

Positioning equipment

A complete offer of positioning equipment for every manual and automatic welding applications.



2662-031R

Air Liquide Welding positioning range

Since control over the welding process is the key to any system's performance, Air Liquide Welding offer procedural support in addition to their range of positioning equipment.

Positioning equipment from Air Liquide Welding can be adapted to all welding needs:

- Comfortable for the operator,
- Correct welder position,
- Elimination of fatigue due to manipulations,
- In the automatic mode, it provides the assurance of regular and high-quality welding.

Further, positioning is extremely easy and the work is done faster, more rationally and more safely.

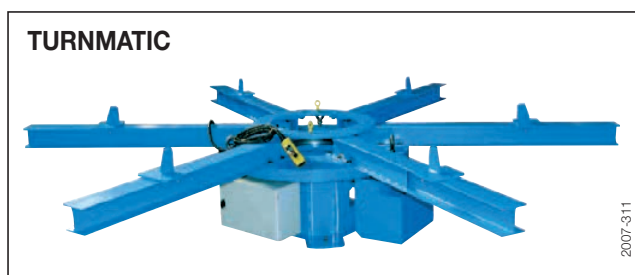
Air Liquide Welding range of positioning equipment includes:



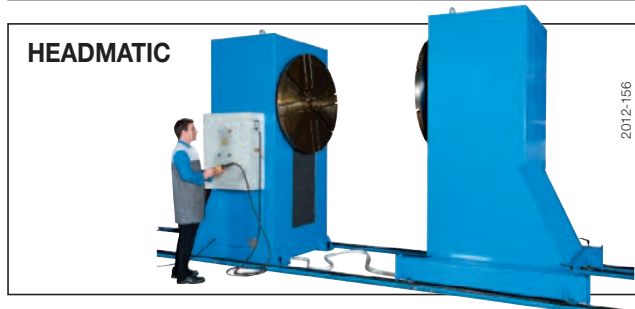
The ROTAMATIC range from 2 tons to 600 tons allows the rotation of vessels for manual or automatic welding. A large choice of options completes the range.



The POSIMATIC range from 100 kg to 30 tons allows the rotation of piece for manual or automatic welding. The standard POSIMATIC has a rotation and tilting movement. The TPE Positioner has an additional lifting movement.



The TURNMATIC range from 5 tons to 30 tons allows the rotation of piece for automatic welding. The standard range accepts a diameter piece of 1000 to 4500 mm.



The HEADMATIC range up to 32 tons in standard allows the rotation of piece for manual or automatic welding. The addition of idler headstock on lorry offers the possibility to manipulate longer piece. The synchronized lifting device allows the operator to work in safety conditions.



These MIG/MAG carriages are used for automatic and semi-automatic welding of large work pieces. These self-propelled tractors carry 1 or 2 manual welding torches equipments and offer practical, efficient and not expensive solutions



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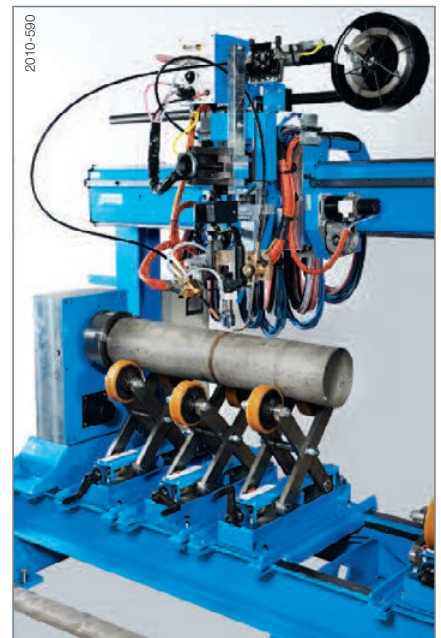
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2010-590



1160-044



2000-443

ROTAMATIC ST



2662-031

Easy-to use line of rotators covering a load carrying range from 2 tons up to 600 tons (Drive unit + Idler unit).

Medium-duty rotator: 2 T to 30 T

- ◇ Single powered (one drive roller) for small unbalance work piece.
- ◇ Double powered (two drive rollers) for work pieces having significant unbalance.
- ◇ Roller-to-roller center distance adjusting by screw (except for ST 2: by step).

■ Polyurethane roller for better drive

■ Symetrical movement of roller axis distance for an easy adaptation of piece diameter

