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# DIAGRAM

# ORDERING NUMBER

# WEAR PARTS

# ACCESSORIES
1 DIRECTIVE

DECLARATION OF CONFORMITY

ESAB AB, Welding Equipment, SE-695 81 Laxå, Sweden, declares that Wire feed unit Feed L3004 from serial number 613 are constructed and tested in compliance with the standard EN 60974-5 and EN 60974-10 (Class A) in accordance with the requirements of directive (2006/95/EC) and (2004/108/EEC).

Laxå 2007-03-14

Kent Eimbrodt
Global Director
Equipment and Automation

2 SAFETY

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

2. The operator must ensure that:
   - no unauthorized person is stationed within the working area of the equipment when it is started up.
   - no-one is unprotected when the arc is struck

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

4. Personal safety equipment
   - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
   - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.

5. General precautions
   - Make sure the return cable is connected securely.
   - Work on high voltage equipment may only be carried out by a qualified electrician.
   - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
   - Lubrication and maintenance must not be carried out on the equipment during operation.
WARNING

Arc welding and cutting can be injurious to yourself and others. Take precautions when welding and cutting. Ask for your employer’s safety practices which should be based on manufacturers’ hazard data.

ELECTRIC SHOCK - Can kill
• Install and earth the 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.

PROTECT YOURSELF AND OTHERS!

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

CAUTION
Read and understand the instruction manual before installing or operating.

CAUTION
This product is solely intended for arc welding.

Dispose of electronic equipment at the recycling facility!
In observance of European Directive 2002/96/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.
3 INTRODUCTION

The wire feed units Feed L3004 with control panels U6, MA23 or MA23A are intended for MIG/MAG welding with the Mig L3000i power source.

They come in different variants, see page 14.

The wire feed units contain four-wheel drive wire feed mechanisms as well as control electronics.

They can be used together with wire on ESAB’s MarathonPac™, or on wire bobbin (standard Ø 300 mm, accessory Ø 440 mm).

The wire feed unit can be installed either at the trolley for the power source, suspended above the workplace, on a counter balance device or on the floor with or without wheel set.

ESAB's accessories for the product can be found on page 18.

3.1 Equipment

The wire feed unit is supplied with:
- instruction manual for the wire feed unit
- instruction manual in english for the control panel
- decal with recommended wear parts.

Instruction manuals in other languages can be downloaded from the website, www.esab.com.

3.2 Control panel

The units are supplied with one of the following control panels:

<table>
<thead>
<tr>
<th>Equipment</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>U6</td>
<td>With knobs for setting the voltage and wire feed speed / current. Other settings by pushbuttons, with text indication on the display panel.</td>
</tr>
<tr>
<td>MA23</td>
<td>With knobs for setting the voltage and wire feed speed / current. Other settings by pushbuttons.</td>
</tr>
<tr>
<td>MA23A</td>
<td>With knobs for setting the voltage / QSet™ and wire feed speed / current. Other settings by pushbuttons.</td>
</tr>
</tbody>
</table>

Detailed descriptions of the control panels can be found in separate Instruction manual.
4 TECHNICAL DATA

<table>
<thead>
<tr>
<th>Feed L3004</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Power supply</strong></td>
</tr>
<tr>
<td><strong>Power requirement</strong></td>
</tr>
<tr>
<td><strong>Motor current</strong> $I_{\text{max}}$</td>
</tr>
<tr>
<td><strong>Wire feed speed</strong></td>
</tr>
<tr>
<td><strong>Gun connection</strong></td>
</tr>
<tr>
<td><strong>Max. diameter wire bobbin</strong></td>
</tr>
<tr>
<td><strong>Wire dimension</strong></td>
</tr>
<tr>
<td>Fe</td>
</tr>
<tr>
<td>Ss</td>
</tr>
<tr>
<td>Al</td>
</tr>
<tr>
<td>Cored wire</td>
</tr>
<tr>
<td><strong>Weight</strong></td>
</tr>
<tr>
<td><strong>Dimensions (l x w x h)</strong></td>
</tr>
<tr>
<td><strong>Operating temperature</strong></td>
</tr>
<tr>
<td><strong>Shielding gas</strong></td>
</tr>
<tr>
<td>max pressure</td>
</tr>
<tr>
<td><strong>Type of cooling</strong></td>
</tr>
<tr>
<td>max pressure</td>
</tr>
<tr>
<td><strong>Maximum permissible load at 60% duty cycle</strong></td>
</tr>
<tr>
<td><strong>Enclosure class</strong></td>
</tr>
<tr>
<td>with sealed bobbin holder</td>
</tr>
<tr>
<td>without sealed bobbin holder</td>
</tr>
</tbody>
</table>

* Accessories, see page 18.

