

CITOLINE

New MIG/MAG power sources range
switched technology



2007-125

2333-001

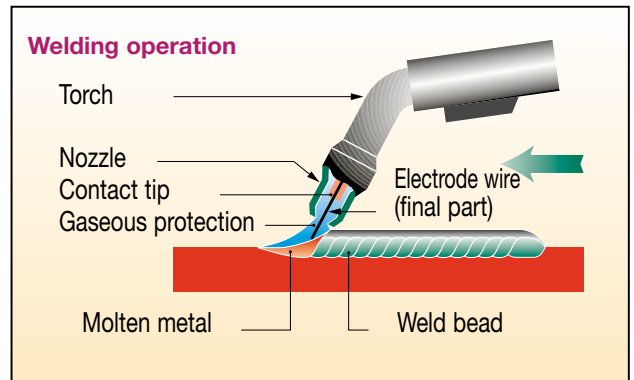
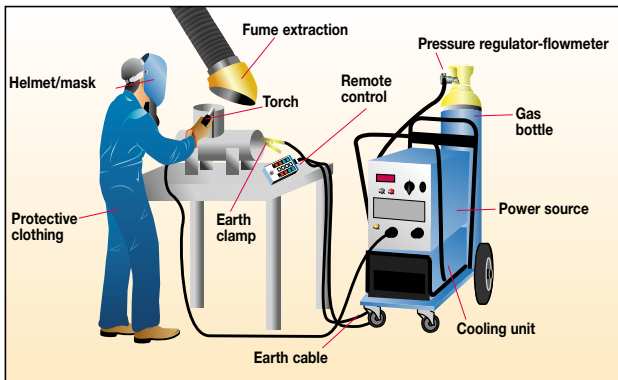
CITOLINE: simplicity and efficiency



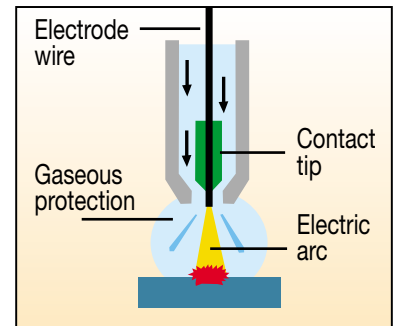
2003-390

Primary power supply cable connection:

Single-phase 230 V = connection between phase and neutral
 400 V = connection between 2 phases
 Three-phase 400 V = connection between 3 phases
 230 V = connection between 3 phases
 230 V three-phase only exists in certain companies that have their own transformer.



The MIG (Metal Inert Gas) and MAG (Metal Active Gas) welding implement an electric arc under gaseous protection (inert gas: Argon+CO₂). The wire that constitutes the consumable electrode is continuously unrolled in the electric arc and is deposited in the molten metal.



MIG welding glossary

CE European standards

They warranty quality, electrical and mechanical characteristics and the safety level of an equipment. The Oerlikon power sources are certified CE.

These standards define manufacturing according to 2 directives:

- 89/336/CEE relative to the electro-magnetic compatibility (CEM), which imposes limitation in the electro-magnetic disturbance respecting the EN 50 199 standard.
- BT 73/23/CEE relative to the safety rules for welding equipments respecting the EN 60 974-1 standard.

Protection Class IP

The first digit indicates the maximum diameter of an object to be introduced inside the equipment and that could come into contact with an element under dangerous tension.

The second digit indicates the protection level against falling rain.
 Ex: IP 23 (the 2 means that an object of 12.5 mm diameter can be introduced in the device, the 3 means that it is protected against falling rain up to a maximum angle of 60°).

2 times mode

The welding starts when the trigger of the torch is pulled and stops when the trigger is released.

4 times mode

The pre-gas starts when the trigger is pulled and the welding starts when the trigger is released. With the next pull on the trigger, the welding stops and the post gas stays active until the trigger is released.

Spot mode

The power source starts to weld when the trigger is pulled. The welding stops automatically after a pre-set delay.

Intermittance mode

This a point mode which is repeatable. If the pulled trigger is maintained, welding will be repeated after another interval time (can be adjusted).

