The complete range for workshops and industrial applications

Enduring Performance...

Stronger, with Castolin Eutectic

- New step-switched generation
- Wide range including 3 versions: Compact, Synergic and with External wire feeder
- Synergic programs for your special applications
- Compact and robust
- User friendly
CastoMIG® - The new step switched generation

CastoMIG® welding machine

Our multi adaptable CastoMIG® welding equipment range is always used for applications which impose special requirements:

- High welding capacity combined with outstanding seam quality
- High alloy steel with faster deposition rate wires (EnDOtec)
- Specific welding parameter settings
- Program-controlled welding operations
- Tough conditions

Features

- Welding parameters
  - Synergic adjustment for the CP version
  - “CastoMized” synergic programs
  - User-friendly selection of the parameters
- Reliable wire drive system for precise and constant wire feeding
- Precise and constant Arc ignition
- Excellent arc stability
- Equipped for tough environment with:
  - Robust wheels, protected control panel, large handle and metallic structure
  - Pre and post gas adjustments
  - 2 step and 4 step welding
  - Spot welding
  - For CastoMIG® 271CP, 381CP/DS, 501CP/DS

Technical data

<table>
<thead>
<tr>
<th></th>
<th>CastoMIG® 271 C/CP</th>
<th>CastoMIG® 381 C/CP/DS</th>
<th>CastoMIG® 501 C/CP/DS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Welding amperage range</td>
<td>25 - 270 A</td>
<td>45 - 380 A</td>
<td>60 - 500 A</td>
</tr>
<tr>
<td>Duty cycle amperage range (10 min at 40°C)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>.35%</td>
<td>250 A</td>
<td>380 A (30%)</td>
<td>500 A (30%)</td>
</tr>
<tr>
<td>.60%</td>
<td>180 A</td>
<td>260 A</td>
<td>350 A</td>
</tr>
<tr>
<td>.100%</td>
<td>140 A</td>
<td>200 A</td>
<td>280 A</td>
</tr>
<tr>
<td>Operating voltage</td>
<td>230 / 400 V</td>
<td>230 / 400 V</td>
<td>230 / 400 V</td>
</tr>
<tr>
<td>Open circuit voltage</td>
<td>17 - 37 V</td>
<td>18 - 48 V</td>
<td>19 - 51 V</td>
</tr>
<tr>
<td>Power factor (cosφ)</td>
<td>0.97</td>
<td>0.98</td>
<td>0.98</td>
</tr>
<tr>
<td>Fuse rating (slow blow)</td>
<td>16/10</td>
<td>32/16</td>
<td>45/25</td>
</tr>
<tr>
<td>Wire dimensions</td>
<td>0.6 - 1.2 mm</td>
<td>0.6 - 1.2 mm</td>
<td>0.6 - 1.6 mm</td>
</tr>
<tr>
<td>Protection index</td>
<td>IP 23</td>
<td>IP 23</td>
<td>IP 23</td>
</tr>
<tr>
<td>Insulation class</td>
<td>H</td>
<td>H</td>
<td>H</td>
</tr>
<tr>
<td>Dimensions L x W x H</td>
<td>865 x 545 x 795 mm</td>
<td>1060 x 595 x 765 mm</td>
<td>1060 x 595 x 765 mm</td>
</tr>
<tr>
<td>Weight</td>
<td>69 kg</td>
<td>109 kg</td>
<td>123 kg</td>
</tr>
</tbody>
</table>
Synergic semi-automatic welding

This synergic step-switch semi-automatic welding equipment allows non expert users to very easily adjust the welding parameters in a user friendly way.

Equipped with the latest innovative microprocessor with digital technology, you will be able to recall the best welding parameters according to the material, gas and wire diameter, for perfect MIG/MAG quality welding on any base metal.

All inclusive - even with the basic version

Although the extensive practical equipment is ideally suited for series-production applications in the steel and wagon building industries, it is also oriented to the specific requirements of single piece production in the plant. Our range consists of 9 models, including 4 compact equipment, 3 compact & synergic ones and 2 with external wire feeder.

- **DS for with external wire feeder**: step-switch synergic welding equipment with a range of 3 external wire feeders that can be mounted according to your applications. The wire feeder range is made of synergic, 2 feeding rolls and 4 rolls unit.

- **C for compact**: step-switch welding equipment. 4 versions availables: CastoMIG® 271 C, 381 C and 501 C.

