INSTRUCTIONS for

F12-310-L
May, 2009

OXWELD®

C-32

CUTTING TORCH

Cutting Range using acetylene	1/8" - 12" (3 - 300 mm)
Cutting Range using other fuel gases	1/8" - 3" (3 - 76 mm) †
Cutting Nozzles	1500 series
Torch-Hose Connections	Oxy. — CGA-022 (9/16" — 18)
	F. G. — CGA-023 (9/16" — LH)
Torch Overall Length	21-in. (532 mm)
Weight	3-1/2 lbs. (1.6 kg)

† Cutting range can be extended to 12" by installing optional Medium-Pressure Fuel Gas (MPFG) Mixer Assembly, P/N 01Y67, in place of factory installed P/N 01Y33 Acetylene Mixer Assembly. Other fuel gases include natural gas, propane, FG-2, etc.

⚠ CAUTION

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for oxy-fuel gas equipment, we urge you to read our booklet "Precautions and Safe Practices for Gas Welding, Cutting and Heating," Form 2035. The same information appears in the "Oxy-Acetylene Handbook" which may be purchased from any ESAB distributor. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information.

The cutting torch covered by these instructions is listed by third party listed, and when they are used in the gas service for which they are designed and listed. The use of other parts that cause damage for failure to the equipment will void the manufacturer's warranty.

OPERATING INSTRUCTIONS

CONNECTING

1. Attach regulators to the oxygen and fuel gas cylinders. Follow all instructions supplied with the regulators.
2. Attach oxygen and fuel gas hoses to the regulators and to the torch, after making sure all metal seating surfaces are clean. Tighten all connection nuts with a wrench.
3. Attach nozzle to torch head, and tighten connection nut with a wrench.
4. Check the valve packing nuts for tightness.

⚠ WARNING

Flashbacks can cause serious burns.

Be sure gas flow is sufficient for head or nozzle size.
Adjust regulators for proper psig pressures.
Adjust throttle valves properly.
Keep torch in good repair.
DO NOT throttle back gases to use large head or nozzle on thin material.

ADJUSTING GAS PRESSURES

Fuel Gas: Open the fuel gas valve about one turn. Turn in the pressure-adjusting screw on the fuel gas regulator until its delivery-pressure gauge registers the desired pressure (see cutting chart on page 4). Then immediately close the fuel gas valve.

Oxygen: Open the cutting oxygen valve by depressing its valve lever fully. Turn in the pressure-adjusting screws on the oxygen regulator until its delivery-pressure gauge registers the desired pressure (see cutting chart on page 4). Then release the cutting oxygen lever.

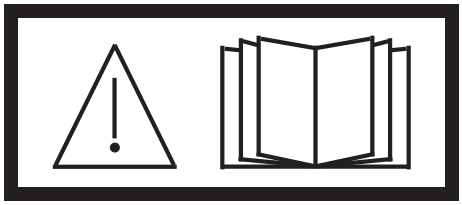
NOTE: When gaugeless regulators are used, do not open torch valves. Merely turn in the pressure-adjusting screws to the desired pressures as indicated on the scales of regulator caps.

TESTING FOR LEAKS

Every cutting outfit should be thoroughly tested for leaks after it is first hooked up, and at regular intervals thereafter. After all connections have been made, make sure all valves on the torch handle are closed. Then turn in

Be sure this information reaches the operator. You can get extra copies through your supplier.

ESAB® ESAB Welding & Cutting Products



READ AND UNDERSTAND INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING. PROTECT YOURSELF AND OTHERS!

CAUTION

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USER RESPONSIBILITY

This equipment will perform in conformity with the description thereof contained in this manual and accompanying labels and/or inserts when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Malfunctioning or poorly maintained equipment should not be used. Parts that are broken, missing, worn, distorted or contaminated should be replaced immediately. Should such repair or replacement become necessary, the manufacturer recommends that a telephone or written request for service advice be made to the Authorized Distributor from whom it was purchased.

