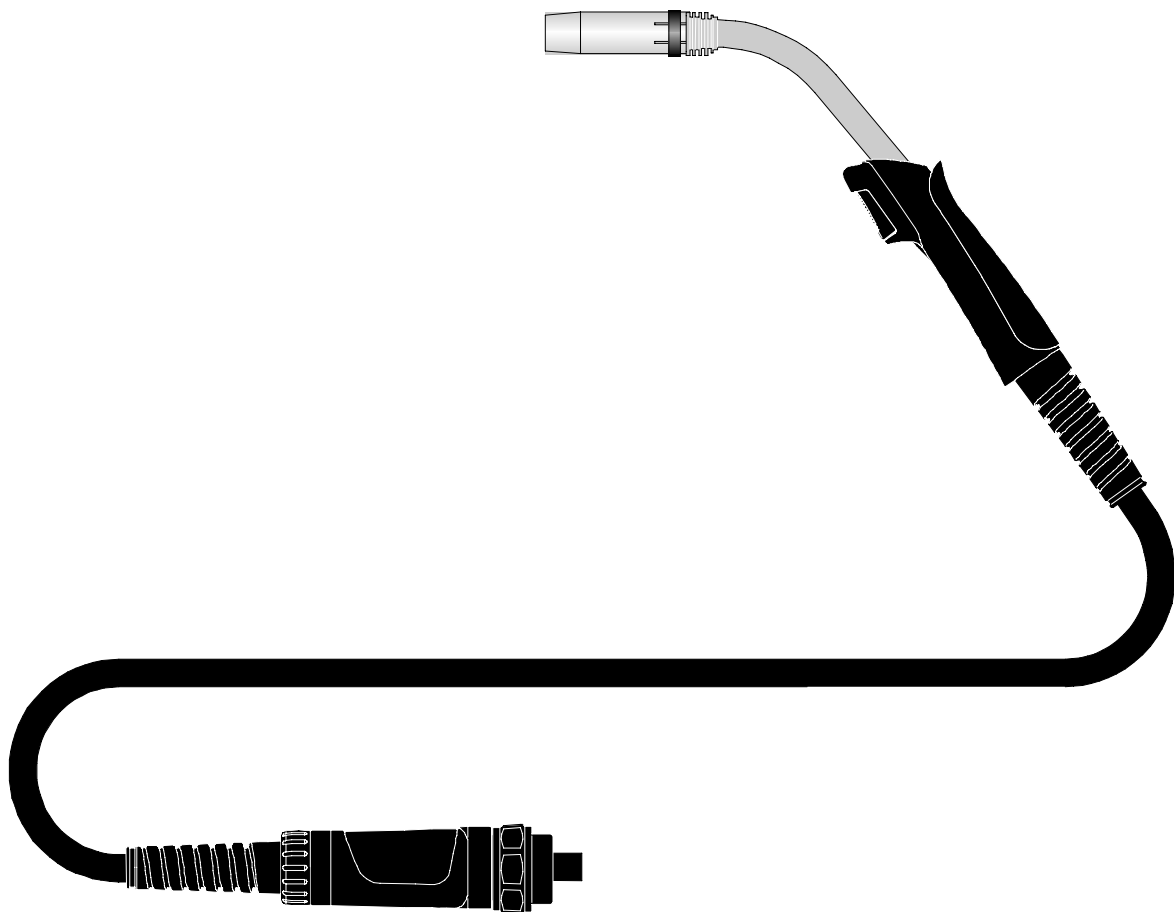


***MXL™ 150v, MXL™ 200,  
MXL™ 270, MXL™ 340***



**Instruction manual**

**SE** Ytterligare språk av bruksanvisningen och reservdelsförteckning finns tillgängligt på internetadressen **www.esab.com**

**DK** Du kan finde yderligere sprogversioner af brugsanvisningen og reservedelsfor-tegnelsen på internet-adressen **www.esab.com**

**NO** Du finner flere språkversjoner av bruksanvisningen samt reservdelsliste på Internett-adressen **www.esab.com**

**FI** Muilla kielillä olevia käyttöohjeita ja varaosaluetteloita löydät Internet-sivuiltamme **www.esab.com**

**GB** The instructions and the spare parts list are available in other languages on the Internet at **www.esab.com**

**DE** Weitere Sprachversionen von Betriebsanweisung und Ersatzteilverzeichnis finden Sie im Internet unter **www.esab.com**.

