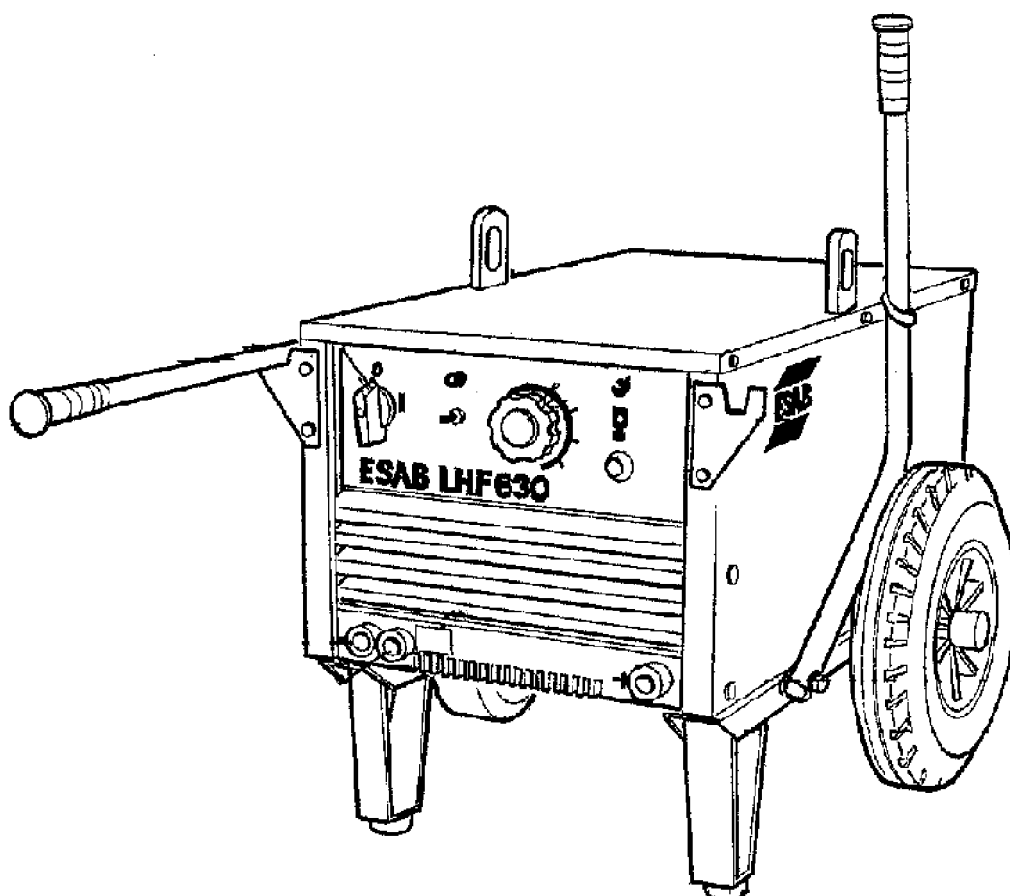


LHF 250, LHF 400, LHF 630, LHF 800



Instruction manual

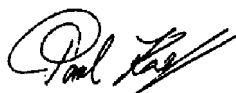
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1 DIRECTIVE

DECLARATION OF CONFORMITY

ESAB Welding Equipment AB, S-695 81 Laxå, Sweden, gives its unreserved guarantee that welding power source LHF 250 / 400 / 630 / 800 from serial number 550 complies with standard IEC/EN 60974-1, in accordance with the requirements of directive (73/23/EEC) and addendum (93/68/EEC) and with standard EN 50199 in accordance with the requirements of directive (89/336/EEC) and addendum (93/68/EEC).

Laxå 1995-04-10



Paul Karlsson
Managing Director
ESAB Welding Equipment AB
695 81 LAXÅ
SWEDEN

Tel: + 46 584 81000

Fax: + 46 584 12336

2 SAFETY



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!

3 INTRODUCTION

LHF 250/400/630/800 are thyristor controlled welding rectifiers designed for welding with coated electrodes, TIG welding and arc air gouging.

The welding rectifiers can be used with the following remote control devices:

PHA 1, PHA 2, PHA 5, PHB 1, PHB 2, och PHC 2.

An auxiliary control unit is required for TIG welding with high frequency arc ignition.

LHF 400/630, versions with meters and timed cooling fan.

These welding rectifiers are equipped with a voltmeter, ammeter and a circuit that reduces the idle speed of the cooling fan.

The meters allow current and voltage settings to be read from the front of the rectifier.

To minimise the amount of dust and dirt that is drawn into the rectifier the fan runs at a reduced idle speed of 300 rpm. When welding with currents greater than 30 A the fan speed increases to its working speed of around 1350 rpm. A timer relay maintains the higher speed setting for 6 1/2 minutes after welding has stopped to ensure adequate cooling of the rectifier.

4 TECHNICAL DATA

	LHF 250	LHF 400	LHF 630	LHF 800
Maximum load				
35 % duty cycle	250 A/30 V	400 A/36 V	630 A/44 V	800 A/44 V
60 % duty cycle	200 A/28 V	315 A/33 V	500 A/40 V	630 A/44 V
100 % duty cycle	160 A/26 V	250 A/30 V	400 A/36 V	500 A/40 V
Setting range	8A/20V-250A/30 (33)V	8A/20V-400A/36 V	8A/20V-630A/44 (49)V	8A/20V-800A/44 (50)V
Open circuit volt.	78-84 V	80-87 V	65-72 V	65-72 V
Open circuit output at 400 V	300 W	340 W	615 W	640 W
Power factor (max current)	0,88	0,90	0,87	0,82
Efficiency (max current)	68 %	74 %	77 %	78 %
Enclosure class	IP 23	IP 23	IP 23	IP 23
Application class	S	S	S	S
Weight	160 kg	195 kg	260 kg	295 kg
Dimens. l x w x h	1310/765/705	1310/765/705	1310/765/705	1310/765/705

Duty cycle

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

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.

Application class

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

5 INSTALLATION

The installation must be executed by a professional.



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.

- Installation must be carried out by a qualified electrician.
- Check that the welding rectifier is configured for the **available mains supply** before connecting it to the mains.
- See Connecting to mains for cable rating and fuse rating.
- Connect the mains cable to the rectifier according to the relevant regulations and install a suitable fuse in the main fuse box.
- Make sure the welding rectifier is not covered or positioned so that cooling is obstructed.

5.1 Connecting to mains

	LHF 250	LHF 400	LHF 630	LHF 800
Frequency	50 Hz	50 Hz	50 Hz	50 Hz
Voltage	400/415/500 V	400/415/500 V	400/415/500 V	400/415/500 V
Current at				
100% duty cycle	11/11/9A	19/19/16 A	38/38/30 A	49/49/40 A
60% duty cycle	14/14/11 A	24/24/20 A	47/47/38 A	62/60/50A
35% duty cycle	18/18/14 A	31/31/25 A	59/59/47A	79/79/63A
Fuse, slow	16/16/16 A	25/25/20 A	50/50/35 A	63/63/50A
Cable area (4xmm2)	1,5/1,5/1,5	4/4/2,5	10/10/6	10/10/10

	LHF 250	LHF 400	LHF 630	LHF 800
Frequency	60 Hz	60 Hz	60 Hz	60 Hz
Voltage	440/550V	440/550V	440/550V	440/550V
Current at				
100% duty cycle	11/9 A	19/16 A	38/30 A	49/40 A
60% duty cycle	14/11 A	24/20 A	47/38 A	62/50 A
35% duty cycle	18/14 A	31/25 A	59/47 A	79/63 A
Fuse, slow	16/16 A	25/20 A	50/35 A	63/50 A
Cable area (4xmm2)	1,5/1,5	4/2,5	10/6	10/10

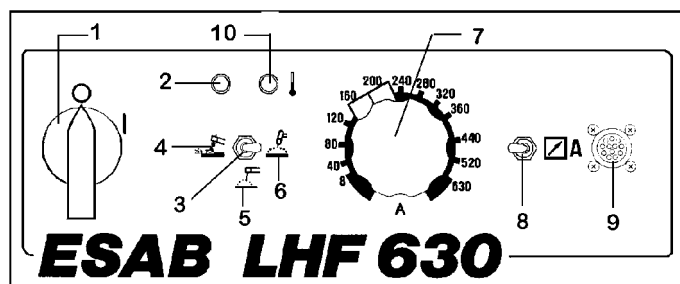
Cable areas comply with Swedish regulations.

