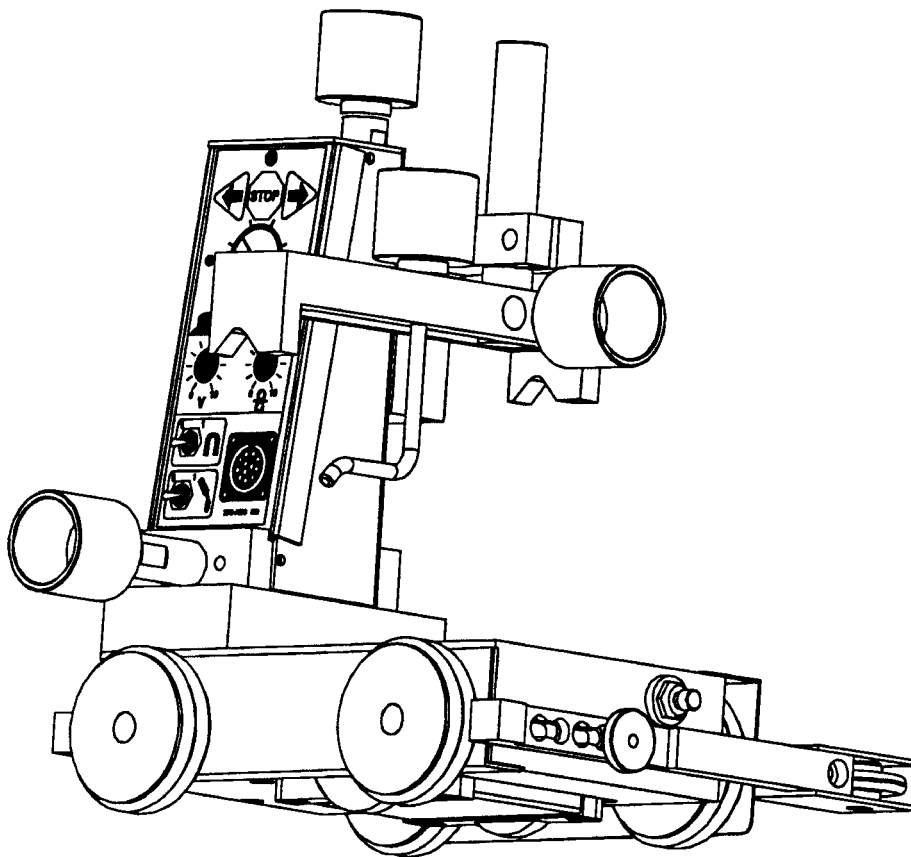




Miggytrac 1000



**Bruksanvisning
Brugsanvisning
Bruksanvisning
Käyttöohjeet
Instruction manual
Betriebsanweisung
Manuel d'instructions**

**Gebruiksaanwijzing
Instrucciones de uso
Istruzioni per l'uso
Manual de instruções
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FÖRSÄKRAN OM ÖVERENSSTÄMMELSE

ESAB AB, Welding Automation, SE-695 81 Laxå, Sverige, försäkrar under eget ansvar att svetsautomat **Miggytrac 1000** från serienummer **739** är i överensstämmelse med standard IEC/EN 60292 och IEC/EN 60204-1 enligt villkoren i direktiv (98/37/EG) och standard EN 50199 enligt villkoren i direktiv (89/336/EEG).

ÖVERENSSTEMMELSEERKLÄRING

ESAB AB, Welding Automation, SE-695 81 Laxå, Sverige, erklærer på eget ansvar, at svejseautomat **Miggytrac 1000** fra serienummer **739** er i overensstemmelse med standarden IEC/EN 60292 og IEC/EN 60204-1 ifølge betingelserne i direktiv (98/37/EØF) og standarden EN 50199 ifølge betingelserne i direktiv (89/336/EØF).

FORSIKRING OM SAMSVAR

Esab Welding Equipment AB, SE-695 81 Laxå, Sverige, försäkrar på eget ansvar at sveiseautomat **Miggytrac 1000** fra serienummer **739** er i overensstemmelse med standard EN 60292 og EN 60204-1 i følge vilkårene i direktiv (98/37/EF) og standard EN 50199 i følge vilkårene i direktiv (89/336/EF).

VAATIMUSTENMUKAISUUSVAKUUTUS

ESAB AB, Welding Automation, SE-695 81 Laxå, Ruotsi, vakuuttaa omalla vastuullaan, että hitsausautomaatti **Miggytrac 1000** alkaen sarjanumerosta **739** täyttää standardin IEC/EN 60292 ja IEC/EN 60204-1 vaatimukset direktiivin (98/37/ETY) ehtojen mukaisesti sekä standardin EN 50199 vaatimukset direktiivin (89/336/ETY).

DECLARATION OF CONFORMITY

ESAB AB, Welding Automation, SE-695 81 Laxå, Sweden, gives its unreserved guarantee that automatic welding machine **Miggytrac 1000** from serial number **739** complies with standard IEC/EN 60292 and IEC/EN 60204-1, in accordance with the requirements of directive (98/37/EEC) and with standard EN 50199, in accordance with the requirements of directive (89/336/EEC).

ZULASSUNGSNACHWEIS

ESAB AB, Welding Automation, SE-695 81 Laxå Schweden, bestätigt hiermit in Eigenverantwortung, daß der Schweißautomat **Miggytrac 1000** ab Seriennummer **739** dem Standard IEC/EN 60292 und IEC/EN 60204-1 gemäß den Bedingungen der Direktive (98/37/EEG) und dem Standard EN 50199 gemäß den Bedingungen der Direktive (89/336/EEG).

CERTIFICAT DE CONFORMITÉ

ESAB AB, Welding Automation, SE-695 81 Laxå, Suède, certifie que la appareil de soudage automatique **Miggytrac 1000** à partir du numéro de série **739** est conforme à la norme IEC/EN 60292 et IEC/EN 60204-1 selon les conditions de la directive (98/37/CEE) et à la norme EN 50199 selon les conditions de la directive (89/336/CEE).

VERKLARING VAN OVEREENSTEMMING

ESAB AB, Welding Automation, SE-695 81 Laxå Zweden, verklaart geheel onder eigen verantwoordelijkheid dat lasautomaat **Miggytrac 1000** van het serienummer **739** in overeenstemming is met norm IEC/EN 60292 en IEC/EN 60204-1 conform de bepalingen in richtlijn (98/37/EEG) en met norm EN 50199 conform de bepalingen in richtlijn (89/336/EEG).

DECLARACIÓN DE CONFORMIDAD

ESAB AB, Welding Automation, SE-695 81 Laxå, Suecia, garantiza bajo propia responsabilidad que la equipo para soldadura automática **Miggytrac 1000** a partir del número de serie **739** concuerda con la norma IEC/EN 60292 y IEC/EN 60204-1 conforme a la directiva (98/37/CEE) y con la norma EN 50199 según los requisitos de la directiva (89/336/CEE).

