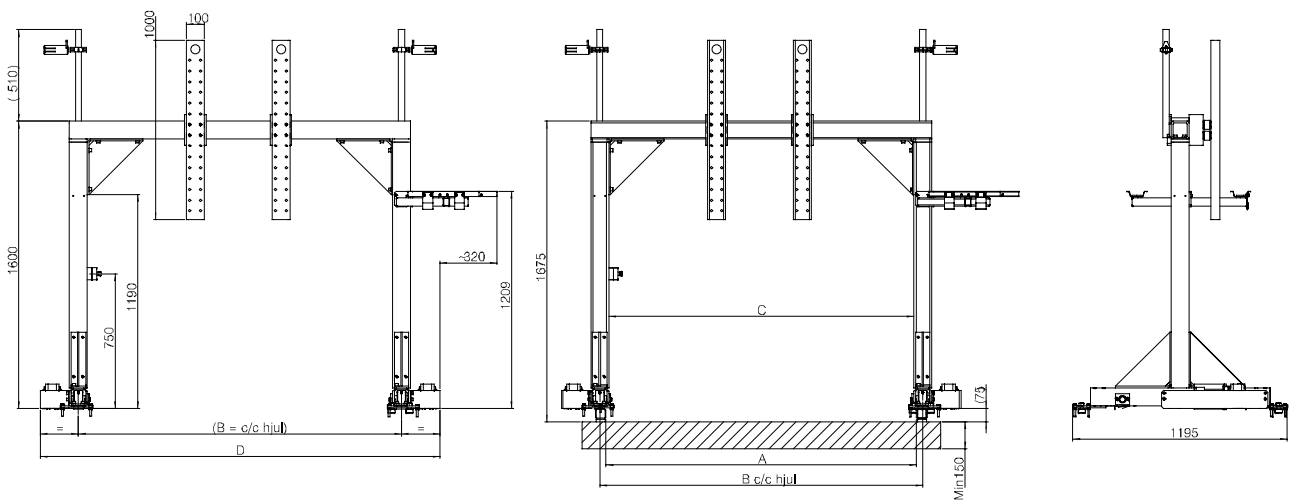
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Spare parts are ordered through your nearest ESAB representative, see back cover. When ordering spare parts, please state machine type and number as well as designation and spare part number as shown in the spare parts list on page 21. This will simplify dispatch and ensure you get the right part.

# Dimension drawing

## Double version

Group	A	B	C	D
881	1730	1800	1700	2227
882	2100	2170	2070	2597
883	2500	2570	2470	2997
884	3000	3070	2970	3497

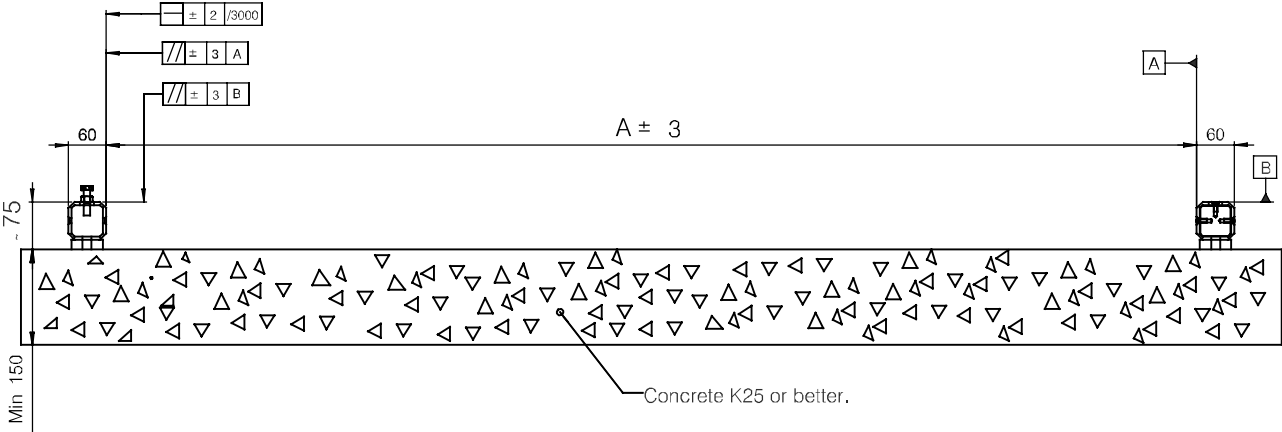


**Rail foundation**

*The rail is bolted with M12 bolts.*

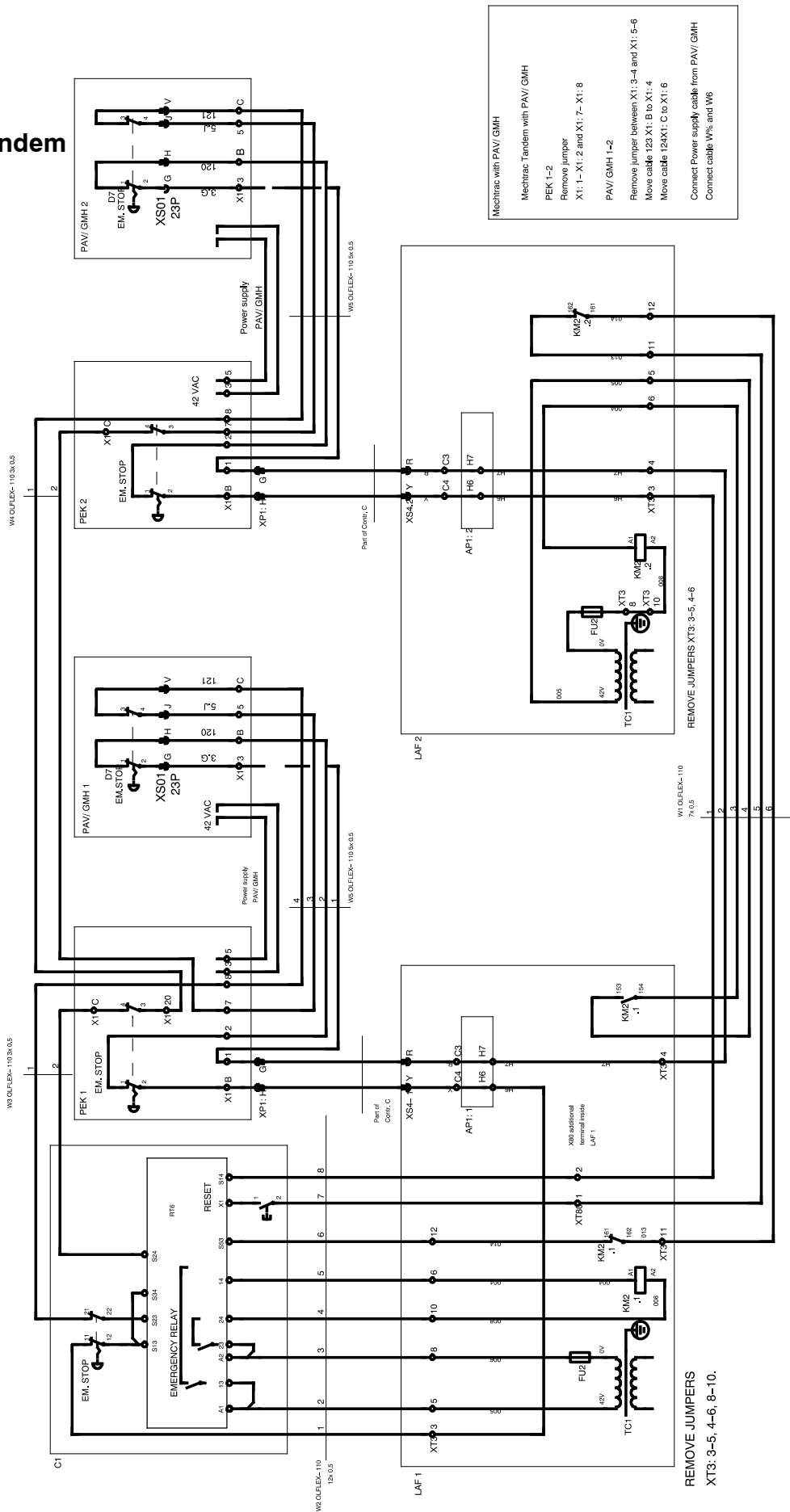
*Use metal sheets of different thickness to adjust the rail according to dimensions.*

