

Réparation & maintenance

PRODUITS D'APPORT REpondant AUX PRINCIPALES APPLICATIONS



R&M Nomenclature

ESAB a révisé sa gamme de produits d'apport pour l'entretien et la réparation. Nous en avons profité pour modifier les noms des produits pour faciliter la sélection.

Nomenclature des électrodes:

OK Weartrode "HRC"	Pour l'abrasion (métal/métal usure)
OK Tooltrode "HRC"	Pour les aciers à outils
OK 13Mn & 14MnNi	Pour les aciers au Mn
OK "AWS class"	Pour les fontes
OK GPC	Gougeage, perçage et coupage

L'abréviation HD signifie le taux de dépôt élevé. Il est utilisé pour différencier les produits de même nuance.



Nomenclature pour FCAW, MIG/MAG et SAW

Fil plein : OK Autrodur "HRC" X Y

Fil fourré : OK Tubrodur "HRC" X Y

La lettre X fait référence au procédé de soudage :

G : Soudage avec gaz de protection

O : Soudage sans gaz de protection

S : Arc submergé

La lettre Y fait référence à l'application:

M : Métal/Métal

A : Abrasion

D : Dissemblable

T : Température élevée

Industries R&M

- Réparation des rails
- Agriculture
- Exploitations forestières
- Exploitations minières
- Forage
- Vis d'extrudeuse
- Racleurs

Tableau de sélection

Nom de produit	Classification	Mn aciers revêtu	Metal/ Metal	Abrasion Minerale	Abrasion + pression	Impact	Haute temp.	Corrosion	Gougeage	Fonte	Alliage Cu	Alliage Al	Usinabilité	Dureté
OK Weartrade 30	E Z Fe1		x										Bon	> 30 HRC
OK Weartrade 30 HD	E Fe1		x										Bon	> 30 HRC
OK Weartrade 35	E Fe1		x	(x)									Bon	35 HRC
OK Weartrade 40	E Z Fe2		x			x	≤ 400°C						Meulage seul.	45 HRC
OK Weartrade 45	E Z Fe3		x										Meulage seul.	43 HRC
OK Weartrade 50	E Z Fe2			x									Meulage seul.	50 HRC
OK Weartrade 50 T	E Z Fe8		x		x	x	≤ 400°C	x					Meulage seul.	45 HRC
OK Weartrade 55	E Z Fe3		x	x			(x)						Meulage seul.	57 HRC
OK Weartrade 55 HD	E Z Fe6		x	x			(x)						Meulage seul.	57 HRC
OK Weartrade 60	E Z Fe2			x			(x)						Meulage seul.	60 HRC
OK Weartrade 60 T	E Z Fe14			x			x	x					Meulage seul.	60 HRC
OK Weartrade 62	N.A.			x		(x)							Meulage seul.	61 HRC
OK Weartrade 65 T	E Fe16			x			≤ 700°C	x					Meulage seul.	65 HRC
OK Tooltrade 50	E Z Fe3		x		x	x	≤ 550°C						Meulage seul.	50 HRC
OK Tooltrade 60	E Fe4		x		x	x	≤ 550°C						Meulage seul.	60 HRC
OK 13Mn	E Fe9	x	x			x							Usinable	46 HRC*
OK 14MnNi	E Z Fe9	x	x			x							Usinable	44 HRC*
OK GPC	N.A.								x				N.A.	N.A.
OK Ni-Cl	ENi-Cl									x			Bon	130- 170HB
OK NiFe-Cl-A	ENi-Cl-A									x			Bon	160- 200HB
OK NiFe-Cl	ENiFe-Cl									x			Bon	180- 200HB
OK NiCu 1	E NiCu 1									x			Bon	140- 160HB
OK 94.25	EL-CuSn7										x			
OK 94.35	EL-CuNi30Mn										x			
OK 92.20	AlMn1											x		
OK 96.40	AlSi5											x		
OK 96.50	AlSi12											x		
OK Tubrodur 55 O A	T Z Fe14			x			x	x					Meulage seul.	52 HRC
OK Tubrodur 200 O D	T Fe10	x	x											200HB
OK Tubrodur 30 O M	T Z Fe1		x											33 HRC
OK Tubrodur 35 G M	T Fe1		x											36 HRC
OK Tubrodur 35 S M	T Fe1		x											36 HRC
OK Tubrodur 35 O M	T Z Fe3				x	x								35 HRC
OK Tubrodur 40 O M	T Z Fe2		x		x	x								40 HRC
OK Tubrodur 40 S M	T Fe1		x		x	x								40 HRC
OK Tubrodur 53 G M	T Fe3		x		x			x					Meulage seul.	53 HRC
OK Tubrodur 58 O/G M	T Fe6		x	x									Meulage seul.	58 HRC
OK Tubrodur 58 S M	T Fe6		x	x									Meulage seul.	58 HRC
OK Tubrodur 60 G M	T Fe9				x								Meulage seul.	60 HRC
OK Tubrodur 13Mn O/G	T Fe9	x	x			x							Usinable	45 HRC*
OK Tubrodur 15CrMn O/G	T Fe9	x	x			x							Usinable	45 HRC*
OK Tubrodur 12Cr S	T Fe7		x				≤ 600°C	x						
OK Tubrodur 13Cr G	T Z Fe7		x				≤ 600°C	x						46 HRC
OK Tubrodur 13Cr S	T Fe7		x				≤ 600°C	x						46 HRC
OK Tubrodur 23Cr S	T Fe7						x	x						40 HRC
Nicore 55										x				
OK Autrodur 30 GM	S Fe1		x										Bon	30 HRC
OK Autrodur 38 G M	S Fe2		x			x							Beperkt	38 HRC
OK Autrodur 56 G M	S Fe8		x	x									Meulage seul.	56 HRC
OK Autrodur 58 G M	S Z Fe8		x	x		x							Meulage seul.	58 HRC

