



Welding procedures – overview

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Root welding of non-alloy and low-alloy steel

Your requirements

Our solution – rootArc® XQ

Inconsistent, changing air gap

- Perfect gap bridging

X-ray proof results

- Good root formation and secure sidewall fusion

Welding in various positions

- High arc force for root welding in all positions

Increased productivity

- Good welding speed and melt rate compared to TIG or MMA welding
- Low-spatter process

Straightforward handling

- Rapid digital control of the process, easy to guide and to control
- Uses standard welding torches without additional wire movement
- Welding even with long hose packages without additional voltage measuring leads thanks to RCC power module (Rapid Current Control)
- For manual and mechanised applications

No grinding of intermediate passes

- Flat, smooth weld surface and virtually spatter-free process for reduced finishing work

Flexibility in production

- EWM allin – one machine for welding all material thicknesses and using all processes

all in

All Root welding in PC position with an air gap and without weld pool backing

1



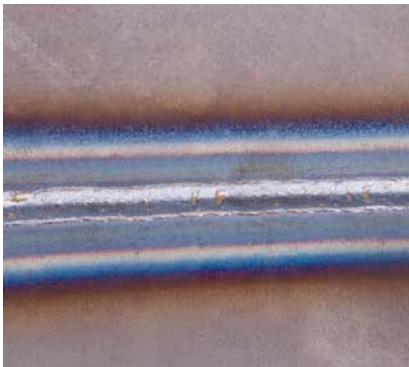
Weld preparation of root welds on pipes, 60° included angle with 3 mm air gap

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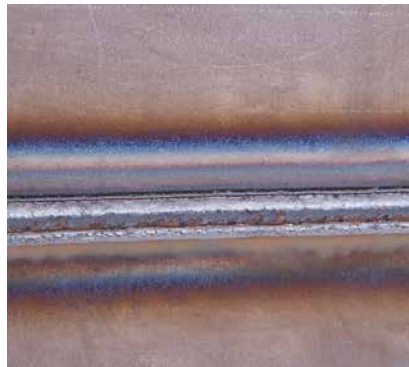


Front view

PC Root welding in PC position with an air gap and without weld pool backing



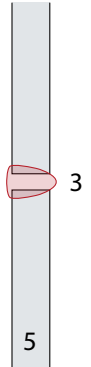
Front view



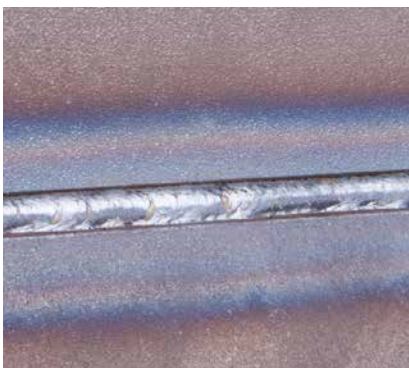
Root



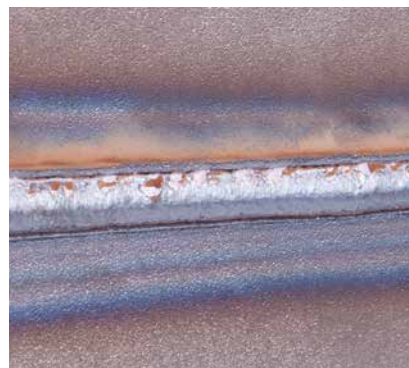
Material thickness 5 mm
Air gap 3 mm



PC Root welding in PC position with an air gap and without weld pool backing



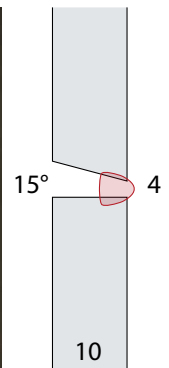
Front view



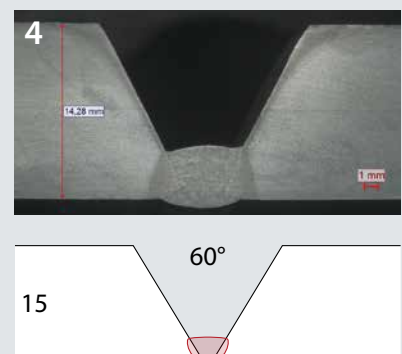
Root



Material thickness 10 mm, one-sided bevel 15 degrees, air gap 4 mm



Root



Pipe welding, wall thickness 15 mm, included angle 60°

Welding of filler passes and cover passes in non-alloy and low-alloy steel

Your requirements

Our solution – forceArc puls® XQ

Straightforward handling

- Easy to learn, even for inexperienced welders, thanks to rapid digital control of the process, virtually spatter free, reduced undercuts

Secure penetration

- Deep penetration for excellent root and sidewall fusion

Minimised distortion of the components

- Modified, heat-reduced, directionally stable pulsed arc

Improved economy

- Enables weld seam volumes to be reduced, potential for over 50% reduction of welding times in production, manual and automated

Reliable welding in poorly accessible areas

- Perfect welding even with very long stick-outs

Changeable, inconsistent air gap

- Excellent gap bridging even in high power ranges

Undercuts, seam appearance

- Excellent wetting of the material surface, smooth weld surface even on heavily oxidised or dirty sheet metal

Welding procedure qualification

- Qualified by welding procedure test (process no. 135) in accordance with DIN EN ISO 15614-1

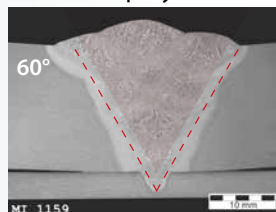
Straightforward handling

- EWM allin – one machine for welding all material thicknesses and using all processes



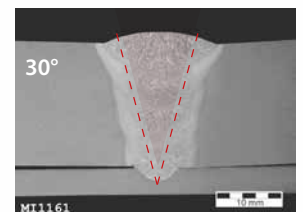
Welding with reduced seam volumes has been tested and confirmed multiple times by independent institutes. EWM's forceArc® XQ and forceArc puls® XQ welding processes allow welding times to be reduced by up to 50% compared to standard spray arc processes. The reduced included angle saves resources without changing the mechanical and technological properties.