DICHIARAZIONE DI CONFORMITA

ESAB AB, Welding Automation, SE-695 81 Laxå Svezia, dichiara sotto la propria responsabilità che la saldatrice automatica **Miggytrac 1000** con numero di serie a partire da **739** è conforme alla norma IEC/EN 60292 e IEC/EN 60204-1 come previsto dalla direttiva (98/37/CEE) ed alla norma EN 50199 come previsto dalla direttiva (89/336/CEE).

DECLARAÇÃO DE CONFORMIDADE

ESAB AB, Welding Automation, SE-695 81 Laxå Suécia, garante sob responsabilidade própria que, o equipamento automático para soldadura **Miggytrac 1000** a partir do número de série **739** está em conformidade com a norma IEC/EN 60292 e IEC/EN 60204-1 segundo os requisitos da directiva (98/37/CEE) e com a norma EN 50199 segundo os requisitos da directiva (89/336/CEE).

ΔΗΛΩΣΗ ΣΥΜΜΟΡΦΩΣΗΣ

Η εταιρεία ESAB AB, Welding Automation, SE-695 81 Laxå, Σουηδία, δηλώνει ότι τα μηχανήματα αυτόματες συγκολλητήs **Miggytrac 1000** από τον αριθμό σειράs **739** και έπειτα, συμμορφώνονται με το πρότυπο IEC/EN 60292 και IEC/EN 60204-1 σύμφωνα με τις απαιτήσεις της οδηγίας (98/37/EEG) και το πρότυπο EN 50199 σύμφωνα με τις απαιτήσεις της οδηγίας (89/336/EEG).

CERTYFIKAT ZGODNOŚCI

Firma ESAB AB, Welding Automation, SE-695 81 Laxå, Szwecja, gwarantuje pod rygorem odpowiedzialności, że automat spawalniczy **Miggytrac 1000** od numeru seryjnego **739** spełnia wymagania normy IEC/EN 60292 i IEC/EN 60204-1 według dyrektywy (98/37/EG) oraz normy EN 50199 według dyrektywy (89/336/EEG).

Laxå 2004-04-16



Henry Selenius
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SE-695 81 LAXÅ
SWEDEN

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1 SAFETY

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!

2 INTRODUCTION

2.1 General

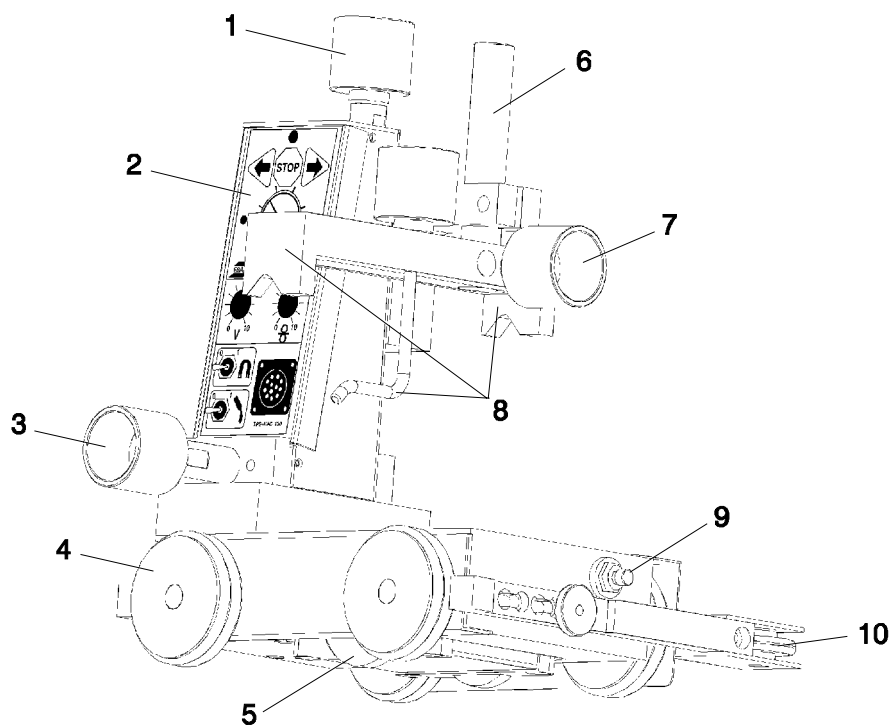
Miggytrac 1000 is designed for MIG/MAG welding of plates and beams.

The welding carriage is powered by an electric motor. It is provided with a 12-pin Burndy socket for connection to a corresponding 23-pin socket on the wire feed unit MEK 4 for remote control of the wire feed.

Miggytrac 1000 is a small compact motor-driven carriage on which an ESAB standard welding gun can easily be fitted. The four driving wheels together with a powerful electro-magnet which is integrated in the chassis of the carriage guarantee smooth and regular operation. The magnet keeps the carriage in the right position on the plate even in the case of welding on bent plates or if a long hose bundle is used. The carriage follows the joint by means of two guide wheels, one at each end of the carriage. The wheels are adjusted in such a way as to make the carriage travel diagonally towards the flange to be welded. Both the carriage and the welding process are stopped automatically by way of limit switches.

From the control panel the carriage can be started in the desired direction, the welding speed steplessly adjusted and the welding and the magnet switched ON/OFF. Remote control of the wire feed unit is integrated in the control panel. There are also two potentiometers for adjustment of wire feed speed and voltage.

- 1 Vertical slide adjustment
- 2 Control panel
- 3 Lateral slide adjustment
- 4 Driving wheels
- 5 Electro-magnet
- 6 Coarse vertical slide adjustment
- 7 Gun angle adjustment
- 8 3-point gun bracket
- 9 Limit switch
- 10 Support wheels



2.2 Technical data

Miggytrac 1000	
Supply voltage	36 - 46 VAC
Power	50 W
Welding speed	150 - 1200 mm/min
Dimensions (l x w x h)	262 x 268 x 324 mm
Weight	8 kg
Slide adjustment	+/- 20 mm
Remote control socket	Volt and ampere (wire feed)
Max. values, remote control	10 kohm, 0.1 W
Max. current, start relay	2 A
Connection	Burndy, 12 pin
Enclosure class	IP 23

Enclosure class

The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP 23** is designed for indoor and outdoor use.