**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.

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

**Enclosure class**
The IP code indicates the enclosure class, i.e. the degree of protection against penetration by solid objects or water. Apparatus marked IP2X are intended for indoor use.

5 INSTALLATION

The installation must be executed by a professional.
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.

WARNING
When welding in an environment with increased electrical danger, only power sources intended for this environment may be used. These power sources are marked with the symbol S.

5.1 Lifting instructions

Order number for lifting eyelet can be found on page 18.

Note! If another mounting device is used, this must be electrically insulated from the wire feed unit.
General safety regulations for the handling of the equipment can be found on page 3. Read through before you start using the equipment!

NOTE: When moving the equipment use intended handle. Never pull on the gun.

WARNING
Assure that the side panels are closed during operation.

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.
6.1 Connections and control devices

1  Control panel, (see separate instruction manual)
2a Connection for remote control unit
2b Connection for U82
3 Connection BLUE, with ELP* for coolant to the welding gun
4 Connection RED, for coolant from welding gun
5 Connection for welding gun
6 Connection for welding current from power source, (OKC)
7 Connection for control cable from power source or cooling unit
8 Connection RED, for coolant to cooling unit
9 Connection for shielding gas
10 Connection BLUE, for coolant from cooling unit

Note! Coolant connections only available on certain models.
* ELP = ESAB Logic Pump, see point 6.2.
6.2 Water connection

The wire feed unit with water connection is equipped with a detection system ELP (ESAB Logic Pump) which checks that the water hoses are connected. When connecting a water-cooled welding gun, the water pump starts. Detection only works with power sources that are equipped with ELP.

6.3 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.

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 gun approx. 5 mm from the piece of wood (fig. 1) the feed rollers should slip.

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

6.4 Replacing and inserting wire

- Open the side panel.
- Disconnect the pressure sensor by folding it backwards, the pressure rollers slide up.
- Straighten out the new wire 10-20 cm. File away 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's track and into the outlet nozzle and the wire guide.
- Secure the pressure sensor.
- Close the side panel.

6.5 Changing feed rollers

- Open the side panel.
- Disconnect the pressure sensor (1) by folding it backwards, the pressure rollers slide up.
- Disconnect the pressure rollers (2) by turning the axle (3) 1/4 turn clockwise and pulling out the axle. The pressure rollers disconnect.
- Disconnect the feed rollers (4) by unscrewing the nuts (5) and pulling out the rollers.
During installation, repeat the above in the reverse order.

**Choice of tracks in the feed rollers**
Turn the feed roller with the dimensioning mark for the required track towards you.

### 7 MAINTENANCE

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

**CAUTION**

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

#### 7.1 Inspection and cleaning

**Wire feed unit**
Check regularly that the wire feed unit is not clogged with dirt.

- Cleaning and replacement of the wire feed unit mechanism's worn parts should take place at regular intervals in order to achieve trouble-free wire feed. Note that if pre-tensioning is set too hard, this can result in abnormal wear on the pressure roller, feed roller and wire guide.

**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 counterclockwise to increase the braking torque. **NB:** Turn both springs through the same amount.

**Welding gun**
- Cleaning and replacement of the welding gun'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.

### 8 ORDERING SPARE PARTS

Feed L3004 is designed and tested in accordance with the international and European standards 60974-5 and 60974-10. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts may be ordered through your nearest ESAB dealer, see the last page of this publication.
Feed L3004