* Dans les conditions de travail en état écroui

Faible ← Résistance à l'abrasion → Élevé

<p>Acier Mn OK 13Mn OK 14MnNi OK Tubrodur 13Mn O OK Tubrodur 15CrMn O</p>	<p>Aciers alliés durcissables</p> <table border="0"> <tr> <td data-bbox="842 213 1211 545"> <p>30 - 50 HRC OK Weartrade 30 OK Weartrade 30 HD OK Weartrade 40 OK Weartrade 45 OK Tubrodur 30 O M OK Tubrodur 35 G M, OK Tubrodur 35 S M OK Tubrodur 40 G M, OK Tubrodur 40 S M OK Tubrodur 58 O/G M, OK Tubrodur 58 S M OK Tubrodur 60 G M</p> </td> <td data-bbox="1211 213 1603 545"> <p>50- 60 HRC OK Weartrade 50 OK Weartrade 50 T OK Weartrade 55 OK Weartrade 55 HD</p> </td> <td data-bbox="1603 213 1881 545"> <p>55- 60 HRC OK Weartrade 60 OK Weartrade 62</p> </td> </tr> </table>			<p>30 - 50 HRC OK Weartrade 30 OK Weartrade 30 HD OK Weartrade 40 OK Weartrade 45 OK Tubrodur 30 O M OK Tubrodur 35 G M, OK Tubrodur 35 S M OK Tubrodur 40 G M, OK Tubrodur 40 S M OK Tubrodur 58 O/G M, OK Tubrodur 58 S M OK Tubrodur 60 G M</p>	<p>50- 60 HRC OK Weartrade 50 OK Weartrade 50 T OK Weartrade 55 OK Weartrade 55 HD</p>	<p>55- 60 HRC OK Weartrade 60 OK Weartrade 62</p>
<p>30 - 50 HRC OK Weartrade 30 OK Weartrade 30 HD OK Weartrade 40 OK Weartrade 45 OK Tubrodur 30 O M OK Tubrodur 35 G M, OK Tubrodur 35 S M OK Tubrodur 40 G M, OK Tubrodur 40 S M OK Tubrodur 58 O/G M, OK Tubrodur 58 S M OK Tubrodur 60 G M</p>	<p>50- 60 HRC OK Weartrade 50 OK Weartrade 50 T OK Weartrade 55 OK Weartrade 55 HD</p>	<p>55- 60 HRC OK Weartrade 60 OK Weartrade 62</p>				