3 INSTALLATION

3.1 General

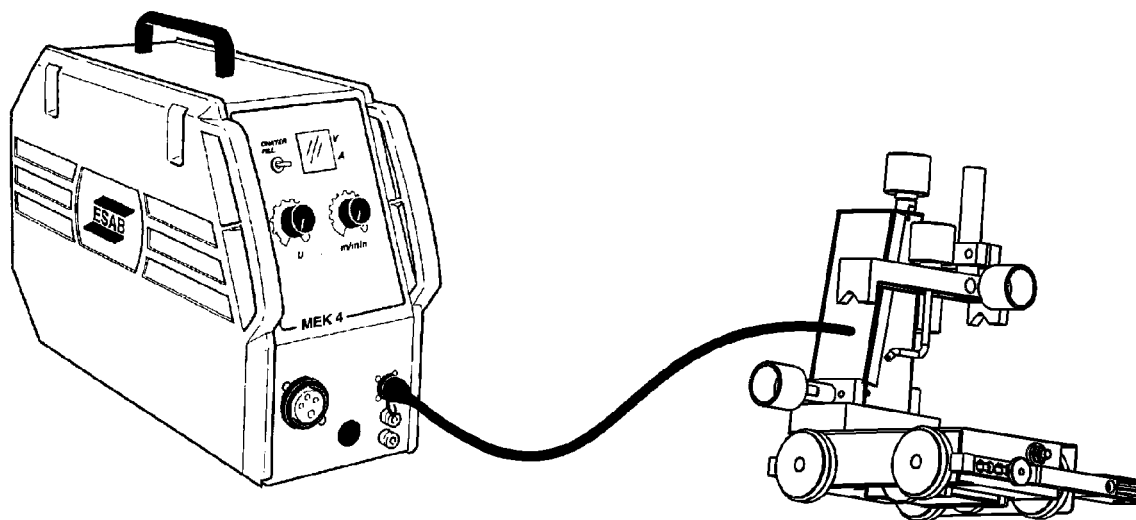
The installation must be executed by a professional.

Miggytrac 1000 can be connected to one of the wire feed units MEK 4, MEK 4SP, MEK 4C, MEK 44C, MED 44A, MEH 30, MEH 44, MED 302, MED 304, MED 44B or MEK 2.. In the case of welding at a great distance from the feed unit an intermediate wire feed unit (MEK 25) can be connected.

For necessary adaptation of these units, see side NO TAG.

Miggytrac 1000 can also be powered by other power sources via a transformer unit, see side

For connection of the wire feed unit to Miggytrac 1000, use control cable acc. to Accessories, pos 1.

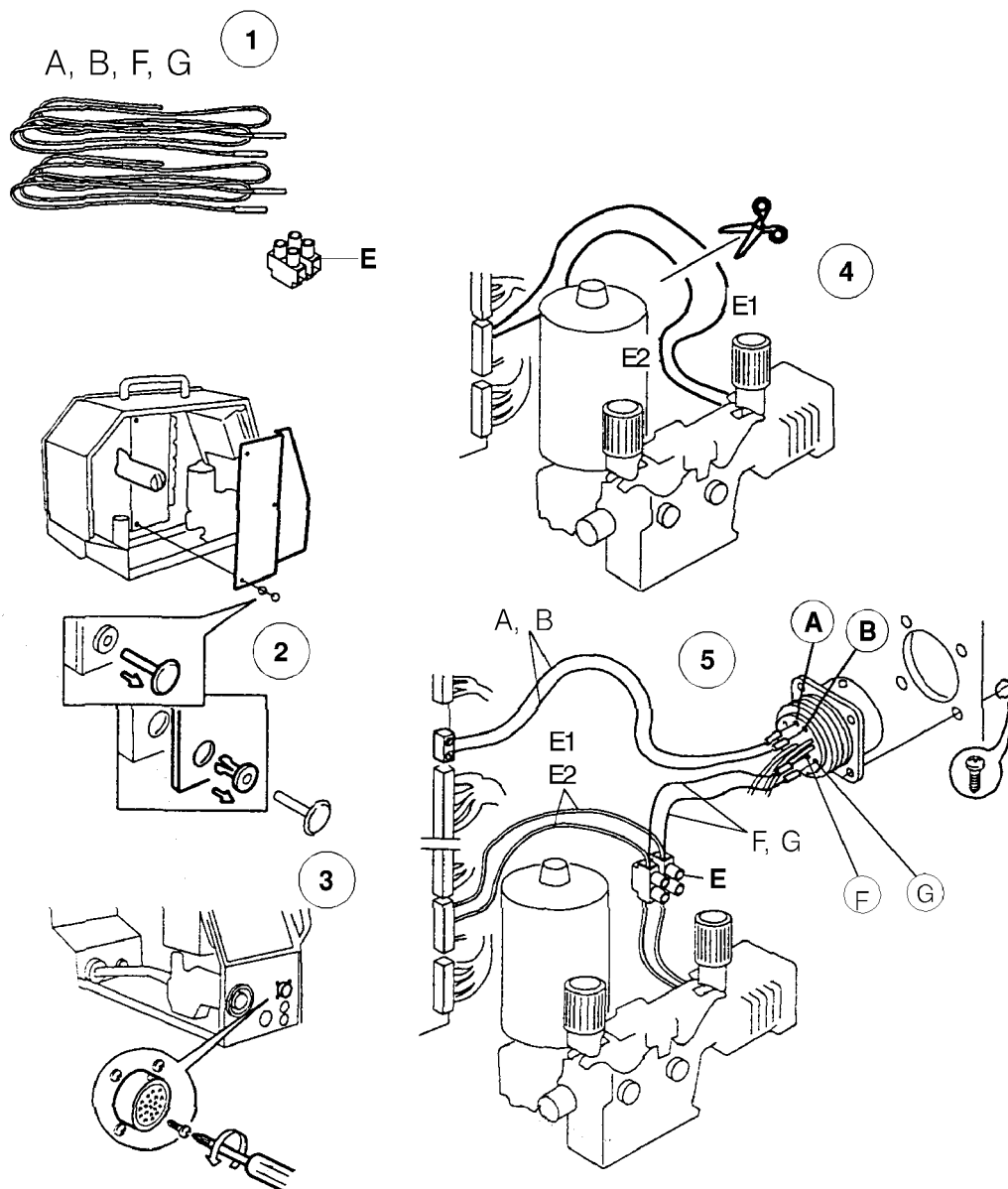


3.2 Other connections

MEK 4 / MEK 4SP → MIGGYTRAC 1000

Accessories: cables A, B, F and G, terminal block E, ①.