A
1730
2100
2500
3000



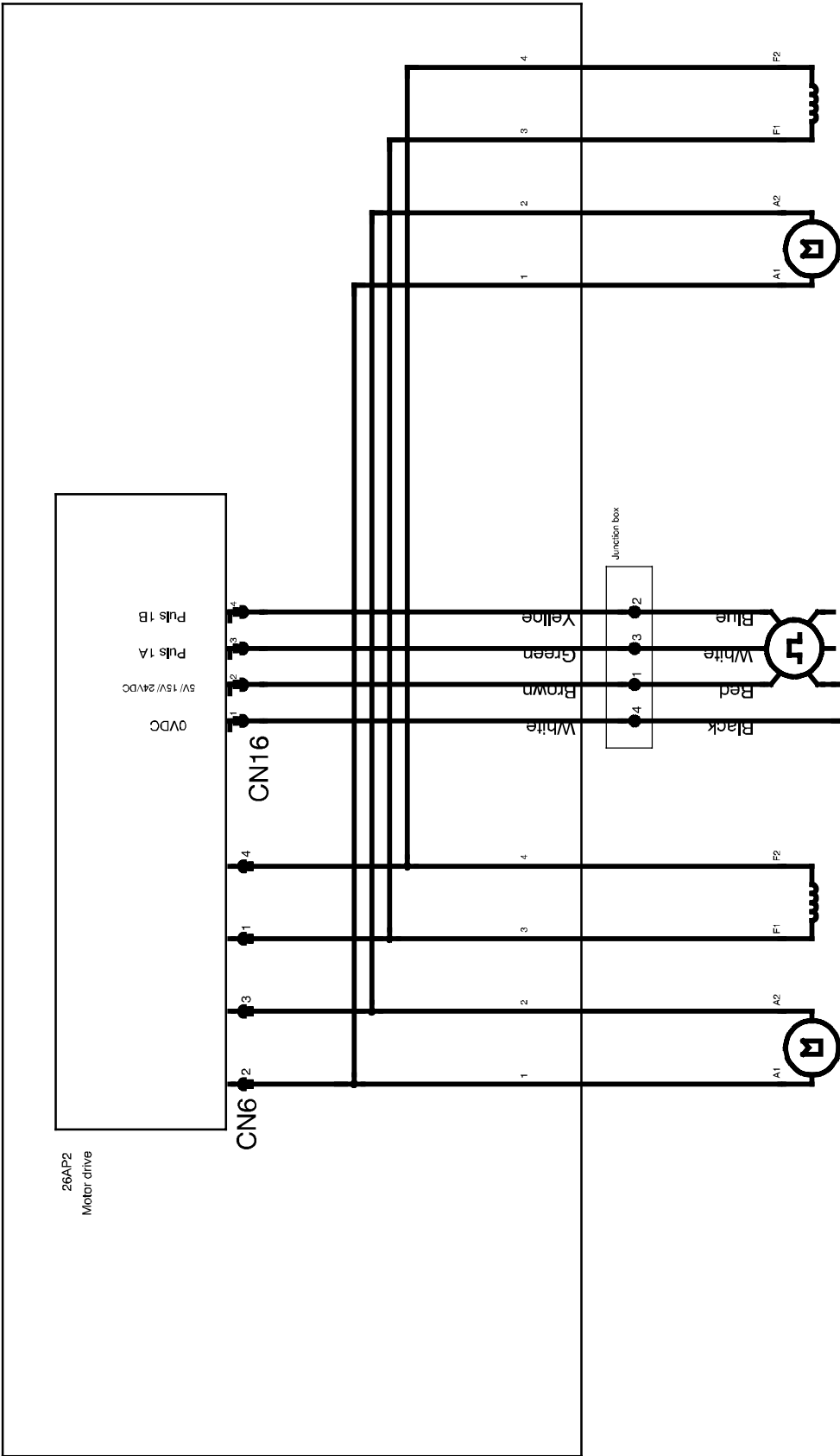
# Diagram

## Mechtrac Tandem



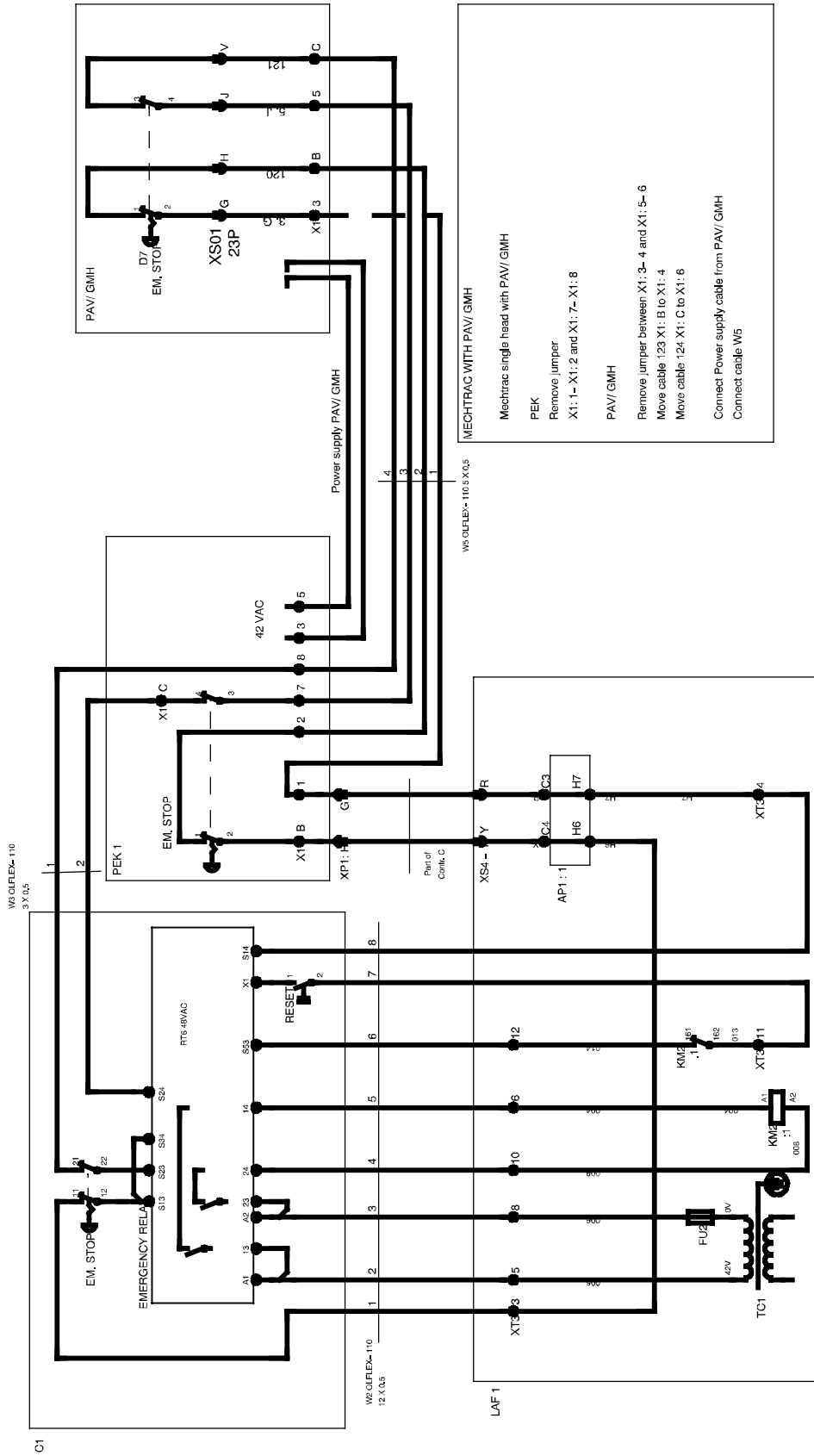