<p>Acier Inoxydable Cr OK Tubrodur 12Cr O OK Tubrodur 12Cr S OK Tubrodur 13Cr S OK Tubrodur 17Cr S</p>	<p>Acier à outil OK Tooltrode 50 OK Tooltrode 60 OK Tubrodur 53 G M</p>	<p>Ferrochrome OK Weartrade 60 T OK Weartrade 65 T OK Tubrodur 55 O A</p>
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<p>Acier Austénitique CrNi OK 67.60, OK 67.70 OK Autrod 309LSi OK Autrod 309MoL Shield-Bright 309L Shiled-Bright 309LMo</p>	<p>Acier austénitique CrNiMn OK 67.43, OK 67.45 OK Autrod 16.95 OK Tubrodur 200 O D</p>	<p>Acier austéno - ferritique CrNi OK 68.81, OK 68.82 OK Autrod 312</p>
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<p>Alliage base Nickel OK NiCrFe-3 OK Autrod 19.85 OK NiCrMo-5</p>	<p>Fonte OK Ni-CI OK NiFe-CI-A OK NiFe-CI OK NiCu 1 Nicore 55</p>
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Élevé ← Résistance à l'impact → Faible

Faible ↑ Résistance à la chaleur et à la corrosion ↓ Élevé

Gamme R&M MMA

Description	Ancienne description	Code article	Poids par emballage (kg)	Poids par carton CT (kg)	Quantité min. de commande MOQ (kg)
OK GPC 2.5x350mm	OK 21.03	2103253030	1.5	9.0	9.0
OK GPC 3.2x350mm	OK 21.03	2103323020	3.5	10.5	10.5
OK GPC 4.0x350mm	OK 21.03	2103403020	3.3	9.9	9.9
OK GPC 5.0x450mm	OK 21.03	2103504020	4.3	12.9	12.9
OK GPC 6.0x450mm	OK 21.03	2103604020	4.4	13.2	**
OK Weartrode 30 2.5x350mm	OK 83.28	8328253030	1.8	10.8	10.8
OK Weartrode 30 3.2x450mm	OK 83.28	8328324030	2.5	15.0	15.0
OK Weartrode 30 4.0x450mm	OK 83.28	8328404020	5.7	17.1	17.1
OK Weartrode 30 5.0x450mm	OK 83.28	8328504020	5.8	17.4	17.4
OK Weartrode 30 6.0x450mm	OK 83.28	8328604020	5.7	17.1	17.1
OK Weartrode 30 3.2x450 ½ VP	OK 83.28	83283240G0	2.5	15.0	15.0
OK Weartrode 30 4.0x450 ½ VP	OK 83.28	83284040G0	2.5	15.0	15.0
OK Weartrode 30 5.0x450 ¾ VP	OK 83.28	83285040V0	4.3	17.2	17.2
OK Weartrode 30 HD 3.2x450mm	OK 83.29	8329324030	2.4	14.4	14.4
OK Weartrode 30 HD 4.0x450mm	OK 83.29	8329404020	5.8	17.4	17.4
OK Weartrode 30 HD 5.0x450mm	OK 83.29	8329504020	5.5	16.5	16.5
OK Weartrode 35 3.2x450mm	E-B 502	8012324030 *	2.8	16.8	**
OK Weartrode 35 4.0x450mm	E-B 502	8012404020 *	6.0	18.0	**
OK Weartrode 35 5.0x450mm	E-B 502	8012504020 *	6.2	18.6	18.6
OK Weartrode 40 2.5x350mm	E-B 503	8013253030 *	1.9	11.4	**
OK Weartrode 40 3.2x450mm	E-B 503	8013324030 *	3.0	18.0	18.0
OK Weartrode 40 4.0x450mm	E-B 503	8013404020 *	5.5	16.5	16.5
OK Weartrode 40 5.0x450mm	E-B 503	8013504020 *	5.8	17.4	17.4
OK Weartrode 45 3.2x450mm	EN 450B	8014324020 *	5.4	16.2	16.2
OK Weartrode 45 4.0x450mm	EN 450B	8014404020 *	5.4	16.2	16.2
OK Weartrode 45 5.0x450mm	EN 450B	8014504020 *	5.6	16.8	16.8
OK Weartrode 50 3.2x350mm	OK 83.50	8350323030	1.8	10.8	10.8
OK Weartrode 50 4.0x450mm	OK 83.50	8350404020	4.6	13.8	13.8
OK Weartrode 50 5.0x450mm	OK 83.50	8350504020	4.7	14.1	14.1
OK Weartrode 50 2.5x350mm	OK 83.50	8350253030	1.8	10.8	10.8
OK Weartrode 50 T 2.0x300mm	E-B 511	8016202030 *	1.6	9.6	**
OK Weartrode 50 T 2.5x350mm	E-B 511	8016253030 *	1.8	10.8	10.8
OK Weartrode 50 T 3.2x450mm	E-B 511	8016324030 *	2.3	13.8	13.9
OK Weartrode 50 T 4.0x450mm	E-B 511	8016404020 *	5.9	17.7	17.7
OK Weartrode 50 T 5.0x450mm	E-B 511	8016504020 *	5.6	16.8	16.8
OK Weartrode 55 3.2x450mm	EN 600B	8017324020 *	5.3	15.9	15.9
OK Weartrode 55 4.0x450mm	EN 600B	8017404020 *	5.2	15.6	15.6
OK Weartrode 55 5.0x450mm	EN 600B	8017504020 *	5.6	16.8	16.8
OK Weartrode 55 6.0x450mm	EN 600B	8017604020 *	5.5	16.5	16.5
OK Weartrode 55 HD 2.5x350mm	OK 84.58	8458253030	1.8	10.8	10.8
OK Weartrode 55 HD 3.2x450mm	OK 84.58	8458324030	2.4	14.4	14.4
OK Weartrode 55 HD 4.0x450mm	OK 84.58	8458404020	5.0	15.0	15.0
OK Weartrode 55 HD 5.0x450mm	OK 84.58	8458504020	5.0	15.0	15.0
OK Weartrode 60 3.2x450mm	OK 83.65	8365324030	2.6	15.6	15.6
OK Weartrode 60 4.0x450mm	OK 83.65	8365404020	5.6	16.8	16.8

