



Air gouger

GT600

099-016099-EW501

17.05.2010

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3 Years **5** Years
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and rectifier

ewm-warranty*
24 hours / 7 days

* Details for ewm-warranty
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General instructions

CAUTION



Read the operating instructions!

The operating instructions provide an introduction to the safe use of the products.

- Read the operating instructions for all system components!
- Observe accident prevention regulations!
- Observe all local regulations!
- Confirm with a signature where appropriate.

NOTE



In the event of queries on installation, commissioning, operation or special conditions at the installation site, or on usage, please contact your sales partner or our customer service department on +49 2680 181-0.

A list of authorised sales partners can be found at www.ewm-group.com.

Liability relating to the operation of this equipment is restricted solely to the function of the equipment. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning the equipment.

The manufacturer is unable to monitor whether or not these instructions or the conditions and methods are observed during installation, operation, usage and maintenance of the equipment.

An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, we do not accept any responsibility or liability for losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way.

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2 Safety instructions

2.1 Notes on the use of these operating instructions



DANGER

Working or operating procedures which must be closely observed to prevent imminent serious and even fatal injuries.

- Safety notes include the "DANGER" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol on the edge of the page.



WARNING

Working or operating procedures which must be closely observed to prevent serious and even fatal injuries.

- Safety notes include the "WARNING" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol in the page margin.



CAUTION

Working or operating procedures which must be closely observed to prevent possible minor personal injury.

- The safety information includes the "CAUTION" keyword in its heading with a general warning symbol.
- The risk is explained using a symbol on the edge of the page.

CAUTION

Working and operating procedures which must be followed precisely to avoid damaging or destroying the product.

- The safety information includes the "CAUTION" keyword in its heading without a general warning symbol.
- The hazard is explained using a symbol at the edge of the page.

NOTE

Special technical points which users must observe.

- Notes include the "NOTE" keyword in the heading without a general warning symbol.

Instructions and lists detailing step-by-step actions for given situations can be recognised via bullet points, e.g.:

- Insert the welding current lead socket into the relevant socket and lock.

2.2 Explanation of icons

Symbol	Description
	Press
	Do not press
	Turn
	Switch
	Switch off machine
	Switch on machine
	ENTER (enter the menu)
	NAVIGATION (Navigating in the menu)
	EXIT (Exit the menu)
	Time display (example: wait 4s/press)
	Interruption in the menu display (other setting options possible)
	Tool not required/do not use
	Tool required/use
	Wire feed unit
	Power source (Welding machine)

2.3 General

DANGER



Electric shock!

Welding machines use high voltages which can result in potentially fatal electric shocks and burns on contact. Even low voltages can cause you to get a shock and lead to accidents.

- Do not touch any live parts in or on the machine!
- Connection cables and leads must be free of faults!
- Switching off alone is not sufficient!
- Place welding torch and stick electrode holder on an insulated surface!
- The unit should only be opened by specialist staff after the mains plug has been unplugged!
- Only wear dry protective clothing!
- Wait for 4 minutes until the capacitors have discharged!



Electromagnetic fields!

The power source may cause electrical or electromagnetic fields to be produced which could affect the correct functioning of electronic equipment such as IT or CNC devices, telecommunication lines, power cables, signal lines and pacemakers.

- Observe the maintenance instructions! (see Maintenance and Testing chapter)
- Unwind welding lines completely!
- Shield devices or equipment sensitive to radiation accordingly!
- The correct functioning of pacemakers may be affected (obtain advice from a doctor if necessary).



Validity of this document!

This document describes an accessory and is only valid in combination with the operating instructions for the power source being used (welding machine)!

- Read the operating instructions, in particular the safety instructions for the power source (welding machine)!

WARNING



Risk of accidents if these safety instructions are not observed!

Non-observance of these safety instructions is potentially fatal!

- Carefully read the safety information in this manual!
- Observe the accident prevention regulations in your country.
- Inform persons in the working area that they must observe the regulations!



Fire hazard!

Flames may arise as a result of the high temperatures, stray sparks, glowing-hot parts and hot slag produced during the welding process.

Stray welding currents can also result in flames forming!

- Check for fire hazards in the working area!
- Do not carry any easily flammable objects such as matches or lighters.
- Keep appropriate fire extinguishing equipment to hand in the working area!
- Thoroughly remove any residue of flammable substances from the workpiece before starting welding.
- Only continue work on welded workpieces once they have cooled down.
Do not allow to come into contact with flammable material!
- Connect welding leads correctly!

 **WARNING****Risk of injury due to radiation or heat!****Arc radiation results in injury to skin and eyes.****Contact with hot workpieces and sparks results in burns.**

- Use welding shield or welding helmet with the appropriate safety level (depending on the application)!
- Wear dry protective clothing (e.g. welding shield, gloves, etc.) according to the relevant regulations in the country in question!
- Protect persons not involved in the work against arc beams and the risk of glare using safety curtains!

**Risk of injury due to hot metal or slag sparks!****Contact with hot metal or slag sparks results in burns! Flying sparks can reach a distance of up to 10 m! Flammable and explosive substances can catch fire!**

- When carrying out air arc gouging tasks, wear a leather apron and a flame retardant welder coverall!
- Install suitable screening to reduce the area affected by flying sparks!
- Remove flammable and explosive substances from the danger zone!

**Hazards due to improper usage!****Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!**

- The equipment must only be used in line with proper usage and by trained or expert staff!
- Do not modify or convert the equipment improperly!