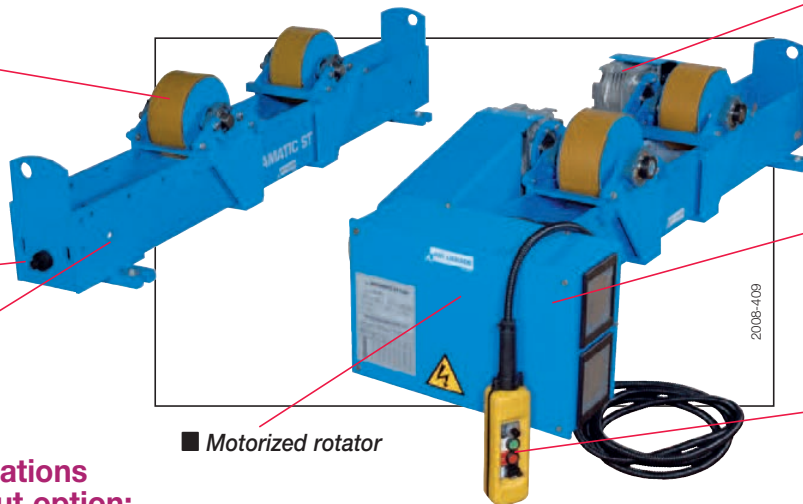
■ Idler rotator

■ Motorized rotator

■ Single or double motorization with mechanical protection

■ CE electrical cabinet

■ Remote pendant on all models



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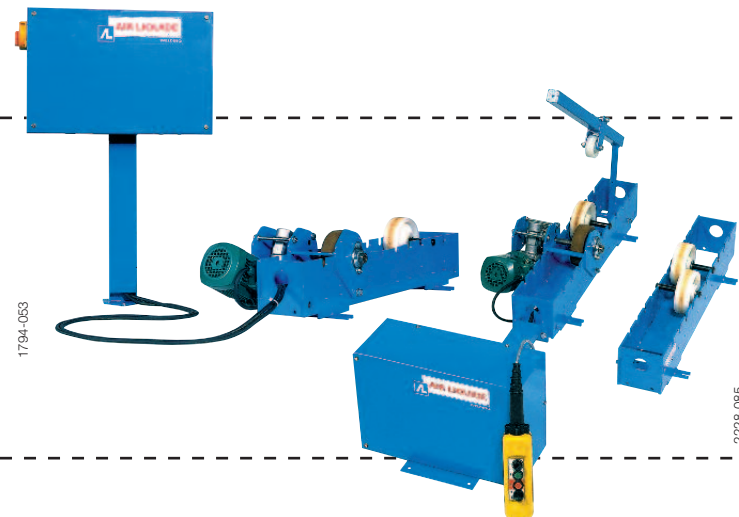
Technical specifications for rotators without option:

Designation	Cat. no.	Load capacity (1 drive + 1 idler) kg	Load capacity per section kg	Shell diameter mm	Peripheral speed cm/min	Wheel dimension OD x width	Wheel material
ST 2	MT	W000315290	2000	1000	30 to 2500	12 to 120	Ø 150 x 50
	M	W000315289					
	W	W000315288					
	F	W000315291					
ST 6	M	W000315297	6000	3000	300 to 3500	12 to 120	Ø 250 x 75
	W	W000315296					
	F	W000315298					
ST 15	M	W000315304	15000	7500	300 to 4000	12 to 120	Ø 250 x 110
	W	W000315303					
	F	W000315305					
ST 30	W	W000315309	30000	15000	350 to 4500	12 to 120	Ø 350 x 150
	F	W000315310					

Keys:

M = Single motorization
W = Double motorization

F = Idler roll
MT = Single motorization with tube system



With the options Kit auto, Kit display, Kit regulation and Kit encoder, you can have a complete set of rotators according your needs. Don't forget the possible options: lorry and antidrift system (see page 9).

Possibility to connect a pedal: W000273453. The option kit auto is required.

References of motorized rotators with options:

- ⇒ Kit auto (A): Synchronization with the welding unit (ON / OFF)
- ⇒ Kit Display (D): Digital speed display on electrical cabinet
- ⇒ Kit Regulation (R): Rotation speed regulation $\pm 1\%$ (Plasma or TIG regulation)
- ⇒ Kit encoder (C): Encoder 5000 points mounted on motor roller

Type	Options				Designation	Cat. no.
	Kit auto	Kit display	Kit regulation	Kit encoder		
2T M	X				ROTAMATIC ST 2M A	W000272451
	X	X			ROTAMATIC ST 2M AD	W000272452
	X	X	X		ROTAMATIC ST 2M ADR	W000272453
	X	X	X	X	ROTAMATIC ST 2M ADRC	W000272454
2T MT	X				ROTAMATIC ST 2MT A	W000272455
	X	X			ROTAMATIC ST 2MT AD	W000272456
	X	X	X		ROTAMATIC ST 2MT ADR	W000272457
	X	X	X	X	ROTAMATIC ST 2MT ADRC	W000272458
2T W	X				ROTAMATIC ST 2W A	W000272459
	X	X			ROTAMATIC ST 2W AD	W000272460
	X	X	X		ROTAMATIC ST 2W ADR	W000272461
	X	X	X	X	ROTAMATIC ST 2W ADRC	W000272462
6T M	X				ROTAMATIC ST 6M A	W000272463
	X	X			ROTAMATIC ST 6M AD	W000272464
	X	X	X		ROTAMATIC ST 6M ADR	W000272465
	X	X	X	X	ROTAMATIC ST 6M ADRC	W000272466
6T W	X				ROTAMATIC ST 6W A	W000272467
	X	X			ROTAMATIC ST 6W AD	W000272468
	X	X	X		ROTAMATIC ST 6W ADR	W000272469
	X	X	X	X	ROTAMATIC ST 6W ADRC	W000272470
15T M	X				ROTAMATIC ST 15M A	W000272471
	X	X			ROTAMATIC ST 15M AD	W000272472
	X	X	X		ROTAMATIC ST 15M ADR	W000272473
	X	X	X	X	ROTAMATIC ST 15M ADRC	W000272474
15T W	X				ROTAMATIC ST 15W A	W000272475
	X	X			ROTAMATIC ST 15W AD	W000272476
	X	X	X		ROTAMATIC ST 15W ADR	W000272477
	X	X	X	X	ROTAMATIC ST 15W ADRC	W000272478
30T W	X				ROTAMATIC ST 30W A	W000272479
	X	X			ROTAMATIC ST 30W AD	W000272480
	X	X	X		ROTAMATIC ST 30W ADR	W000272481
	X	X	X	X	ROTAMATIC ST 30W ADRC	W000272482

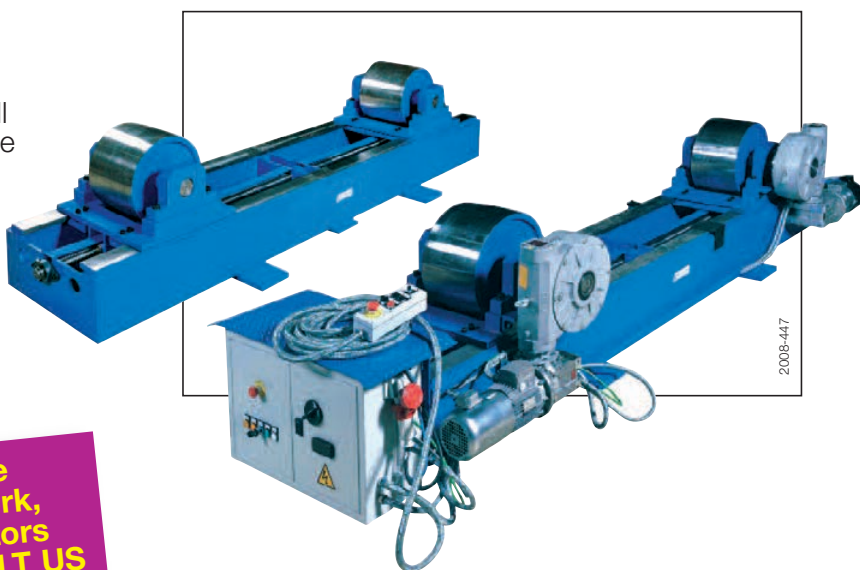
ROTAMATIC LP



Heavy-duty rotator: 42 T to 600 T

In standards, up to 200 tons:

- ◇ Special frame conception with built-in roll supports reduces welding height from the ground.
- ◇ Machined bed on the idler and drive roll for perfect alignment.
- ◇ Remote pendant, kit auto and display in standard on all versions.
- ◇ Possible options:
 - lorry and railway (see page 9)
 - screw adjusting or step adjusting



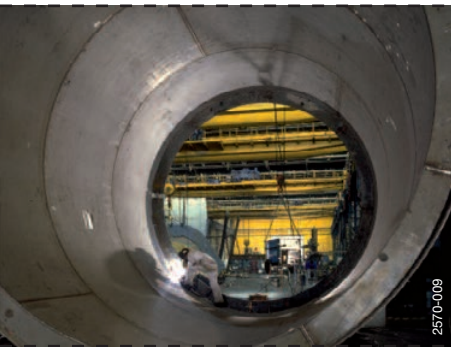
With our experience in the heavy boilerwork, we can propose rotators up to 600 tons: CONSULT US

Technical specifications:

Designation	Load capacity (1 drive + 1 idler) kg	Load capacity per section kg	Shell diameter mm	Peripheral speed cm/min	Wheel dimension OD x width	Wheel material
LP42*	42000	21000	700 to 5000	10 to 100 or 9 to 180	Ø 400 x 200	Steel
					Ø 400 x 250	Polyurethane
LP55*	55000	27500	700 to 5000	10 to 100 or 9 to 180	Ø 400 x 250	Steel
					Ø 400 x 300	Polyurethane
LP70*	70000	35000	900 to 6000	10 to 100 or 8 to 160	Ø 460 x 250	Steel
					Ø 460 x 300	Polyurethane
LP100*	100000	50000	900 to 6000	10 to 100 or 8 to 160	Ø 450 x 250	Steel
					Ø 460 x 300	Polyurethane
LP160*	160000	80000	1200 to 6000	10 to 100 or 9 to 160	Ø 450 x 300	Steel
LP200*	200000	100000	1200 to 6000	10 to 100 or 10 to 160	Ø 500 x 300	Steel

* Available in version **W** (Double motorization) or **F** (Idler roll)

ROTAMATIC: fit-up rotator



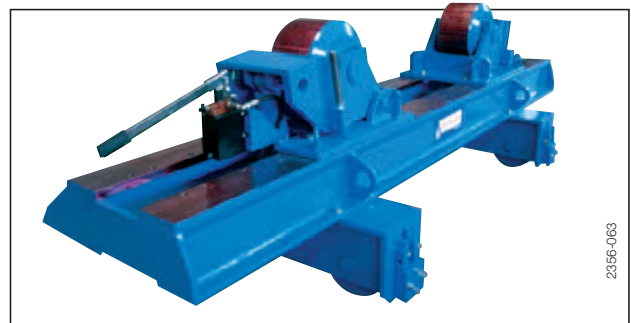
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The fit-up rotator allows to manipulate the vessels without any other exterior elements (crane...). Up to 200 tons, with 1 set of single roller rotators (idler + motorized) and 2 fit-up rotators, the operators can easily adjust the vessels in order to make a good adjustment of the shells.

Fit-up rotator: 30 T to 200 T

- ⇨ In standard, the up and down movement is made by a manual hydraulic pump.
- ⇨ Possible options:
 - automatic hydraulic pump (hydraulic central)
 - lorry and railway (see page 9)

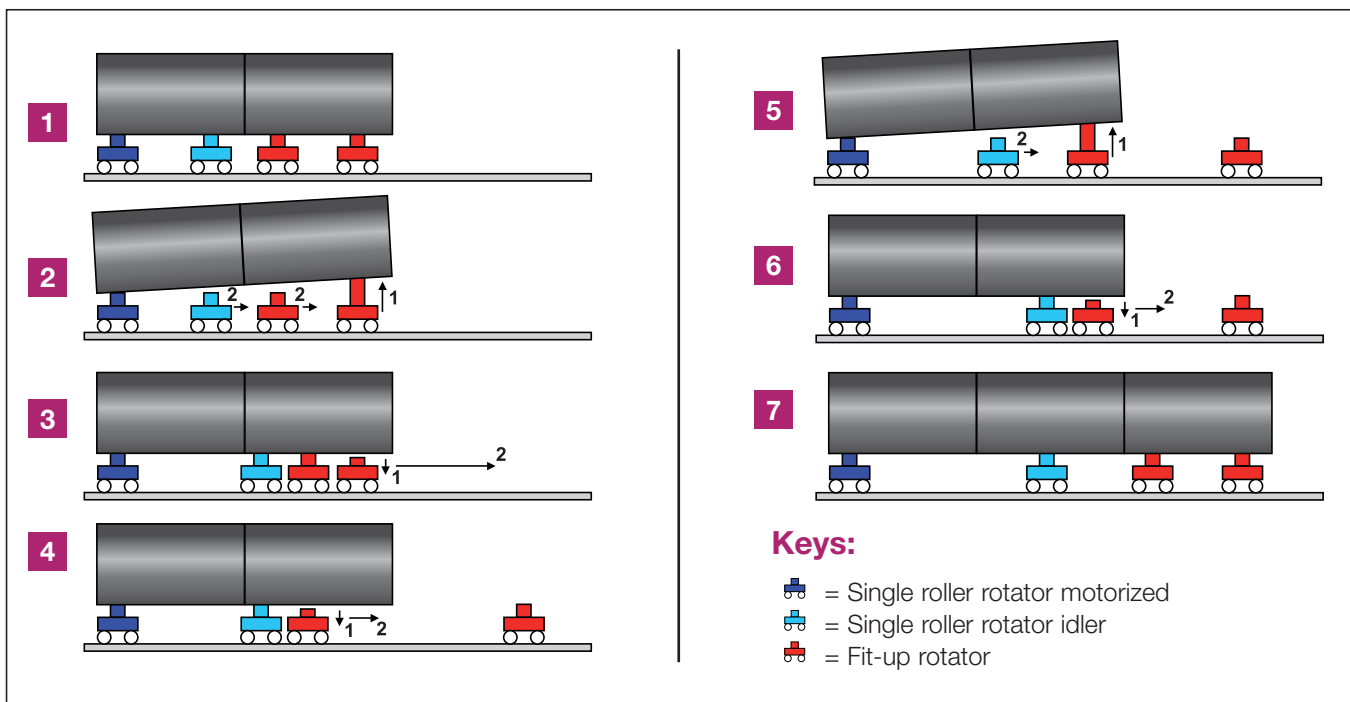
For a higher capacity rotators: consult us.