* Nouveau code article

** Cartons multiples sont à commander. Veuillez contacter ESAB ou son représentant

Gamme R&M d'électrodes enrobées pour procédé de soudage MMA

Description	Ancienne description	Code article	Poids par emballage (kg)	Poids par carton CT (kg)	Quantité min. de commande MOQ (kg)
OK Weartrode 60 T 2.5x350mm	OK 84.78	8478253030	1.8	10.8	10.8
OK Weartrode 60 T 3.2x350mm	OK 84.78	8478323030	1.7	10.2	10.2
OK Weartrode 60 T 4.0x450mm	OK 84.78	8478404020	5.0	15.0	15.0
OK Weartrode 60 T 5.0x450mm	OK 84.78	8478504020	4.8	14.4	14.4
OK Weartrode 62 2.5x350mm	OK 84.84	8484253030	1.9	11.4	11.4
OK Weartrode 62 3.2x350mm	OK 84.84	8484323030	1.9	11.4	11.4
OK Weartrode 62 4.0x350mm	OK 84.84	8484403020	4.2	12.6	12.6
OK Weartrode 65 T 3.2x350mm	OK 84.80	8480323030	1.9	11.4	11.4
OK Weartrode 65 T 4.0x350mm	OK 84.80	8480403020	3.7	11.1	11.1
OK Tooltrode 50 2.5x350mm	OK 85.58	8558253030	2.0	12.0	72.0
OK Tooltrode 50 3.2x350mm	OK 85.58	8558323030	1.9	11.4	11.4
OK Tooltrode 50 4.0x350mm	OK 85.58	8558403020	4.4	13.2	13.2
OK Tooltrode 50 5.0x350mm	OK 85.58	8558503020	4.4	13.2	13.2
OK Tooltrode 60 2.5x350mm	OK 85.65	8565253030	1.8	10.8	10.8
OK Tooltrode 60 3.2x350mm	OK 85.65	8565323030	1.7	10.2	10.2
OK Tooltrode 60 4.0x350mm	OK 85.65	8565403020	3.8	11.4	**
OK 13Mn 3.2x450mm	OK 86.08	8608324030	2.4	14.4	14.4
OK 13Mn 4.0x450mm	OK 86.08	8608404020	5.9	17.7	17.7
OK 13Mn 5.0x450mm	OK 86.08	8608504020	5.5	16.5	16.5
OK 14MnNi 3.2x450mm	OK 86.28	8628324030	2.2	13.2	13.2
OK 14MnNi 4.0x450mm	OK 86.28	8628404020	5.0	15.0	15.0
OK 14MnNi 5.0x450mm	OK 86.28	8628504020	5.0	15.0	30.0
OK Ni-CI 2.5x300mm ¼ VP	OK 92.18	92182520L0	0.7	4.2	4.2
OK Ni-CI 3.2x350mm ¼ VP	OK 92.18	92183230L0	0.8	4.8	4.8
OK Ni-CI 4.0x350mm ½ VP	OK 92.18	92184030G0	2.3	13.8	13.8
OK NiF-CI-A 2.5x300mm ¼ VP	OK 92.58	92582520L0	0.7	4.2	4.2
OK NiFe-CI-A 3.2x350mm ¼ VP	OK 92.58	92583230L0	0.7	4.2	4.2
OK NiFe-CI-A 4.0x350mm ½ VP	OK 92.58	92584030G0	1.9	11.4	11.4
OK NiFe-CI 2.5x300mm ¼ VP	OK 92.60	92602520L0	0.8	4.8	4.8
OK NiFe-CI 3.2x350mm ¼ VP	OK 92.60	92603230L0	0.7	4.2	4.2
OK NiFe-CI 4.0x350mm ½ VP	OK 92.60	92604030G0	2.1	12.6	12.6
OK NiCu 1 2.5x300mm ¼ VP	OK 92.78	92782520L0	0.8	4.8	4.8
OK NiCu 1 3.2x350mm ¼ VP	OK 92.78	92783230L0	0.7	4.2	4.2
OK NiCu 1 4.0x350mm ½ VP	OK 92.78	92784030G0	2.2	13.2	**

** Cartons multiples sont à commander. Veuillez contacter ESAB ou son représentant



Gamme R&M de fils fourrés FCAW