**FR** Les instructions et la liste des pièces de rechange sont disponibles dans d'autres langues sur le site **www.esab.com**.

**NL** Op **www.esab.com** vindt u de instructies en de lijsten met reserveonderdelen in andere talen.

**PT** As instruções e a lista de peças sobressalentes estão disponíveis noutras línguas na Internet em **www.esab.com**

**ES** Las instrucciones y las listas de repuestos están disponibles en otros idiomas en Internet, en la dirección **www.esab.com**

**IT** Le istruzioni e l'elenco dei pezzi di ricambio sono disponibili in altre lingue su Internet all'indirizzo **www.esab.com**

**PL** Instrukcja i lista części zamiennych są dostępne w innych wersjach językowych w Internecie w witrynie **www.esab.com**

**CZ** Pokyny a seznam náhradních dílů v jiných jazycích jsou k dispozici na Internetu na adrese **www.esab.com**

**HU** Az utasítások és a pótalkatrészlista más nyelveken elérhető az interneten a **www.esab.com** honlapon.

Svenska	0459 560 101 SE	Norsk	0459 560 101 NO
Dansk	0459 560 101 DK	Soumi	0459 560 101 FI
English	0459 560 101 GB	Deutsch	0459 560 101 DE
Français	0459 560 101 FR	Nederlands	0459 560 101 NL
Español	0459 560 101 ES	Italiano	0459 560 101 IT
Português	0459 560 101 PT	Polski	0459 560 101 PL
Česky	0459 560 101 CZ	Magyar	0459 560 101 HU

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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 the welding torch/welding gun MXL 150v, MXL 200, MXL 270, MXL 340 are constructed and tested in compliance with the standard EN 60974-7 in accordance with the requirements of directive (2006/95/EC).

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Laxå 2007-03-08



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.
  - 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.**

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### 3 INTRODUCTION

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The MIG / MAG welding torches of this series are exclusively intended for shielded-arc welding using inert gas (MIG) or active gas (MAG) for industrial and commercial use by suitably trained employees. The torches are only available in manual versions.

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### 4 SHIPMENT AND PACKAGING

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The components are carefully checked and packaged however damage may occur during shipping.

**Checking procedure on receipt of goods**

- Check that the shipment is correct by referring to the shipping note.

**In case of damage**

- Check the package and components for damage (visual inspection).

**In case of complaints**

If the package and/or components have been damaged during shipment:

- Contact with the last carrier immediately.
- Keep the packaging (for possible inspection by the carrier or supplier, or for returning the goods).



## Storage in an enclosed space

Ambient temperature

- for shipment and storage: - 25 °C to + 55 °C

Relative air humidity: up to 90% at a temperature of 20 °C

## 5 TECHNICAL DATA

Welding torch	MXL 150v	MXL 200	MXL 270	MXL 340
<b>Type of cooling</b>	Air	Air	Air	Air
<b>Permitted load at 20% intermittence *</b>				
Carbon dioxide CO <sub>2</sub>	150 A			
Mixed gas Ar/CO <sub>2</sub>	150 A			
<b>Permitted load at 35% intermittence *</b>				
Carbon dioxide CO <sub>2</sub>	120 A	200 A	270 A	340 A
Mixed gas Ar/CO <sub>2</sub>	120 A	170 A	260 A	320 A
<b>Recommended gas flow</b>	8 - 15 l/min	10-18 l/min	10-18 l/min	10-20 l/min
<b>Max pressure</b>	2.5 bar			
<b>Wire diameter</b>	0.6-0.8 mm	0.6-1.0 mm	0.8-1.2 mm	0.8-1.2 mm
<b>Weight</b>				
2.5 m hose package	1.1 kg	-	-	-
3.0 m hose package	-	1.6 kg	2.2 kg	2.6 kg
4.0 m hose package	-	2.0 kg	2.6 kg	3.7 kg
<b>Cable assembly</b>				
Standard length	2.5 m	3.0 m / 4.0 m	3.0 m / 4.0 m	3.0 m / 4.0 m
Standard-control cable	2-pole	2-pole	2-pole	2-pole

\* The capacity may be reduced up to 30% when pulse welding.