# Mechtrac Dual Travel Motor



PEK1

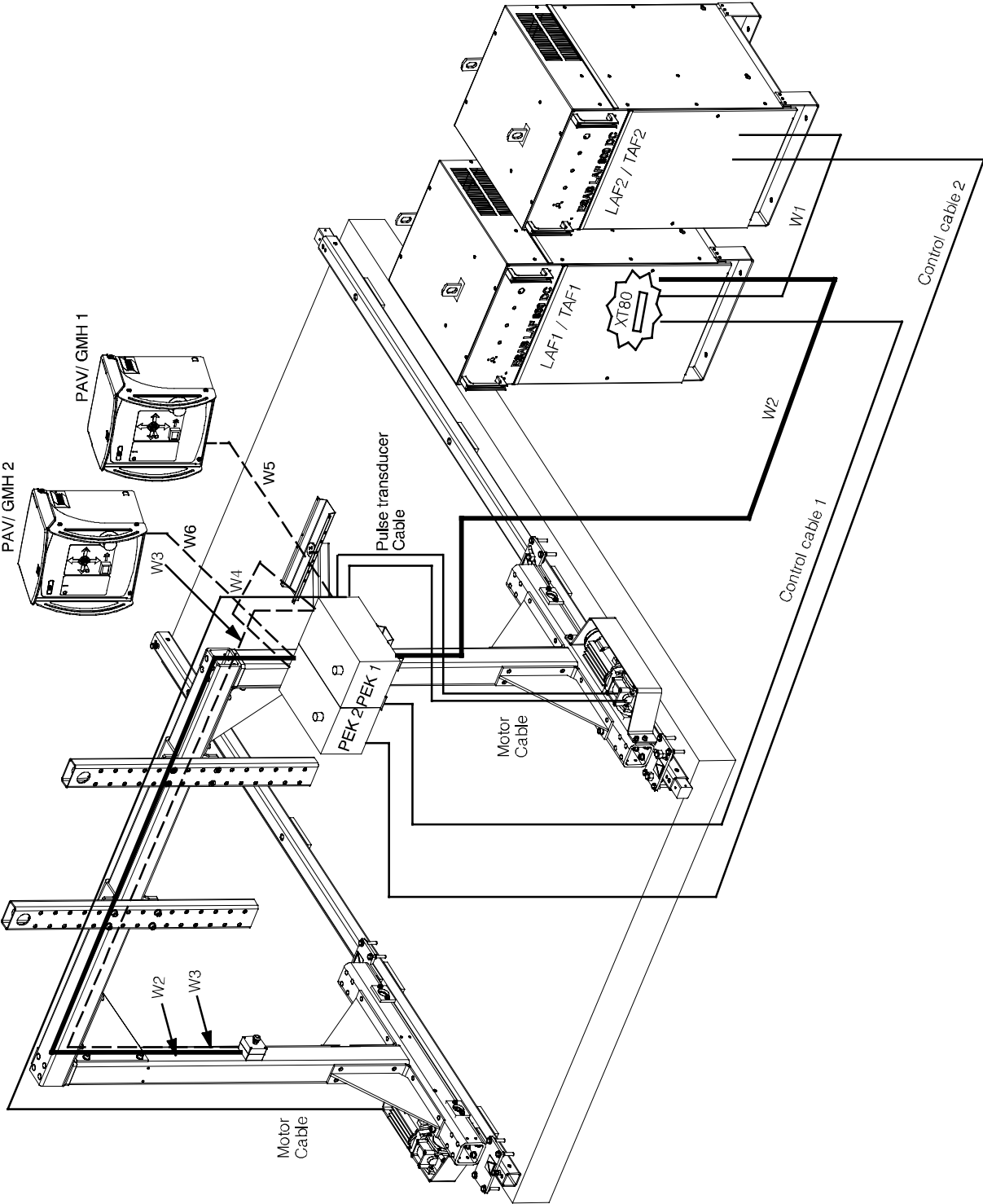
# Mechtrac Single head



REMOVE JUMPERS XT3: 3-5, 4-6, 8-10.