6 OPERATION

- Set switch (1) to position "I". The white lamp (2) will light and the fan will start.
- Select the welding method using the toggle switch (3).
- Adjust the welding current using the knob (7) on the front, and set the toggle switch (8) to the position nearest the socket.
- Select suitable earth and return cables and connect them to the terminals marked + and - on the front of the rectifier. Connect the return cable to the work piece.
- The rectifier is now ready for welding.

6.1 Controls and connections

1. On/Off
2. White lamp (power on)
3. Method selector switch
4. Arc air gouging
5. MMA
6. TIG
7. Current setting
8. Remote switch
9. Remote socket
10. Yellow lamp (thermal cut-out)



bh10d001

The yellow lamp comes on when the thermal cut-out trips.
When the rectifier has cooled down the thermal cut - out is automatically reset.

7 MAINTENANCE

Note!

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.

Only those persons who have appropriate electrical knowledge (authorised personnel) may remove the safety plates to connect or carry out service, maintenance or repair work on welding equipment.

Cleaning

Check regularly that the power source is free from dirt.

How often, and to what extent, cleaning should be carried out depends on the welding process, arc time, disposition and the surrounding environment. It will normally suffice to blow the power source clean using compressed air (reduced pressure) once a year.

If the power source is very dirty, brushing and vacuuming are recommended.

- Disconnect the welding power source from the mains current supply.
- Remove the adapter from the socket. Lock the socket to prevent unauthorised connection.

At fixed installations, the safety switch should be set to the off position. Lock the switch.

- Remove the power source's safety plates for best access.

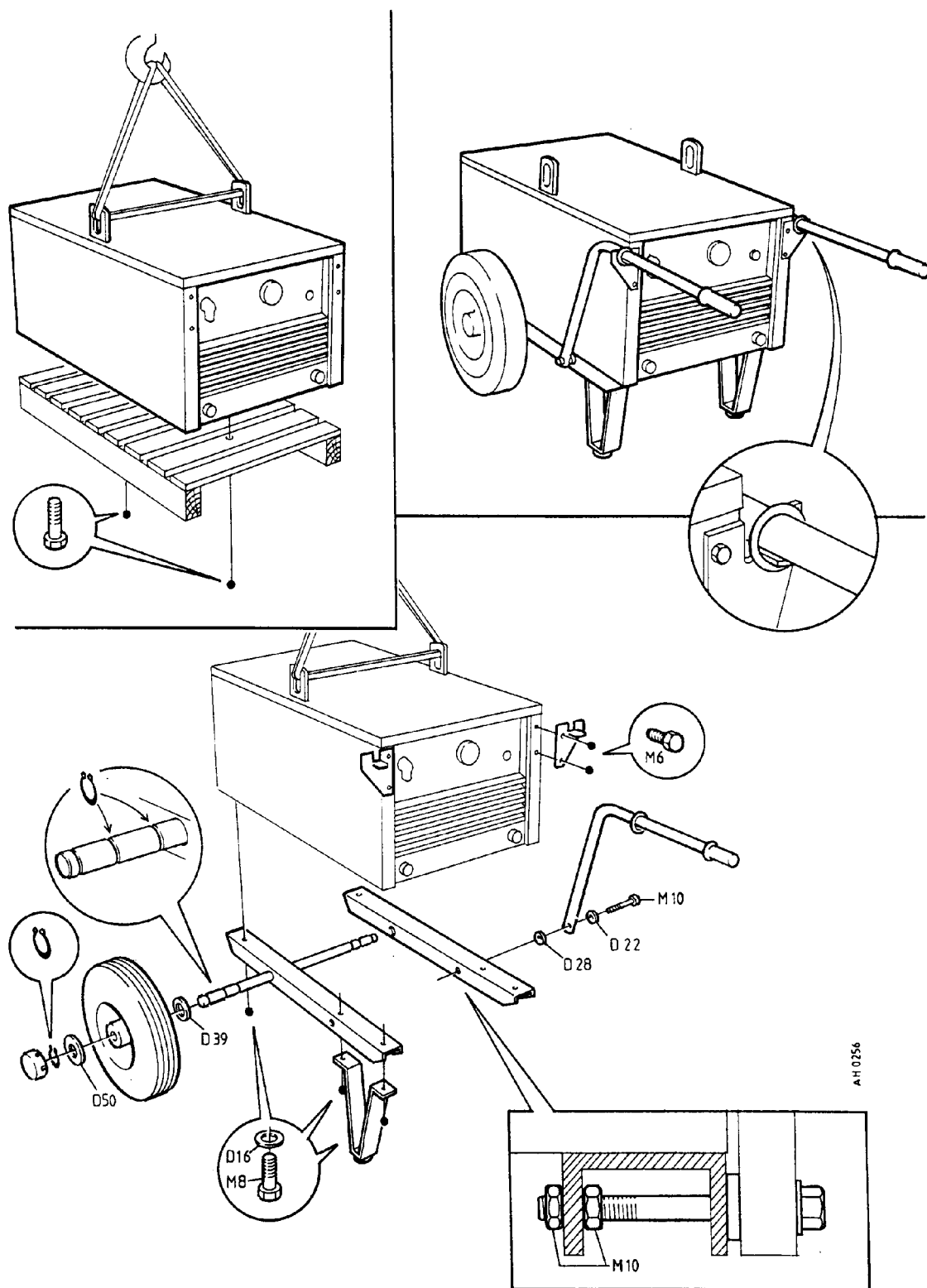
After cleaning, all safety plates must be mounted before you connect the power source to the mains supply.

8 ORDERING OF SPARE PARTS

LHF 250, LHF 400, LHF 630, LHF 800 is designed and tested in accordance with the international and European standards IEC/EN 60 974-1 and EN 60 974-1. 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 13. This will simplify shipment and ensure you get the right part.