Duty cycle

It is defined in the standard EN 60974-1. It corresponds to the continuous use of an equipment during 10 minutes at a temperature of 40 °C. A duty cycle of 100 A at 60%, means that during 10 minutes, the power source can weld during 6 mn at 100 A followed by 4 mn of stop. A duty cycle 100 A at 100% means that the power source can provide continuously 100 A.

Wide choice for a better satisfaction.

The complete CITOLINE range was designed with the welding professional in mind. The CITOLINE range offers an industrial solution with a 35% duty cycle making it ideal for maintenance/repair and manufacturing applications. The complete range and reliability make it one of the MIG references in today's market.

| Designation | Duty cycle | Supply | Feeding | Steel. Stainless steel (mm) | Aluminium (mm) | Cored wire (mm) | Display |
|----------------------|-------------|--------------|-----------|--------------------------------|-------------------|--------------------|---------|
| CITOLINE 1700 M | 140 A (18%) | single-phase | 2 rollers | 0.6 to 1.0 | 0.8 to 1.0 | 1.0 | No |
| CITOLINE 2000 M | 180 A (20%) | single-phase | 4 rollers | 0.6 to 1.0 | 0.8 to 1.0 | 1.0 | Option |
| CITOLINE 2000 T | 200 A (30%) | three-phase | 4 rollers | 0.6 to 1.0 | 0.8 to 1.0 | 1.0 | Option |
| CITOLINE 2500 M | 250 A (30%) | single-phase | 4 rollers | 0.6 to 1.0 | 0.8 to 1.0 | 1.0 | Option |
| CITOLINE 2500 T | 250 A (30%) | three-phase | 4 rollers | 0.6 to 1.0 | 0.8 to 1.0 | 1.0 | Yes |
| CITOLINE 3000 M | 300 A (30%) | single-phase | 4 rollers | 0.8 to 1.2 | 1.0 to 1.2 | 1.0 to 1.2 | Option |
| CITOLINE 3000 T | 300 A (35%) | three-phase | 4 rollers | 0.8 to 1.2 | 1.0 to 1.2 | 1.0 to 1.2 | Yes |
| CITOLINE 3500 T | 350 A (35%) | three-phase | 4 rollers | 0.8 to 1.2 | 1.0 to 1.2 | 1.0 to 1.2 | Yes |
| CITOLINE 2500 MS | 250 A (30%) | single-phase | 4 rollers | 0.6 to 1.0 | 0.8 to 1.0 | 1.0 | Yes |
| CITOLINE 3000 MS | 300 A (30%) | single-phase | 4 rollers | 0.8 to 1.2 | 1.0 to 1.2 | 1.0 to 1.2 | Yes |
| CITOLINE 3000 TS | 300 A (35%) | three-phase | 4 rollers | 0.8 to 1.2 | 1.0 to 1.2 | 1.0 to 1.2 | Yes |
| CITOLINE 3500 TS | 350 A (35%) | three-phase | 4 rollers | 0.8 to 1.2 | 1.0 to 1.2 | 1.0 to 1.2 | Yes |
| CITOLINE 4500 TS | 450 A (35%) | three-phase | 4 rollers | 0.8 to 1.6 | 1.0 to 1.6 | 1.0 to 1.6 | Yes |
| CITOLINE 4500 TS (W) | 450 A (35%) | three-phase | 4 rollers | 0.8 to 1.6 | 1.0 to 1.6 | 1.0 to 1.6 | Yes |

Welding performance and ergonomy



2007-178

Power source:

- Compact and light due to the dynamicaly self-adusting power transformer technology.

Controlled striking

- Possibility to adjust the striking speed.
- Stick out adjustment.

4 rollers mounting plate:

- Equipped with self-adjusting pressure idle rollers to improve feeding quality and avoid unevenness.

Flexibility

- Reverse polarity for gasless cored wire application (compact version).



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Easy to use

- Inclined front panel for a complete view.
- Wire feeder with wheels.
- Wire feeder easily storable on the power source.
- Large pivot foot to allow easy installation of the wire feeder.



2003-583



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CITOLINE M: single-phase range.



Basic equipment:

- Digital display depending on model.
- 4 rollers mounting plate (except on CITOLINE 1700 M).
- Reverse polarity depending on model.
- Complete welding cycle (2T-4T-Spot-Intermittent).
- Ground cable with clamp.
- K 300 depending on model.