This equipment or any of its parts should not be altered without the prior written approval of the manufacturer. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use, faulty maintenance, damage, improper repair or alteration by anyone other than the manufacturer or a service facility designated by the manufacturer.

IMPORTANT SAFEGUARDS

When using Oxy-Fuel Gas Torches, basic safety precautions should always be followed:

a. Never use Acetylene gas at a pressure over 15 psig.
b. Never use damaged equipment.
c. Never use oil or grease on or around Oxygen equipment.
d. Never use Oxygen or fuel gas to blow dirt or dust off clothing or equipment.
e. Never light a torch with matches or a lighter. Always use a striker.
f. Always wear the proper welding goggles, gloves and clothing when operating Oxy-Acetylene equipment. Pants should not have cuffs.
g. Do not carry lighters, matches or other flammable objects in pockets when welding or cutting.
h. Always be aware of others around you when using a torch.
i. Be careful not to let welding hoses come into contact with torch flame or sparks from cutting.
j. SAVE THESE INSTRUCTIONS.

BE SURE THIS INFORMATION REACHES THE OPERATOR.
YOU CAN GET EXTRA COPIES THROUGH YOUR SUPPLIER.

SAVE THESE INSTRUCTIONS!

SAFETY PRECAUTIONS

WARNING

These Safety Precautions are for your protection. They summarize precautionary information from the references listed in Additional Safety Information section. Before performing any installation or operating procedures, be sure to read and follow the safety precautions listed below as well as all other manuals, material safety data sheets, labels, etc. Failure to observe Safety Precautions can result in injury or death.

PROTECT YOURSELF AND OTHERS - Some welding, cutting and gouging processes are noisy and require ear protection. Hot metal can cause skin burns and heat rays may injure eyes. Training in the proper use of the processes and equipment is essential to prevent accidents. Also:

1. Always wear safety glasses with side shields in any work area, even if welding helmets, face shields, or goggles are also required.
2. Wear flameproof gauntlet type gloves, heavy long-sleeve shirt, cuffless trousers, high-topped shoes, and a welding helmet or cap for hair protection, to protect against hot sparks and hot metal. A flameproof apron may also be desirable as protection against radiated heat and sparks.
3. Hot sparks or metal can lodge in rolled up sleeves, trousers cuffs, or pockets. Sleeves and collars should be kept buttoned, and open pockets eliminated from the front of clothing.
4. Protect other personnel from hot sparks with a suitable nonflammable partition or curtains.
5. Use goggles over safety glasses when chipping slag or grinding. Chipped slag may be hot and can travel considerable distances. Bystanders should also wear goggles over safety glasses.

FIRES AND EXPLOSIONS - Heat from a flame can act as an ignition source. Hot slag or sparks can also cause fires or explosions. Therefore:

1. Remove all combustible materials well away from the work area or completely cover the materials with a protective nonflammable covering. Combustible materials include wood, cloth, sawdust, liquid and gas fuels, solvents, paints and coatings, paper, etc.
2. Hot sparks or hot metal can fall through cracks or crevices in floors or wall openings and cause a hidden smoldering fire on the floor below. Make certain that such openings are protected from hot sparks and metal.
3. Do not weld, cut, or perform any other hot work on materials, containers, or piping until it has been completely cleaned so that no substances on the material can produce flammable or toxic vapors. Do not do hot work on closed containers. They may explode.
4. Have fire extinguishing equipment handy for instant use, such as a garden hose, a pail of water or sand, or portable fire extinguisher. Be sure you are trained in its use.
5. After completing operations, inspect the work area to be sure that there are no hot sparks or hot metal which could cause a later fire. Use fire watchers when necessary.
6. For additional information, refer to NFPA Standard 51B, “Fire Prevention in Use of Cutting and Welding Processes”, which is available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

FUMES AND GASES - Fumes and gases, particularly in confined spaces, can cause discomfort or injury. Do not breathe fumes or gases from welding or cutting, Therefore:

1. Always provide adequate ventilation in the work area by natural or mechanical ventilation means. Do not weld, cut, or gouge on materials such as galvanized steel, stainless steel, copper, zinc, lead, beryllium, or cadmium unless positive mechanical ventilation is provided. Do not breathe fumes and gases from these materials.
2. If you develop momentary eye, nose, or throat irritation while operating, this is an indication that ventilation is not adequate. Stop work at once and take necessary steps to improve ventilation in the work area. Do not continue to operate if physical discomfort persists.
3. Refer to ANSI/ASC Standard Z49.1 listed below for specific ventilation recommendations.

EQUIPMENT MAINTENANCE - Faulty or improperly maintained equipment, such as torches, hoses and regulators, can result in poor work, but even more important, it can cause injury or death through fires. Therefore:

1. Always have qualified personnel perform the installation, troubleshooting, and maintenance work. Do not operate or repair any equipment unless you are qualified to do so.
2. Keep all oxy-fuel equipment free of grease or oil. Grease, oil, and other similar combustible materials, when ignited, can burn violently in the presence of oxygen.
3. Do not abuse any equipment or accessories. Keep equipment away from heat and wet conditions, oil or grease, corrosive atmospheres and inclement weather.
4. Keep all safety devices in position and in good repair.
5. Use equipment for its intended purpose. Do not modify it in any manner.

GAS CYLINDER HANDLING - Gas cylinders, if mishandled, can rupture or explode violently. Sudden rupture of a cylinder, valve or relief device can injure or kill you. Therefore:

1. Use the proper gas for the process and use the proper pressure reducing regulator designed to operate from the compressed gas cylinder. Do not use adaptors to mount the regulator on the cylinder. Maintain hoses and fittings in good condition. Follow manufacturer’s operating instructions for mounting the regulator to the gas cylinder.
2. Always secure cylinders in an upright position by chain or strap to suitable hand trucks, benches, walls, post, or racks. Never secure cylinders to work tables or fixtures where they may become part of an electrical circuit.
3. When not in use, keep cylinder valves closed. Have the valve protection cap in place on top of the cylinder if no regulators is installed. Secure and move cylinders by using suitable hand trucks. Avoid rough handling of cylinders.
4. Locate cylinders away from heat, sparks, or flame of a welding, cutting, or gouging operation. Never strike an arc on a cylinder.
5. For additional information, refer to CGA Standard P-1, “Precautions for Safe Handling of Compressed Gases in Cylinders:, which is available from the Compressed Gas Association, 1235 Jefferson Davis Highway, Arlington, VA 22202.

ADDITIONAL SAFETY INFORMATION - For more information on safe practices for oxy-fuel welding and cutting equipment, ask your distributor for a copy of “Precautions and Safe Practices for Gas Welding, Cutting, and Heating”, Form 2035. Gas apparatus safety guidelines are also available on video cassettes from your distributor.

The following publications, which are available from the American Welding Society, 550 N.W. LeJuene Road, Miami, FL 33126, are recommended to you:

1. ANSI/AWS Z49.1 - “Safety in Welding and Cutting”.
2. AWS F4.1 - “Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances”/
3. AWS SP - “Safe Practices” - Reprint, Welding Handbook.

This symbol appearing in this manual means **Attention! Be Alert! Your safety is involved.**

DANGER Used to call attention to immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

WARNING Used to call attention to potential hazards which could result in personal injury or loss of life.

CAUTION Used to call attention to hazards which could result in minor personal injury.

the regulator pressure-adjusting screws until the oxygen delivery-gauge registers 60 psi and the fuel gas delivery-pressure gauge register 10 psi. Using Leak Test Solution that is suitable for oxygen service, such as P/N 998771 (8 oz. container), check for leaks at the cylinder valves, the cylinder-to-regulator connections, and regulator-to-hose connections. If bubbling at any point indicates leakage, tighten the connection. If this does not stop the leakage, close the appropriate cylinder valve, open the corresponding torch valve to remove all pressure from the line, and finally release the regulator pressure-adjusting screw by turning it counterclockwise. Then break the leaky connection, wipe metal seating surfaces with a clean cloth, and examine then for nicks and scratches. Remake the connection(s) and retest. Do not try to light the torch until you are satisfied that all connections are gas-tight.