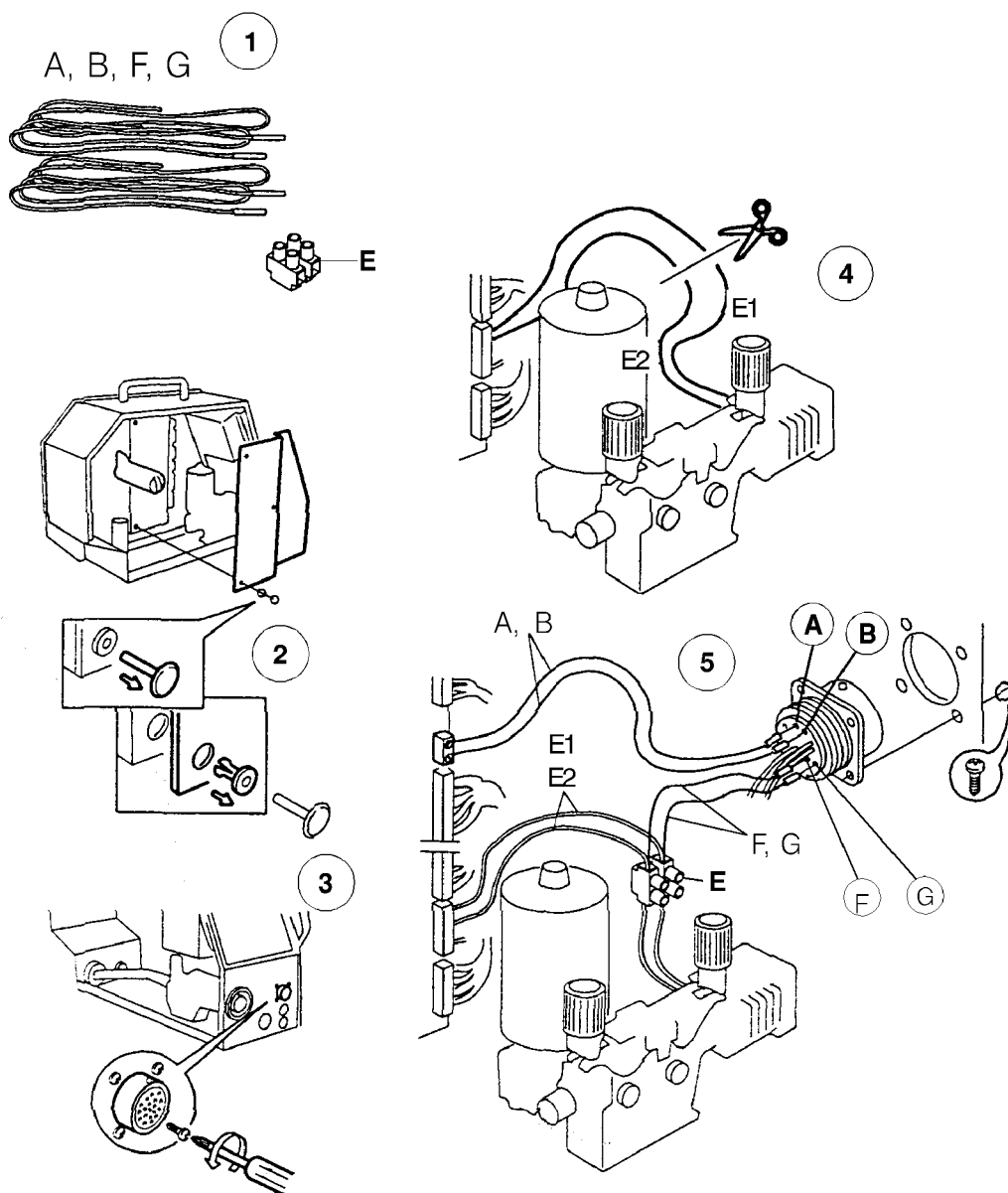
- Remove the cover, ②.
- Unscrew the sleeve socket, ③.
- Cut off the cables E1 and E2, ④.
- Connect the two cables to terminal block E and cables F and G, ⑤.
- Connect the cables A and B between the terminal block, G1 and G2, and the sleeve socket, pins A and B, ⑤.
- Connect the cables F and G to the sleeve socket, pins F and G ⑤.
- Fasten the sleeve socket, ③.
- Fit the cover, ②.



MEK 4C → MIGGYTRAC 1000

Accessories: The cables A, B, F, G and terminal block E, ①.

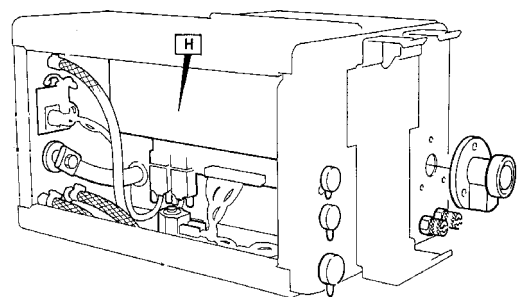
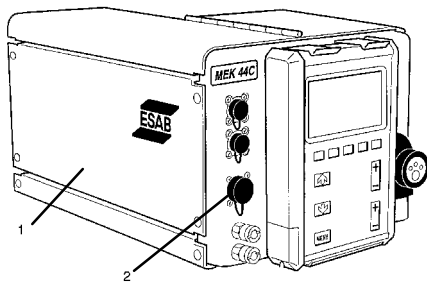
- Remove the cover, ②.
- Unscrew the sleeve socket, ③.
- Cut off the cables E1 and E2, ④.
- Connect the two cables to terminal block E and cables F and G, ⑤.
- Connect the cables A and B between the terminal block, J1 and J2, and the sleeve socket, pins A and B, ⑤.
- Connect the cables F and G to the sleeve socket, pins F and G, ⑤.
- Fasten the sleeve socket, ③.
- Fit the cover, ②.



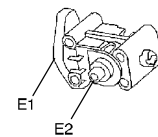
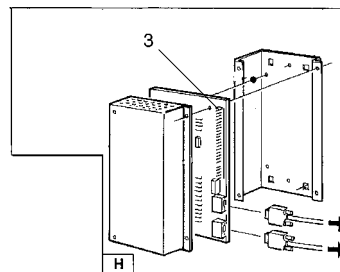
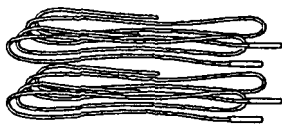
MEK 44C → MIGGYTRAC 1000

Accessories: The cables C, D, J, K and terminal block E.

- Remove the cover (1).
- Unscrew the sleeve socket (2), 23-pol.
- Connect the cables J and K between the terminal block, J1 and J2, on circuit card AP01 (3) and sleeve socket (2), pins A and B.
- Cut off the cables E1 and E2.
- Connect the two cables to terminal block E and cables C and D.
- Connect the cables C and D to the sleeve socket (2), pins G and F.
- Fasten the sleeve socket , (2).
- Fit the cover, (1).



C, D, J, K



MED 44A → MIGGYTRAC 1000

Accessories: The cables C, D, J, K and terminal block E.

- Remove the cover, (1).
- Unscrew the sleeve socket (2), 23-pol.
- Connect cable C between terminal block M7 (5) screw no. 10 and sleeve socket (2), pin A.
- Connect cable D between terminal block M7 (5) screw no. 11 and sleeve socket (2), pin B.
- Cut off the cables 093 and 094.
- Connect the two cables to terminal block E and cables J and K.
- Connect the cables J and K to sleeve socket (2), pins G and F.
- Fasten the sleeve socket, (2).
- Fit the cover, (1).