# Electrical system

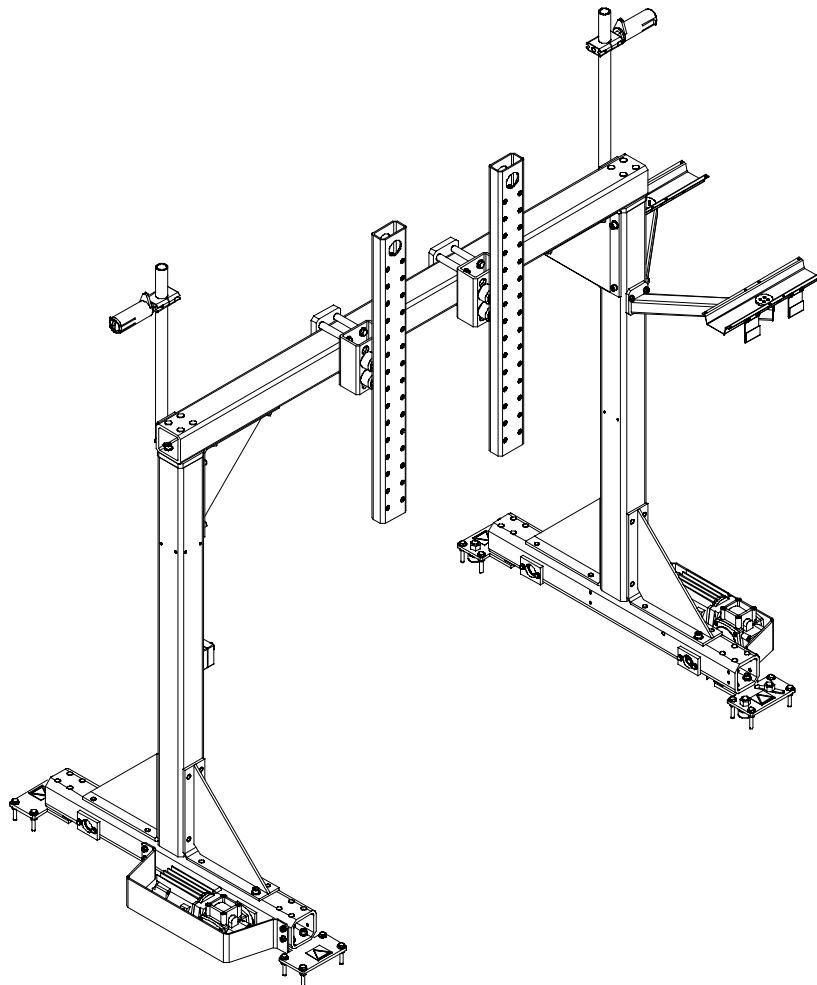
Mount **XT80** in an appropriate place in LAF1/ TAF1