After lighting the torch and adjusting the flames, use leak test solution to check for leakage at all torch valves and at the nozzle nut.

LIGHTING AND FLAME ADJUSTMENT

1. Open the preheat oxygen valve on the torch about 1/8 turn.
2. Open the fuel gas valve on the torch about 1/8 turn and light the gas at the nozzle with a friction lighter. DO NOT USE A MATCH. Use of a match can seriously burn your hand.
3. If using acetylene, open fuel gas valve until preheat flames leave the end of the nozzle and then close just enough to return the flames to the nozzle. Depress lever to open cutting oxygen valve and then readjust preheat flames to neutral by opening preheat oxygen valve gradually.

   If using FG-2 or other fuel gases but acetylene, open fuel gas valve until flames just starts to leave the end of the nozzle and then open the preheat oxygen valve until the flames are at their shortest length. Depress the cutting oxygen valve lever and then readjust the preheat flames to the shortest length by opening the preheat oxygen valve gradually.

   The above procedure usually provides adequate preheat for the nozzle in use. If desiring to change the preheat flames, always hold the cutting oxygen valve open while readjusting the preheat oxygen and fuel gas valves.

SHUTTING OFF

Release the cutting oxygen valve lever. Then close the fuel gas valve, and finally the preheat oxygen valve.

If operations are to be stopped for a half-hour or more, all pressure should be released from the torch, hoses, and regulators by doing the following:

1. Close each cylinder or station valve.
2. Open torch valves.
3. After relieving the gases, back out the pressure-adjusting screw of each regulator and close the torch valves.

OPERATING PRECAUTIONS

Do not exceed 15 psig acetylene during operation.

Flow: There must be proper flow of gases for safe operation and full performance. This requires the following three conditions: (1) the regulators that determine the inlet pressure to the hoses must be set to the correct pressure: (2) the hoses and their connectors must have adequate capacity for the job (hoses that are too long, too small or have connectors with small passageways can cause problems); and (3) the throttle valves on the torch must be adjusted with the procedure shown in these instructions.

Note: Items (1) and (2) can be checked by measuring the gas pressures at the torch. Gauge adaptors are available for this purpose.

Backfire: Improper operation of the torch may cause the flames to go out with a loud 'pop'. Such a backfire may be caused by contact of nozzle with the work, by spatter from the work, by the use of incorrect gas pressures, or by leakage at the cutting nozzle seats due to dirt or nicks on seats or to a loose nozzle nut.

Flashback: Under certain circumstances, the flame may not 'pop' out (backfire) but instead burn back inside the torch with a shrill hissing or squeal. This is called a 'flashback'. A flashback should never occur if (1) the equipment is in good condition; (2) preheat ports on cutting nozzles or welding tips are cleaned frequently; (3) operating pressures are correct; and (4) throttle valves are adjusted properly. Should a flashback occur, IMMEDIATELY shut off the torch. Allow it to cool off for at least a minute. Then check your nozzle or tip, gas pressures, readjust regulators if necessary, and relight the torch. If flashback recurs, send the torch with nozzle in use when flashback occurred to your distributor for repair.

ACCESSORIES

Special rosebud heating nozzles are available to replace the cutting nozzle for multi-flame heating applications:

No. 55 O-A Heating Nozzle, P/N 20238 (for acetylene use only.
No. 70 O-FG Heating Nozzle, P/N 20234 (for fuel gases other than acetylene).