Ordering number

<table>
<thead>
<tr>
<th>Ordering no.</th>
<th>Denomination</th>
<th>Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>0458 806 586</td>
<td>Wire feed unit</td>
<td>Aristo™ Feed L3004, U6</td>
</tr>
<tr>
<td>0458 806 596</td>
<td>Wire feed unit</td>
<td>Aristo™ Feed L3004w, U6 with water cooling</td>
</tr>
<tr>
<td>0459 116 597</td>
<td>Wire feed unit</td>
<td>Origo™ Feed L3004w, MA23 with water cooling</td>
</tr>
<tr>
<td>0459 116 598</td>
<td>Wire feed unit</td>
<td>Origo™ Feed L3004w, MA23A with water cooling</td>
</tr>
<tr>
<td>0459 839 001</td>
<td>Spare parts list</td>
<td>Feed L3004</td>
</tr>
<tr>
<td>0459 287</td>
<td>Instruction manual</td>
<td>Control panel U6</td>
</tr>
<tr>
<td>0459 912</td>
<td>Instruction manual</td>
<td>Control panel MA23 and MA23A</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item</th>
<th>Ordering no.</th>
<th>Denomination</th>
<th>Wire type</th>
<th>Wire dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td>HI 1</td>
<td>0455 072 002</td>
<td>Intermediate nozzle</td>
<td>Fe, Ss &amp; cored</td>
<td>Ø 2 mm steel for 0.6-1.2 mm</td>
</tr>
<tr>
<td></td>
<td>0456 615 001</td>
<td>Intermediate nozzle</td>
<td>Al</td>
<td>Ø 2.0 mm plastic for 0.8-1.2 mm</td>
</tr>
<tr>
<td>HI 2</td>
<td>0469 837 880</td>
<td>Outlet nozzle</td>
<td>Fe, Ss &amp; cored</td>
<td>Ø 2.0 mm steel for 0.6-1.2 mm</td>
</tr>
<tr>
<td></td>
<td>0469 837 881</td>
<td>Outlet nozzle</td>
<td>Al</td>
<td>Ø 2.0 mm plastic for 0.8-1.2 mm</td>
</tr>
<tr>
<td>HI 3</td>
<td>0191 496 114</td>
<td>Key</td>
<td></td>
<td></td>
</tr>
<tr>
<td>HI 4</td>
<td>0215 701 007</td>
<td>Locking washer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>HI 5a</td>
<td>0459 440 001</td>
<td>Motor gear euro</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Use only pressure and feed rollers marked A2, R2 or S2. The rollers are marked with wire dimension in mm, some are also marked with inch.

## HD = Heavy Duty

<table>
<thead>
<tr>
<th>Item</th>
<th>Ordering no.</th>
<th>Denomination</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>HI 6</td>
<td>0156 602 001</td>
<td>Inlet nozzle (HD)</td>
<td>Ø 2 mm plastic for 0.6-1.2 mm</td>
</tr>
<tr>
<td></td>
<td>0332 318 001</td>
<td>Inlet nozzle (HD)</td>
<td>Ø 2.4 mm steel for 1.2 mm</td>
</tr>
</tbody>
</table>

Welding with aluminium wire

In order to weld with aluminium wire, proper rollers, nozzles and liners for aluminium wire MUST be used. It is recommended to use 3 m long welding gun for aluminium wire, equipped with appropriate wear parts.
<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Bobbin cover, plastic Ø 300mm</td>
<td>0458 674 880</td>
</tr>
<tr>
<td>1</td>
<td>Bobbin cover, metal Ø 300mm</td>
<td>0459 431 880</td>
</tr>
<tr>
<td>1</td>
<td>Bobbin holder</td>
<td>0458 704 880</td>
</tr>
<tr>
<td>2</td>
<td>Adapter for 5 kg bobbin</td>
<td>0455 410 001</td>
</tr>
<tr>
<td>1</td>
<td>Adapter for 440 mm bobbin</td>
<td>0459 233 880</td>
</tr>
<tr>
<td>2</td>
<td>Lifting eye</td>
<td>0458 706 880</td>
</tr>
<tr>
<td>2</td>
<td>Quick connector MarathonPac™</td>
<td>F102 440 880</td>
</tr>
</tbody>
</table>

*Note! The wire feed unit must be placed on the floor when this adaptor is used.*
### Feed L3004

| 1 | Turning piece | 0458 703 880 |
| 2 | Guide pin     | 0349 302 303 |
| 3 | Quick connector MarathonPac™ | F102 440 880 |

| 1 | Wheel kit | 0458 707 880 |

| 1 | Strain relief for welding gun | 0457 341 881 |

| Strain relief bracket for connection set | 0459 234 880 |

<table>
<thead>
<tr>
<th>Connection set 50mm²</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1.7 m</td>
<td>0456 528 580</td>
</tr>
<tr>
<td>5 m</td>
<td>0456 528 581</td>
</tr>
<tr>
<td>10 m</td>
<td>0456 528 582</td>
</tr>
<tr>
<td>15 m</td>
<td>0456 528 583</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Connection set water 50mm²</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1.7 m</td>
<td>0456 528 590</td>
</tr>
<tr>
<td>5 m</td>
<td>0456 528 591</td>
</tr>
<tr>
<td>10 m</td>
<td>0456 528 592</td>
</tr>
<tr>
<td>15 m</td>
<td>0456 528 593</td>
</tr>
</tbody>
</table>
**Counter balance device** .................. 0458 705 880
(includes mast and counter balance)

**Remote control adapter RA23** 23 pole ...... 0459 491 911
For connecting welding gun with RS3 program selector to CAN based equipment.