### Duty cycle

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

General torch data with reference to IEC/EN 60 974-7	
Type of voltage:	DC voltage
Wire type:	Standard round wire
Voltage measurement:	Peak value of 113V
Connection protection Machine side (EN 60 529):	IP3X
Shielding gas:	CO <sub>2</sub> or Ar/CO <sub>2</sub>

## 6 OPERATION

**General safety regulations for the handling of the equipment can be found on page 4. Read them before you start using the equipment!**



### 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.

MXL welding torches can be used in any welding position.

The torch switch in the MXL handle is suitable for 42 V, maximum 1 A.

### 6.1 Fitting the liner

Fit the correct wire guide liner for the application, as needed to suit the wire type and diameter, see 7.3.



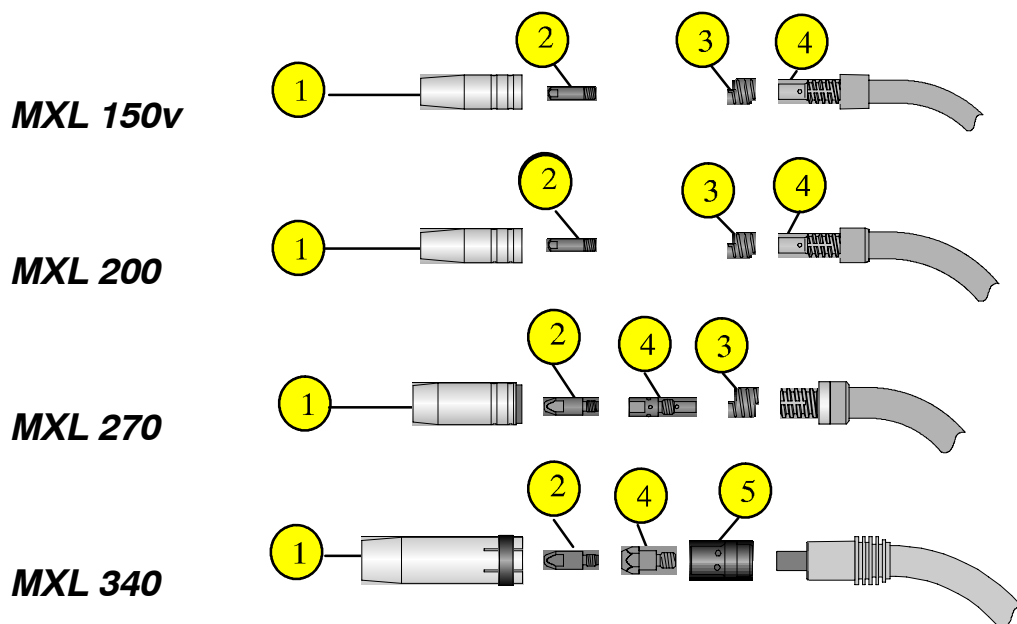
**For information on how to install new liners and about correct assembly procedure, see the chapter entitled "Maintenance"**

Spiral liner = for steel wires

PTFE-liner = for aluminium, copper, nickel and stainless steel wires

### 6.2 Assembling the swan neck

The following figures indicate how to assemble the different welding torch types.



1. Gas nozzle

2. Contact tip

3. Nozzle spring

4. Tip adaptor

5. Gas diffuser

### 6.3 Fitting the central adaptor assembly to the equipment

1. Check that the wire guide liner is fitted correctly.
2. Insert the central plug into the socket on the wire feed unit and secure it by tightening the adaptor nut firmly.

### 6.4 Setting the level of shielding gas

Set the quantity of gas required on the gas regulator. The type and quantity of gas to be used depend on the welding task to be performed.