Standard spray arc



11 runs

forceArc® XQ



5 runs
50% shorter welding time

Unchanged mechanical/technological properties

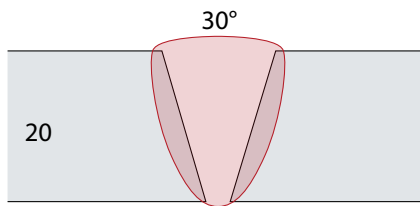
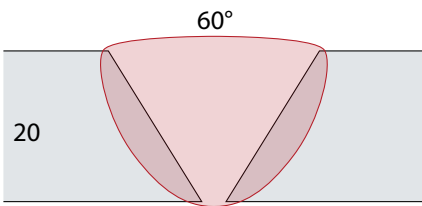
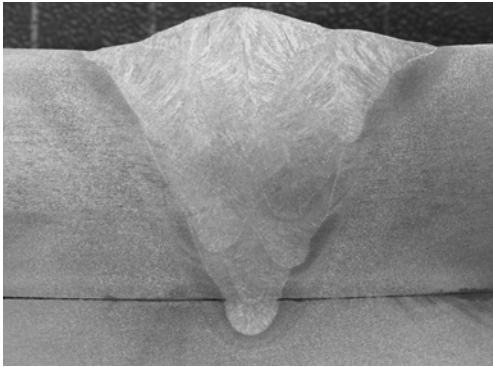
A complete technical report documenting all the advantages can be found online at the following link:

www.ewm-group.com/sl/professionalreport



forceArc puls[®] XQ

PA Root welding with a reduced included angle

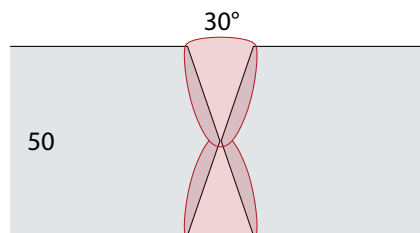
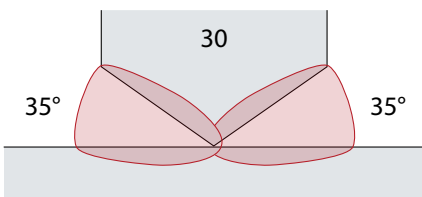


S355, 20 mm, included angle 60 °
8 runs, standard spray arc

S355, 20 mm, included angle 30 °
4 runs, forceArc puls[®]

PB Full penetration, T-joint welded on both sides

PA Full penetration, butt joint welded on both sides



S235, 30 mm, included angle 35 °
8 runs

S355, 50 mm, included angle 30 °
15 runs

Welding fillet welds with deep penetration on non-alloy and low-alloy steel

Your requirements

Our solution – forceArc puls® XQ

Improved economy

- Reduced number of welding passes for fillet welds

Secure penetration

- Deep penetration for excellent root and sidewall fusion

Minimised distortion of the components

- Modified, heat-reduced, directionally stable spray arc

Reliable welding in poorly accessible areas

- Perfect welding in narrow joints, even with very long stick-outs
- Rapid correction of alterations to stick-out lengths, reliable processing of stick-out lengths up to 40 mm

Reduced voltage in the fillet weld area

- Forces transferred to the interior of the component by deep penetration, seam volume reduced by large effective seam thickness in line with DIN EN ISO 17659:2005-09, reduced heat input into the component

Welding procedure qualification

- Qualified by welding procedure test (process no. 135), in line with DIN EN ISO 15614-1

Simple, safe handling

- Rapid digital control of the process, easy to learn and directly applicable regardless of torch angle

Flexibility in production

- EWM allin – one machine for welding all material thicknesses and using all processes



Energy savings



Reduced production time
(welding, finishing work)



Reduced material costs



Reduced welding fume emissions

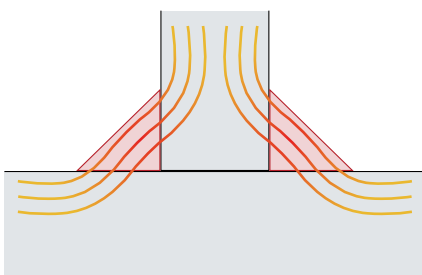
forceArc puls[®] XQ

Welding with deep penetration as per DIN EN 1090

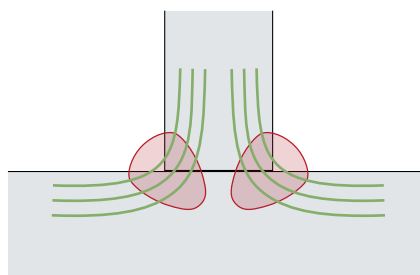
Use the full potential of your weld seam. By taking the effective seam thickness of fillet welds into account, the forceArc puls[®] process enables single-pass welds up to throat = 8 mm to be created as opposed to throat = 5 mm in processes without deep penetration.