2356-063

Technical specifications:

Designation	Load capacity (2 fit-up) kg	Lifting capacity per section kg	Shell diameter mm	Wheel dimension OD x width	Wheel material	Wheels adjustment
TR30	30000	15000	700 to 4500	Ø 300 x 160	Polyurethane	Screw
TR42	42000	21000	700 to 5000	Ø 350 x 250	Polyurethane	Screw
TR55	55000	27500	700 to 5000	Ø 350 x 250	Polyurethane	Screw
TR70	70000	35000	900 to 6000	Ø 400 x 300	Polyurethane	Screw
TR100	100000	50000	900 to 6000	Ø 400 x 250	Steel	Step
TR160	160000	80000	1200 to 6000	Ø 450 x 250	Steel	Step
TR200	200000	100000	1200 to 6000	Ø 450 x 300	Steel	Step



ROTAMATIC: self-aligning rotator



The self-aligning rotator range, up to 250 tons (drive unit + idler unit), allows the easy positioning of pieces. The rollers tilting allows to align the piece with the rotator without pre-adjusting of the rollers.

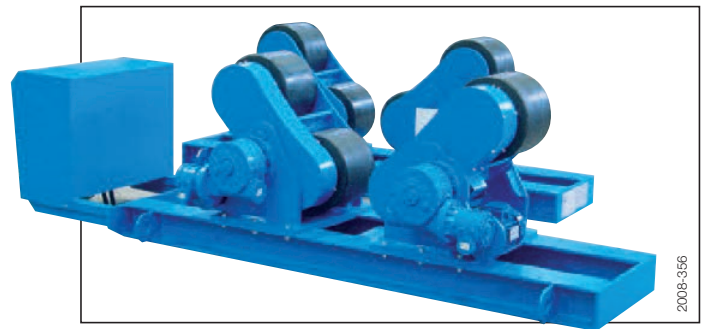
Self-aligning rotator: 12 T to 250 T

⇨ In standard: remote control, kit auto and display on all versions.

⇨ Possible options:

- lorry and railway (see page 9)

For a higher capacity rotators: consult us.

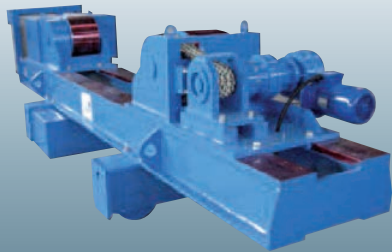


Technical specifications:

Designation	Load capacity (1 drive + 1 idler) kg	Load capacity per section kg	Shell diameter for 1/2 load mm	Shell diameter for maximum load mm	Peripheral speed cm/min	Wheel dimension OD x width	Wheel material
LP12-2R*	12000	6000	500 to 1500	1500 to 4000	10 to 100 or 10 to 200	Ø 300 x 220	Rubber
LP20-2R*	20000	10000	500 to 1500	1500 to 4000	10 to 100 or 10 to 200	Ø 350 x 300	Rubber
LP30-2R*	30000	15000	500 to 1500	1500 to 4500	10 to 100 or 8 to 160	Ø 400 x 300	Rubber
LP42-2R*	42000	21000	500 to 1500	1500 to 5000	10 to 100 or 9 to 180	Ø 400 x 400	Rubber
LP55-2R*	55000	27500	800 to 1800	1800 to 5000	10 to 100 or 9 to 180	Ø 500 x 230	Rubber
LP70-2R*	70000	35000	800 to 1800	1800 to 6000	10 to 100 or 9 to 180	Ø 500 x 400	Rubber
LP100-2R*	100000	50000	600 to 1500	1500 to 6000	10 to 100 or 8 to 160	Ø 420 x 300	Polyurethane
LP160-2R*	160000	80000	1000 to 1500	1500 to 6000	10 to 100 or 8 to 160	Ø 460 x 300	Polyurethane
LP200-2R*	200000	100000	1000 to 1500	1500 to 7000	10 to 100 or 7.5 to 150	Ø 500 x 300	Steel
						Ø 500 x 300	Polyurethane
LP250-2R*	250000	125000	1000 to 1500	1500 to 7000	10 to 100 or 7.5 to 150	Ø 500 x 300	Steel
						Ø 550 x 400	Polyurethane

* Available in version **W** (double motorization) or **F** (idler roll)

ROTAMATIC options



Options are available to make easy the manipulation of pieces with rotators.

Lorry

The lorry allows to move the rotators with or without the piece.

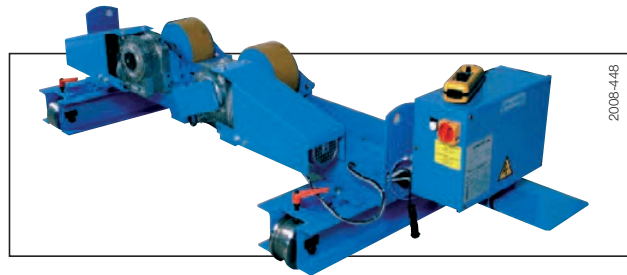
The idler lorry and the motorized lorry can be mounted on same rail.