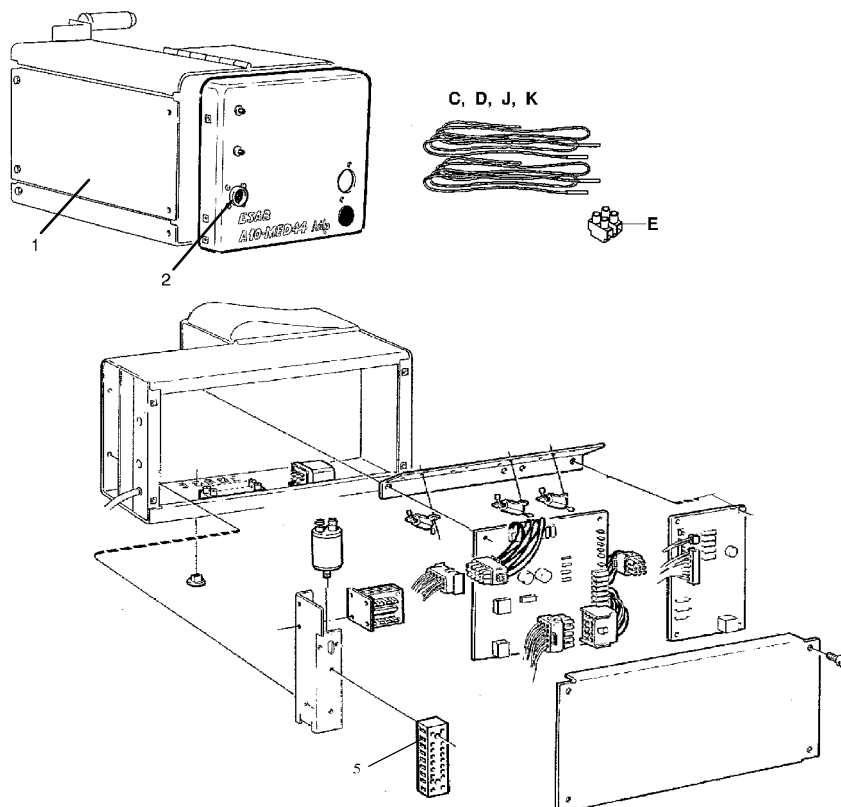
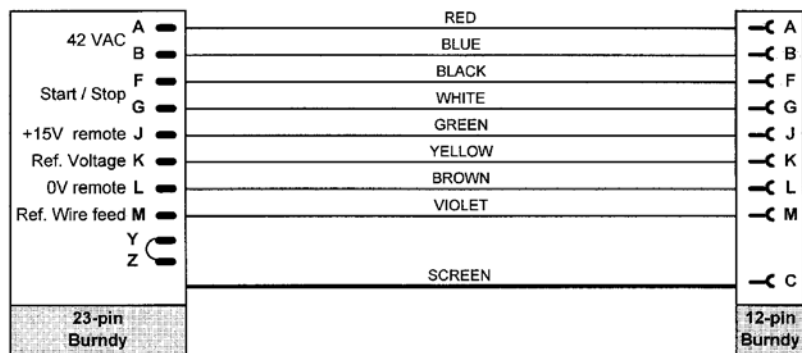


Diagram MEK 4, MEK 4SP, MEK 4C, MEK 44C, MED 44A → MIGGYTRAC 1000



MEH 30 / MEH 44 → MIGGYTRAC 1000

Cable set 0443 341 880 consists of a 4-pole Amphenol sleeve socket to be fitted in the prepared hole (2). By using a separate contact for Miggytrac 1000 the possibility of using a remote control unit remains.

- Remove the side plate.
- Unscrew the sleeve socket, (2).
- Connect cable A (600 mm) between terminal block B (1) no. 1 on the circuit card, parallel to the pink cable and sleeve socket (2), pin A.
- Connect cable B (600 mm) between terminal block B (1) no. 2 on the circuit card, parallel to the grey cable and sleeve socket (2), pin B.
- Connect cable C (160 mm)) between the flat-pin connection on the connection plate parallel to cable 011 (4) and sleeve socket (2), pin C.
- Pull the insulating hose (Elcotherm) over the 110 mm cable.
- Connect cable D (160 mm) between the flat-pin connection on the connection plate parallel to cable 012 (3) and sleeve socket (2), pin D.
- Pull the insulating hose (Elcotherm) over the 110 mm cable.
- Fasten the sleeve socket, (2).
- Fit the side plate.
- Connect the 12-pole Burndy contact to the sleeve socket, (5).

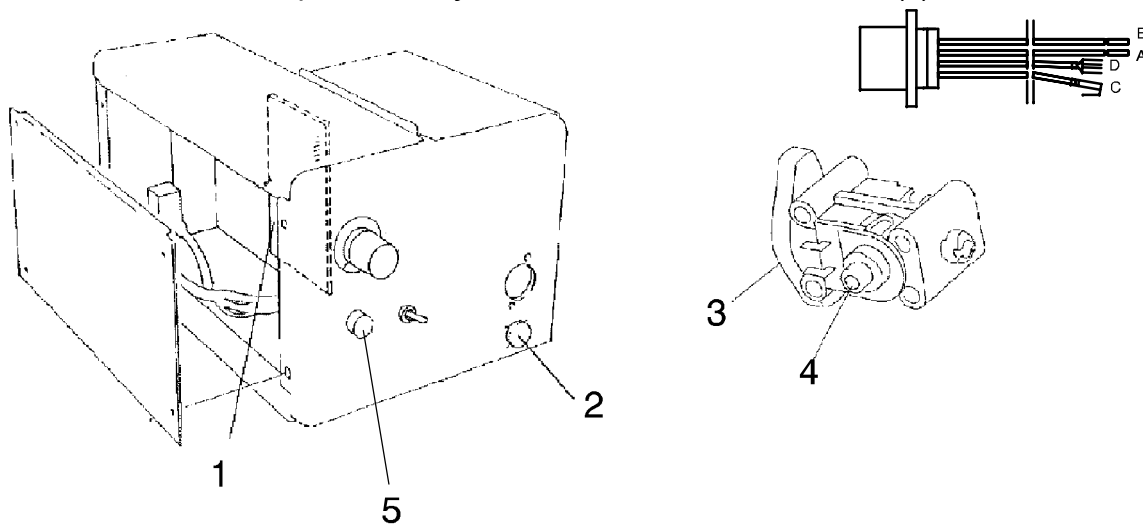
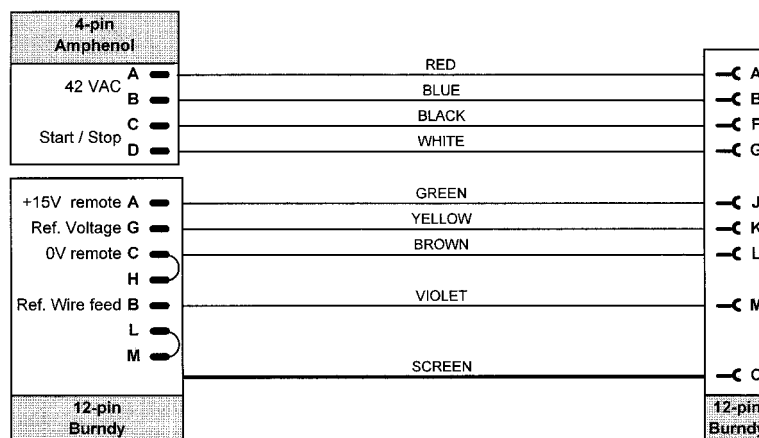