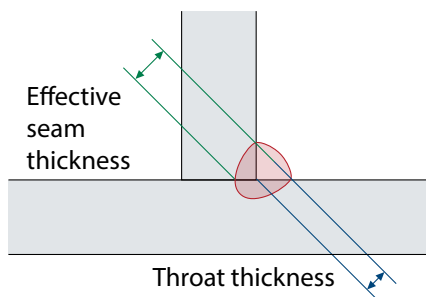
Additional information
www.ewm-group.com/sl/titanforcearc



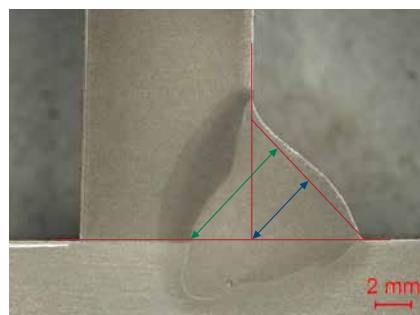
Flow of force in standard fillet welds



Improved flow of force thanks to deep penetration



Definition of effective seam thickness as per DIN EN ISO 17659:2005-09

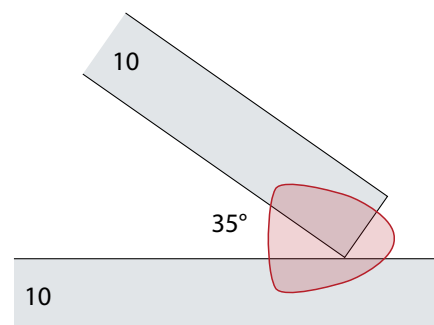


S355, 10 mm, effective seam thickness of 8 mm as per DIN EN ISO 17659:2005-09

All Welding with deep penetration and long stick-out



Web plate material thickness 10 mm, included angle 35°



Welding with consistent penetration and consistent power on non-alloy, low-alloy and high-alloy steel

wiredArc XQ / wiredArc puls XQ

Your requirements

Our solution – wiredArc XQ/wiredArc puls XQ

Secure penetration, root and sidewall fusion

- Welding process with consistently high penetration depth regardless of alterations to the stick-out

Reduced or no weld spatter

- Virtually spatter-free welding results thanks to rapid digital control of the welding process

Controlled heat input

- Digital process control supplies a consistent welding current
- The energy per unit length and heat input remain virtually consistent despite changes to the stick-out

Increased productivity

- Ability to reduce the seam's included angle and therefore the weld seam volume

Visually pleasing weld surface

- Flat, even weld surface and virtually spatter-free process for reduced finishing work

Straightforward handling

- Easy to learn and to control

Flexibility in production

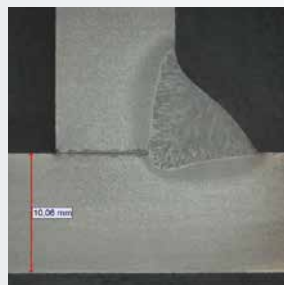
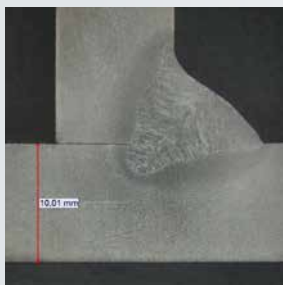
- EWM allin – one machine for welding all material thicknesses and using all processes



12 mm stick-out

30 mm stick-out

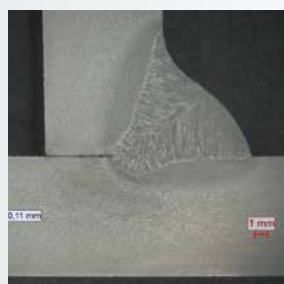
Standard



Standard

Alteration of the stick-out causes the penetration depth to change in standard welding processes. In particular, welding with an increasing stick-out length can cause the weld root to be insufficiently fused (lack of fusion).

wiredArc XQ



wiredArc XQ

With EWM wiredArc XQ, the penetration remains consistent when the stick-out is altered. The innovative control keeps the welding current and the heat input virtually consistent.

Welding using 100% CO₂ on non-alloy and low-alloy steel

100% CO₂

Your requirements

Our solution – coldArc® XQ/rootArc® XQ/Standard

Minimised spatter similar to mixed gas

- Digital process control for low-spatter droplet transfer thanks to the RCC power module (Rapid Current Control)

Process stability

- Rapid process control thanks to the use of the latest microelectronics

Increased productivity

- Minimised weld spatter similar to mixed gas
- Welding even with long hose packages without additional voltage measuring leads thanks to RCC power module (Rapid Current Control)

Straightforward handling

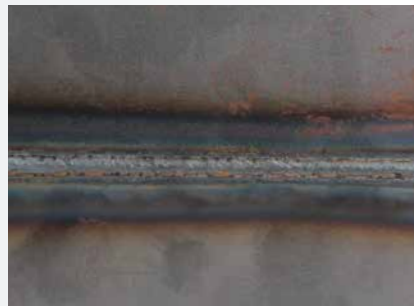
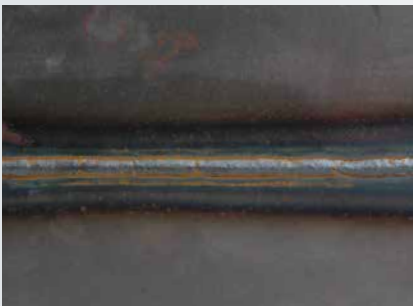
- Easy to guide and control