Rail 6 m long: W000315250

Rail 3 m long: W000315251.

For Rotators

	Idler lorry	Motorized lorry	Translation speed m/min
ST6 / ST15 / ST30	W000272574	-	-
LP12-2R / LP20-2R / LP30-2R / TR30	LFC 30	-	-
LP42 / LP55 / LP42-2R / LP55-2R / TR42 / TR55	LFC 55	LMC 55	1,5
LP70 / LP100 / LP70-2R / LP100-2R / TR70 / TR100	LFC 100	LMC 100	1,4
LP160 / LP200 / LP160-2R / LP200-2R / TR160 / TR200	LFC 200	LMC 200	1,2
LP250-2R	LFC 250	LMC 250	1,2

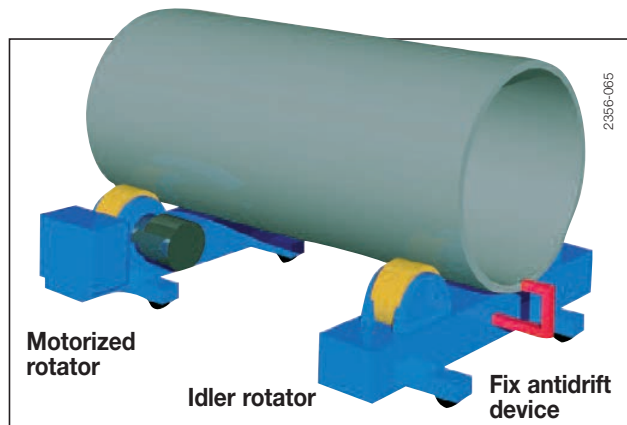


Antidrft system

The manual antidrift device allows the piece to turn without twisting.

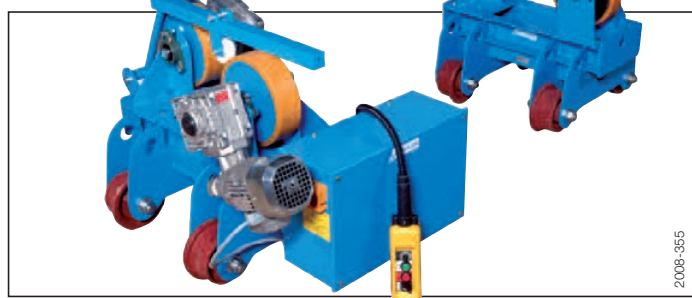
This system is fixed on the idler rotator.

For rotators	Manual Antidrft Device
LP12-2R / LP20-2R / LP30-2R / TR30	MAD 30
LP42 / LP55 / LP42-2R / LP55-2R / TR42 / TR55	MAD 55
LP70 / LP100 / LP70-2R / LP100-2R / TR70 / TR100	MAD 100
LP160 / LP200 / LP160-2R / LP200-2R / TR160 / TR200	MAD 200
LP250-2R	MAD 250

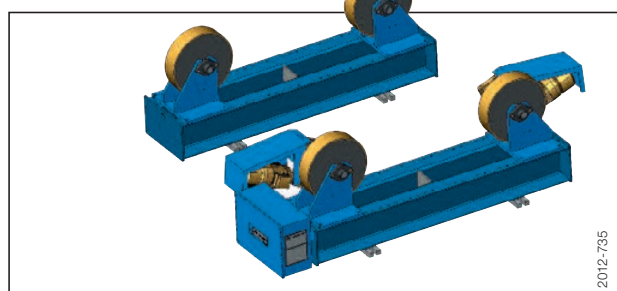


Special rotators

Small rotators: 6 tons, 100 to 600 mm diameter



Special rotators with large diameter of rollers for tanks with pipe nozzle



Positioners: POSIMATIC

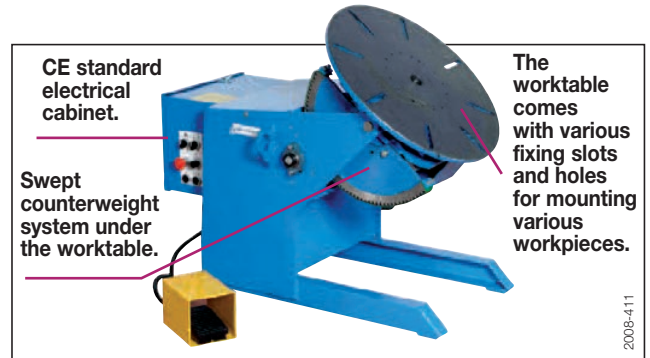


Air Liquide Welding offers a range of positioners tables of varying capacities. These devices therefore provide significant improvements in productivity, operator ergonomics and quality standards, both for manual work and for medium series production.

2 types of positioners are available:

- conventional: from 100 kg to 30 T
- with lifting table: from 1500 kg to 10 T

For higher capacity or different rotation speed range, please consult us.



Conventional: from 100 kg to 3 tons



POSIMATIC P1E:
100 kg at 175 mm from the plate



POSIMATIC P2E:
200 kg at 130 mm from the plate



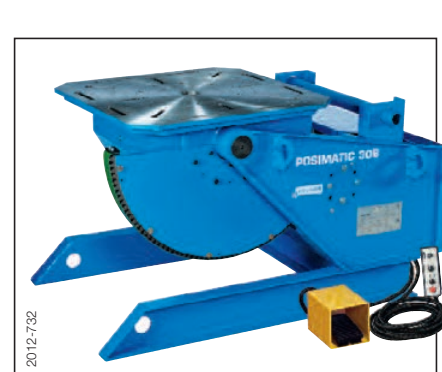
POSIMATIC 3F:
300 kg at 230 mm from the plate