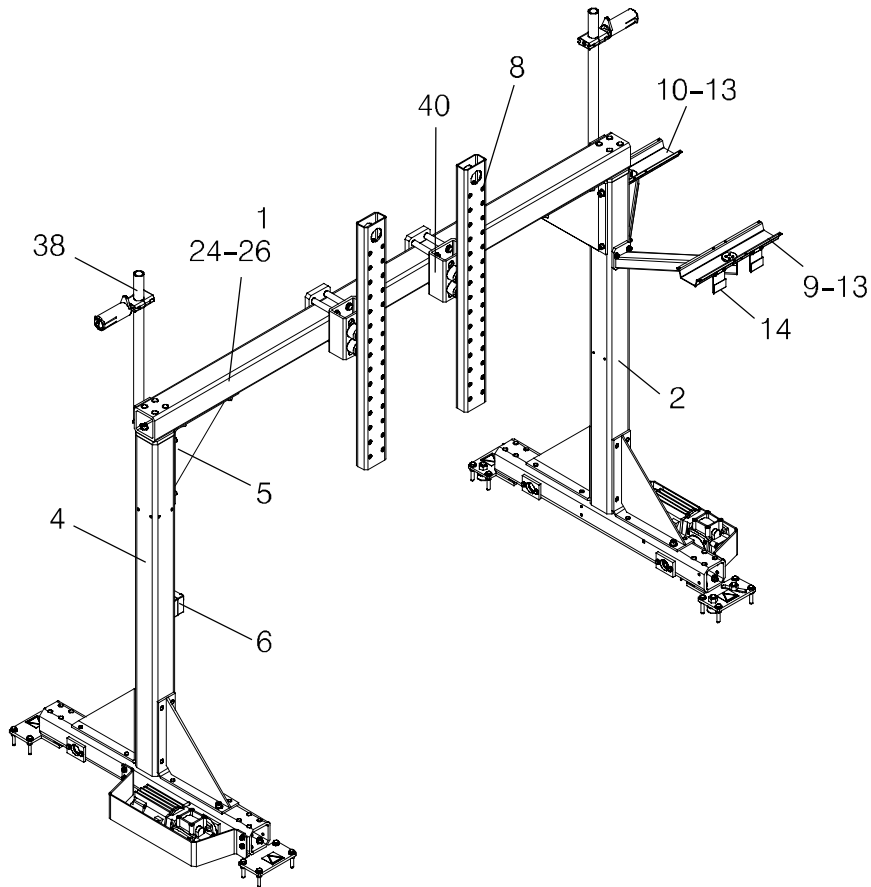
## Spare parts list

Edition 2010-04-15

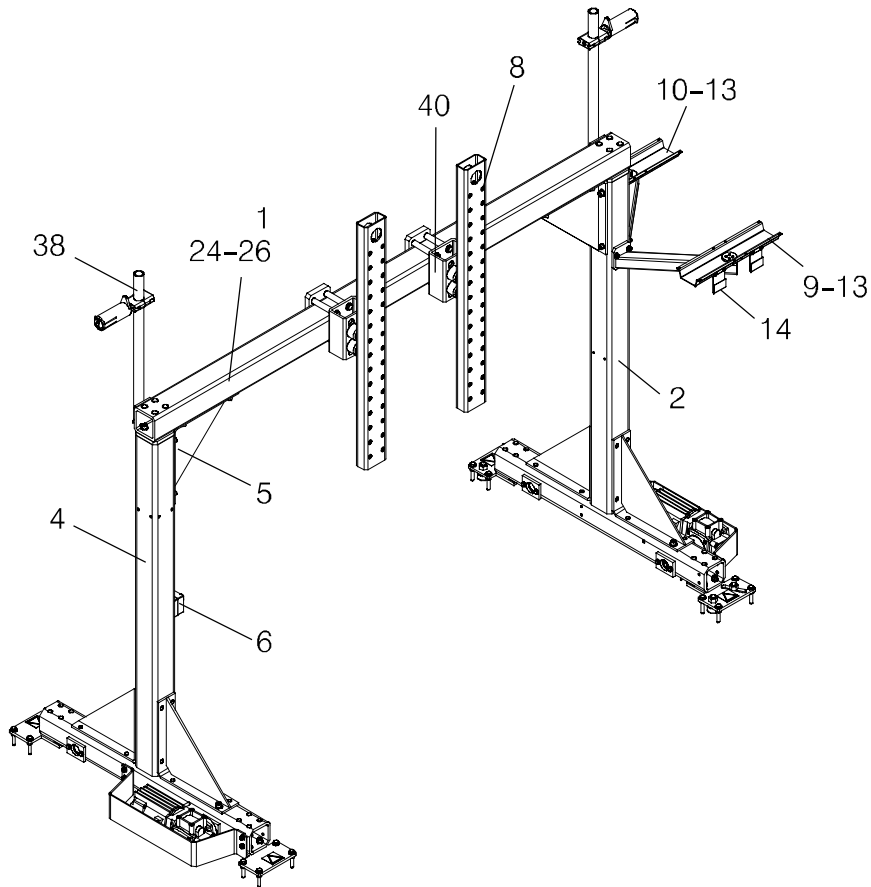


Ordering no.	Denomination	Notes
0809 670 881	Gantry	MechTrac 1730 (double)
0809 670 882	Gantry	MechTrac 2100
0809 670 883	Gantry	MechTrac 2500
0809 670 884	Gantry	MechTrac 3000
0806 707 880	Rail complete	
0806 707 881	Rail complete	

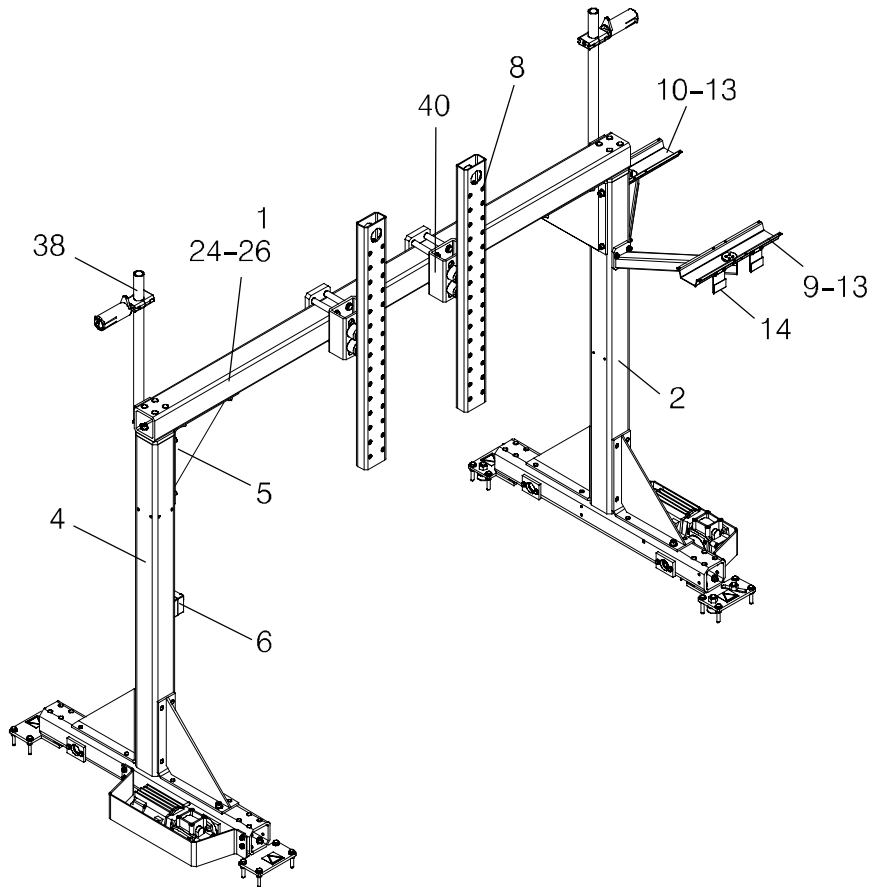
Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0809 670 881</b>	<b>Gantry</b>	<b>MechTrac 1730 (double)</b>
1	1	0809 662 001	Beam	
2	1	0809 667 881	Drive kit, right	
4	1	0809 667 880	Drive kit, left	
5	2	0806 474 880	Support	
6	1	0449 472 880	Emergency stop box	
8	2	0806 471 001	Arm	
9	1	0334 522 880	Box holder	
10	2	0334 187 001	Box girder beam	
11	16	0219 504 405	Cup spring	
12	2	0153 321 001	Disc	
13	2	0153 322 001	Disc	
14	2	0433 744 001	Hanger	
32	1	0805 586 103	Auxiliary contact block	
33	3	0802 803 263	Cable	4x1.5
34	10	0802 803 420	Cable	2x1.5
38	2	0449 255 880	Bobbin holder complete	
40	2	0812578880	Mounting kit, carriage travel	



Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0809 670 882</b>	<b>Gantry</b>	<b>MechTrac 2100 (double)</b>
2	1	0809 667 881	Drive kit, right	
4	1	0809 667 880	Drive kit, left	
5	2	0806 474 880	Support	
6	1	0449 472 880	Emergency stop box	
8	2	0806 471 001	Arm	
9	1	0334 522 880	Box holder	
10	2	0334 187 001	Box girder beam	
11	16	0219 504 405	Cup spring	
12	2	0153 321 001	Disc	
13	2	0153 322 001	Disc	
14	2	0433 744 001	Hanger	
24	1	0809 662 002	Beam	
32	1	0805 586 103	Auxiliary contact block	
33	3	0802 803 263	Cable	4x1.5
34	10	0802 803 420	Cable	2x1.5
38	2	0449 255 880	Bobbin holder complete	
40	2	0812578880	Mounting kit, carriage travel	