Flexibility in production

- EWM allin – one machine for welding all material thicknesses and using all processes

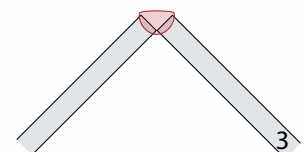
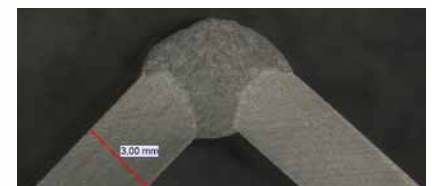


PC Root welding in PC position with an air gap and without weld pool backing



S355, material thickness 3 mm, using G3Si1 1.2 mm diameter at 100% CO₂

PA Root welding in PC position with an air gap and without weld pool backing



S355, material thickness 3 mm, using G3Si1 1.2 mm diameter at 100% CO₂

Welding full penetration fillet welds on non-alloy, low-alloy and high-alloy steel

Your requirements

Our solution – forceArc puls® XQ

Simple, safe handling

- Good gap bridging even in high power ranges, easy to learn and directly applicable
- Considerably reduced welding fume emissions compared to pulsed arc welding

Improved economy

- Secure full penetration even without an air gap, therefore good for fitting work
- Enables included angles to be reduced thereby reducing weld seam volumes, lowering the number of runs and significantly lowering costs

No gouging or grinding of the transverse root side

- Double-sided full penetration welds on butt joints or T-joints without grinding or gouging the transverse root side

Secure penetration

- Deep penetration for excellent root and sidewall fusion

Stable arc

- Good process stability when welding on the weld pool even at small included angles

Reliable welding in poorly accessible areas

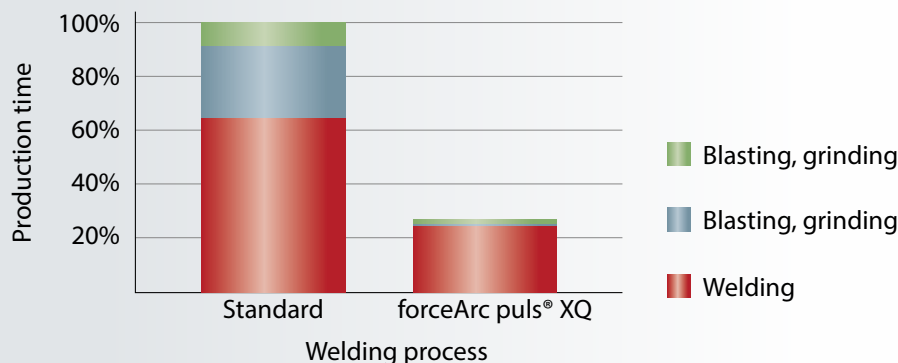
- Perfect welding, even with very long stick-outs
- Even in tight and narrow gaps with very long stick-outs
- Rapid correction of alterations to stick-out lengths, reliable processing of stick-out lengths up to 40 mm

Flexibility in production

- EWM allin – one machine for welding all material thicknesses and using all processes



Time saved by using forceArc puls® XQ in production



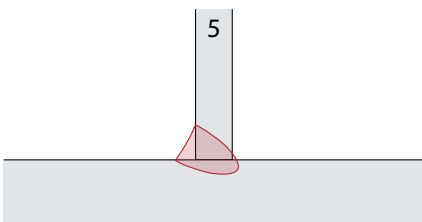
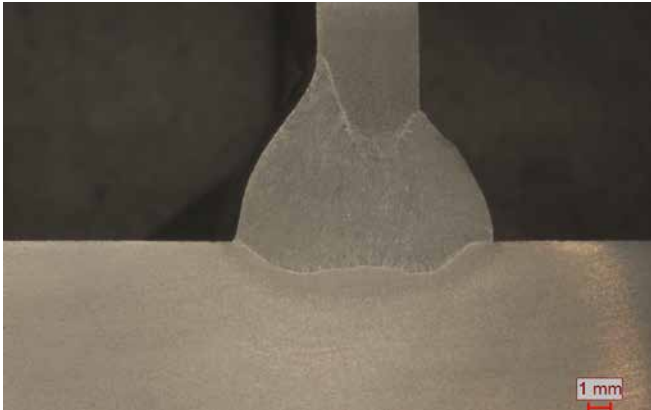
Additional information