**Remote control unit MTA1 CAN** ............ 0459 491 880
MIG/MAG: wire feed speed and voltage MMA:
current and arc force
TIG: current, pulse and background current

**Remote control unit M1 10Prog CAN** ...... 0459 491 882
Choice of on of 10 programs
MIG/MAG: voltage deviation
TIG and MMA: current deviation

**Remote cable CAN 4 pole - 12 pole**
5 m ............................................. 0459 554 880
0.25 m ........................................ 0459 554 884
Welding gun MXH 400w PP
6.0 m ........................................ 0700 200 015
10.0 m ....................................... 0700 200 016

Welding gun MXH 300 PP
6.0 m ........................................ 0700 200 017
10.0 m ....................................... 0700 200 018

Remote adapter kit
For MXH 400w PP .......................... 0459 681 881

Connection kit without wire feed speed adjustment
For MXH 400w PP .......................... 0459 020 883

Welding torch

<table>
<thead>
<tr>
<th>Type</th>
<th>Ordering no. 3 m</th>
<th>Ordering no. 4.5 m</th>
<th>Max welding current CO₂</th>
<th>Max welding current Mix Ar</th>
<th>Wire dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td>PSF 250</td>
<td>0368 100 882</td>
<td>0368 100 883</td>
<td>250A 60%</td>
<td>225A 60%</td>
<td>0.6 - 1.0</td>
</tr>
<tr>
<td>PSF 250 C</td>
<td>0468 410 882</td>
<td>0468 410 883</td>
<td>250A 60%</td>
<td>225A 60%</td>
<td>0.6 - 1.0</td>
</tr>
<tr>
<td>PSF 305</td>
<td>0458 401 880</td>
<td>0458 401 881</td>
<td>315A 60%</td>
<td>285A 60%</td>
<td>0.8 - 1.2</td>
</tr>
<tr>
<td>PSF 315 CLD</td>
<td>0468 410 885</td>
<td>0468 410 886</td>
<td>315A 60%</td>
<td>285A 60%</td>
<td>0.8 - 1.2</td>
</tr>
<tr>
<td>PSF 405</td>
<td>0458 401 882</td>
<td>0458 401 883</td>
<td>380A 60%</td>
<td>325A 60%</td>
<td>0.8 - 1.6</td>
</tr>
<tr>
<td>PSF 405 C</td>
<td>0458 499 882</td>
<td>0458 499 883</td>
<td>380A 60%</td>
<td>325A 60%</td>
<td>1.0 - 1.6</td>
</tr>
<tr>
<td>PSF 405 RS3</td>
<td>0458 401 892</td>
<td>0458 401 893</td>
<td>380A 60%</td>
<td>325A 60%</td>
<td>0.8 - 1.6</td>
</tr>
<tr>
<td>PSF 405 C RS3</td>
<td>0458 499 889</td>
<td>0458 499 889</td>
<td>380A 60%</td>
<td>325A 60%</td>
<td>1.0 - 1.6</td>
</tr>
<tr>
<td>PSF 410 CW</td>
<td>0458 450 880</td>
<td>0458 450 881</td>
<td>380A 100%</td>
<td>325A 100%</td>
<td>0.8 - 1.6</td>
</tr>
<tr>
<td>PSF 410 W</td>
<td>0458 400 882</td>
<td>0458 400 883</td>
<td>400A 100%</td>
<td>350A 100%</td>
<td>0.8 - 1.6</td>
</tr>
<tr>
<td>PSF 410 CW RS3</td>
<td>0458 450 884</td>
<td>0458 450 885</td>
<td>380A 100%</td>
<td>325A 100%</td>
<td>0.8 - 1.6</td>
</tr>
<tr>
<td>PSF 410 W RS3</td>
<td>0458 400 898</td>
<td>0458 400 899</td>
<td>400A 100%</td>
<td>350A 100%</td>
<td>0.8 - 1.6</td>
</tr>
</tbody>
</table>

= Self cooled
C = Smoke exhausters, Centrovac
LD = Smaller, Light duty
W = Water cooled
RS3 = 3-step program switch for selecting preset programs.
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