OPERATING DATA, CLEANING DATA, and PART NUMBERS
GENERAL NOTES:

1. Pressures given are measured at the torch; therefore, pressure drop through hose should be considered when setting pressure at the regulator. Generally, 1/4-in. hoses up to 25-ft. long are adequate for cutting steel up to 4-in. thick. If longer hoses are required and if cutting thicker steel, 3/8-in. hoses should be used.
2. The tables show average values based on typical conditions. The type and quality of steel, its surface condition, the purity of oxygen, etc. will aways have a bearing on the end results.

Acetylene Cutting Nozzles

Nozzle		Steel Thickness		Gas Pressure, psig		Gas Consumption, ft^3/hr		Cleaning Drill Size	
Size	Part No.	in.	mm	Oxygen	Acetylene	Oxygen	Acetylene	Preheat	Cutting
1565 Series (Low Acetylene Consumption)									
1/8"	639182	1/8	3			30 - 40			78
1/4"	639263	1/4	6			35 - 40			69
1/2"	639264	1/2	13			55 - 65	5 - 9	73	65
3/4"	639265	3/4	19	40	5 - 7	60 - 70			61
1"	639266	1	25			85 - 95			54
2"	639267	2	50			155 - 165	8 - 12	70	51
3"	639268	3	75			215 - 230	10 - 12	69	47
4"	639269	4	100			340 - 360	15 - 20	65	40
6"	998742	6	150	35 - 45	8 - 10	395 - 460	20 - 25	57	39
		8	200	55 - 65		545 - 625	30 - 35		
10"	998743	10	250	40 - 55	8 - 10	630 - 710	40 - 45	56	31
		12	300	55 - 65	10 - 12	790 - 905	45 - 55		
1502 Series (Medium Preheat)									
1/4"	08Z67	1/4	6	20 - 25	5 - 7	35 - 45	6 - 8	69	68
1/2"	15Z17	1/2	13	30 - 35		65 - 75	8 - 10	66	60
1-1/2"	15Z18	3/4	19	39 - 35	5 - 7	120 - 135	14 - 16	65	53
		1	25	35 - 40		130 - 140	14 - 16		
4"	15Z19	2	50	25 - 30	6 - 8	185 - 210	16 - 20	60	46
		3	75	30 - 40		205 - 255	16 - 20		
		4	100	35 - 45		235 - 285	19 - 22		
8"	15Z20	6	150	35 - 45	6 - 10	395 - 460	20 - 25	57	39
		8	200	55 - 65		545 - 625	30 - 35		
12"	15Z21	10	250	45 - 55	8 - 10	630 - 710	40 - 45	56	31
		12	300	55 - 65	10 - 12	790 - 905	45 - 55		

Fuel Gas Two-Piece Cutting Nozzles

NOTE: Do NOT use with acetylene.

Nozzle Size	Nozzle (Internal) Part No.	Sleeve External Part No. Nat. Gas Propane	Sleeve External Part No. FG-2 MAPP	Sleeve External Part No. FG-2 MAPP◆	Steel Thickness in.	Steel Thickness mm	Gas Pressure, psig Oxygen	Gas Pressure, psig Fuel Gas	Gas Consumption ft³/hr Oxygen	Gas Consumption ft³/hr FG-2■	Gas Consumption ft³/hr Nat. Gas	Cleaning Drill Size Cutting●
1567 Series (High Preheat)												
1/8"	639614	639322	998277	998557	1/8	3	40	3 - 4	20 - 40	5 - 10	20 - 25	79
1/4"	639615				1/4	6		3 - 4	45 - 65	5 - 10	20 - 20	69
1/2"	639616				1/2	13		3 - 4	65 - 85	5 - 10	20 - 25	65
3/4"	639617				3/4	19		3 - 4	70 - 90	5 - 10	20 - 25	61
1"	639618				1	25		4 - 5	95 - 115	5 - 10	25 - 30	54
2"	639619				2	50		4 - 5	175 - 200	8 - 15	30 - 35	51
3"	639620				3	75		6 - 7	235 - 260	8 - 15	35 - 40	47
4"	998734	14Z39	114Z08	998561	4	100	40	5 - 10	300 - 335	15 - 20	35 - 40	46
8"	998735	14Z77*	639755	998558	6	150	39	5 - 10	450 - 480	15 - 20	40 - 45	39
					8	200	55 - 60	5 - 10	560 - 590	20 - 25	45 - 55	
12"	998736	14Z69	998269	998559	10	250	50 - 60	10 - 15	840 - 900	25 - 30	55 - 65	31
					12	300	60 - 70	10 - 15	900 - 970	25 - 30	55 - 65	
1534 Series (Medium Preheat)												
2	14Z66	14Z38	114Z07	998560	1/8	3	25	3 - 4	25 - 45	5 - 10	15 - 20	76
3	14Z50				1/4	6	30		45 - 65			68
4	14Z51				1/2	13	30		70 - 90			60
6	14Z52	14Z39	114Z08	998561	3/4	19	30	3 - 4	125 - 145	5 - 10	15 - 20	53
					1	25	35		140 - 160			
8	14Z53	14Z39	114Z08	998561	2	50	25	4 - 5	150 - 170	8 - 15	30 - 40	46
					3	75	40		280 - 300			
					4	100	40		258 - 305			