### 6.5 Checklist

- Check the cable assembly before connecting it to the wire feed unit to confirm the wire liner is suitable for the wire diameter and type.
- Check the fixed end consumable parts on the swan neck, whether the correct contact tip etc. is being used for the wire diameter and type.

### 6.6 Changing wire

- When changing the wire, ensure that the end of the wire is deburred.
- Insert the wire into the wire feeding unit in accordance with the operating instructions.
- When inserting the wire, press the wire jog button on the wire feed unit.

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## 7 MAINTENANCE

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*Regular maintenance is important for safe, reliable operation.*

### Welding torch

- Cleaning and replacement of the welding torch's wear parts should take place at regular intervals in order to achieve trouble-free wire feed. Blow the wire guide clean regularly and clean the contact tip.



Before carrying out cleaning, servicing and repair work, the following shutdown procedure must be followed.

1. Switch off the power supply.
2. Close off the gas supply.

**Make sure that the power supply and gas remain turned off all the time while servicing the machine.**

### 7.1 Cable assembly

- Check that all the nuts are tight.
- Replace the liner if it is worn or dirty.
- Replace damaged, deformed or worn parts.



## 7.2 Cleaning the wire feed

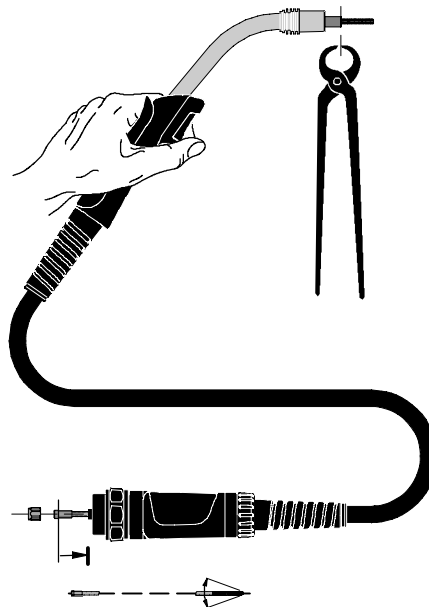
- Disconnect the torch cable assembly from the equipment and lay it out straight.
- Unscrew the nut and pull out the wire guide liner. Remove other parts from the swan neck.
- Blow compressed air through the wire conduit from both ends in order to remove wire shavings.
- Insert the liner into the wire conduit and screw the nut back on.



**New liners must be cut to the correct length.  
Please follow the following tips and suggestions:**

## 7.3 Spiral liner / PTFE liner

1. Unscrew all the fittings from the swan neck.
2. Unscrew the union nut on the central plug.
3. Remove the old liner, and then push the guide spiral liner through the hose as far as it will go.  
Make sure the cable is stretched out more or less straight.
4. Tighten the union nut by hand.
5. Cut the overhang off the spiral at the swan neck and remove the guide spiral liner again.
6. For a smooth transition to the contact tip, grind the end of the spiral to an angle of approx. 40°. Deburr the cutting edge.
7. Push the sharpened guide spiral liner through the hose to the holder nipple.
8. Screw the union nut into position and tighten it using the multiple spanner.
9. Screw the fittings back on again.



## 7.4 Cleaning the swan neck

- Clean the inside of the gas nozzle regularly to remove welding spatter and spray with ESAB<sup>®</sup> anti-spatter agent.
- Check the consumables for visible damage and replace if necessary.

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## 8 FAULT-TRACING

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If the measures described below are not successful, please consult your dealer or the manufacturer.

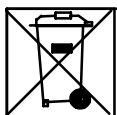
*Please also read the operating instructions for the welding components, e.g. power source and wire feed unit.*