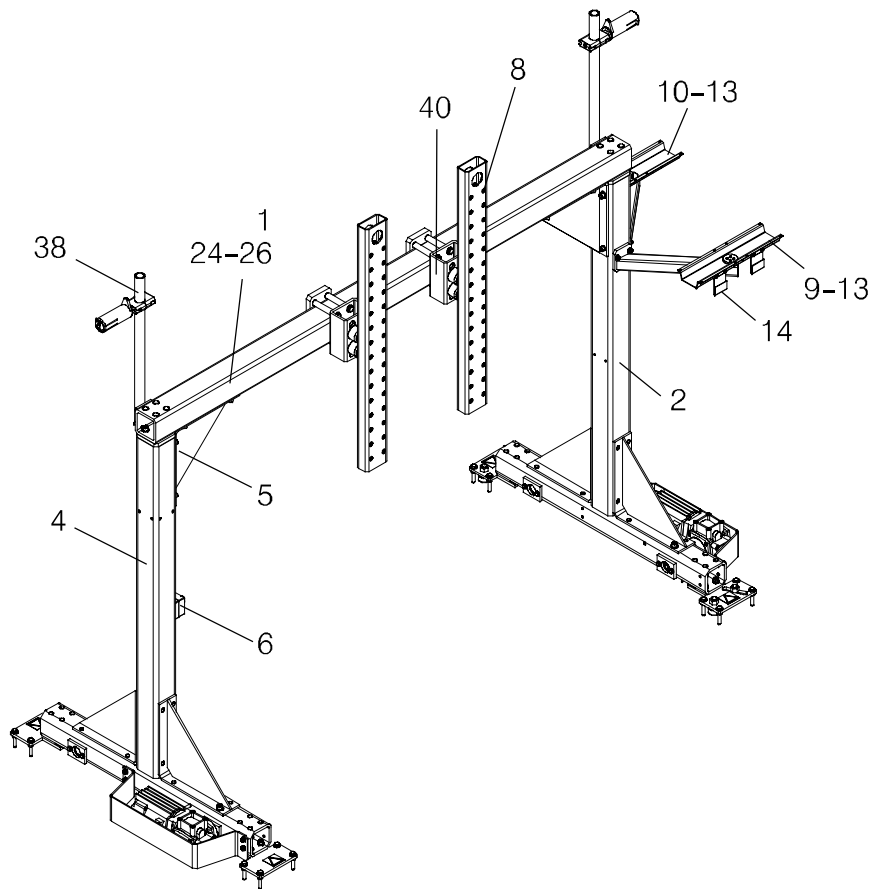


Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0809 670 883</b>	<b>Gantry</b>	<b>MechTrac 2500 (double)</b>
2	1	0809 667 881	Drive kit, right	
4	1	0809 667 880	Drive kit, left	
5	2	0806 474 880	Support	
6	1	0449 472 880	Emergency stop box	
8	2	0806 471 001	Arm	
9	1	0334 522 880	Box holder	
10	2	0334 187 001	Box girder beam	
11	16	0219 504 405	Cup spring	
12	2	0153 321 001	Disc	
13	2	0153 322 001	Disc	
14	2	0433 744 001	Hanger	
25	1	0809 662 003	Beam	
32	1	0805 586 103	Auxiliary contact block	
33	3	0802 803 263	Cable	4x1.5
34	10	0802 803 420	Cable	2x1.5
38	2	0449 255 880	Bobbin holder complete	
40	2	0812578880	Mounting kit, carriage travel	

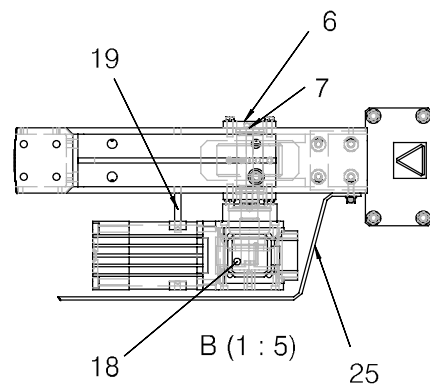
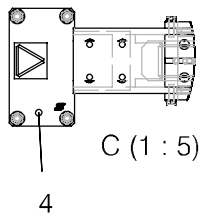
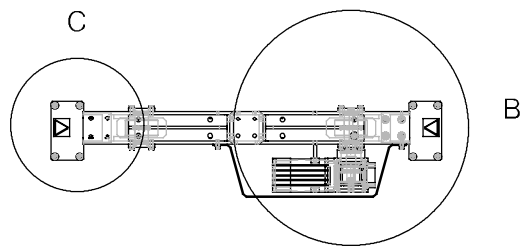
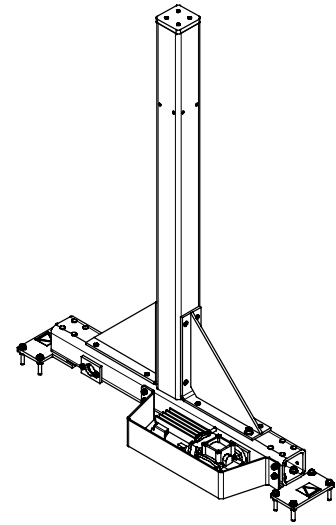
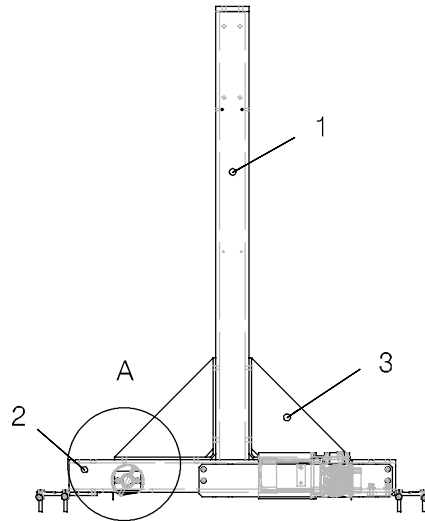
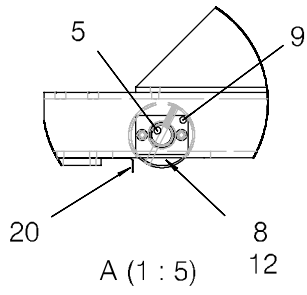




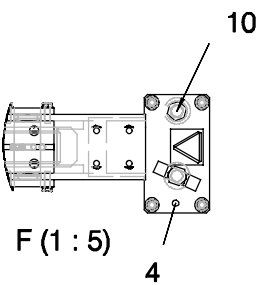
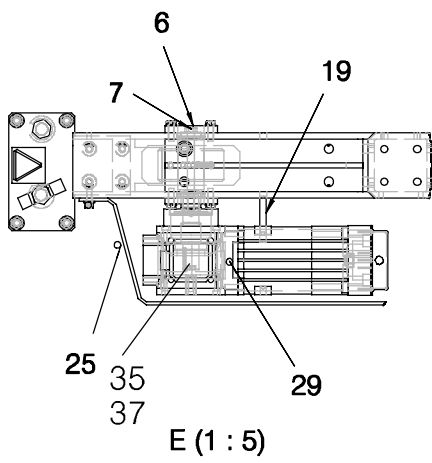
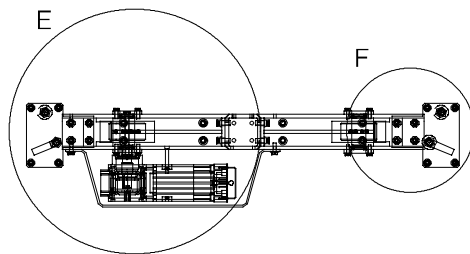
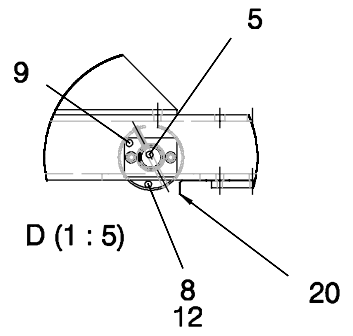
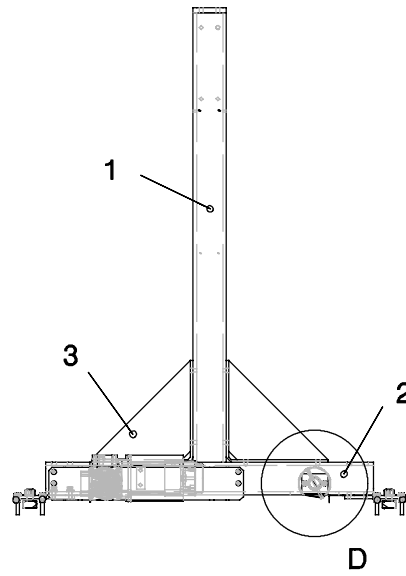
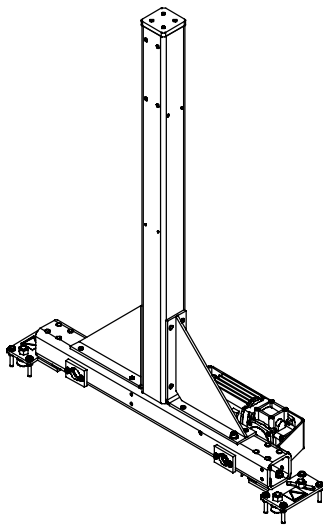
Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0809 670 884</b>	<b>Gantry</b>	<b>MechTrac 3000 (double)</b>
2	1	0809 667 881	Drive kit, right	
4	1	0809 667 880	Drive kit, left	
5	2	0806 474 880	Support	
6	1	0449 472 880	Emergency stop box	
8	2	0806 471 001	Arm	
9	1	0334 522 880	Box holder	
10	2	0334 187 001	Box girder beam	
11	16	0219 504 405	Cup spring	
12	2	0153 321 001	Disc	
13	2	0153 322 001	Disc	
14	2	0433 744 001	Hanger	
26	1	0809 662 004	Beam	
32	1	0805 586 103	Auxiliary contact block	
33	3	0802 803 263	Cable	4x1.5
34	10	0802 803 420	Cable	2x1.5
38	2	0449 255 880	Bobbin holder complete	
40	2	0812578880	Mounting kit, carriage travel	