◆ Use where high preheat intensity is desired.
■ Consumption of MAPP or propane is approximately the same as FG-2.
● Use soft-bristled brush (750F99) to clean preheat slots of internal nozzles.
* Heavy-duty sleeve (14Z96) available for use in place of 14Z77 sleeve.

MAINTENANCE INSTRUCTIONS

For all repairs other than those covered below, send the apparatus to your ESAB distributor or ESAB Remanufacturing Center, 411 S. Ebenezer Road, Florence, SC 29501. Improperly repaired apparatus is hazardous.

Preheat Valves: Leakage around either throttle valve can usually be corrected by tightening the packing nut slightly. If this does not stop the leakage, replace the throttle valve assembly.

If either preheat valve fails to shut off completely, remove the valve assembly from the torch. With a clean cloth, wipe the ball in the end of the stem. Then reinsert valve assembly and tighten it several times with maximum force. If this does not eliminate leakage, try a new valve assembly. If then the valve does not shut off completely, send the torch to a repair station for reseating of the body.

After installing a new valve assembly, tighten the packing nut until the valve can be turned only with great difficulty, and set the unit aside, for three or four hours at least, to set the packing. Then back off the packing nut until the valve turns readily.

Cutting Valve: If leakage develops around the cutting valve stem or between the cutting valve guide and the torch body, or if the cutting valve fails to shut off completely, proceed as follows:

1. Remove cutting valve lever. Drive out the fulcrum roll pin with a 7/32-in. diam. rod.
2. Unscrew cutting valve guide and lift out entire valve assembly; guide (with external and internal O-rings) valve stem, spring, and O-ring retaining washer.
3. Pull stem out of guide. Replace it with new part unless the molded rubber seat appears to be in excellent condition.
4. Remove the internal O-ring (85W10) from the guide. Before installing new O-ring lubricate sparingly with silicone lubricant (17672 - 1 oz. tube). Replace the external O-ring (638797) if it shows distinct signs of wear.
5. Reassemble by placing retaining washer and spring in guide, then placing stem through spring and O-ring in guide.
6. Screw valve assembly into body. Before reassembling cutting lever, connect torch to oxygen source, apply at least 60 psi pressure, and check for leakage through the valve, around the stem, and around the guide.
7. Reassemble cutting lever to torch. Install roll pin with slot facing the body.

Mixer. To remove the mixer for cleaning or replacement, first unscrew the mixer chamber plug. Then let the two springs drop out in your hand. Finally, dislodge the mixer and its three washers (two brass, one neoprene) either by rapping the torch, held vertically, against a block of soft wood, or by turning a long 10-32 machine screw into the thread in the end of the mixer and pulling it out.