Assembly instructions

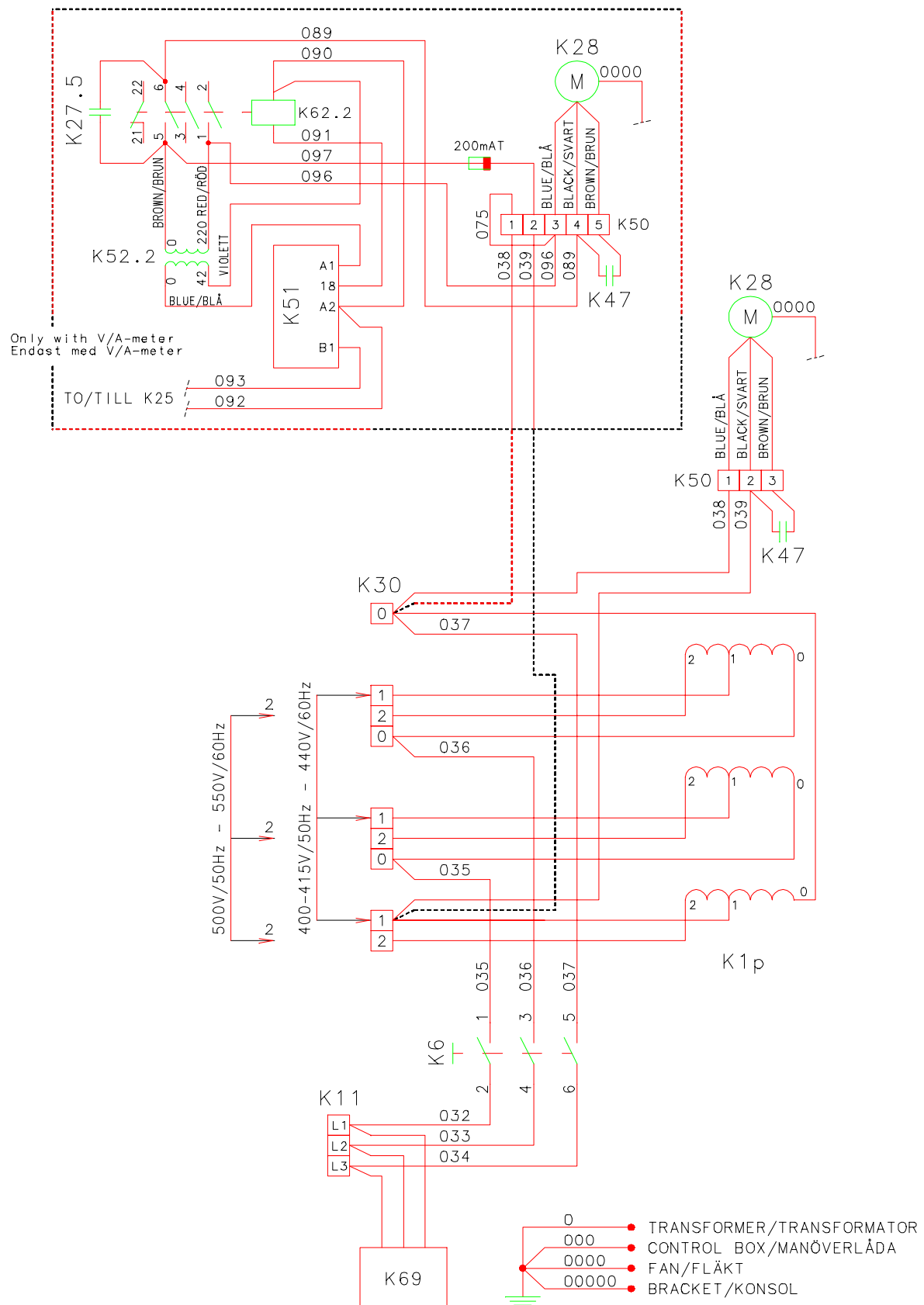


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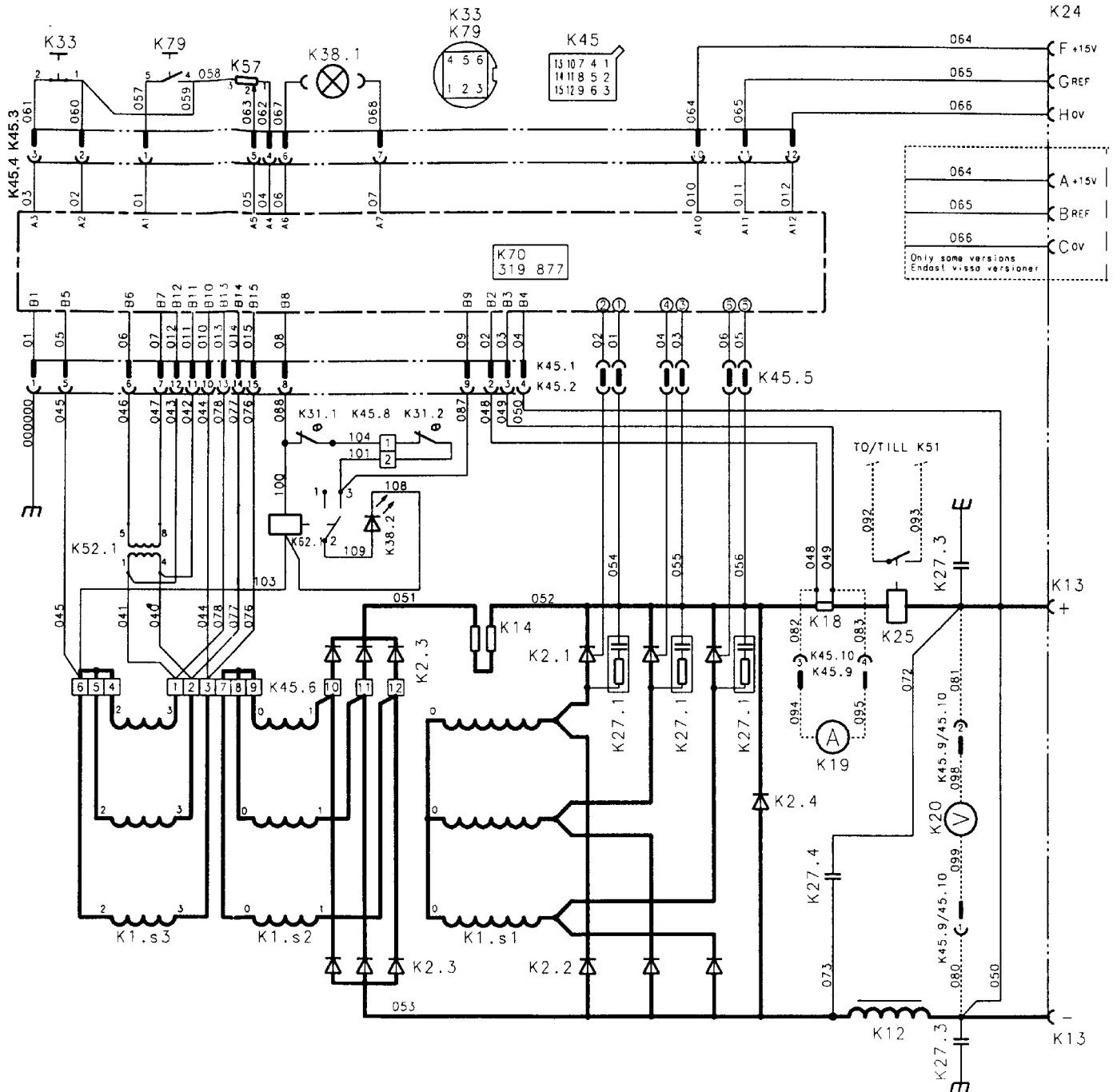
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Diagram