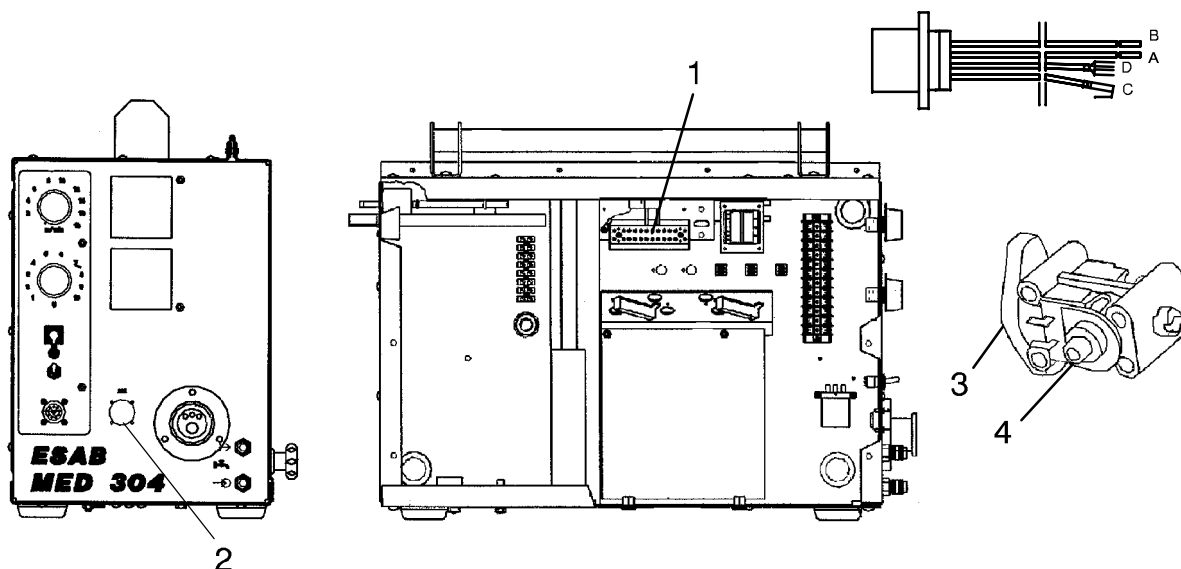
Diagram MEH 30, MEH 44 → MIGGYTRAC 1000



MED 302 / MED 304 → MIGGYTRAC 1000

Cable set 0443 341 880 consists of a 4-pole Amphenol sleeve socket to be fitted in the prepared hole (2). By using a separate contact for Miggytrac 1000 the possibility of using a remote control unit remains.

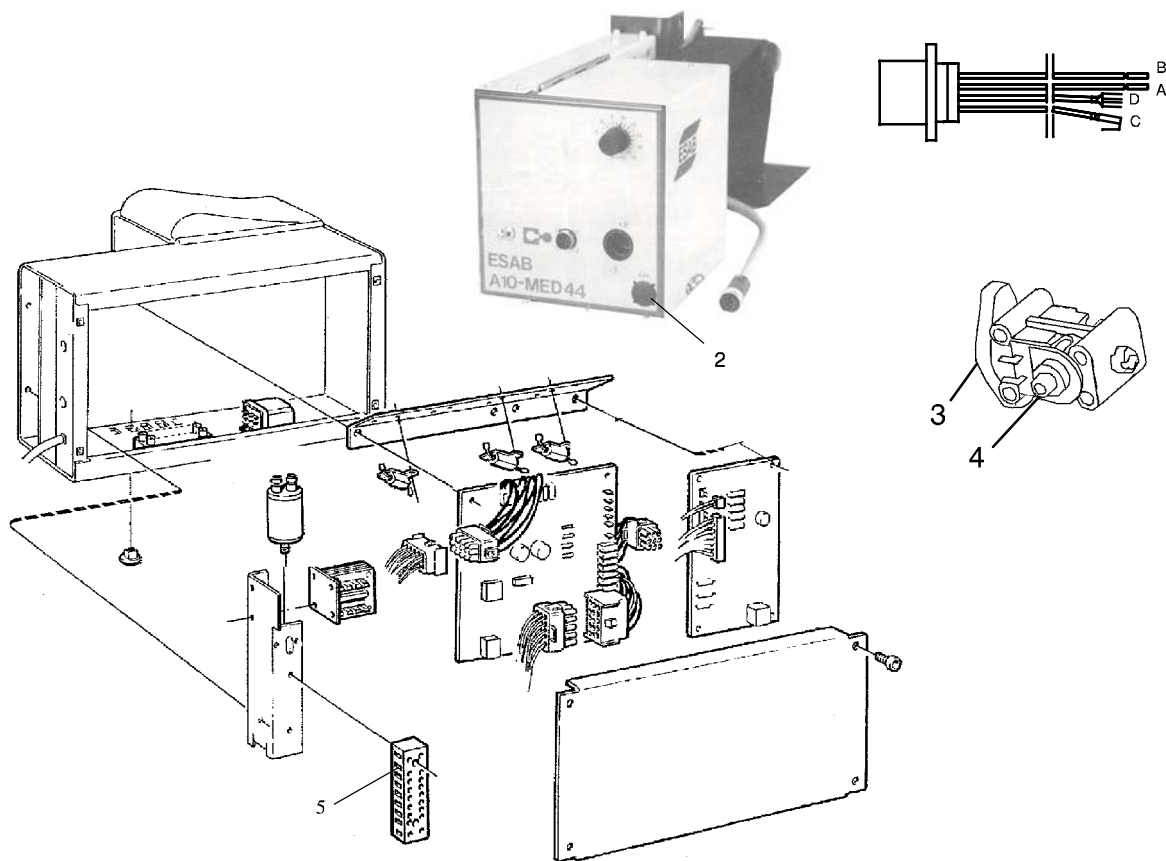
- Remove the side plate.
- Remove the plug, (2).
- Connect cable A between terminal block M7 (1) no. 1 on the circuit card, and sleeve socket (2), pin A.
- Connect cable B between terminal block M7 (1) no. 2 on the circuit card, and sleeve socket (2), pin B.
- Connect cable C between the flat-pin connection on the connection plate parallel to cable 047 (4) and sleeve socket (2), pin C.
- Connect cable D between the flat-pin connection on the connection plate parallel to cable 045 (3) and sleeve socket (2), pin D.
- Fit the side plate.