When reassembling, place the three washers (one neoprene between two brass) on the extreme back end of the mixer. (Be sure to use a new neoprene washer unless the old one appears to be in equal-to-new condition.) Slip mixer into torch, then insert large spring and push it down hard to seat the forward brass washer against shoulder in body. Then drop small spring inside large spring, insert mixer plug, and tighten plug firmly. Be sure the mixer chamber plug is fitted with an O-ring in good condition (even in cases where the plug carried no O-ring originally).

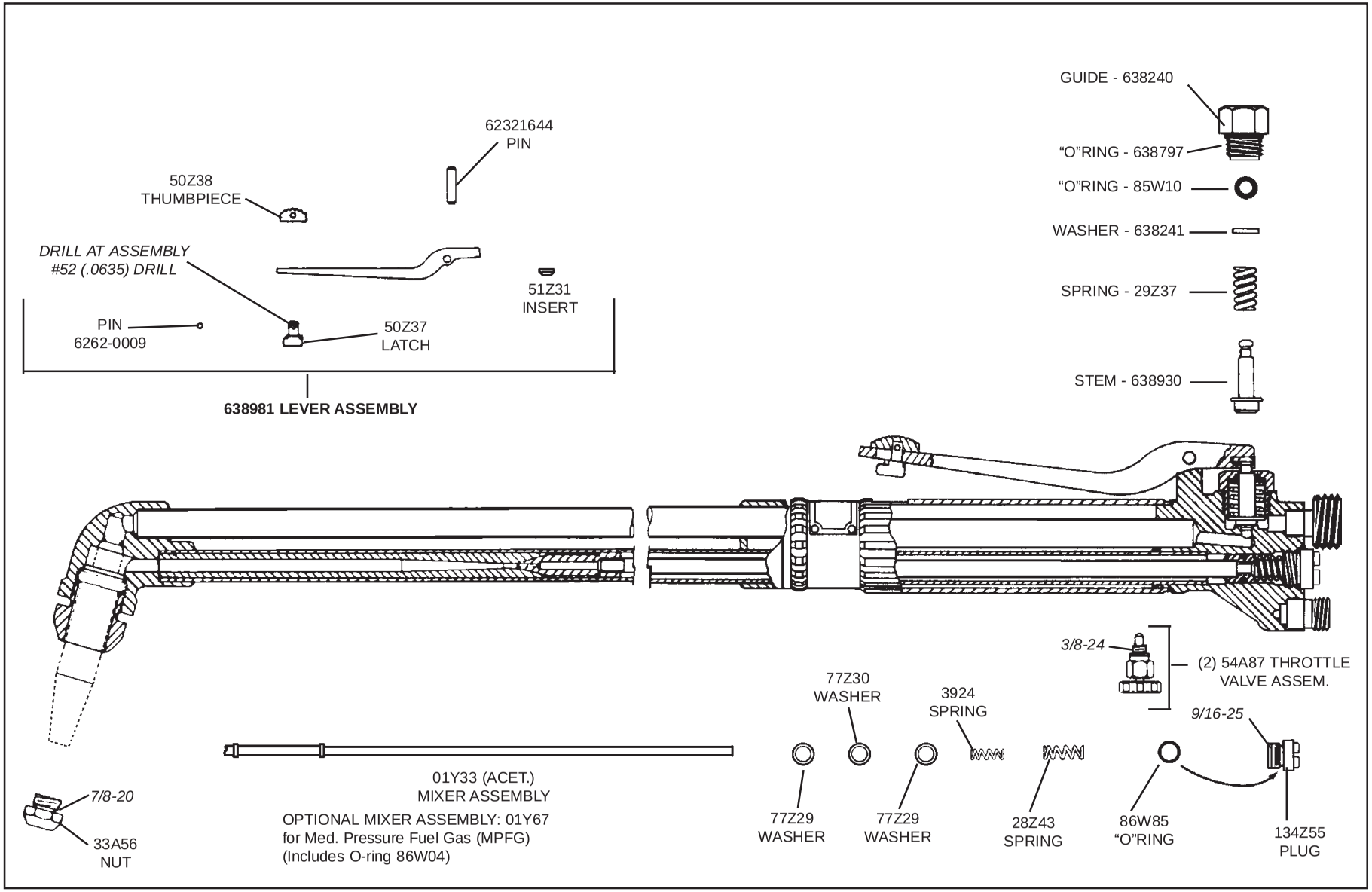
Cleaning Cutting Nozzles: Cutting nozzle orifices should be cleaned by hand, using OXWELD tip cleaners, whenever a flame distortion is noticed. Maintaining clean orifices is highly recommended for reducing any incidence of flashbacks. If you do not have tip cleaners, twist drills of the correct sizes (see table on pg. 4) may be used. Insert the drill carefully, and push it back and forth. DO NOT TWIST THE DRILL.