Technical characteristics:

| | | SINGLE-PHASE CO | |
|------------------------------------|------------------------------------|-------------------------|------------------------|
| | | CITOLINE 1700 M | CITOLINE 2000 M |
| Primary | Power supply | 230 V - 1ph | 230 V - 1ph |
| | Frequency | 50 - 60 Hz | 50 Hz |
| | Consumption at max. current | 24 A | 32 A |
| Secondary | No-load voltage | 18 - 32 V | 18 - 35 V |
| | Welding current | 30 - 170 A | 35 - 180 A |
| Duty cycle at 40 °C | at 100 % | 60 A | 85 A |
| | at 60 % | 75 A | 110 A |
| | at 35 % | 140 A (18 %) | 180 A (20 %) |
| Wires diameter | Steel | 0.6-0.8-(1.0) mm | 0.6-0.8-(1.0) mm |
| | Stainless steel | 0.8-(1.0) mm | 0.8-(1.0) mm |
| | Flux cored wire | 1.0 mm | 1.0 mm |
| | Aluminium | 0.8-1.0 mm | 0.8-1.0 mm |
| Protection index | | IP 21 | IP 23 |
| Standards | | EN 60974-1; EN 60974-10 | |
| Insulation classification | | H | |
| Dimensional characteristics | Dimensions (W x H x L) | 440 x 670 x 750 mm | 500 x 870 x 950 mm |
| | Net weight | 39 kg | 52 kg |
| Wire feed | | 2 rollers | 4 rollers |
| Digital display | | No | Option W 000 352 093 |
| Number of self position | | 1 | |
| Reverse polarity | | Yes | |

To order

| | | | |
|---------------------------|-------------------------|---------------|---------------|
| Power source | Power supply | W 000 261 954 | W 000 261 963 |
| | DV 4004 CTL 5 m | - | - |
| Wire feeder | DV 4004 CTL 10 m | - | - |
| | | | |
| Package* | | W 000 261 780 | W 000 266 707 |
| Torch (air cooled) | WELDLINE | WMT 15 A | WMT 25 A |
| | length 3 m | W 000 010 600 | W 000 010 602 |
| | length 4 m | W 000 010 601 | W 000 010 603 |

* Powersource + torch + pressure regulator (for French market).

Compact and separate (S) versions.



| COMPACT VERSIONS | | SINGLE-PHASE SEPARATED VERSIONS | |
|-------------------------|----------------------|---------------------------------|------------------|
| CITOLINE 2500 M | CITOLINE 3000 M | CITOLINE 2500 MS | CITOLINE 3000 MS |
| 230 V - 1ph | 230 V - 1ph | 230 V - 1ph | 230 V - 1ph |
| 50 Hz | 50 Hz | 50 Hz | 50 Hz |
| 54 A | 67 A | 54 A | 67 A |
| 20 - 53 V | 20 - 55 V | 20 - 53 V | 20 - 55 V |
| 32 - 250 A | 28 - 300 A | 32 - 250 A | 28 - 300 A |
| 140 A | 165 A | 140 A | 165 A |
| 180 A | 215 A | 180 A | 215 A |
| 250 A (30 %) | 300 A | 250 A (30 %) | 300 A |
| 0.8-1.0 mm | 0.8-1.2 mm | 0.8-1.0 mm | 0.8-1.2 mm |
| 0.8-1.0 mm | 0.8-1.2 mm | 0.8-1.0 mm | 0.8-1.2 mm |
| 1.0 mm | 1.0-1.2 mm | 1.0 mm | 1.0-1.2 mm |
| 0.8-1.0 mm | 1.0-1.2 mm | 0.8-1.0 mm | 1.0-1.2 mm |
| IP 23 | | IP 23 | |
| EN 60974-1; EN 60974-10 | | EN 60974-1; EN 60974-10 | |
| H | | H | |
| 500 x 870 x 950 mm | 500 x 870 x 950 mm | 500 x 870 x 950 mm | |
| 86 kg | 86 kg | 86 kg | |
| 4 rollers | 4 rollers | 4 rollers | 4 rollers |
| Option W 000 352 093 | Option W 000 352 093 | Yes (on wire feeder) | |
| 1 | 1 | 1 | 4 |
| Yes | Yes | No | No |
| W 000 261 964 | W 000 261 965 | W 000 261 972 | W 000 261 973 |
| - | - | W 000 262 182 | |
| - | - | W 000 262 183 | |
| - | - | - | |
| WMT 25 A | WMT 36 A | WMT 36 A | |
| W 000 010 602 | W 000 010 605 | W 000 010 605 | |
| W 000 010 603 | W 000 010 606 | W 000 010 606 | |

CITOLINE T: three-phase range.