www.ewm-group.com/sl/savings

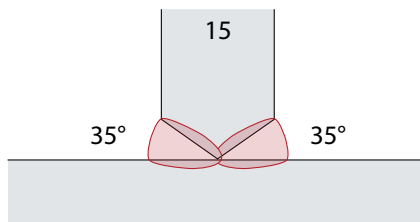
forceArc puls[®] XQ

PB Fillet weld welded on one side



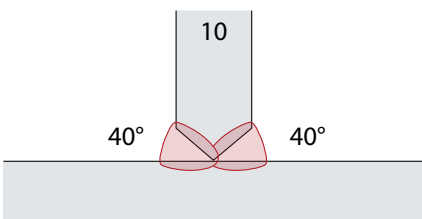
S355, 5 mm on 10 mm

PB Full penetration, welded on both sides



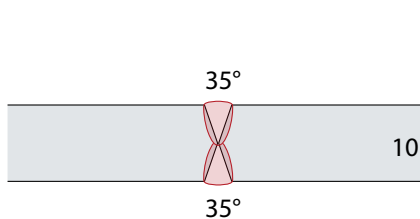
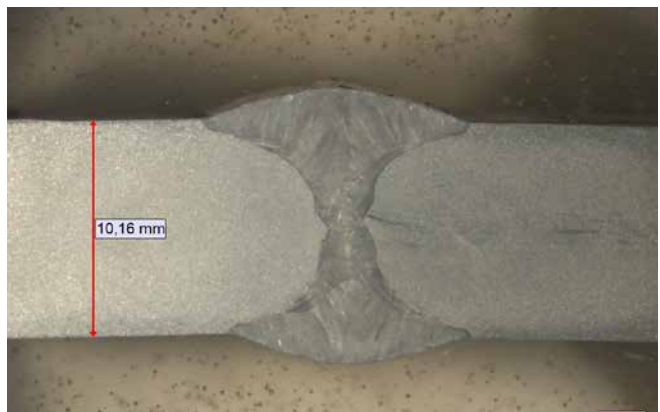
S355, 15 mm, included angle 35°

PB Full penetration, welded on both sides



1.4301, 10 mm, included angle 40°

PA Full penetration, welded on both sides



1.4301, 10 mm, double-sided full penetration on a butt joint with an included angle of 35°

Positional welding without using the “Christmas tree” technique on non-alloy, low-alloy and high-alloy steel

Your requirements

Increased productivity

Secure penetration, root and sidewall fusion

Reduced or no weld spatter

Controlled heat input

Visually pleasing weld surface

Straightforward handling

Flexibility in production

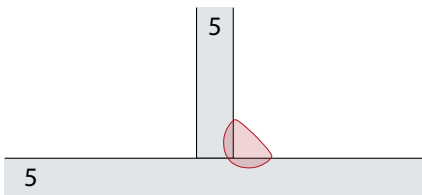
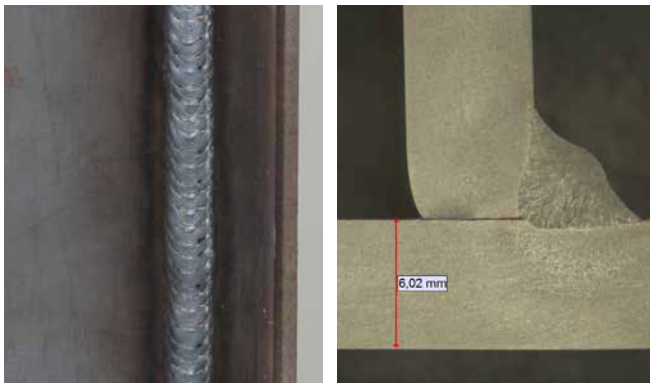
Our solution – Positionweld

- High welding speeds compared to the traditional "Christmas tree" technique
- Concentrated, digitally modified pulsed arc
- Virtually spatter-free welding results thanks to rapid digital control of the welding process
- Optimum, factory-configured switching between low and high welding power
- Heat-reduced process with low arc power and energy per unit length
- Flat, evenly spaced bead ripples and virtually spatter-free process for reduced finishing work
- Easy to set and easy to guide
- EWM allin – one machine for welding all material thicknesses and using all processes



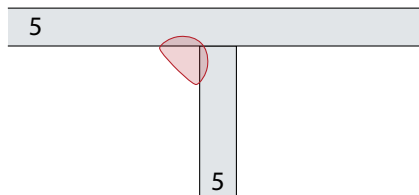
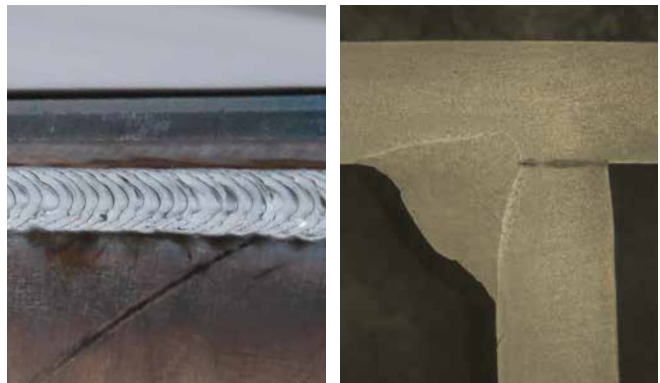
Positionweld

PF Vertical-up weld, straight torch guidance without using the "Christmas tree" technique



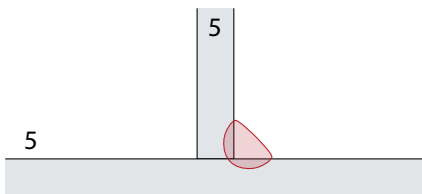
S355, material thickness 5 mm

PD Overhead welding, easy handling



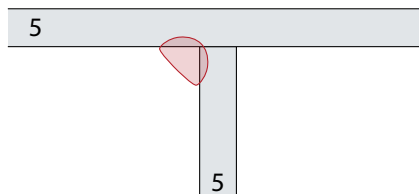
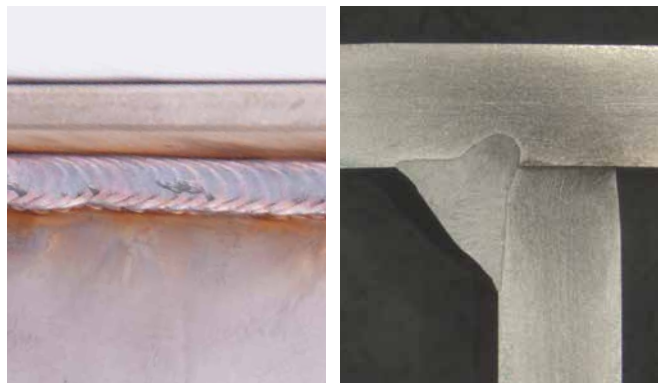
S355, material thickness 5 mm