Problem	Cause	Solution
Torch becomes too hot	<ul style="list-style-type: none"> <li>• Contact tip / Collets not tight enough</li> <li>• Current connections on the torch side and to the work piece are loose</li> </ul>	<ul style="list-style-type: none"> <li>• Check and tighten</li> <li>• Check and tighten</li> </ul>
No switch function	<ul style="list-style-type: none"> <li>• Control line interrupted / faulty</li> </ul>	<ul style="list-style-type: none"> <li>• Check / Repair</li> </ul>
Wire burnt back onto the contact tip	<ul style="list-style-type: none"> <li>• Wrong parameter setting</li> <li>• Worn contact tip</li> </ul>	<ul style="list-style-type: none"> <li>• Check or correct the setting</li> <li>• Replace</li> </ul>
Irregular wire feed	<ul style="list-style-type: none"> <li>• Liner blocked</li> <li>• Contact tip and wire diameter do not match one another</li> <li>• Wrong tension set on the wire feed unit</li> </ul>	<ul style="list-style-type: none"> <li>• Blow through in both directions</li> <li>• Replace contact tip</li> <li>• Correct according to manufacturer's instructions</li> </ul>
Short arc between the gas nozzle and the work piece	<ul style="list-style-type: none"> <li>• Spatter bridge between the contact tip and the gas nozzle</li> </ul>	<ul style="list-style-type: none"> <li>• Clean and spray the inside of the gas nozzle</li> </ul>
Variable arc	<ul style="list-style-type: none"> <li>• Contact tip does not match the wire diameter, or the contact tip is worn</li> <li>• Incorrect welding parameters set</li> <li>• Liner worn</li> </ul>	<ul style="list-style-type: none"> <li>• Check and replace the contact tip</li> <li>• Correct the welding parameters</li> <li>• Replace the wire guide</li> </ul>
Porous welds	<ul style="list-style-type: none"> <li>• Large amount of spatter in the gas nozzle</li> <li>• Insufficient or total lack of gas shield</li> <li>• Draught is disturbing the shielding gas</li> </ul>	<ul style="list-style-type: none"> <li>• Clean the gas nozzle</li> <li>• Check contents of the gas bottle and the pressure setting</li> <li>• Shield welding area with protective screens</li> </ul>

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## 9 DISASSEMBLY AND DISPOSAL

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**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!

The welding torch system is mainly made from steel, plastics and non-ferrous metal, and must be disposed of in accordance with local environmental regulations.

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## 10 IN THE EVENT OF AN EMERGENCY

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In the event of an emergency, the power supply must be switched off immediately.

For further action in such circumstances, consult the 'Power source' Instruction manual.

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## 11 ORDERING OF SPARE PARTS

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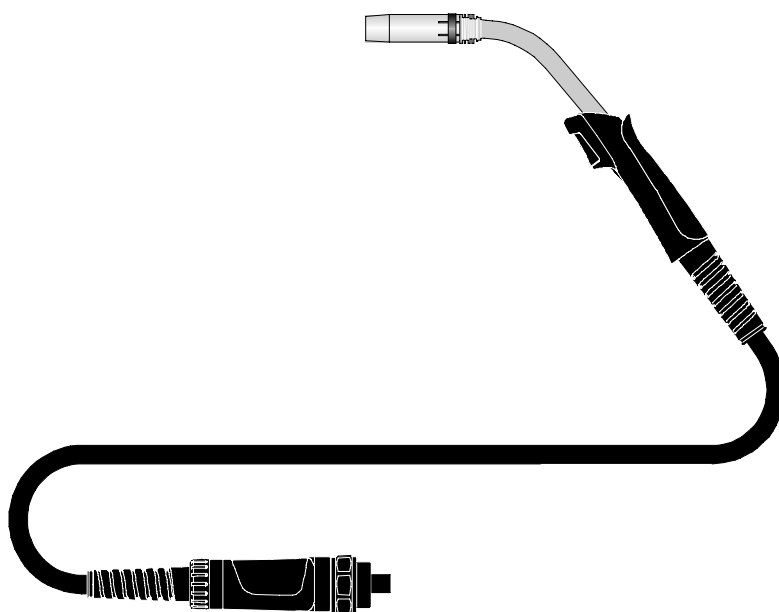
**MXL 150v, MXL 200, MXL 270, MXL 340 is designed and tested in accordance with the international and European standards IEC-/EN 60974-7 It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.**