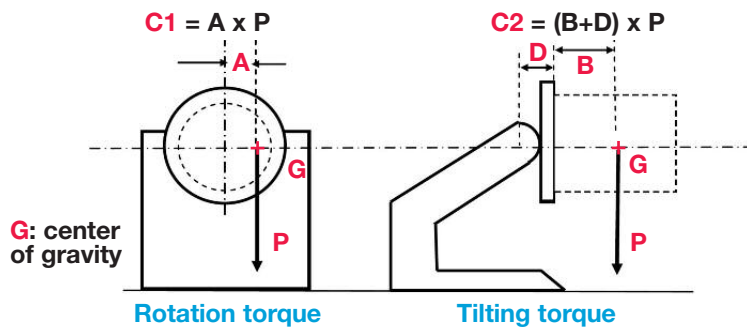
POSIMATIC 7F:
650 kg at 175 mm from the plate



POSIMATIC 16B:
1600 kg at 120 mm from the plate

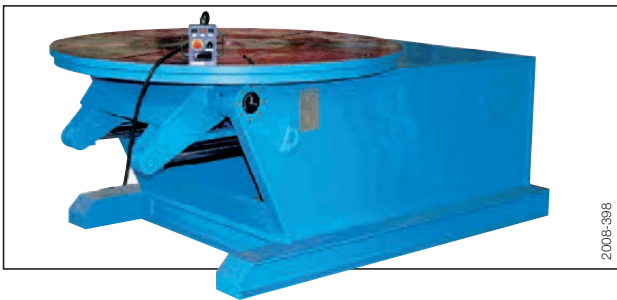


POSIMATIC 30B:
3000 kg at 140 mm from the plate



For higher capacity or different rotation speed range, please consult us.

Conventional: TP range from 4 T to 30 T



With lifting: TPE range from 1.5 T to 10 T



	Cat. no.	Load all positions kg	Tilt torque m.kg (C1)	Rotation torque m.kg (C2)	Rotation speed tr/min	Turntable height mm	Remote control or pedal	Plate dimension	Axis-plate distance mm (D)
P1E	W000315254	100	25	2	0.2 to 5	385	Pedal	Ø 300	75
P2E	W000315256	200	40	4	0.25 to 5	500	Pedal	Ø 400	70
3F	W000315255	400	90	20	0.14 to 2.2	650	Pedal	Ø 600	70
7F	W000315257	650	175	75	0.076 to 1.53	896	RC+ pedal	Ø 800	95
16B	W000315258	1600	400	150	0.074 to 1.48	975 to 1400	RC+ pedal	Ø 980	130
30B	W000315259	3000	840	250	0.06 to 1.18	980 to 1380	RC+ pedal	Ø 1000	140
TP4	Consult us	4000	1100	500	0.045 to 0.45	1110	RC	Ø 1600	160
TP6	Consult us	6000	2500	720	0.03 to 0.3	1150	RC	Ø 1800	175
TP8	Consult us	8000	3600	850	0.025 to 0.25	1000	RC	Ø 1800	175
TP10	Consult us	10000	6750	1450	0.022 to 0.22	1190	RC	Ø 2000	200
TP15	Consult us	15000	10300	2100	0.02 to 0.2	1275	RC	Ø 2250	240
TP20	Consult us	20000	14200	2900	0.018 to 0.18	1340	RC	Ø 2500	270
TP30	Consult us	30000	22500	4400	0.015 to 0.15	1450	RC	Ø 2750	300
TPE 1.5	Consult us	1500	375	160	0.06 to 0.6	970 to 1700	RC	Ø 1000	120
TPE 2.5	Consult us	2500	600	200	0.06 to 0.6	1030 to 1850	RC	Ø 1200	140
TPE 4	Consult us	4000	1100	500	0.045 to 0.45	1060 to 2010	RC	Ø 1600	160
TPE 6	Consult us	6000	2500	720	0.035 to 0.35	1125 to 2125	RC	Ø 1800	175
TPE 8	Consult us	8000	3600	850	0.025 to 0.25	1125 to 2125	RC	Ø 1800	175
TPE 10	Consult us	10000	6750	1450	0.022 to 0.22	1150 to 2350	RC	Ø 2000	200

Turn-tables: TURNMATIC

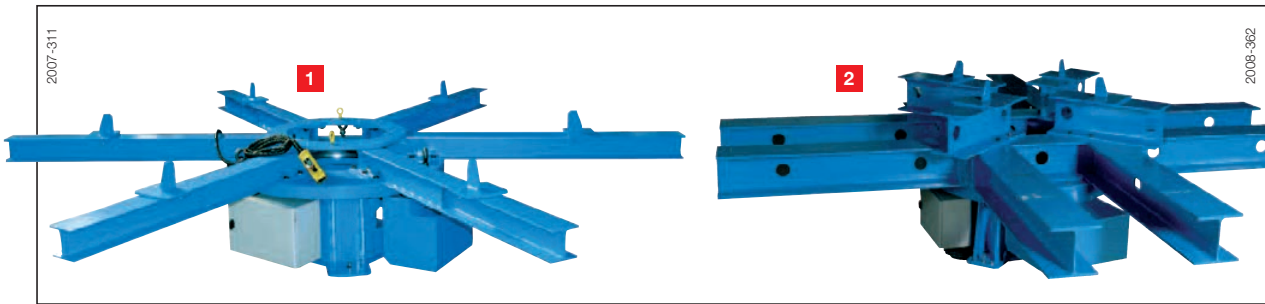


Air Liquide Welding proposes a range of turn-table up to 30 tons. A backing gas device can complete a welding solution with column and boom and plasma welding.

Turntable 5 T to 30 T

Circular welding can be performed by the movement of the turn table without moving the torch. In the standard range, a turn table can make the rotation of shells up to 30 tons and up to 4500 mm diameter.

For other sizes, capacities or rotation speed range: consult us.