- **CP for compact and programmed**: step-switch synergic welding equipment. 3 versions availables: CastoMIG® 271CP, 381 CP and the 501 CP.

Useful welding options enable the welding equipment to be adapted to meet the respective requirements for each application before leaving the factory.
CastoMIG® - The new step switched generation

Smart details make working easier

We want to make your life easier for example with the ingenious four-roller drive unit with reproducible pressure settings and tool-free, changeable drive rollers. Also the programme table affixed to each CastoMIG® CP welding unit which helps you to select a suitable standard program.

«CastoMized» synergic programs

The new CastoMIG® range is the answer to your Repair and Maintenance needs with the new unique on the job synergic programming. Castolin Eutectic’s engineers are able to input a totally bespoke program into your CastoMIG®, either on your premises or in one of our local CastoLab® Services.

This will give you 100% repeatability safe in the knowledge that this program was designed for your particular requirement. More than one item don’t worry the CastoMIG® machines have the ability to store up to 10 bespoke programs. Or for a truly tailor made solution why not discuss the option of training.

Your Castolin Eutectic specialist can offer on or off site training. We can train you on the actual parts to be welded giving you best practice procedure. This can be combined with your CastoMIG® machine being programmed at the same time, giving you the total solution from the wear specialists.

Visible programme options: you can select the most important Synergic programmes supplied with the unit from the affixed table; then simply enter the programme number on the front panel.

Innovative Solution

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Selecting the optimum
Consumable and parameters
have never been easier in
just 3 simple steps you can
achieve success:

- Discuss your requirements with one of our Sales people.
- Let us provide samples of what we can achieve
- Have your machine delivered pre programmed with the optimum settings.
Wire feeding systems

Features:
- Professional wire driving system for precise and constant wire feeding
- Solid brass central connection
- Feed rollers can be replace without tools
- Simple, reproducible electrode pressure adjustment
- Feed rollers available to suit all requirements. Trapezoidal slot, semi circular slot and grooved drive rollers.
- Protection from the feed rollers for highest operator safety

Synergic wire feeder DS P
- Wire feeders for the CastoMIG® 381 DS and for the 501 DS
- Available with 4 roll driving system

<table>
<thead>
<tr>
<th>DS P</th>
<th>ESC: 752 554</th>
</tr>
</thead>
</table>

Standard wire feeder DS 21 & DS 22
- Wire feeders for the CastoMIG® 381 DS and for the 501 DS
- Available with 2 or 4 roll driving system according to your applications.

<table>
<thead>
<tr>
<th>DS 21</th>
<th>ESC: 752 552</th>
</tr>
</thead>
<tbody>
<tr>
<td>DS 22</td>
<td>ESC: 752 553</td>
</tr>
</tbody>
</table>

4 roll / 2 roll systems

2) Feedroll
3) Pressure roll
4) Drive gear

<table>
<thead>
<tr>
<th>Power supply</th>
<th>DS 21</th>
<th>DS 22</th>
<th>DS P</th>
</tr>
</thead>
<tbody>
<tr>
<td>48V-50/60Hz</td>
<td>48V-50/60Hz</td>
<td>48V-50/60Hz</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>No rollers</th>
<th>2</th>
<th>4</th>
<th>4</th>
</tr>
</thead>
</table>

| Wire diameter           | 0.6 - 2.4 mm | 0.6 - 2.4 mm | 0.6 - 2.4 mm
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>manual</td>
<td>0.8 - 1.6 mm</td>
<td>synergetic</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Wire feeding speed</th>
<th>0.5-20 m/min</th>
<th>0.5-20 m/min</th>
<th>0.5-20 m/min</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Spool diameter</th>
<th>300mm</th>
<th>300mm</th>
<th>300mm</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Spool weight</th>
<th>20 Kg (Max)</th>
<th>20 Kg (Max)</th>
<th>20 Kg (Max)</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Protection index</th>
<th>IP 23</th>
<th>IP 23</th>
<th>IP 23</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Dimensions L x W x H</th>
<th>505 x 230 x 335 mm</th>
<th>505 x 230 x 335 mm</th>
<th>505 x 230 x 335 mm</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Weight</th>
<th>12 Kg</th>
<th>13 Kg</th>
<th>13 Kg</th>
</tr>
</thead>
</table>
CastoMIG® - The new step switched generation