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



**MXL™ 150v, MXL™ 200, MXL™ 270, MXL™ 340**

**Ordering number**



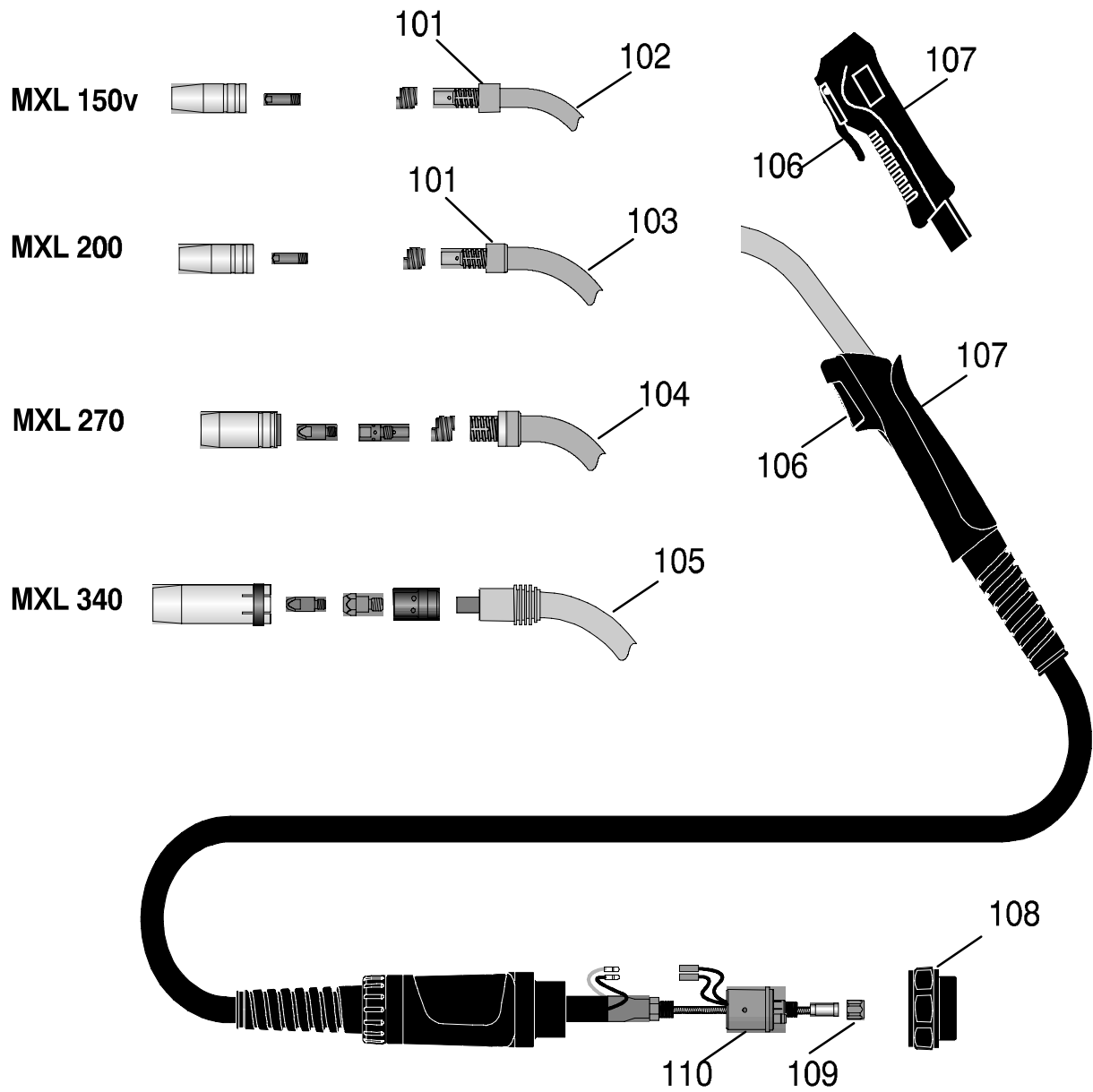
**Ordering Number**

Ordering no.	Type	Description	Notes
0700 200 001	MXL™ 150v	Welding torch 2.5 m	with fixed connection
0700 200 002	MXL™ 200	Welding torch 3.0 m	EURO Connection
0700 200 003	MXL™ 200	Welding torch 4.0 m	EURO Connection
0700 200 004	MXL™ 270	Welding torch 3.0 m	EURO Connection
0700 200 005	MXL™ 270	Welding torch 4.0 m	EURO Connection
0700 200 006	MXL™ 340	Welding torch 3.0 m	EURO Connection
0700 200 007	MXL™ 340	Welding torch 4.0 m	EURO Connection