Description	Ancienne description	Code article	Poids par emballage (kg)	Poids par carton CT (kg)	Quantité min. de commande MOQ (kg)
OK Tubrodur 55 O A 1.6mm 16kg	OK Tubrodur 14.70	1470167730	16	16	16
OK Tubrodur 200 O D 1.6mm 16kg	OK Tubrodur 14.71	1471167730	16	16	16
OK Tubrodur 35 G M 1.6mm 16kg	OK Tubrodur 15.40	1540167630	16	16	16
OK Tubrodur 30 O M 1.6mm 16kg	OK Tubrodur 15.41	1541167630	16	16	16
OK Tubrodur 30 O M 1.6mm 300kg	OK Tubrodur 15.41	1541169460	300	300	300
OK Tubrodur 30 O M 2.4mm 16kg	OK Tubrodur 15.41	1541247630	16	16	**
OK Tubrodur 40 O M 1.6mm 16kg	OK Tubrodur 15.42	1542167630	16	16	16
OK Tubrodur 35 O M 1.2mm4x4.5kg	OK Tubrodur 15.43	1543124630	18	18	**
OK Tubrodur 35 O M 1.2mm 16kg	OK Tubrodur 15.43	1543127630	16	16	16
OK Tubrodur 35 O M 1.6mm 16kg	OK Tubrodur 15.43	1543167630	16	16	16
OK Tubrodur 35 O M 1.6mm 10.5kg	OK Tubrodur 15.43	1543167680	10.5	10.5	**
OK Tubrodur 60 G M 1.2mm 16kg	OK Tubrodur 15.50	1550127730	16	16	16
OK Tubrodur 60 G M 1.6mm 16kg	OK Tubrodur 15.50	1550167730	16	16	16
OK Tubrodur 58 O/G M 1.6mm 16kg	OK Tubrodur 15.52	1552167630	16	16	16
OK Tubrodur 53 G M 1.6mm 16kg	OK Tubrodur 15.84	1584167730	16	16	**
OK Tubrodur 13Mn O/G 1.6mm 12kg	OK Tubrodur 15.60	1560167740	12	12	**
OK Tubrodur 15CrMn O/G 1.2mm 4x5kg	OK Tubrodur 15.65	1565125600	5	20	20
OK Tubrodur 15CrMn O/G 1.6mm 4x5kg	OK Tubrodur 15.65	1565165600	5	20	**
OK Tubrodur 15CrMn O/G 1.6mm 16kg	OK Tubrodur 15.65	1565167730	16	16	16
OK Tubrodur 13Cr G 1.6mm 16kg	OK Tubrodur 15.73	1573167630	16	16	16
OK Tubrodur 35 S M 3.0mm 25kg	OK Tubrodur 15.40S	1V40300300	25	25	**
OK Tubrodur 35 S M 3.2mm 300kg	OK Tubrodur 15.40S	1V40325800	300	300	300
OK Tubrodur 35 S M 4.0mm 25kg	OK Tubrodur 15.40S	1V40400300	25	25	25
OK Tubrodur 35 S M 4.0mm 300kg	OK Tubrodur 15.40S	1V40405800	300	300	300
OK Tubrodur 40 S M 4.0mm 25kg	OK Tubrodur 15.42S	1V42400300	25	25	**
OK Tubrodur 40 S M 4.0mm 270kg	OK Tubrodur 15.42S	1542403410	270	270	270
OK Tubrodur 58 S M 3.0mm 25kg	OK Tubrodur 15.52S	1V52300300	25	25	25
OK Tubrodur 12Cr S 3.0mm 25kg	OK Tubrodur 15.72S	1V72300300	25	25	**
OK Tubrodur 13Cr S 2.4mm 300kg	OK Tubrodur 15.73S	1V73245800	300	300	300
OK Tubrodur 13Cr S 3.0mm 25kg	OK Tubrodur 15.73S	1V73300300	25	25	**
OK Tubrodur 23Cr S 3.0mm 25kg	OK Tubrodur 15.91S	1V91300300	25	25	25