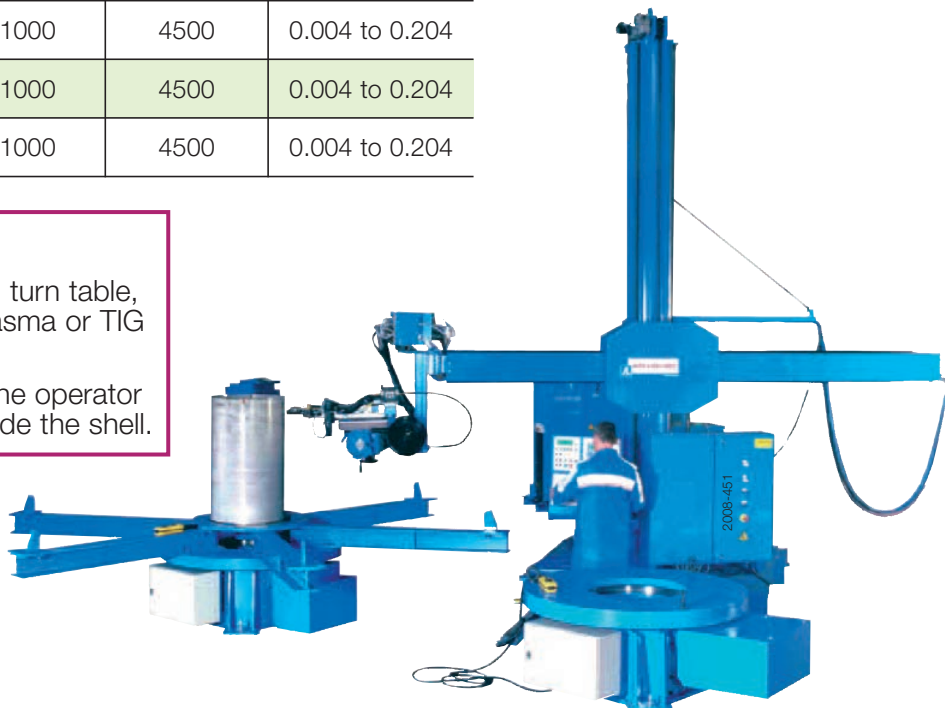
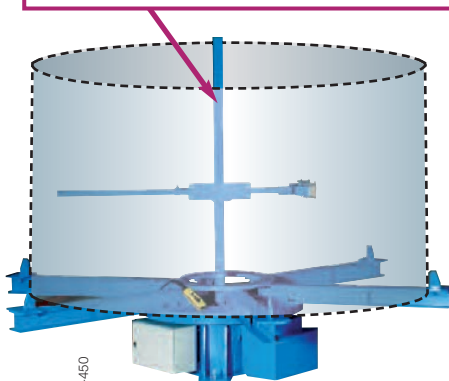


	Designation	Load capacity kg	Mini shell diameter mm	Maxi shell diameter mm	Rotation speed tr/min
1	TURNMATIC 5 T	5000	1200	4500	0.004 to 0.204
	TURNMATIC 10 T	10000	1000	4500	0.004 to 0.204
2	TURNMATIC 20 T	20000	1000	4500	0.004 to 0.204
	TURNMATIC 30 T	30000	1000	4500	0.004 to 0.204

Backing gas device:

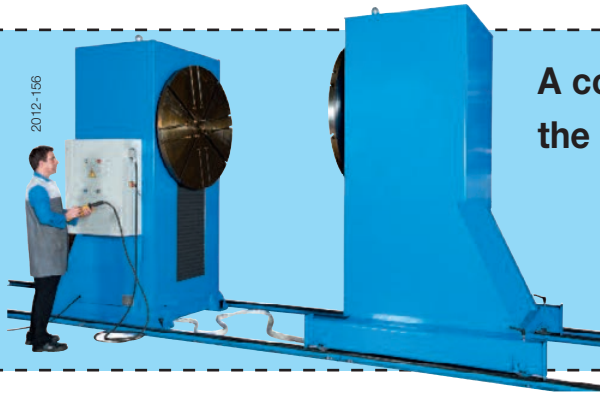
The backing gas device mounted on turn table, complete the turn-key solution of plasma or TIG welding column and boom.

A man hole in the turn table allows the operator to adjust the backing gas device inside the shell.



For other sizes, capacities or rotation speed range: consult us.

Headstock: HEADMATIC



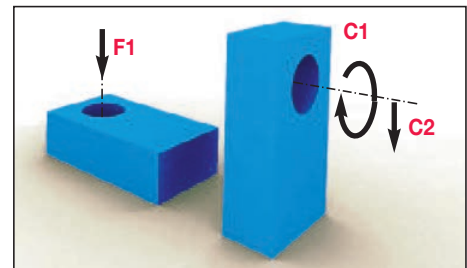
A complete range of headstock allows the rotation piece in horizontal position.

Headstock

The headstock range allows the rotation of pieces up to 32 tons.

3 types of headstock:

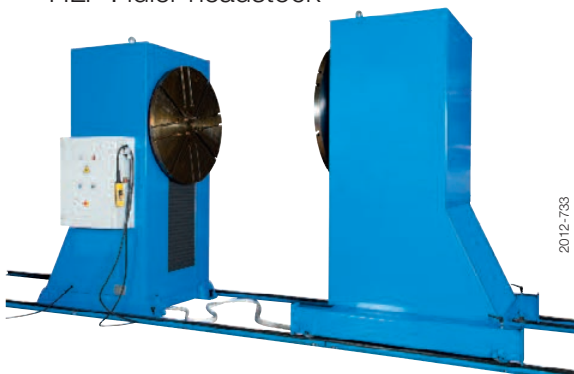
- **MINITOP, TOP and SUPERTOP II** to be integrated on a mechanization.