**Spare parts list**

Pos	Denomination	Ordering no.	MXL150v	MXL 200	MXL 270	MXL 340	Notes
101	Head insulator	0700 200 096	x	x			
102	Swan neck Standard	0700 200 050	x				
103	Swan neck Standard	0700 200 051		x			
104	Swan neck Standard	0700 200 052			x		
105	Swan neck Standard	0700 200 053				x	
106	Trigger 2 pol	0700 200 077	x				MXL 150v
106	Trigger 2 pol	0700 200 095		x	x	x	MXL 200/ 270/ 340
107	Handle complete	0700 200 093	x				MXL 150v Incl trigger pos 106
107	Handle complete	0700 200 094		x	x	x	MXL 200/ 270/ 340 Incl trigger pos 106
108	Adaptor nut complete	0700 200 097		x	x	x	
109	Liner lock nut	0700 200 098		x	x	x	M10x1
110	Central connector	0700 200 101		x	x	x	Incl. control leads

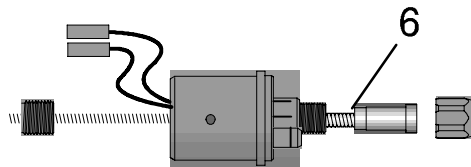
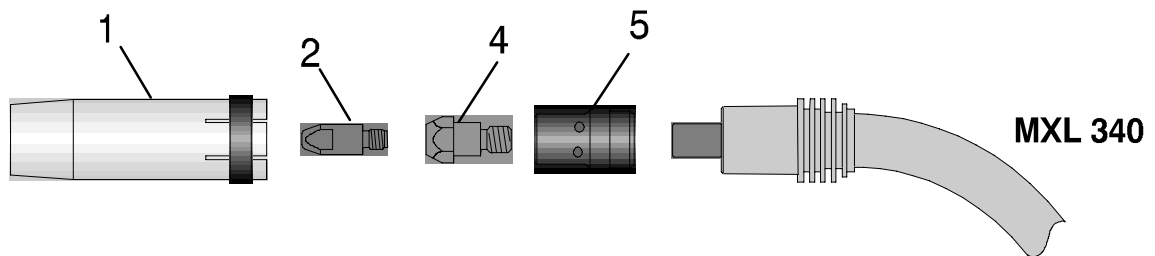
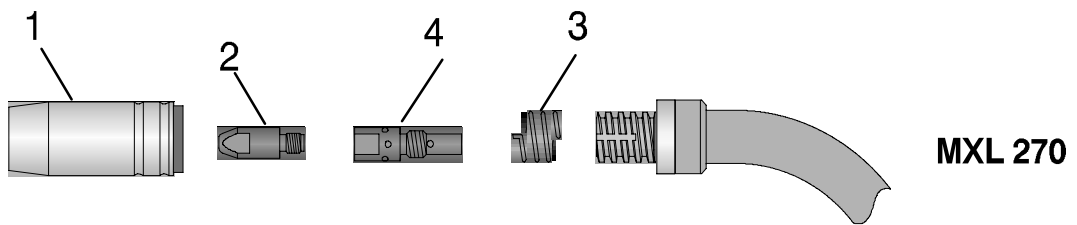
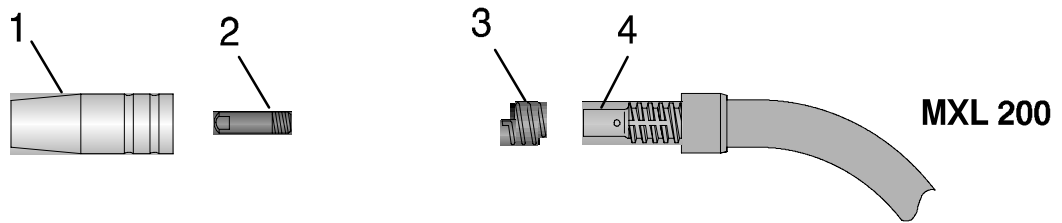
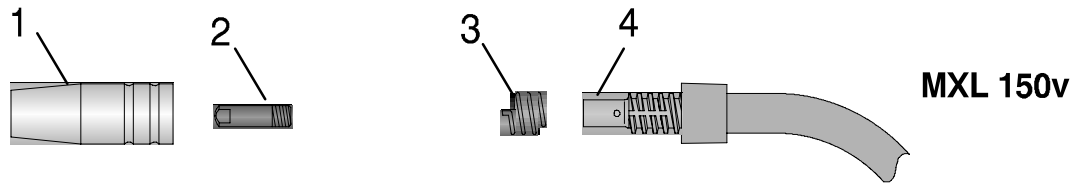
**MXL™ 150v, MXL™ 200, MXL™ 270, MXL™ 340**