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Gamme R&M de fils massifs MIG/MAG

Description	Ancienne description	Code article	Poids par emballage (kg)	Poids par carton CT (kg)	Quantité min. de commande MOQ (kg)
OK Autrodur 30 G M 1.2mm 15kg	C 508	3066127600	15	15	15
OK Autrodur 30 G M 1.6mm 15kg	C 508	3066167600	15	15	15
OK Autrodur 38 G M 1.0mm 15kg	OK Autrod 13.89	1389107700	15	15	**
OK Autrodur 38 G M 1.2mm 15kg	OK Autrod 13.89	1389127700	15	15	**
OK Autrodur 58 G M 1.0mm 15kg	OK Autrod 13.90	1390107700	15	15	**
OK Autrodur 58 G M 1.2mm 15kg	OK Autrod 13.90	1390127700	15	15	**
OK Autrodur 56 G M 1.0mm 15kg	OK Autrod 13.91	1391107700	15	15	15
OK Autrodur 56 G M 1.2mm 15kg	OK Autrod 13.91	1391127700	15	15	15
OK Autrodur 56 G M 1.2mm 250kg	OK Autrod 13.91	1391129320	250	250	**
OK Autrodur 56 G M 1.6mm 15kg	OK Autrod 13.91	1391167700	15	15	**

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ESAB est au premier rang de la technologie de soudage et de coupage. Plus d'un siècle d'amélioration continue des produits et procédés nous permet de relever le défi du progrès technologique dans chaque secteur dans lequel ESAB intervient.

Normes environnementales et d'environnement.

La qualité, l'environnement et la sécurité sont trois domaines essentiels. ESAB est l'une des rares entreprises internationales à détenir les certifications ISO 14001 et OHSAS 18001. Santé et systèmes de gestion de la sécurité, dans toutes ses usines dans le Monde.

Chez ESAB, la qualité est un processus permanent qui se situe au coeur de tous les procédés de production et de toutes les installations, et ce dans le monde entier.

La fabrication multinationale, la représentation locale et un réseau international de distributeurs indépendants placent les avantages de la qualité d'ESAB et son expertise inégalée des matériaux et procédés à la portée de tous nos clients, où qu'ils se trouvent.



*Unités de vente ESAB et distributeurs agréés dans le monde

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