PF Vertical-up weld, straight torch guidance without using the "Christmas tree" technique



1.4301 material thickness 5 mm

PD Overhead welding, easy handling



1.4301 material thickness 5 mm

Welding and brazing of thin sheet metal made from non-alloy, low-alloy, high-alloy steel and galvanised sheet metal

Your requirements

Our solution – coldArc® XQ/coldArc® puls XQ

Less distortion, minimal discolouration

- Lower heat input due to digital control of droplet transfer in short-circuit welding thanks to RCC power module (Rapid Current Control)

Visually pleasing, smooth weld surface, less or no weld spatter

- Flat, smooth weld surface and virtually spatter-free process, less discolouration and distortion reduces finishing work, excellent wetting of surfaces when brazing

Changeable, inconsistent air gap

- No sagging of the molten metal, secure sidewall fusion even with misaligned edges

Secure penetration

- Optimum process performance configuration, steady and stable welding process

Straightforward handling

- Rapid digital control of the process, easy to guide and control
- Welding even with long hose packages without additional voltage measuring leads thanks to RCC power module

Welding and brazing of coated (galvanised) sheet metal

- Minimal spatter formation, minimal impact on corrosion resistance

Flexibility in production

- EWM allin – one machine for welding all material thicknesses and using all processes



coldArc[®] XQ / coldArc[®] puls XQ



Welding unalloyed sheet metal



Welding high-alloy sheet metal



Welding galvanised sheet metal



Brazing galvanised sheet metal



Brazing high tensile sheet metal, e.g. Usibor[®]



Brazing high-alloy (CrNi) sheet metal

Filler pass and cover pass welding of high-alloy steel

Your requirements

Our solution – forceArc puls® XQ

Secure deep penetration

- Concentrated, digitally modified pulsed arc

Reduced or no weld spatter

- Virtually spatter-free welding results thanks to rapid digital control of the welding process
- Lower welding fume emissions compared to pulse arc welding

Minimal distortion

- Heat-reduced process with low arc power and energy per unit length reduced by up to 20% compared to pulsed arc

Increased productivity

- Ability to reduce the seam volume thanks to the smaller included angle in multipass welding
- Symmetrical fillet welds with maximum attainable seam thickness (throat thickness)
- Low interpass temperature/reduced non-productive time

Visually pleasing, smooth weld surface

- Flat, smooth weld surface and virtually spatter-free process for reduced finishing work, minimal discolouration

Straightforward handling

- Rapid digital control of the process, easy to guide and control
- Consistent weld surface from various torch positions

Flexibility in production

- EWM allin – one machine for welding all material thicknesses and using all processes



Your benefits

Up to 30% total cost savings

- Reduced costs for wages, welding consumables, shielding gas and power
- Reduced production time

Up to 15% lower heat input

- Less finishing work (straightening, sanding, cleaning) due to reduced distortion, discolouration and stress
- Minimised non-productive time due to shorter waiting times in multipass welding

Up to 20% greater throat thickness**

- Symmetrical seams due to deep, concentrated penetration with reliable root fusion

Virtually spatter free

- Minimised finishing work, even on panels with scaling or very dirty surfaces

forceArc puls[®] XQ



Front view: Lower heat input using forceArc puls[®] XQ, less surface oxidation resulting in a better finish

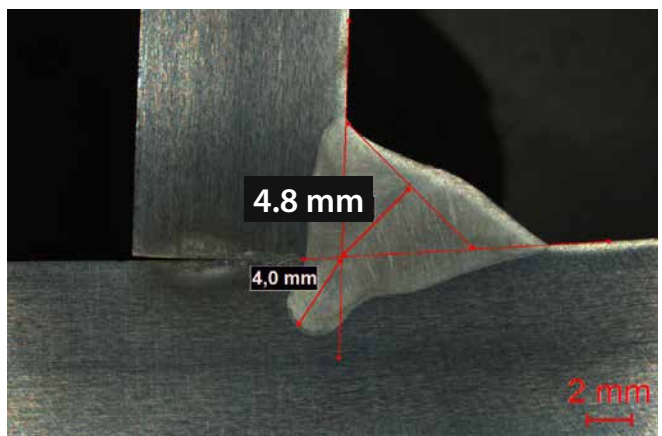
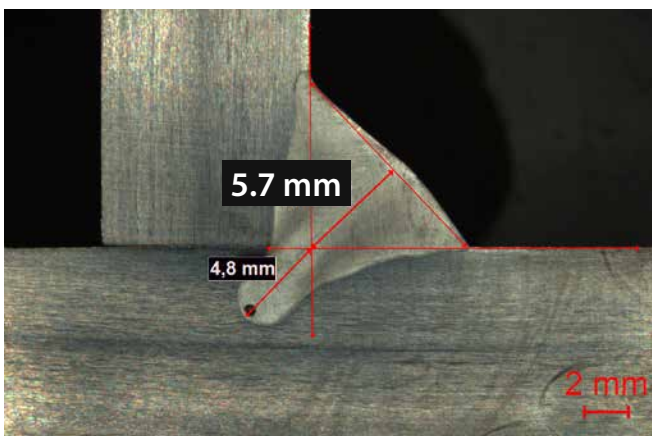


Back view: Low heat input using forceArc puls[®] XQ, less surface oxidation

Compared to pulsed arc welding, forceArc puls[®] XQ inputs up to 15% less heat in the upper power ranges. This results in less discolouration and less distortion in the component.