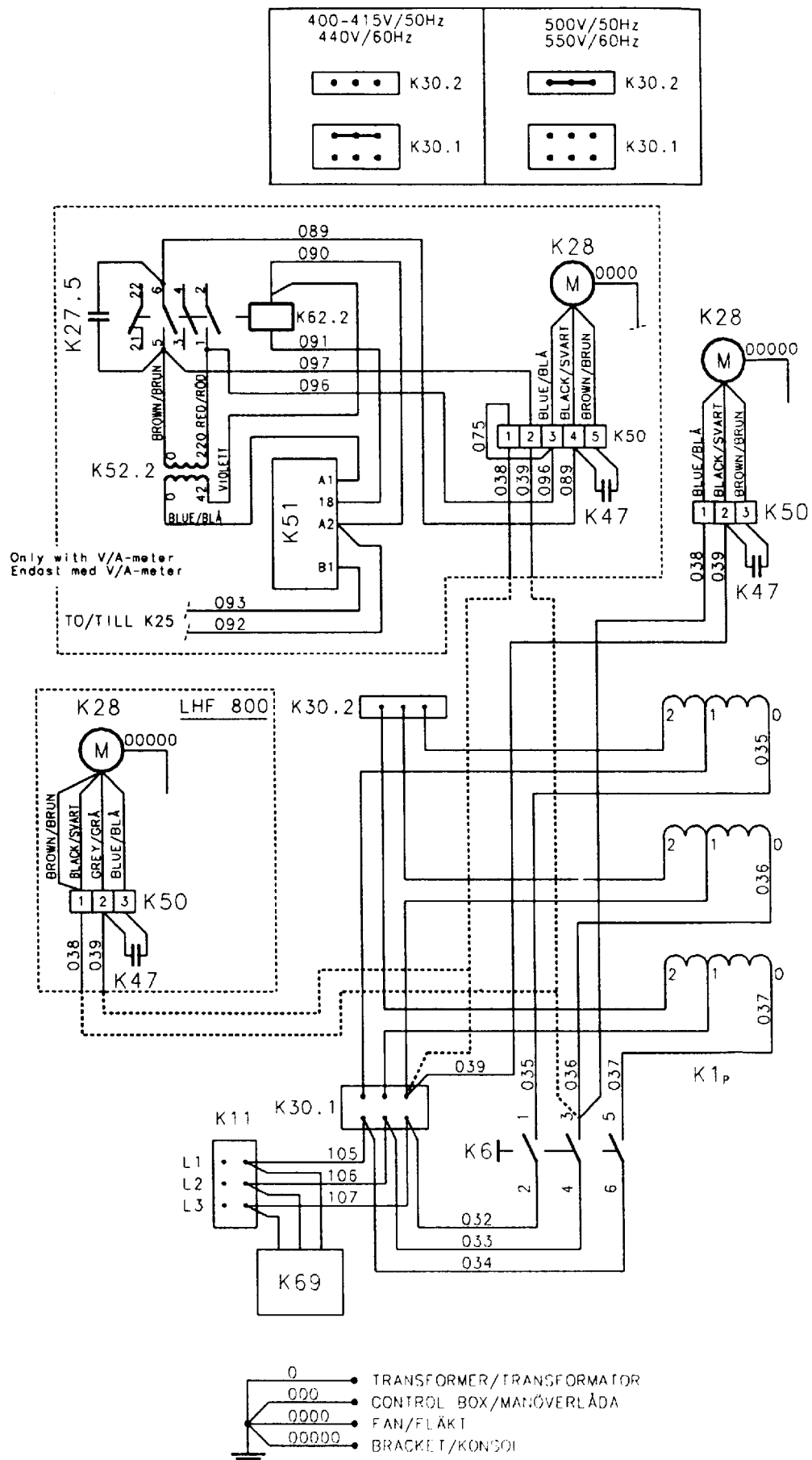
Prim. 250/400



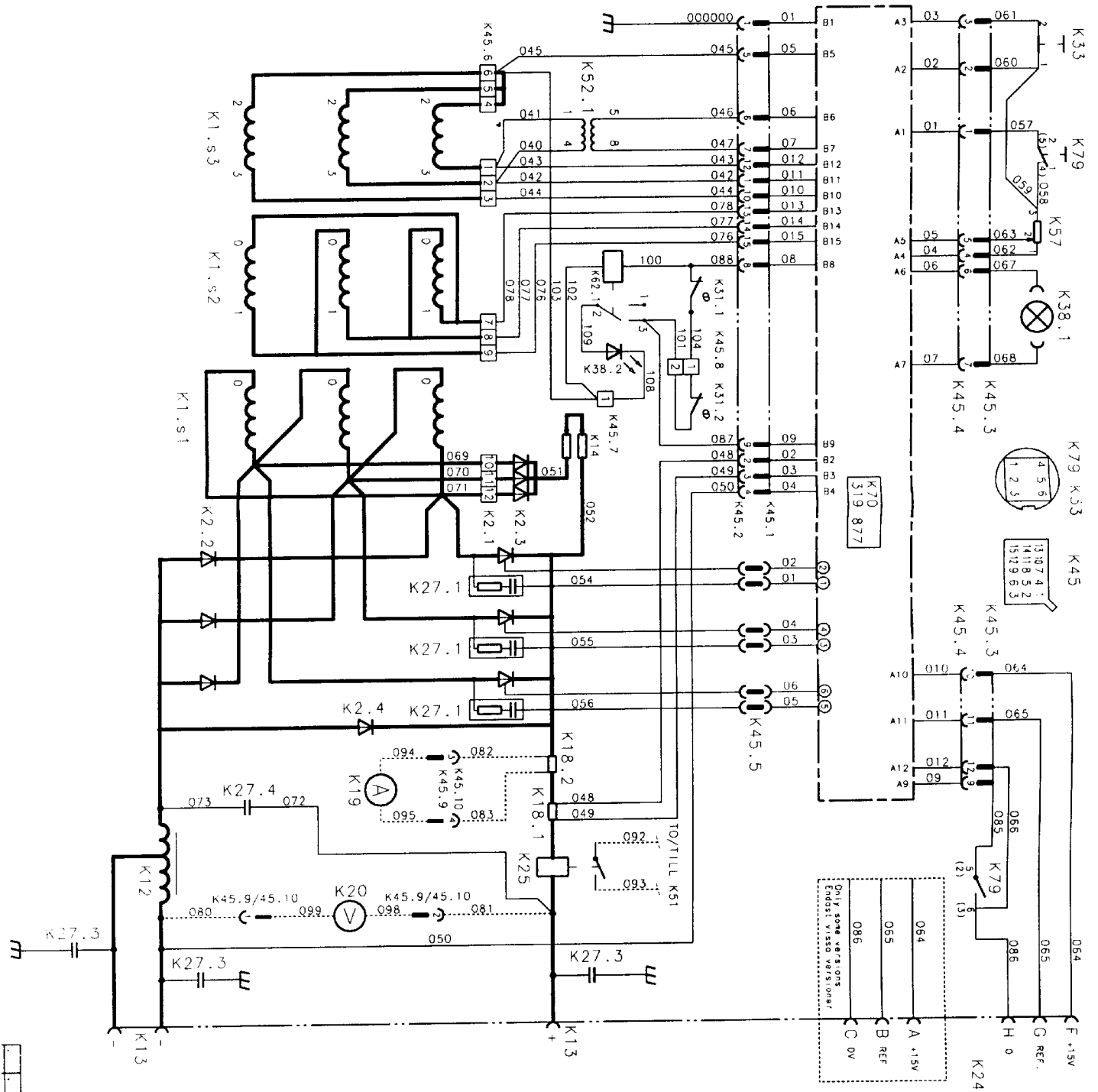
Sek. 250/400



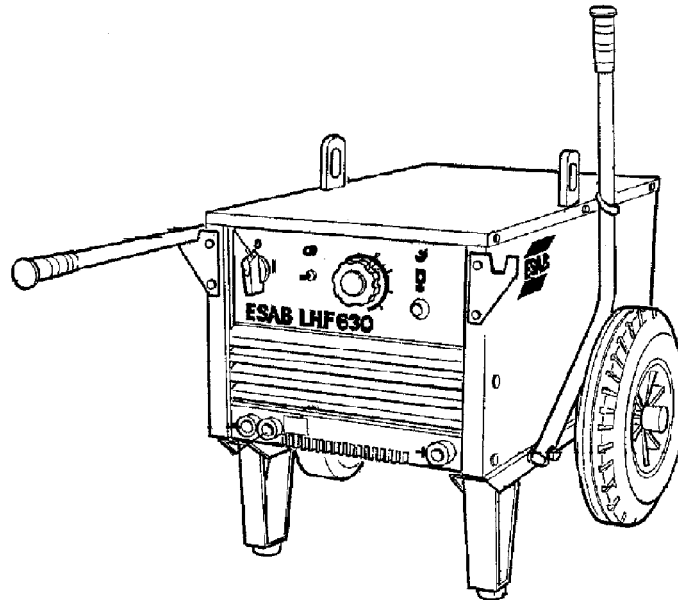
Prim. 630/800



Sek. 630/800



Spare parts list



Valid for serial no. 906-xxx-xxxx

Ordering numbers for LHF 250, LHF 400, LHF 630, LHF 800

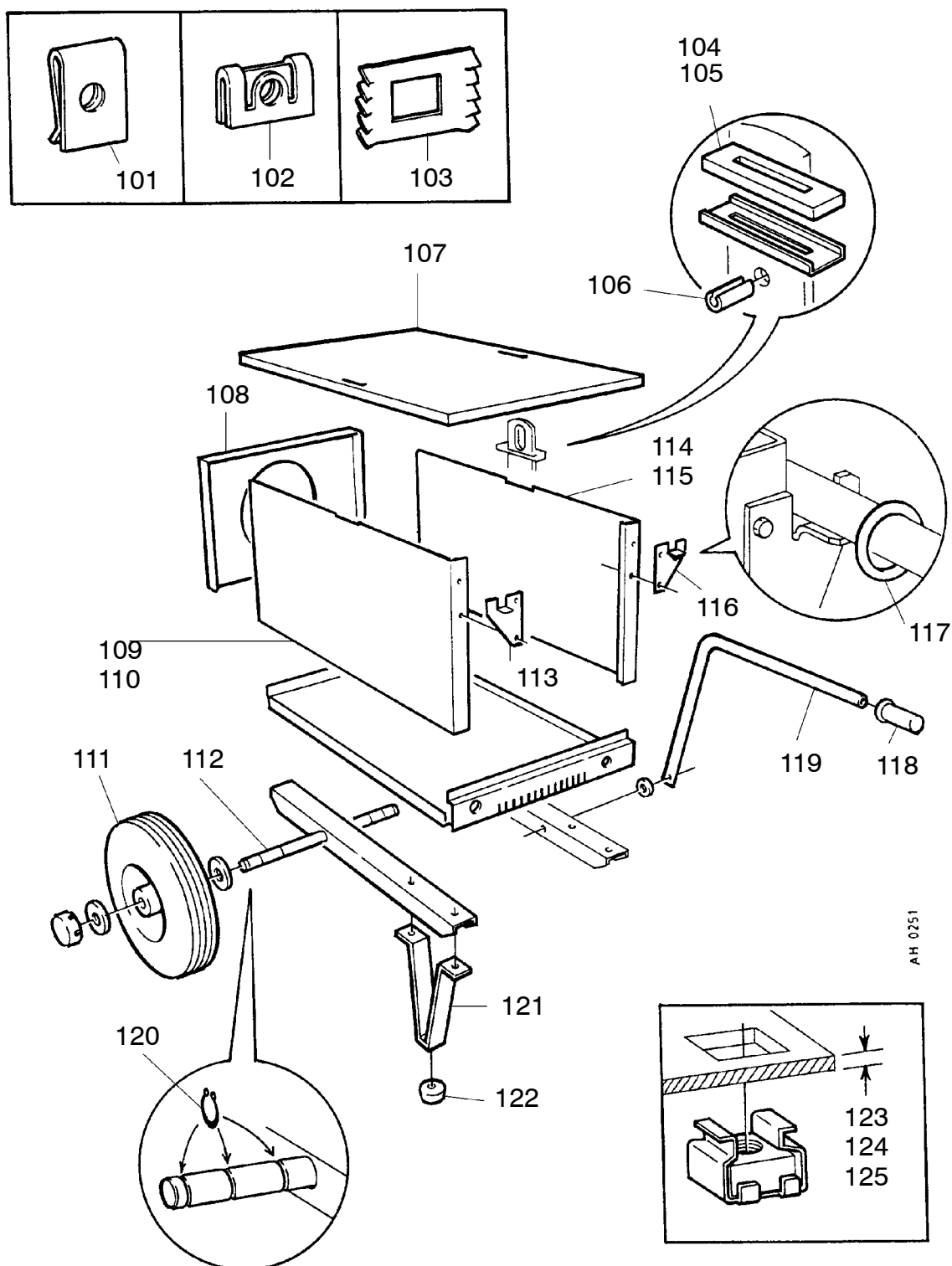
0319 782 882 LHF 250, 400/415/500V 50Hz, 440/550V 60Hz
0319 783 882 LHF 400, 400/415/500V 50Hz, 440/550V 60Hz