To clean preheat slots on fuel gas internal nozzles, remove the external sleeve and use a soft bristled brush (750F99).

For longer life, nozzles should be cleaned periodically in a solution of OXWELD Nozzle Cleaning Compound (P/N 761F00) made up and used as directed on the jar in which it is packed.

PARTS INFORMATION

All parts which can be replaced without breaking soldered or brazed joints are illustrated and listed below. When ordering parts, please give both part number and description (including size where appropriate). Parts may be ordered from your ESAB distributor or from ESAB Welding and Cutting Products, Customer Service Department, Florence, SC.



C-32 Cutting Torch (75-deg. head - 21" long) ..... P/N 01X23
C-32 Cutting Torch (90-deg. head - 21" long) ..... P/N 01X26

ESAB Welding & Cutting Products, Florence, SC Welding Equipment
COMMUNICATION GUIDE - CUSTOMER SERVICES

A. CUSTOMER SERVICE QUESTIONS:
Order Entry | Product Availability | Pricing | Delivery
Order Changes | Saleable Goods Returns | Shipping Information

Eastern Distribution Center
Telephone: (800)362-7080 / Fax: (800) 634-7548

Central Distribution Center
Telephone: (800)783-5360 / Fax: (800) 783-5362

Western Distribution Center
Telephone: (800) 235-4012/ Fax: (888) 586-4670

B. ENGINEERING SERVICE: Telephone: (843) 664-4416 / Fax : (800) 446-5693
Welding Equipment Troubleshooting — Hours: 7:30 AM to 5:00 PM EST
Warranty Returns | Authorized Repair Stations

C. TECHNICAL SERVICE: Telephone: (800) ESAB-123/ Fax: (843) 664-4452
Part Numbers | Technical Applications — Hours: 8:00 AM to 5:00 PM EST
Performance Features | Technical Specifications | Equipment Recommendations

D. LITERATURE REQUESTS: Telephone: (843) 664-5562 / Fax: (843) 664-5548
Hours: 7:30 AM to 4:00 PM EST

E. WELDING EQUIPMENT REPAIRS: Telephone: (843) 664-4487 / Fax: (843) 664-5557
Repair Estimates | Repair Status — Hours: 7:30 AM to 3:30 PM EST

F. WELDING EQUIPMENT TRAINING:
Telephone: (843)664-4428 / Fax: (843) 679-5864
Training School Information and Registrations — Hours: 7:30 AM to 4:00 PM EST

G. WELDING PROCESS ASSISTANCE:
Telephone: (800) ESAB-123 / Fax: (843) 664-4454 — Hours: 7:30 AM to 4:00 PM EST

H. TECHNICAL ASST. CONSUMABLES:
Telephone : (800) 933-7070 — Hours: 7:30 AM to 5:00 PM EST

IF YOU DO NOT KNOW WHOM TO CALL

Telephone: (800) ESAB-123/ Fax: (843) 664-4452/ Web:http://www.esab.com

Hours: 7:30 AM to 5:00 PM EST

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ESAB® ESAB Welding & Cutting Products
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