Your benefits

- Lower heat input
- Minimised energy per unit length
- Reduces distortion, discolouration and stress in the workpiece
- Less finishing work (straightening, sanding, cleaning)
- Less melting loss of alloy elements resulting in greater corrosion resistance



Process	forceArc puls [®] XQ	Pulse
Wire feed in m/min	13	13
Energy per unit length in kJ/mm	1.21 (-15%)	1.44
Weld speed in m/min	0.45	0.45
Throat thickness	5.7 (+15%)	4.8

For welding aluminium and aluminium alloys

Pulsed arc XQ

Your requirements

Secure penetration, root and sidewall fusion

Visually pleasing weld surface

Minimised spatter

For welding any material thickness

Straightforward handling

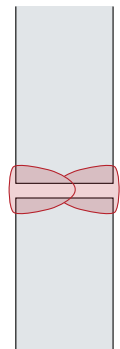
Flexibility in production

Our solution – pulsed arc XQ

- Rapid and stable process control thanks to the use of the latest microprocessor technology
- Steady, stable droplet transfer, less smoke residue on surface
- Individual weld appearance thanks to freely adjustable superPuls function
- Wire feed reverse for spatter-free ignition
- Reliable process starting from 1 mm
- Rapid digital control of the process, easy to guide and control
- EWM allin – one machine for welding all material thicknesses and using all processes



PC Welding on both sides of aluminium in shipbuilding



Welding of aluminium and aluminium alloys in positional welding without using the “Christmas tree” technique

Positionweld

Your requirements

Secure penetration, root and sidewall fusion

Controlled heat input

Increased productivity

Visually pleasing weld surface

Straightforward handling

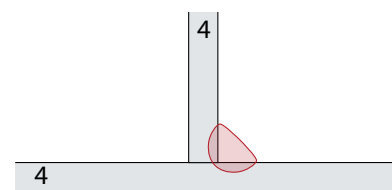
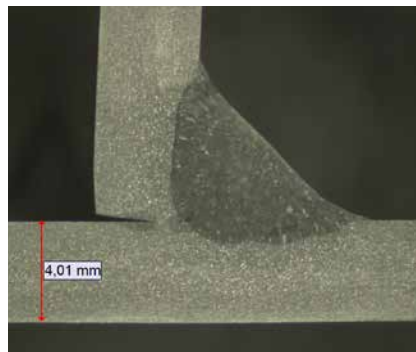
Flexibility in production

Our solution – Positionweld

- Concentrated, digitally controlled pulsed arc
- Optimum, factory configured switching between low and high welding power
- High welding speeds compared to the traditional weaving techniques
- Flat, evenly spaced bead ripples and virtually spatter-free process for reduced finishing work
- Rapid digital control of the process, easy to guide and to control
- EWM allin – one machine for welding all material thicknesses and using all processes

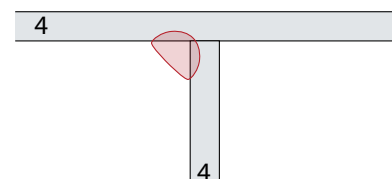
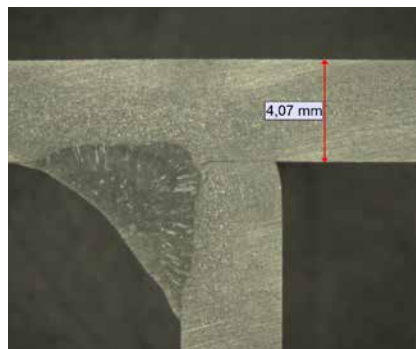
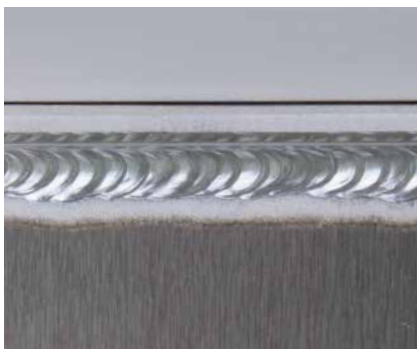
all in