0319 783 886 LHF 400 Offshore, 400/415/500V 50Hz, 440/550V 60Hz
0319 950 882 LHF 630, 400/415/500V 50Hz, 440/550V 60Hz
0319 950 882 LHF 630 Offshore, 400/415/500V 50Hz, 440/550V 60Hz
0319 951 884 LHF 800 Offshore, 400/415/500V 50Hz, 440/550V 60Hz

Spare parts are to be ordered through the nearest ESAB agency as per the list on the back of the cover. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

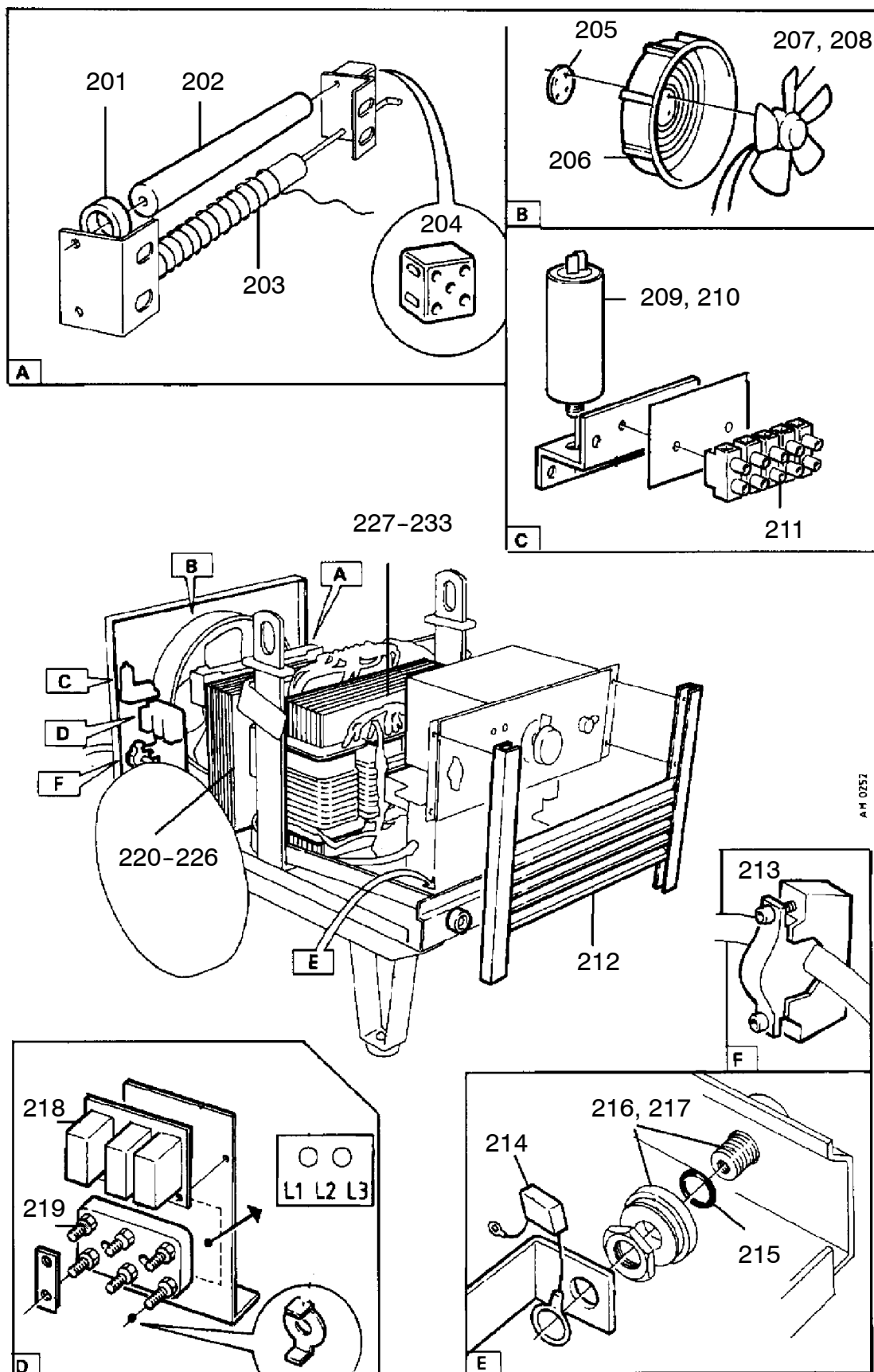
C = component designation in the circuit diagram