Basic equipment:

- Digital display depending on model.
- 4 rollers mounting plate.
- Reverse polarity depending on model.
- Complete welding cycle (2T-4T-Spot-Intermittent).
- Ground cable with clamp.
- K 300 depending on model.
- Water cooled version on CITOLINE 3500TS and 4500TS.



Technical characteristics:

| | | THREE-PHASE COMPACT VERSIONS | | |
|------------------------------------|------------------------------------|-------------------------------------|------------------------|------------------------|
| | | CITOLINE 2000 T | CITOLINE 2500 T | CITOLINE 3000 T |
| Primary | Power supply | 230 / 400 V - 3ph | | |
| | Frequency | 50 Hz | | |
| | Consumption at max. current | 19 - 11 A | 27 - 16 A | 33 - 19 A |
| Secondary | No-load voltage | 18 - 35 V | 18 - 40 V | 18 - 45 V |
| | Welding current | 27 - 200 A | 35 - 250 A | 35 - 300 A |
| | Duty cycle at 40 °C | | | |
| | at 100 % | 110 A | 140 A | 180 A |
| | at 60 % | 140 A | 170 A | 230 A |
| | at 35 % | 200 A (30 %) | 250 A (30 %) | 300 A |
| Wires diameter | Steel | 0.6-1.0 mm | 0.8-1.0 mm | 0.8-1.2 mm |
| | Stainless steel | 0.8-1.0 mm | 0.8-1.0 mm | 0.8-1.2 mm |
| | Flux cored wire | 1.0 mm | 1.0 mm | 1.0-1.2 mm |
| | Aluminium | 0.8-1.0 mm | 0.8-1.0 mm | 1.0-1.2 mm |
| Protection index | | IP 23 | | |
| Standards | | EN 60974-1; EN 60974-10 | | |
| Insulation classification | | H | | |
| Dimensional characteristics | Dimensions (W x H x L) | 500 x 870 x 950 mm | 500 x 870 x 950 mm | 620 x 940 x 1.000 mm |
| | Net weight | 71 kg | 80 kg | 96 kg |
| Wire feed | | 4 rollers | | |
| Digital display | | Option W 000 352 093 | Option W 000 352 093 | Yes |
| Number of self position | | 1 | 2 | 3 |
| Reverse polarity | | Yes | | |

To order

| | | | | |
|-----------------------------|--|-------------------------------|---------------|---------------|
| Power source only | | W 000 261 966 | W 000 261 967 | W 000 261 970 |
| Air cooled version | Wire feeder DV 4004 CTL | - | - | - |
| | | including 5 m harness | - | - |
| | | including 10 m harness | - | - |
| | WELDLINE torch | | WMT 25 A | WMT 36 A |
| | length 3 m | W 000 010 602 | W 000 010 605 | |
| | length 4 m | W 000 010 603 | W 000 010 606 | |
| Water cooled version | Wire feeder DV 4004 CTL W + 10 m harness | - | - | - |
| | Wire feeder DV 4004 CTL 42 V + 10 m harness | - | - | - |
| | Cooling unit | - | - | - |
| | WELDLINE torch | | - | - |
| | | length 3 m | - | - |
| | length 4 m | - | - | |
| Package* | | W 000 261 782 | W 000 261 783 | W 000 261 785 |

* Powersource + torch + pressure regulator (for French market).

Compact and separate (S) versions.