PF Vertical-up welding, easy handling



AlMg5, material thickness 4 mm

PD Overhead welding, easy handling



AlMg5, material thickness 4 mm

Surfacing, cladding/hardfacing

Your requirements

Deposit with good corrosion resistance

Little material removal after welding

Stable arc

Straightforward handling

Flexibility in production

Our solution – cladding/hardfacing

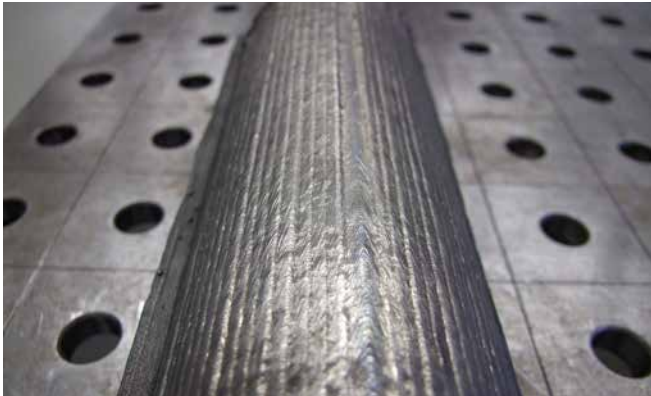
- Low dilution due to optimum process configuration for surfacing
- Even deposit structure, minimal machining work
- High process stability thanks to digitally controlled arc, minimised spatter formation
- Easy to operate and set
- EWM allin – one machine for welding all material thicknesses and using all processes
- Surfacing processes at no extra cost for Co-based and Ni-based alloys and high-alloy CrNi alloys

all in

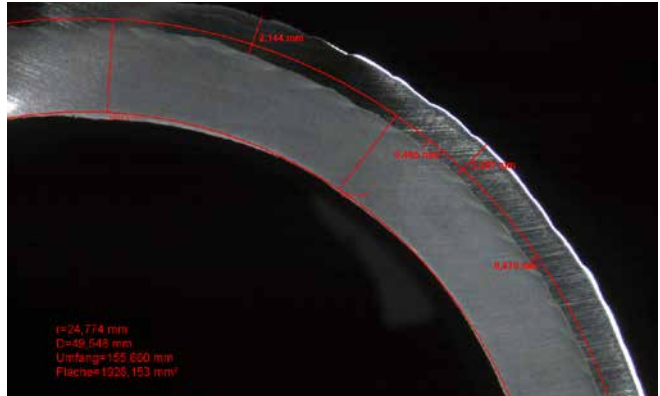


Cladding/hardfacing

PA Surfacing of finned tube walls



Corrosion-resistant surfacing of Alloy 625 Ni-based materials



PA MAG + hot wire surfacing for increased deposition rate



New process variant combines a MAG welding process supplemented with an additional hot wire.

- Up to 13.8 kg deposition rate for significantly increased productivity
- Minimal dilution
- Further improved properties of deposited layers
- Process easy to set up and configure
- Suitable for cladding and hardfacing



Additional information



www.ewm-group.com/sl/cladding

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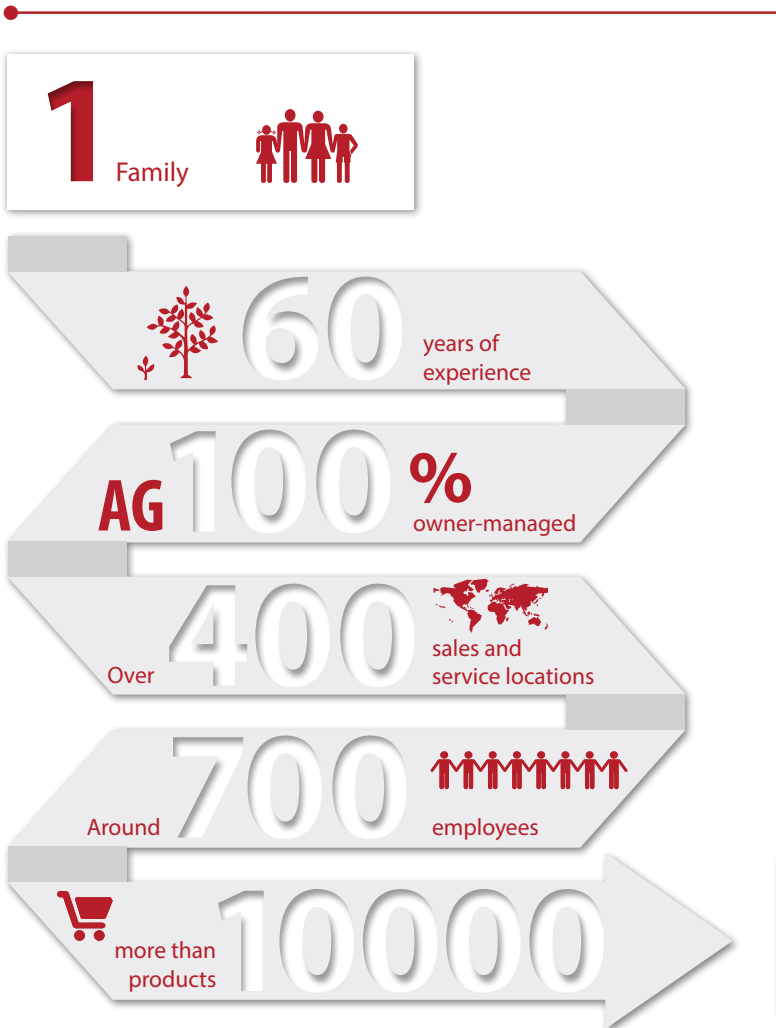
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Quality from Germany

EWM AG is Germany's largest and one of the most important world-wide manufacturers of arc welding technology and a major driving force in welding technology.

The family-run company from Mündersbach has been living its motto "WE ARE WELDING" for over 60 years with forward-looking, well thought-out and sustainable complete solutions, designed with a large helping of passion for industrial clients, as well as skilled craft businesses.

1 Partner for all your welding technology needs

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