Item no.	Qty	Ordering no.	Denomination	Notes	C
101	12	0151 270 001	Quick-locking nut		
102	4	0192 547 001	Nut		
103	6	0320 029 002	Ground link		
104	2	0468 797 001	Gasket		
105	2	0468 796 001	Support plate		
106	2	02121 030 05			
107	1	0321 497 001	Top cover		
108	1	0455729 001	Side plate		
109	1	0469 937 002	Cover plate with screen		
110	1	0466 931 002	Cover with text	LHF 250	
111	2	0365 038 001	Wheel		
112	1	0365 046 001	Axle		
113	1	0320 939 002	Bracket left		
114	1	0469 937 001	Cover plate with screen		
115	1	0466 931 001	Cover with text	LHF 250	
116	1	0320 939 001	Bracket right		
117	2	0321 001 001	Ring		
118	2	02188 012 02	Rubber handle		
119	2	0321 000 001	Handle		
120	6	02157 010 19	Circlip		
121	2	0319 738 001	Foot		
122	2	0319 455 002	Foot		
123	8	0192 562 105	Nut	M6/t=0.7-1.6	
124	4	0192 562 106	Nut	M6/t=1.8-2.6	
125	21	0192 562 108	Nut	M8/t=1.8-2.6	



C = component designation in the circuit diagram

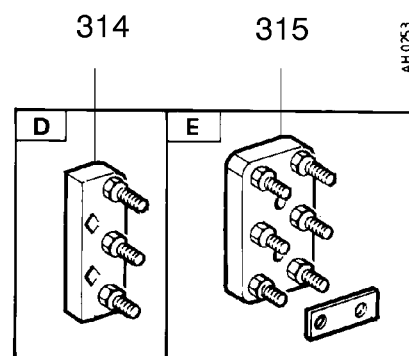
Item no.	Qty	Ordering no.	Denomination	Notes	C
201	2	0318 980 001	Insulating ring		
202	2	0317 660 001	Element rod		
203	1	0162 548 005	Resistor		K14
204	1	00407 055 01	Connection block	2 pole	
205	1	0320 178 001	Washer		
206	1	0319 838 001	Fan casing		
207	1	0162 430 001	Fan	LHF 250/400/800	K28
208	1	0162 430 002	Fan	LHF 800	K28
209	1	0191 085 202	Capacitor, 2uf, 400V	LHF 250/400/630	K47
210	1	0191 085 106	Capacitor	LHF 800	K47
211	1	0193 587 005	Connection block	5 pole	K50
212	1	0320 131 880	Front panel		
213	1	0469 950 880	Cable clamp		
214	2	0320 805 881	Capacitor		K27.3
215	2	0215 201 218	Seal o-ring, 24.2x3	LHF 250, LHF 400	
	3	0215 201 218	Seal o-ring, 24.2x3	LHF 630, LHF 800	
216	2	0160 362 881	Cable connector OKC 50	LHF 250, LHF 400	K13
	3	0160 362 881	Cable connector OKC 50	LHF 630	K13
217	3	0160 362 882	Cable connector OKC 120	LHF 800	K13
218	1	0486 216 880	Filter		K69
219	1	0162 772 001	Connection block		K11
220	1	0319 774 880	Choke	LHF 250	K12
221	1	0319 774 883	Inductor	LHF 250	K12
222	1	0319 774 881	Inductor	LHF 400	K12
223	1	0319 774 882	Inductor	LHF 400 Offshore	K12
224	1	0319 944 880	Inductor	LHF 630	K12
225	1	0319 944 882	Inductor	LHF 630 Offshore	K12
226	1	0319 944 883	Inductor	LHF 800 Offshore	K12
227	1	0469 920 880	Transformer	LHF 250	K1
228	1	0469 920 881	Transformer	LHF 250 Offshore	K1
229	1	0469 920 882	Transformer	LHF 400	K1
230	1	0469 920 883	Transformer	LHF 400 Offshore	K1
231	1	0469 923 880	Transformer	LHF 630	K1
232	1	0469 923 881	Transformer	LHF 630 Offshore	K1
233	1	0469 923 883	Transformer	LHF 800 Offshore	K1



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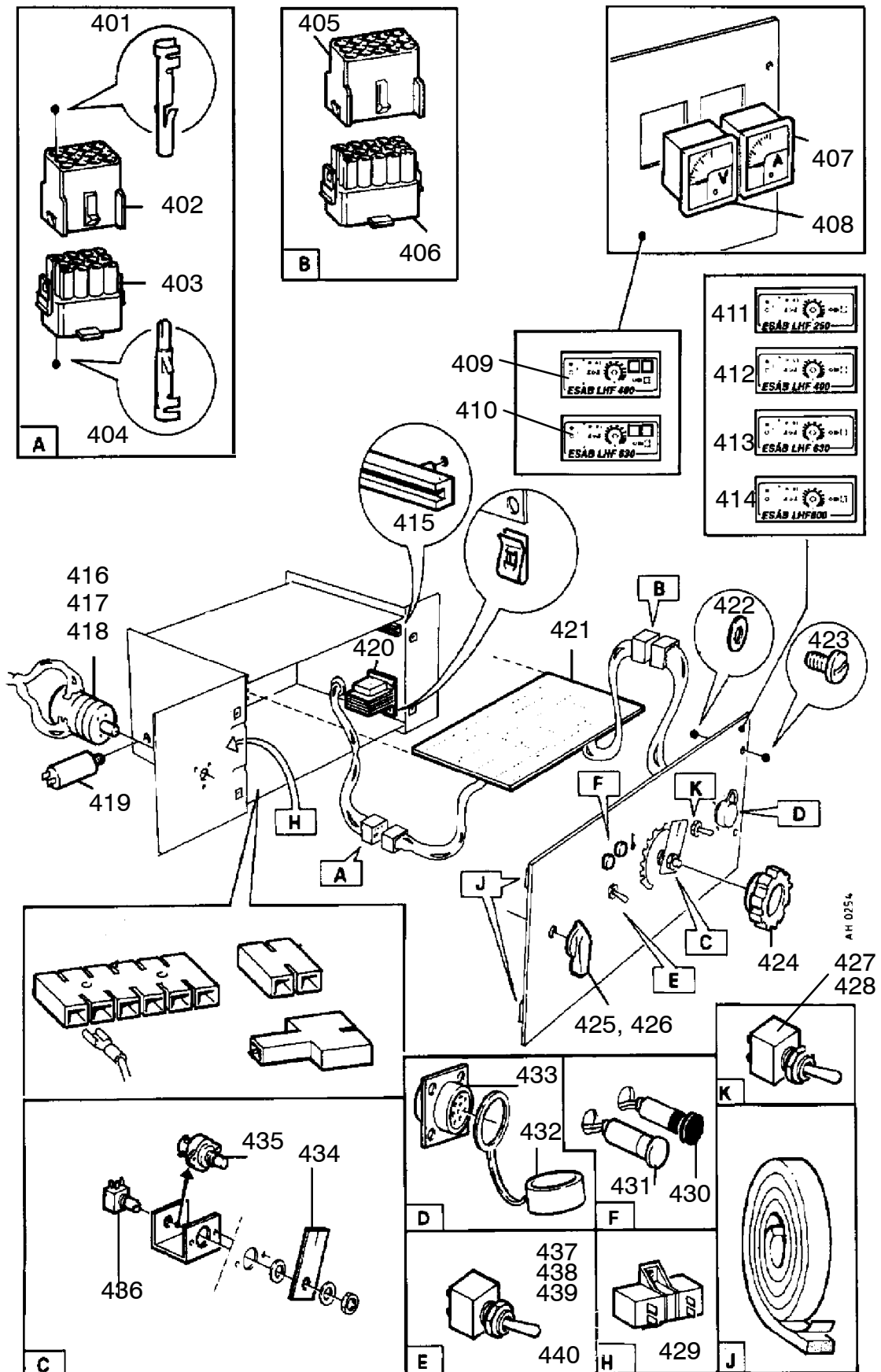
C = component designation in the circuit diagram