THREE-PHASE SEPARATED VERSIONS

| CITOLINE 3500 T | CITOLINE 3000 TS | CITOLINE 3500 TS / 3500 TS (W) | CITOLINE 4500 TS / 4500 TS (W) |
|-------------------------|-------------------------|--------------------------------|--------------------------------|
| 230 / 400 V - 3ph | 230 / 400 V - 3ph | | |
| 50 Hz | 50 Hz | | |
| 41.5 - 24 A | 34 - 19.5 A | 41.5 - 24 A | 64 - 37 A |
| 18 - 45 V | 18 - 42 V | 18 - 45 V | 19 - 54 V |
| 35 - 350 A | 35 - 300 A | 35 - 350 A | 35 - 450 A |
| 210 A | 180 A | 210 A | 270 A |
| 270 A | 230 A | 270 A | 345 A |
| 350 A | 300 A | 350 A | 450 A |
| 0.8-1.2 mm | 0.8-1.2 mm | 0.8-1.2 mm | 0.8-1.6 mm |
| 0.8-1.2 mm | 0.8-1.2 mm | 0.8-1.2 mm | 0.8-1.6 mm |
| 1.0-1.2 mm | 1.0-1.2 mm | 1.0-1.2 mm | 1.0-1.6 mm |
| 1.0-1.2 mm | 0.8-1.2 mm | 1.0-1.2 mm | 1.0-1.2 mm (1.6 mm) |
| IP 23 | IP 23 | | |
| EN 60974-1; EN 60974-10 | EN 60974-1; EN 60974-10 | | |
| H | H | | |
| 620 x 940 x 1.000 mm | 500 x 865 x 900 mm | 500 x 865 x 900 mm | 610 x 915 x 1.030 mm |
| 116 kg | 81 kg | 100 kg | 135 kg |
| 4 rollers | 4 rollers | | |
| Yes | Yes (on wire feeder) | | |
| 3 | 1 | 3 | |
| Yes | No | | |

| | | | | |
|---------------|---------------|---------------|---------------|---------------|
| W 000 261 971 | W 000 261 981 | W 000 261 974 | W 000 305 243 | W 000 261 975 |
| - | - | - | W 000 262 182 | - |
| - | - | - | W 000 262 183 | - |
| WMT 36 A | - | - | WMT 36 A | - |
| W 000 010 605 | - | - | W 000 010 605 | - |
| W 000 010 606 | - | - | W 000 010 606 | - |
| - | - | - | - | W 000 262 184 |
| - | - | - | W 000 271 010 | W 000 271 010 |
| - | - | - | - | W 000 262 188 |
| - | - | - | WMT 500 W | WMT 500 W |
| - | - | - | W 000 010 608 | W 000 010 608 |
| - | - | - | W 000 010 609 | W 000 010 609 |
| W 000 261 787 | W 000 261 784 | W 000 261 786 | W 000 266 715 | W 000 261 788 |
| - | - | - | - | W 000 266 708 |

CITOLINE: friendly and easy to adjust.



CITOLINE 1700 M



- 1** Transformer temperature monitoring indicator light
- 2** Step time potentiometer (if used for continuous welding, potentiometer in "timer off" position)
- 3** Torch connector, "Euro" type
- 4** Voltage switch (used to adjust the voltage)
- 5** Wire speed regulation potentiometer (carries out current calibration)
- 6** Primary power supply cable
- 7** Ground cable with its clamp

CITOLINE M/T



- A** Digital Volt/Ampere display
 - Shows the parameters before and after welding.
 - Facilitates parameter setting.
- B** Welding cycle selector
 - 2T: pressing the trigger activates the arc, releasing it activates the end of the cycle.
 - 4T: pressing the trigger starts the cycle, the trigger can be released. Pressing it again stops the cycle.
 - Spot weld: supplies a welding current for a given time.
- 3** Torch connector
- C** Step time
 - Used to set the spot welding time.
- D** Priming speed
 - Sets the wire run-up speed which improves arc striking.
- E** Anti-sticking
 - Adjusts the length of the "burnt" wire at the end of welding. This function avoids the wire sticking to the workpiece.
- F** Wire speed potentiometer
 - Allow continuous adjustment of the wire feed speed.
- G** Wire test
 - Checks the wire feed mechanism is working properly.
- H** Test gas
 - Used to check the gasflow.
- I** Switch
 - Switch on and pre-adjustment of the welding voltage.
- J** Voltage selector switch
 - Allows the voltage to the terminals of the welding circuit to be finely adjusted.
- K** Grounding cable terminals:
 - On small inductance coil: dynamic and penetrating arc
 - On large inductance coil: soft arc, damp cable.