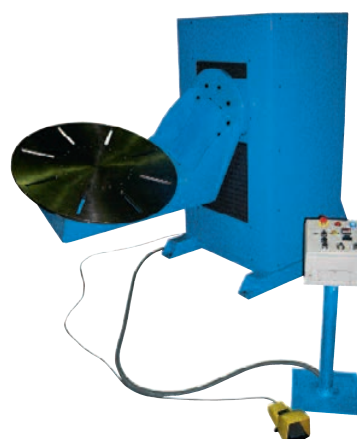
Designation	Motorized Cat. no.	Idler Cat. no.	Flat Load capacity (F1) kg	Rotation torque (C1) m.kg	Tilting torque (C2) m.kg	Rotation speed tr/min
MINITOP 26.8 tr	W000315429	W000315426	50	3.6	14	2.7 to 26.8
MINITOP 8.25 tr	W000315427		50	9.4	14	0.82 to 8.25
MINITOP 3.75 tr	W000315425		50	16	14	0.37 to 3.75
TOP	W000315371	W000315367	300	15	90	0.05 to 4.5
SUPERTOP II	W000276829	W000315402	1000	60	300	0.05 to 5

- **HL range** with synchronized lifting movement for manual manipulation or integrated on machine.
The HL machine is composed of
 - HLM : motorized headstock
 - HLF : idler headstock

Designation	Load capacity kg	Rotation torque (C1) m.kg	Rotation speed tr/min
HLM+F 2x1.5	3000	250	0.1 à 1
HLM+F 2x4	8000	500	0.1 à 1
HLM+F 2x6	12000	720	0.1 à 1
HLM+F 2x8	16000	960	0.1 à 1
HLM+F 2x10	20000	1200	0.1 à 1
HLM+F 2x16	32000	1900	0.1 à 1



- **Special HEADMATIC 3 axes : HL3A**
Possibility to propose HEADMATIC 3 axes up to 20 Tons.








We can propose the HLM without the idler headstock and the load capacity is half of the above value.

Carriages for welding



Air Liquide Welding offers a wide range of welding carriages that features practical and effective solutions depending on the application.
The WELDY range dedicated to MIG/MAG process is used for semi-automatic bulky parts welding.
MEGATRAC carriages will be used for Submerged Arc Welding with robust equipment and high reliability.

Carriages for MIG/MAG welding

	 2012-196	 2006-509	 2012-195	 2012-199
	WELDYPOCKET	WELDYCAR NV	WELDYSTIFFENER	WELDY-RAIL
Autonomous carriage with rechargeable battery. MIG/MAG welding with manual equipment.				
	Flat position welding, small footprint. Basic application, easy implementation.	All positions welding (permanent magnet). Exists in three models: <ul style="list-style-type: none"> • WELDYCAR NV - speed 5 – 70 cm/min • WELDYCAR S NV - speed 15 - 140 cm/min • WELDYCAR SP - speed 15 - 140 cm/min with programmation (continuous welding or not). 	Welding with 2 manual welding torches. Programmable carriage. Exists in 2 models: <ul style="list-style-type: none"> • for height: 60-160 mm • for height: 120-320 mm 	All position welding of carbon steels, stainless steels and aluminium. Exists in 2 models: <ul style="list-style-type: none"> • WELDY-RAIL manual • WELDY-RAIL with linear oscillating 2 rail models: <ul style="list-style-type: none"> • Magnetic rail • Pneumatic rail
Applications	This carriage is used to facilitate the implementation of a regular welding. Boiler making in carbon steel.	Angle, butt, overhead and vertical welding with guidance by crabbing arm.	Welding of stiffeners in ship yards 	Angle, butt, overhead and vertical welding. The carriage is travelling on a magnetic or pneumatic rail according to the piece to be welded.

Main features

Carriage speed	15 - 120 cm/min	5 - 70 cm/min or 15 - 140 cm/min	15 - 180 cm/min	5 - 80 cm/min
Dimensions (L x l x h)	140 x 240 x 220 mm	250 x 300 x 260 mm	500 x 500 x 600 mm	220 x 270 x 230 mm
Weight (netto)	5 kg	11 kg	16 kg	7 kg
Cat. nr	W000274909	NV : W000315589 S NV : W000315588 SP NV : W000315587	On request	On request
Options	Arc protection	Pendular oscillating unit: W000315474 Linear oscillating unit: W000276068 Magnetic crabbing arms, aluminium wheels... many other options consult us	-	Linear oscillating unit: W000276068 In version WELDY-RAIL with oscillating unit



2008-337

SAW MEGATRAC 6 carriage

The MEGATRAC 6 carriage, with 42 V-50/60 Hz supply, permits the flat and angle welding. This tractor is equipped with a DX7 wire-feeder, with wire straightening device, 6 liters flux container with manual opening and a spool support.

For additional info see our MEGATRAC 6 leaflet.

Add ons and options for MIG/MAG carriages

Pendular oscillation unit

This oscillation unit equips WELDYPAR, it permits the torch oscillation with setting of amplitude and speed.

The 14 V battery of the carriage is used to supply the needed current.

Cat. nr:
W000315474

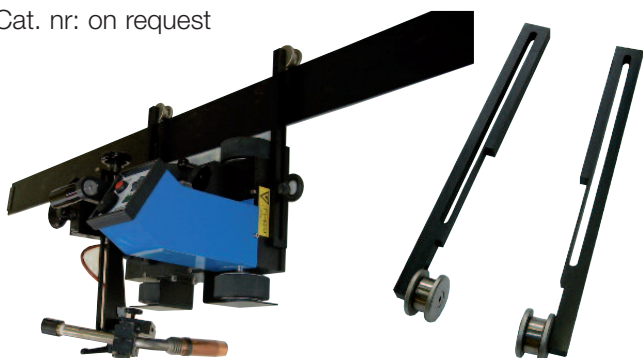


Magnetic rails

The magnetic rails in in hardening steel (1500 x 80 mm), allow the WELDYPAR to follow a welding joint. This bendable rail with 11 magnets, can be fixed on a shell or a flat sheet. With the support arms, WELDYPAR can follow the magnetic rail.

A first section of 1.5 m with 2 support arms is proposed, then additional sections 1.5 m long can be added.

Cat. nr: on request



Linear oscillating unit OSCI-WELDYP for WELDYPAR and WELDYP-RAIL carriages

The OSCI-WELDYP is connected on the welding carriage and allows a regular and controlled oscillation of the MIG/MAG torch.

Setting of :

- left/right temporisation,
 - oscillation's amplitude
 - shifting of the zero
- is possible with a remote control.

The 14 V battery of the carriage is used to supply the needed current.

Cat. nr: W000276068



Aluminium wheel

For welding of preheated pieces, the WELDYPAR carriage has to be equipped with 4 aluminium wheels.

Cat. nr: on request



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