Item no.	Qty	Ordering no.	Denomination	Notes	C
301	1	0193 655 012	Terminal	12 pole	K45.6
302	6	0192 716 004	Diode	6A 400W LHF 250, LHF 400	K2.3
	3	0192 716 004	Diode	6A 400W LHF 630, LHF 800	K2.3
303	1	0469 947 001	Sign		
304	1	0162 781 008	Connection block	9 pole	K30
305	1	0456 111 001	Sign		
307	1	0341 035 880	Circuit board	Current relay	K25
308	1	0156 688 001	Magnetic plate		K25
309	1	0193 296 101	Contacteur		K62.2
310	1	0193 764 001	Time relay		K51
311	1	0193 298 101	Bar		
312	1	0191 085 202	Capacitor	2uF, 400V	K27.5
313	1	0365 028 001	Control transformer		K52.2
314	1	0162 772 001	Connection block	3 pole	K30.2
315	1	0040 894 001	Connection block	6 pole	K30



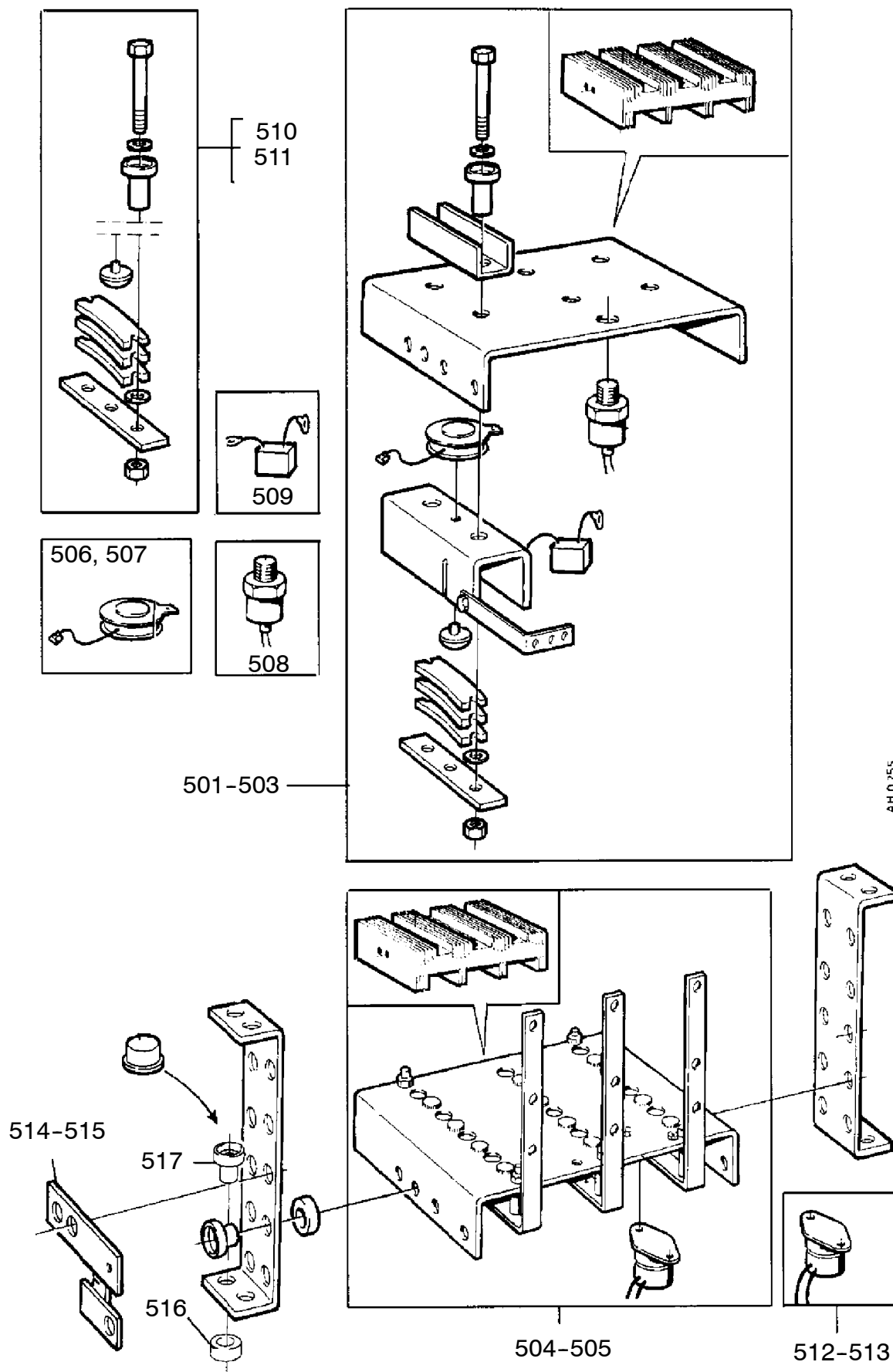
C = component designation in the circuit diagram

Item no.	Qty	Ordering no.	Denomination	Notes	C
401	23	0192 784 102	Cap		
402	1	0192 784 014	Socket	12 pole	K45.4
403	1	0192 784 013	Connector pin plug	12 pole	K45.3
404	23	0192 784 101	Pin		
405	1	0192 784 016	Sleeve plug	15 pole	K45.2
406	1	0192 784 015	Plug	15 pole	K45.1
407	1	0320 498 002	Ammeter		K19
408	1	0320 497 001	Voltmeter		K20
409	1	0469 929 001	Front plate	LHF 400 V/A	
410	1	0469 932 001	Front plate	LHF 630 V/A	
411	1	0469 927 001	Front plate	LHF 250	
412	1	0469 928 001	Front plate	LHF 400	
413	1	0469 930 001	Front plate	LHF 630	
414	1	0469 933 001	Front plate	LHF 800	
415	2	0365 745 001	Circuit card holder		
416	1	0320 745 001	Switch	LHF 250	K6
417	1	0320 745 002	Circuit braker	LHF 400	K6
418	1	0320 745 003	Switch	LHF 630/800	K6
419	1	0192 884 002	Capacitor	5uF	K27.4
420	1	0319 828 001	Transformer		K52.1
421	1	0319 876 880	Circuit card		K70, K45.1, K45.4
422	2	0468 797 001	Gasket		
423	4	02121 086 49	Screw	M6x12	
424	1	02188 107 84	Knob		
425	1	0318 113 003	Knob	LHF 250/400	
426	1	0318 113 004	Knob	LHF 630/800	
427	1	0147 866 001	Toggle switch		K79
428	1	0193 219 001	Toggle switch	Offshore	K79
429	1	0194 057 008	Relay		K62.1
430	1	0369 733 009	Indicating lamp	Yellow	K38.2
431	1	0369 733 008	Indicating lamp	White	K38.1
432	1	0366 285 001	Dust cap	12 pole	
433	1	0368 544 003	Burndy socket	12 pole	
434	1	0319 187 001	Indicator		
435	1	0317 942 001	Gearing for rheostat		
436	1	0192 724 007	Potentiometer		K57
437	1	0147 866 001	Toggle switch	LHF 250/400	K33
438	1	0193 219 001	Toggle switch	LHF 250/400 Offshore	K33
439	1	0147 866 002	Toggle switch	LHF 630/800	K33
440	1	0193 219 002	Toggle switch	LHF 630/800 Offshore	K33