Accessories

**CastoMIG® cooling**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power supply</td>
<td>230 V / 400 V - 50 Hz</td>
</tr>
<tr>
<td>Max power supply</td>
<td>0.3 kW</td>
</tr>
<tr>
<td>Max current absorbed</td>
<td>1.35 - 0.9 A</td>
</tr>
<tr>
<td>Cooling power</td>
<td>1.1 W</td>
</tr>
<tr>
<td>Capacity</td>
<td>1.15 - 1.6 l/mn</td>
</tr>
<tr>
<td>Max pressure</td>
<td>4.3 bar</td>
</tr>
<tr>
<td>Protection index</td>
<td>IP 23</td>
</tr>
<tr>
<td>Tank capacity</td>
<td>5.25 l</td>
</tr>
<tr>
<td>Dimensions</td>
<td>190 / 469 / 280 mm</td>
</tr>
<tr>
<td>Weight</td>
<td>14 kg</td>
</tr>
</tbody>
</table>

**Torches**

Our CastoMIG® range includes a wide range of professional torches available with high quality spare parts.
- Water cooled torches
- Gas cooled torches

**Options**

**Wheel kit for external wire feeder**: special kit for upgrading your wire feeder to a fully transportable one. Can be mounted on the DS 21 & DS 22, and on the DS P.

**Digital V/A display**: Display showing instantaneous voltage and current on digital screens.

**Fan on demand**: Stop using too much energy and consume only what you need. This controls the cooling fan to be on or off as necessary.

**ID weld 2501**: IDweld 2501 is a unit for welding, circular exteriors and interiors designed mainly for coating internal bores from Ø 30 mm upwards. A modular mechanical unit rotates depending on the application whilst driving a MIG welding head. This head is fitted with a special compact torch, which produces very high quality circumferential weld deposits, even in very tight spaces.

**Technical Data**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical displacement</td>
<td>170 mm</td>
</tr>
<tr>
<td>Rotational speed</td>
<td>0.3 to 12 RPM</td>
</tr>
<tr>
<td>Power supply</td>
<td>1 x 230 V</td>
</tr>
<tr>
<td>Weight</td>
<td>19 Kg</td>
</tr>
<tr>
<td>Torch</td>
<td>41800 B</td>
</tr>
<tr>
<td>IDweld 2501</td>
<td>305339</td>
</tr>
</tbody>
</table>
Upgrade for specific applications

Our comprehensive range of useful accessories enables you to adapt the system to suit your specific requirements: from cooling and connecting hoses of various lengths, right through to the CastoPlus MIG torch and – for special applications - a variety of iWire feeders with 2 or 4 rolls drive according to your specific applications.

**Power Source**
- CastoMIG 271 C: 752 540
- CastoMIG 381 C: 752 542
- CastoMIG 501 C: 752 543
- CastoMIG 271 CP: 752 541
- CastoMIG 381 CP: 752 544
- CastoMIG 501 CP: 752 545
- CastoMIG 381 DS: 752 537
- CastoMIG 501 DS: 752 538

**Cooling**
- Cooling 230V: 752 556
- Cooling 400V: 752 555

**Feeding rolls**
- Steel (v-groove)
- AL (Semi-circular)
- EnDOTec (semi-circular knurled)

**Interconnecting cable**
- Gas cooled:
  - 1.2 m: 752 546
  - 5m: 752 547
  - 10m: 752 548
- Water cooled:
  - 1.2 m: 752 549
  - 5m: 752 550
  - 10m: 752 551

**Wire feeder**
- DS 21 (2 rolls)
  - Ø 1.0 / 1.2
  - 752 552
- DS 22 (4 rolls)
  - Ø 1.0 / 1.2
  - 752 553
- DSP synergic (4 rolls)
  - Ø 1.0 / 1.2
  - 752 554

**Digital V/A meter with hold function**: 752 559
- Fan on demand: 752 560
- Earth cable
- Pressure reducer Ar/CO2

**Spool cover**
- for DS 21/ DS 22

**Spare parts kit**
- for CastoPlus torches

**CastoPlus MIG – Torches**
- Gas or water cooled

**Spare parts kit**
- for CastoPlus torches

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www.castolin.com  www.eutectic.com
Outstanding consumables quality

To obtain perfect welds, you need not only an excellent MIG/MAG equipment but also outstanding consumables quality. Castolin Eutectic has developed for you complete range of solid and cored wires for all type of materials. Our unique CastoMag® and EnDoTec® wire range can be used for a wide range of applications and will provide you highly resistant welds for maintenance and repair as well as for production issues. To avoid corrosion, Castolin Eutectic wires are precision wound on reinforced spools especially treated to resist rusting.