CITOLINE (S)



WIRE FEEDER DV 4004 CTL







CITOLINE: wear parts-options



| Wire feeder parts | Ø 0.6 mm | Ø 0.8 mm | Ø 1.0 mm | Ø 1.2 mm | Ø 1.4 mm | Ø 1.6 mm |
|---|---------------|---------------|---------------|---------------|---------------|---------------|
| Specific to CITOLINE 1700 M | | | | | | |
| Rollers for steel and stainless steel wires | W 000 232 110 | | W 000 232 112 | - | - | - |
| Entry wire guide | W 000 231 810 | | | | | |
| Other models of CITOLINE | | | | | | |
| Entry wire guide | W 000 233 472 | | | | | |
| Rollers for steel and stainless steel wires | W 000 050 096 | W 000 050 097 | W 000 050 098 | W 000 050 099 | - | W 000 218 767 |
| Rollers for flux cored wires | - | - | W 000 264 870 | | W 000 265 883 | |
| Rollers for aluminium wires | - | W 000 050 100 | W 000 050 101 | W 000 050 102 | - | W 000 229 630 |
| Intermediate wire guide | W 000 252 183 | | | | | |
| Outlet wire guide | W 000 269 661 | | | | | |

WELDLINE torches

| Air cooled torches | | | | | |
|----------------------|-----|--------------------|---------------|--|------------|
| Torche name | | Duty cycle at 60 % | Cat. no. | | Max wire Ø |
| WMT 15 A | 3 m | 180 A | W 000 010 600 |  | 1.0 mm |
| | 4 m | | W 000 010 601 | | |
| WMT 25 A | 3 m | 230 A | W 000 010 602 |  | 1.2 mm |
| | 4 m | | W 000 010 603 | | |
| | 5 m | | W 000 010 604 | | |
| WMT 36 A | 3 m | 340 A | W 000 010 605 |  | 1.6 mm |
| | 4 m | | W 000 010 606 | | |
| | 5 m | | W 000 010 607 | | |
| Water cooled torches | | | | | |
| WMT 500 W | 3 m | 500 A | W 000 010 608 |  | 1.6 mm |
| | 4 m | | W 000 010 609 | | |
| | 5 m | | W 000 010 610 | | |

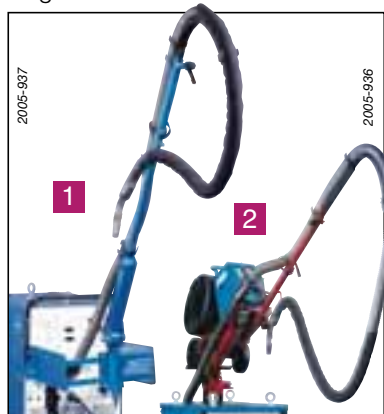
Torch arm rest

2 models in the range

1 for CITOLINE compact version:
W 000 261 845

2 for CITOLINE separate version:
W 000 261 846

Arm adjustable up to 2.5 meters length.



CHAMELEON F, CHAMELEON 3V & CHAMELEON 3V+ self darkening helmets.

CHAMELEON F and 3V helmets are self darkening masks equipped with a fixed liquid crystal cell for the F type (DIN 3/11), and a variable one for the 3V type (DIN 4/9-13). Very light, this high technology helmets are sold with an adjustable headgear.

CHAMELEON 3F
Type fixed cell
DIN 3/11

CHAMELEON 3V
Type variable cell
DIN 4/9-13
specially designed
for MMA, MIG/MAG

CHAMELEON 3V+
Type variable cell
DIN 4/9-13
covering all processes
especially TIG



W 000 261 351

W 000 261 352

W 000 261 353



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www.airliquide.com

Founded in 1902, Air Liquide is the world leader in industrial and medical gases and related services. The company has offices in 75 countries and employs a work force of 40,000. Drawing on constantly renewed technologies, Air Liquide develops groundbreaking solutions used in making countless everyday products and in helping to preserve life.

Air Liquide Welding France reserves the right to carry out modifications to its machinery without prior notice.
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GB: 2436 - 07 2008 - S 05 - Ed. 2
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