C = component designation in the circuit diagram

Item no.	Qty	Ordering no.	Denomination	Notes	C
			Rectifier bridge		
501	1	0319 690 884	Thyristor bridge	LHF 400 Offshore	K2.1
502	1	0319 690 882	Thyristor bridge	LHF 630	K2.1
503	1	0319 932 880	Thyristor bridge	LHF 800	K2.1
504	1	0319 904 880	Diode bridge	LHF 400 Offshore, LHF 630	K2.2
505	1	0319 923 880	Diode bridge	LHF 800	K2.2
506	3	0320 028 002	Thyristor	LHF 400 Offshore, LHF 630	K2.1
507	3	0320 946 001	Thyristor	LHF 800	K2.1
508	1	0490 600 606	Diode	LHF 400 Offshore, LHF 630	K2.4
	2	0490 600 606	Diode	LHF 800	K2.4
509	3	0041 051 606	Contact protection		K27.1
510	3	0319 690 883	Tensioning device	LHF 400 Offshore, LHF 630	
511	3	0319 932 881	Tensioning device	LHF 800	
512	1	0319 999 001	Thermal Relay	LHF 400 Offshore, LHF 630 Offshore, LHF 800	K31.1
513	1	0368 020 001	Thermal Relay	LHF 630	K31.1
514	1	0319 911 880	Shunt	LHF 630	K18
515	1	0319 911 881	Shunt	LHF 800	K18
516		0163 139 001	Bushing		
517		0162 414 002	Insulating tube		



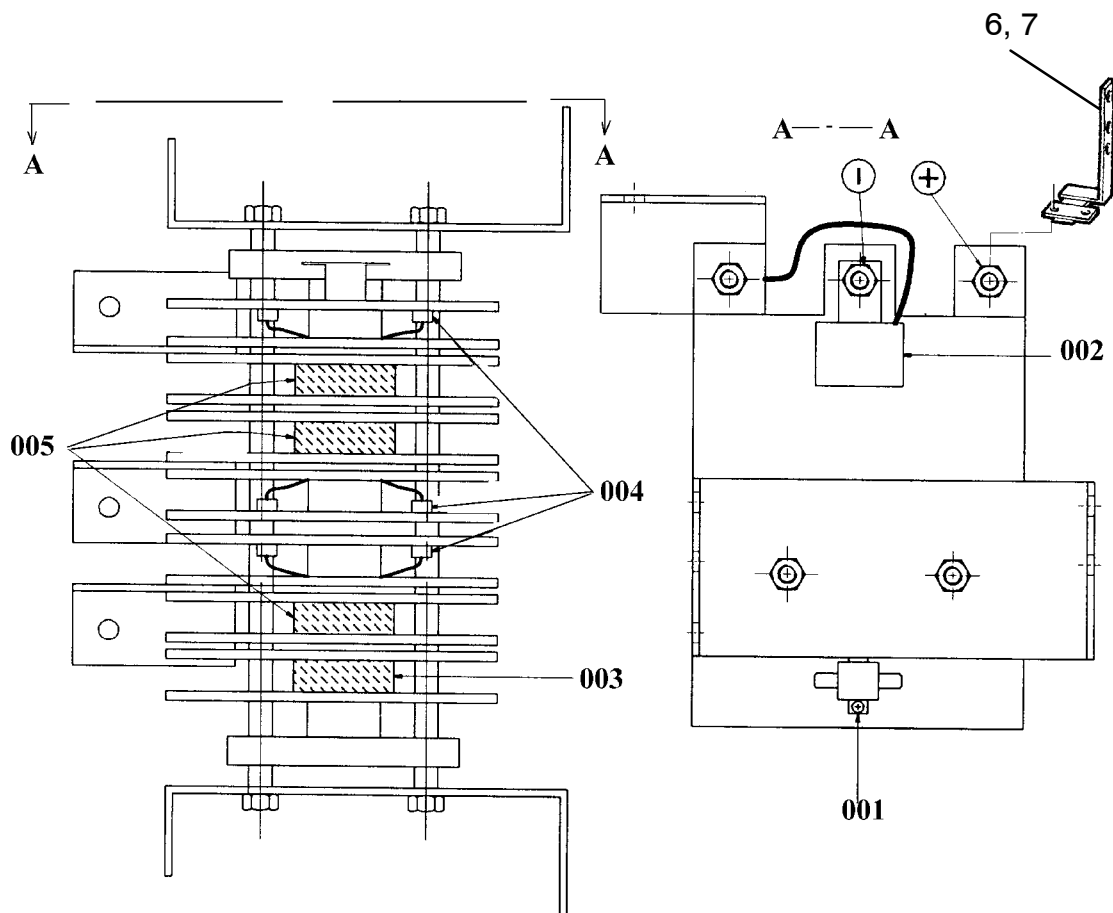
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Rectifier bridge for LHF 250, LHF 400 From serial No. 906.

C = component designation in the circuit diagram

Item no.	Qty	Ordering no.	Denomination	Notes	C
		0458 219 880	Rectifier bridge compl.		
001	1	0458 219 001	Thermal cutout		K31.1
002	1	0458 219 002	Filter		K27.1
003	1	0458 219 003	Diode		K2.4
004	3	0458 219 004	Rectifier bridge		K2.2
005	3	0320 028 008	Thyristor		K2.1
006	1	0320 558 880	Shunt	LHF 400	K18
007	1	0320 558 881	Shunt	LHF 250	K18



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.
Brussels
Tel: +32 2 745 11 00
Fax: +32 2 745 11 28

THE CZECH REPUBLIC

ESAB VAMBERK s.r.o.
Prague
Tel: +420 2 819 40 885
Fax: +420 2 819 40 120

DENMARK

Aktieselskabet ESAB
Copenhagen-Valby
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

FRANCE

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

GERMANY

ESAB GmbH
Solingen
Tel: +49 212 298 0
Fax: +49 212 298 218

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

HUNGARY

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

ITALY

ESAB Saldatura S.p.A.
Mesero (Mi)
Tel: +39 02 97 96 81
Fax: +39 02 97 28 91 81

THE NETHERLANDS

ESAB Nederland B.V.
Utrecht
Tel: +31 30 2485 377
Fax: +31 30 2485 260

NORWAY

AS ESAB
Larvik
Tel: +47 33 12 10 00
Fax: +47 33 11 52 03

POLAND

ESAB Sp.zo.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

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.
Alcalá 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 AG
Dietikon
Tel: +41 1 741 25 25
Fax: +41 1 740 30 55

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 02 20
Fax: +1 905 670 48 79

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 44 11
Fax: +1 843 664 57 48

Asia/Pacific

CHINA

Shanghai ESAB A/P
Shanghai
Tel: +86 21 5308 9922
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 3 5296 7371
Fax: +81 3 5296 8080

MALAYSIA

ESAB (Malaysia) Snd Bhd
Shah Alam Selangor
Tel: +60 3 5511 3615
Fax: +60 3 5512 3552

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

Representative offices

BULGARIA

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

EGYPT

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

ROMANIA

ESAB Representative Office
Bucharest
Tel/Fax: +40 1 322 36 74

RUSSIA-CIS

ESAB Representative Office
Moscow
Tel: +7 095 937 98 20
Fax: +7 095 937 95 80

ESAB Representative Office
St Petersburg
Tel: +7 812 325 43 62
Fax: +7 812 325 66 85

Distributors

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

www.esab.com



ESAB AB
SE-695 81 LAXÅ
SWEDEN
Phone +46 584 81 000

www.esab.com