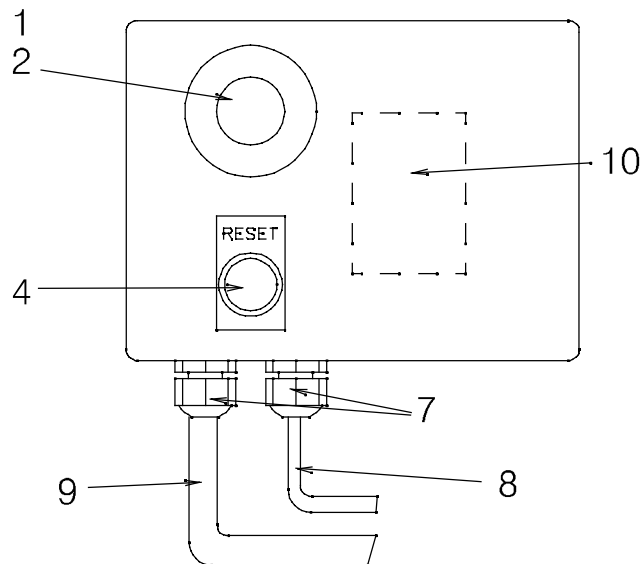
Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0809 667 880</b>	<b>Drive kit, left</b>	
1	1	0806 484 880	Left leg	
2	1	0806 477 001	Leg	
3	2	0806 474 880	Support	
4	2	0809 666 002	Holder	
5	1	0806 479 001	Drive shaft	
6	1	0806 479 002	Drive shaft	
7	4	0806 480 001	Ball-bearing	
8	2	0806 485 001	Wheel	
9	4	0806 472 001	Bracket	
12	2	0211 103 007	Roll pin	d 8x36
18	1	0147 018 902	Motor with gear	A6 VEC (4000rpm 672:1), see separate manual
19	1	0449 218 001	Bar	
20	2	0806 476 001	Scraper,angled	
23	1	0460 907 892	Motor cable	3 m (A6 VEC-PEK)
25	1	0449 319 001	Protection	



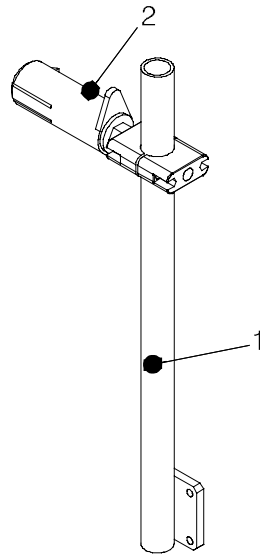
Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0809 667 881</b>	<b>Drive kit, right</b>	
1	1	0806 484 880	Left leg	
2	1	0806 477 001	Leg	
3	2	0806 474 880	Support	
4	2	0809 666 001	Holder	
5	1	0806 479 001	Drive shaft	
6	1	0806 479 002	Drive shaft	
7	4	0806 480 001	Ball-bearing	
8	2	0806 485 001	Wheel	
9	4	0806 472 001	Bracket	
10	4	0806 475 001	Roller	
12	2	0211 103 007	Roll pin	d 8x36
19	1	0449 218 001	Bar	
20	2	0806 476 001	Scraper,angled	
23	1	0460 907 882	Motor cable	10m (A6 VEC-PEK)
25	1	0449 319 001	Protection	
28	1	0161 337 058	Box	
29	1	0147 018 892	Motor with gear	A6 VEC (4000rpm 672:1), see separate manual
31	1	0805 586 103	Auxiliary contact block	lad-n20 2sl
32	4	0802 803 263	Cable	4x1.5
35	1	0449498880	Connection box complete	
37	1	0460 908 892	Pulse transducer cable	3m (A6 VEC- PEK)