MED 44B → MIGGYTRAC 1000

Cable set 0443 341 880 consists of a 4-pole Amphenol sleeve socket to be fitted in the prepared hole (2). By using a separate contact for Miggytrac 1000 the possibility of using a remote control unit remains.

- Remove the side plate.
- Remove the plug, (2).
- Connect the cable between terminal block M7 (5) no. 10 on the circuit card, and sleeve socket (2), pin A.
- Connect the cable between terminal block M7 (5) no. 11 on the circuit card, and sleeve socket (2), pin B.
- Connect the cable between the flat-pin connection on the connection plate parallel to cable 066 (4) and sleeve socket (2), pin C.
- Connect the cable between the flat-pin connection on the connection plate parallel to cable 062 (3) and sleeve socket (2), pin D.
- Fit the side plate.



MEK 2 → MIGGYTRAC 1000

Cable set 0443 341 880 consists of a 4-pole Amphenol sleeve socket to be fitted in the prepared hole (2). By using a separate contact for Miggytrac 1000 the possibility of using a remote control unit remains.

- Open the cover, (6).
- Remove the side plate, (2).
- Remove the plug, (7).
- Cut off the cables E1 and E2, (4).
- Connect the two cables to terminal block E and cables C and D, and to the sleeve socket, pins C and D, (5).
- Connect the cables A and B to the terminal block, H01 and H02, and the sleeve socket, pins A and B, (5).
- Fasten the sleeve socket, (7).
- Fit the side plate, (2).
- Close the cover, (6).

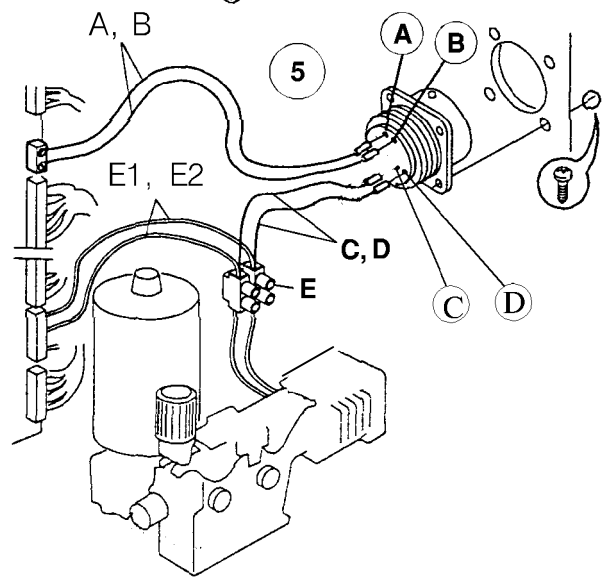
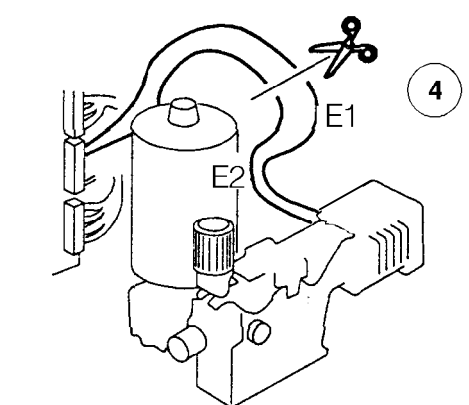
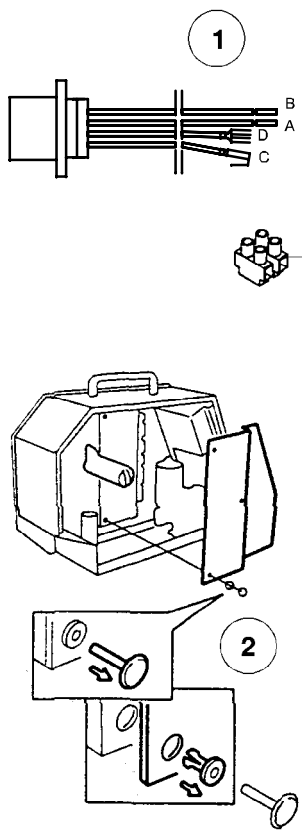
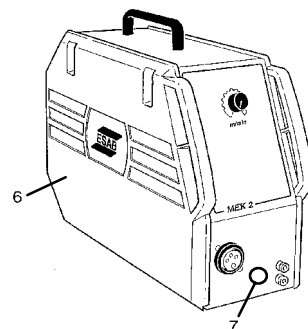
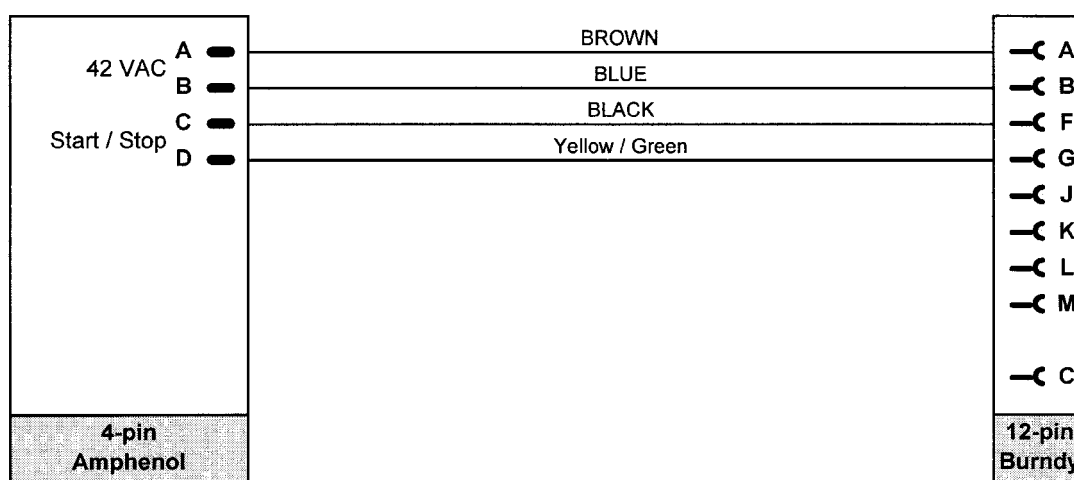