Some of our best wires

<table>
<thead>
<tr>
<th>Product</th>
<th>Base metal</th>
<th>Properties</th>
<th>Program</th>
</tr>
</thead>
<tbody>
<tr>
<td>45513 S</td>
<td>Steel</td>
<td>Heat resist-</td>
<td>For joining and anti-wear protective coating by semi-automatic weld-</td>
</tr>
<tr>
<td></td>
<td></td>
<td>ant</td>
<td>ing of 25Cr/20Ni-type austenitic steels, for applications where service</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>temperatures are high.</td>
</tr>
<tr>
<td>45554 S</td>
<td>Steel</td>
<td>Dissimilar</td>
<td>For joining difficult-to-weld steels and thick steel sections.</td>
</tr>
<tr>
<td>45351</td>
<td>Wearface</td>
<td>Friction</td>
<td>For anti-wear protective coatings on parts subjected to pressure, abra-</td>
</tr>
<tr>
<td>45751</td>
<td>Copper</td>
<td>Aluminium</td>
<td>For joining and anti-wear protective coating of parts in simple or</td>
</tr>
<tr>
<td></td>
<td></td>
<td>bronze</td>
<td>multi-alloy cupro-aluminium copper.</td>
</tr>
<tr>
<td>45802</td>
<td>Aluminium</td>
<td>5% Magnesi-</td>
<td>For joining and rebuilding of cast and wrought aluminium and mag-</td>
</tr>
<tr>
<td></td>
<td></td>
<td>um</td>
<td>nesium alloys.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Product</th>
<th>Base metal</th>
<th>Properties</th>
<th>Program</th>
</tr>
</thead>
<tbody>
<tr>
<td>DO*02</td>
<td>Steel</td>
<td>Impact &amp;</td>
<td>Buffer layers &amp; build-ups subject to heavy impact, pressure, metal/</td>
</tr>
<tr>
<td></td>
<td></td>
<td>pressure</td>
<td>metal wear, oxidation up to 600°C.</td>
</tr>
<tr>
<td>DO*15</td>
<td>Steel</td>
<td>Impact</td>
<td>Wearfacing resistant to tempering, abrasion under low pressure and</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>impact. Fully heat treatable.</td>
</tr>
<tr>
<td>DO*23</td>
<td>Nickel</td>
<td>Repair &amp;</td>
<td>Joining and crack repairs on ductile and grey cast irons, dissimilar</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Joining</td>
<td>welding cast iron / steel. High crack resistance with good machinabil-</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>ity.</td>
</tr>
<tr>
<td>DO*28S</td>
<td>Steel</td>
<td>Corrosion</td>
<td>Developed for fabrication welding and for anti-corrosion coating of</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>stainless steels of the CrNiMo stabilised or non-stabilised, low car-</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>bon type (type L), offering exceptional protection against both intergrau-</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>lar and pitting corrosion.</td>
</tr>
<tr>
<td>DO*30</td>
<td>Steel</td>
<td>Abrasion,</td>
<td>The slag free deposit offers exceptional resistance to fine particle</td>
</tr>
<tr>
<td></td>
<td></td>
<td>erosion and</td>
<td>abrasion and erosion under moderate impact, thanks to a structural</td>
</tr>
<tr>
<td></td>
<td></td>
<td>impact</td>
<td>matrix which is tough and reinforced by extra-hard phases.</td>
</tr>
<tr>
<td>DO*33</td>
<td>Steel</td>
<td>Abrasion,</td>
<td>High resistance to severe abrasion, corrosion, oxidation at high tem-</td>
</tr>
<tr>
<td></td>
<td></td>
<td>erosion and</td>
<td>peratures up to 650°C.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>heat</td>
<td></td>
</tr>
<tr>
<td>DO*80</td>
<td>Cobalt</td>
<td>Wearfacing</td>
<td>Machinable Co based alloy resistant to tempering, corrosion and scal-</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>ing at high temperatures</td>
</tr>
<tr>
<td>DO*390N</td>
<td>Steel</td>
<td>Abrasion,</td>
<td>Designed for protective coatings with extreme resistance to abrasion,</td>
</tr>
<tr>
<td></td>
<td></td>
<td>erosion,</td>
<td>erosion combined with moderate shock on carbon, alloy and stainless</td>
</tr>
<tr>
<td></td>
<td></td>
<td>friction and</td>
<td>steels. Typical industries include steel, cement, waste recycling,</td>
</tr>
<tr>
<td></td>
<td></td>
<td>heat</td>
<td>power generation, foundries, chemical processing, mining, materials</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>handling, petrochemical.</td>
</tr>
<tr>
<td>DO*395N</td>
<td>Steel</td>
<td>Abrasion,</td>
<td>Latest Nano technology, mesomorphic alloy for maximum abrasion</td>
</tr>
<tr>
<td></td>
<td></td>
<td>erosion and</td>
<td>resistance up to 750°C.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>heat</td>
<td></td>
</tr>
<tr>
<td>CaviTec</td>
<td>GMA</td>
<td>Cavitation</td>
<td>Patented alloy for highest cavitation resistance on stainless steel,</td>
</tr>
<tr>
<td></td>
<td>Steel</td>
<td></td>
<td>carbon steel hydro-turbines, pumps.</td>
</tr>
<tr>
<td>EO 8340</td>
<td>Steel</td>
<td>Joining</td>
<td>For joining, fabrication &amp; repair of mild and low alloy steels,</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>galvanised steels, used for containers, vessels, hoppers, truck</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>bodies, piping systems, machinery cast steel parts.</td>
</tr>
</tbody>
</table>
EnDOtec cored wires