**Wear parts**

Pos	Denomination		MXL150v	MXL 200	MXL 270	MXL 340
<b>1</b>	Gas nozzle	standard Ø 12 mm	0700 200 054	0700 200 054		
	Gas nozzle	standard Ø 15 mm			0700 200 055	
	Gas nozzle	standard Ø 16 mm				0700 200 056
	Gas nozzle	straight Ø 16 mm	0700 200 057	0700 200 057		
	Gas nozzle	straight Ø 18 mm			0700 200 058	
	Gas nozzle	straight Ø 19 mm				0700 200 059
	Gas nozzle	conical Ø 9.5 mm	0700 200 060	0700 200 060		
	Gas nozzle	conical Ø 11.5 mm			0700 200 061	
	Gas nozzle	conical Ø 12 mm				0700 200 062
<b>2</b>	Contact tip Cu	W0.6 M6x25	0700 200 063	0700 200 063		
	Contact tip Cu	W0.8 M6x25	0700 200 064	0700 200 064		
	Contact tip Cu	W0.9 M6x25	0700 200 065	0700 200 065		
	Contact tip Cu	W1.0 M6x25	0700 200 066	0700 200 066		
	Contact tip Cu	W0.8 M6x28			0700 200 068	0700 200 068
	Contact tip Cu	W0.9 M6x28			0700 200 069	0700 200 069
	Contact tip Cu	W1.0 M6x28			0700 200 070	0700 200 070
	Contact tip Cu	W1.2 M6x28			0700 200 071	0700 200 071
<b>3</b>	Nozzle spring		0700 200 078	0700 200 078		
	Nozzle spring				0700 200 079	
<b>4</b>	Tip adaptor	M6 MXL 150v	0700 200 076			
	Tip adaptor	M6, Alu MXL 200		0700 200 067		
	Tip adaptor	M6 MXL 200		0700 200 072		
	Tip adaptor	M6, 35 mm MXL 270			0700 200 073	
	Tip adaptor	M6, 28 mm MXL 340				0700 200 074
	Tip adaptor	M6, 32 mm MXL 340				0700 200 075
<b>5</b>	Gas diffusor white					0700 200 080
<b>6</b>	Steel liner	W0.6 - W0.8 2.5 m	0700 200 099			
	Steel liner	W0.6 - W0.8 3.0 m		0700 200 085	0700 200 085	0700 200 085
	Steel liner	W0.6 - W0.8 4.0 m		0700 200 086	0700 200 086	0700 200 086
	Steel liner	W0.9 - W1.2 3.0 m		0700 200 087	0700 200 087	0700 200 087
	Steel liner	W0.9 - W1.2 4.0 m		0700 200 088	0700 200 088	0700 200 088
	PTFE liner	W0.6 - W0.8 3.0 m		0700 200 089	0700 200 089	0700 200 089
	PTFE liner	W0.6 - W0.8 4.0 m		0700 200 090	0700 200 090	0700 200 090
	PTFE liner	W0.9 - W1.2 3.0 m		0700 200 091	0700 200 091	0700 200 091
	PTFE liner	W0.9 - W1.2 4.0 m		0700 200 092	0700 200 092	0700 200 092









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