Diagram MED 302, MED 304, MED 33B, MEK 2 → MIGGYTRAC 1000



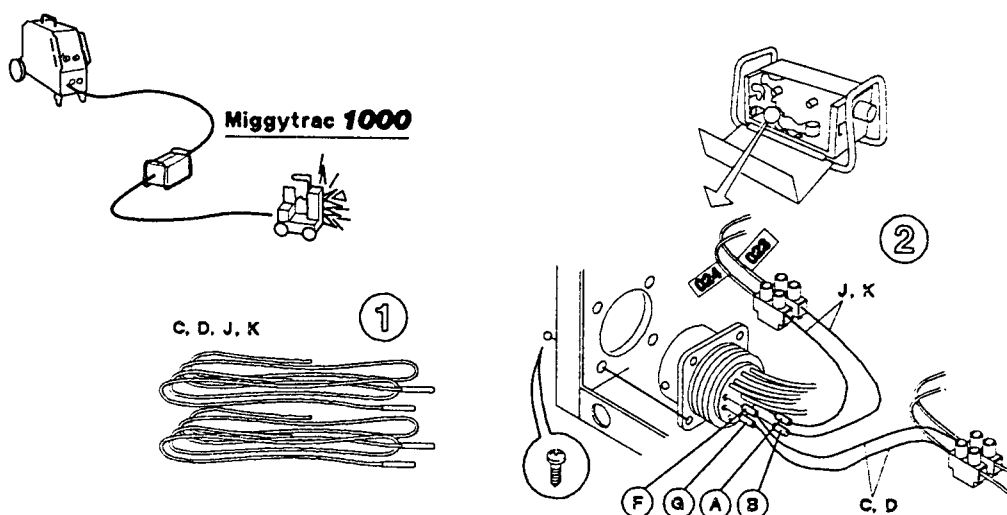
Intermediate wire feed unit MEK 25

Prepare MEK 25 as follows:

Accessories: cables C, D, J and K acc. to ①.

- Open the wire feed unit, see ②.
- Unscrew the sleeve socket.
- Connect the cables J and K to the terminal block already existing on the cables 024 and 025 and to the sleeve socket.
- Connect the cables C and D between the sleeve socket and the existing terminal block, ②.

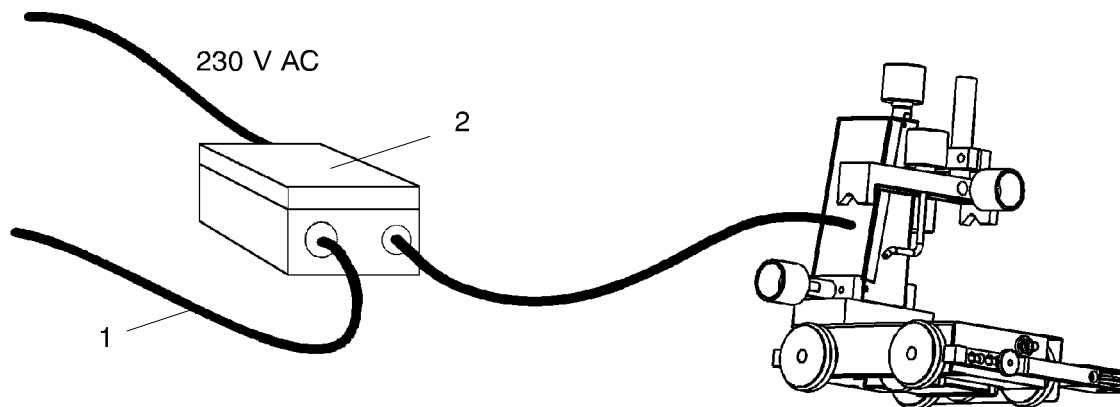
For connection of MEK 25 to Miggytrac 1000, see Accessories, see page 90.



Universal

For the operation of Miggytrac 1000 from other power sources, use transformer unit and control cable acc. to Accessories, see page 90.

- 1 Control cable for other power sources
- 2 Transformer unit



4 OPERATION

4.1 General

General safety regulations for the handling of the equipment can be found on page 75. Read through before you start using the equipment!

- Place Miggytrac 1000 near the joint to be welded.
- Adjust the distance and the direction by way of the guide wheels, which shall press slightly against the flange during operation and by that guide the carriage.

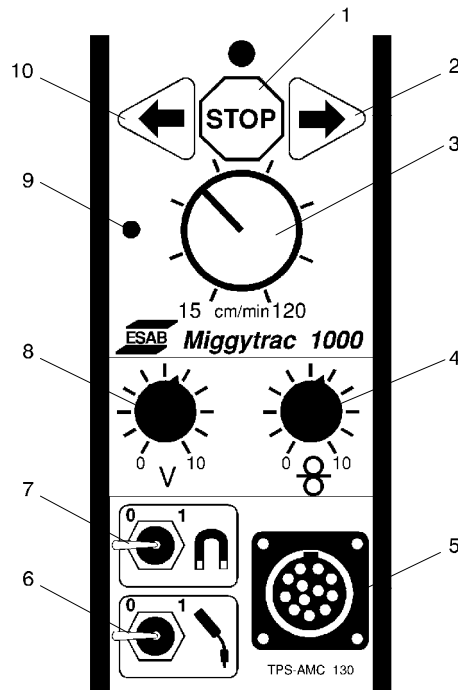
When the magnet is activated the friction between the driving wheel and the plate is increased and the risk of slipping diminishes. The magnet is activated over the welding start switch. Strike the arc using the welding start switch.

- Start the welding motion in optional direction.

A lamp indicates power ON. The speed of the carriage, arc voltage and welding current (wire feed speed) are adjusted from the control panel.

4.2 Controls and connections

- | | |
|--------------------------------------|-----------------------------------|
| 1 Stop | 6 Welding start ON / OFF |
| 2 Start to the right | 7 Magnet ON / OFF |
| 3 Travel speed | 8 Remote control, welding voltage |
| 4 Remote control, welding current | 9 Power indicating lamp |
| 5 12-pin Burndy control cable socket | 10 Start to the left |



5 MAINTENANCE

5.1 General

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.

5.2 Daily

- Check that all cables and plugs are in good condition.
- Clean the magnet fitted under the carriage.
- Clean the guide wheels.

5.3 As necessary

- Replace the O-rings (8 pcs.) on the driving wheels.
- Lubricate the guide wheels and the limit switches using thin oil.

6 ACCESSORIES

	MEK 4	MEK 4SP	MEK 4C	MEK 44C	MED 44A
Control cable 23-p 0457 360 880	X	X	X	X	X
Cable kit, remote control socket 23-p 0457 462 880	X	X	X	X	X

	MEH 30	MEH 44	MED 302	MED 304	MED44B	MEK 2	Universal
Control cable 4-p , 12-p 0457 360 883	X	X					
Cable kit 0443 341 880	X	X	X	X	X	X	
Control cable 4-p 0457 360 882			X	X	X	X	
Control cable 0457 360 881							X
Transformer 0457 467 880							X

3. Welding screen

0457 463 880

4. Bracket for water-cooled PSF

0457 357 251

7 ORDERING OF SPARE PARTS

Miggytrac 1000 is designed and tested in accordance with the EN 60 292 (IEC 292) international standard.
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 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 229. This will simplify dispatch and ensure you get the right part.

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