EnDOtec® is a gas shielded metal arc welding process (GMAW) using specially formulated cored wires which provide industry with wear protection, repair and joining solutions. Primary EnDOtec® advantages & benefits are:
- Higher weld deposition rates
- Peripheric cool-arc concept
- Unique anti-wear alloys
- Easier weldability
- Increased cost savings

Custom made, welding alloy formulations are feasible with cored wires to optimise performance for wear protection, repair & joining applications.

Manufacturing facility

The EnDOtec® range of high performance cored electrodes are formulated, developed and manufactured in Castolin Eutectic's own modern plants using specially designed production equipment and procedures in accordance with ISO 9001 and EN 29001 quality assurance standards.

Each EnDOtec® batch after wire drawing and baking, is weld tested for consistent chemistry, properties & operability before precision spiral spooling and protective packaging for stock.

Flux ingredients:
Arc ionising stabilisers,
fine grain inoculants,
powerful de-oxidisers,
metallurgical refining agents, selected alloying elements, carbide compounds, etc.

Metallic strip:
Selected ferrous or non-ferrous based alloys (steels, nickel alloys, cobalt alloys etc.)
CastoMIG® - The new step switched generation

Castolin Eutectic

Together with our sister companies in the Messer World, we can offer our customers a very powerful range of products and services. Being Part of the Messer World means:

- Investment of over € 420 million
- More than 6,000 motivated employees
- Over 100 factories to meet customer needs
- Technical sales support in over 120 countries
- 2,000 technical sales people in the field with our customers every day

The unique TeroLink® database of Castolin Eutectic contains more than 8,000 fully documented approved applications from around the globe. The case studies include photographs, technical data, detailed descriptions and cost saving analyses.

To increase customer know-how in wear technology and repair techniques, we have developed a full line of seminars and training programs, teaching all relevant personnel from welders and engineers to sales teams and managing directors.

Manufacturing

Quality control laboratory

Product Portfolio - Widest in the Industry

Training
History of Castolin Eutectic

1906: Foundation of Castolin in Lausanne, Switzerland by Jean-Pierre Wasserman. His stroke of genius: to discover a way of welding cast iron at low temperature; in the following years, this innovation was further developed for all industrial metals including aluminium alloys.

1940: Foundation of Eutectic Welding Alloys Corporation in New York

1952: Foundation of Castolin France

1959: Foundation of Eutectic Japan Ltd

1962: Foundation of Eutectic India Ltd.

1960s: International consolidation under Castolin Eutectic

1970s: Creation of training centers for Maintenance & Repair technologies

1978: Establishment of World Head Quarters in St-Sulpice, Switzerland

2000: Merger with Messer Cutting & Welding and creation of the MEC Group - Messer Eutectic Castolin

2005: Part of the Messer World

2006: 100 years of innovation, service and quality.

Addresses of Castolin Eutectic Companies in Europe

Austria, Hungary, South East Europe
Castolin Eutectic GmbH
Brunner Strasse 69
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