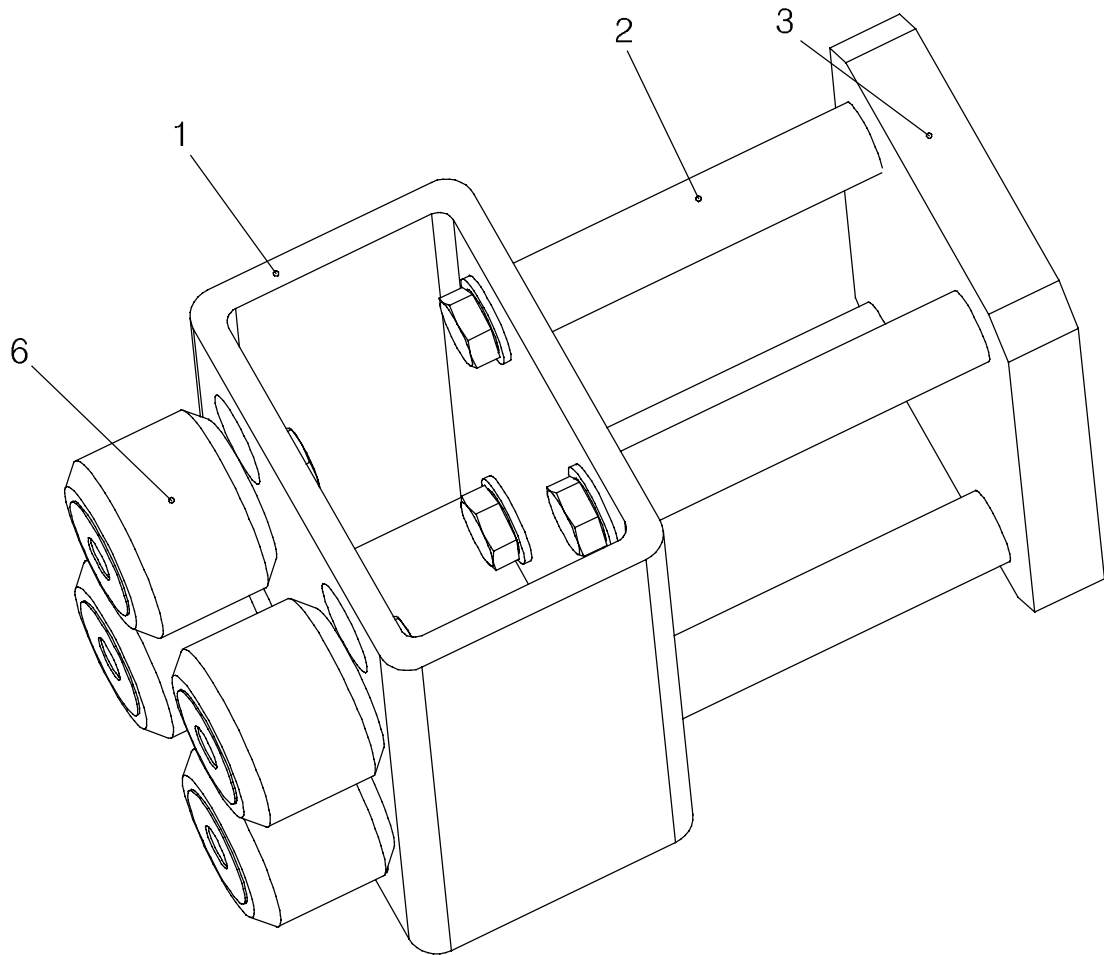
Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0449472880</b>	<b>Emergency stop box</b>	
1		0443740001	Emergency stop	
2		0443740002	Contact block	
4		0806738004	Push button, blue	
7		0807952002	Fitting	ST-M16
8		0802803003	Cable	W3, L = 7m
9		0802803035	Cable	W2, L = 30m
10		0451385010	Emergency stop relay	RT6 48 V AC
W04		0802803003	Cable	Öfflex 110 3*0.5
XT80			Terminal LAF 1	
W1		0802803009	Cable	L = 4m, Öfflex 110 7G0.5
W5		0802803009	Cable	L=4m, Öfflex 110 7G0.5
W6		0802803009	Cable	L=4m, Öfflex 110 7G0.5



Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0449255880</b>	<b>Bobbin holder complete</b>	
1	1	0334318880	Bobbin holder straight	
2	1	0146967880	Brake hub	

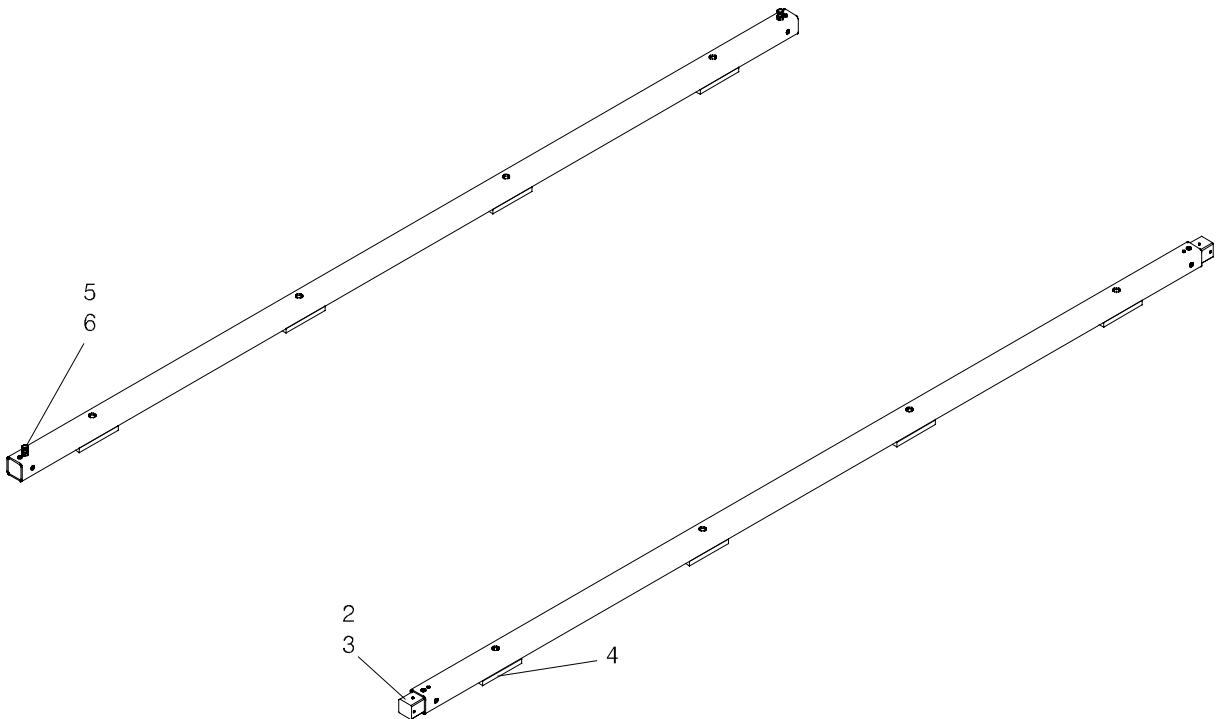


Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0812578880</b>	<b>Mounting kit, carriage travel</b>	
1	1	0812569001	Spacer	
2	4	0812579001	Spacer pipe	
3	1	0812572001	Threaded plate	
6	4	0278300180	Insulator	2000 V





Item no.	Qty	Ordering no.	Denomination	Notes
		<b>0806 707 880</b>	<b>Rail (Basic)</b>	
1	2	0806 700 001	Rail	
4	8	0806 701 001	Base plate	
5	2	0212 601 110	Nut	M10
6	2	0212 101 608	Screw	M10x40
		<b>0806 707 881</b>	<b>Rail (Extension)</b>	
1	2	0806 700 001	Rail	
2	2	0806 703 001	Inner plate	
3	12	0190 684 638	Screw	M16x90
4	8	0806 701 001	Base plate	



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