**Risk of injury due to compressed air!****Compressed air used in air arc gouging can cause injuries if handled incorrectly!**

- Never point compressed air at yourself, other people or animals!
- The working pressure may never exceed the value given in the technical data!
- The compressed air must be free of oil and water!

**Smoke and gases!****Smoke and gases can lead to breathing difficulties and poisoning. In addition, solvent vapour (chlorinated hydrocarbon) may be converted into poisonous phosgene due to the ultraviolet radiation of the arc!**

- Ensure that there is sufficient fresh air!
- Keep solvent vapour away from the arc beam field!
- Wear suitable breathing apparatus if appropriate!

 **CAUTION****Noise exposure!****Noise exceeding 70 dBA can cause permanent hearing damage!**

- Wear suitable ear protection!
- Persons located within the working area must wear suitable ear protection!

CAUTION



Obligations of the operator!

The respective national directives and laws must be observed for operation of the machine!

- National implementation of the framework directive (89/391/EWG), as well as the associated individual directives.
- In particular, directive (89/655/EWG), on the minimum regulations for safety and health protection when staff members use equipment during work.
- The regulations regarding work safety and accident prevention for the respective country.
- Setting up and operating the machine according to IEC 60974-9.
- Check at regular intervals that users are working in a safety-conscious way.
- Regular checks of the machine according to IEC 60974-4.



Damage due to the use of non-genuine parts!

The manufacturer's warranty becomes void if non-genuine parts are used!

- Only use system components and options (power sources, welding torches, electrode holders, remote controls, spare parts and replacement parts, etc.) from our range of products!
- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.



Trained personnel!

Commissioning is reserved for persons who have the relevant expertise of working with arc welding machines.

2.4 Transport

⚠ CAUTION



Damage due to supply lines not being disconnected!

During transport, supply lines which have not been disconnected (mains supply leads, control leads, etc.) may cause hazards such as connected equipment tipping over and injuring persons!

- Disconnect supply lines!

2.4.1 Scope of delivery

The delivery is checked and packaged carefully before dispatch, however it is not possible to exclude the possibility of damage during transit.

Receiving inspection

- Check that the delivery is complete using the delivery note!

In the event of damage to the packaging

- Check the delivery for damage (visual inspection)!

In the event of complaints

If the delivery has been damaged during transport:

- Please contact the last haulier immediately!
- Keep the packaging (for possible checking by the haulier or for the return shipment).

Packaging for returns

If possible, please use the original packaging and the original packaging material. If you have any queries on packaging and protection during transport, please contact your supplier.

2.5 Ambient conditions

CAUTION



Equipment damage due to dirt accumulation!

Unusually high quantities of dust, acid, corrosive gases or substances may damage the equipment.

- Avoid high volumes of smoke, vapour, oil vapour and grinding dust!
- Avoid ambient air containing salt (sea air)!

2.5.1 In operation

Temperature range of the ambient air:

- -10 °C to +40 °C

Relative air humidity:

- Up to 50% at 40 °C
- Up to 90% at 20 °C

2.5.2 Transport and storage

Storage in an enclosed space, temperature range of the ambient air:

- -25 °C to +55 °C

Relative air humidity

- Up to 90% at 20 °C

3 Intended use

3.1 General

The ready-to-use air gouger consists of: hose package, handle, electrode holder and compressed air nozzle, including all necessary accessories and wearing parts.

Together the elements form a functioning unit that, if supplied with the necessary operating material, creates an arc and a compressed air jet for air arc gouging.

With air arc gouging, a carbon electrode creates a molten pool which is then blown off by the compressed air jet.

The slide valve at the air gouger is generally used to switch the compressed air jet on and off.

This machine has been manufactured according to the latest developments in technology and current regulations and standards. It must only be operated in line with the instructions on correct usage.

WARNING



Hazards due to improper usage!

Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!

- The equipment must only be used in line with proper usage and by trained or expert staff!
- Do not modify or convert the equipment improperly!

3.2 Applications

3.2.1 MMA welding

Manual arc welding or, for short, MMA welding. It is characterised by the fact that the arc burns between a melting electrode and the molten pool. There is no external protection; any protection against the atmosphere comes from the electrode.

3.2.2 Air arc gouging

During air arc gouging, bad welding seams are heated with a carbon electrode and then removed with compressed air. Special electrode holders and carbon electrodes are required for air arc gouging.

3.3 Documents which also apply

3.3.1 Warranty

NOTE



For further information, please see the accompanying supplementary sheets "Machine and Company Data, Maintenance and Testing, Warranty"!

3.3.2 Declaration of Conformity



The designated machine conforms to EC Directives and standards in terms of its design and construction:

- EC Low Voltage Directive (2006/95/EC),
- EC EMC Directive (2004/108/EC),

This declaration shall become null and void in the event of unauthorised modifications, improperly conducted repairs, non-observance of the deadlines for the repetition test and / or non-permitted conversion work not specifically authorised by the manufacturer.

The original copy of the declaration of conformity is enclosed with the unit.

3.3.3 Welding in environments with increased electrical hazards



In compliance with IEC / DIN EN 60974, VDE 0544 the machines can be used in environments with an increased electrical hazard.

3.3.4 Service documents (spare parts)



DANGER



Do not carry out any unauthorised repairs or modifications!

To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!

The warranty becomes null and void in the event of unauthorised interference.

- Appoint only skilled persons for repair work (trained service personnel)!

Spare parts can be obtained from the relevant authorised dealer.

4 Machine description – quick overview

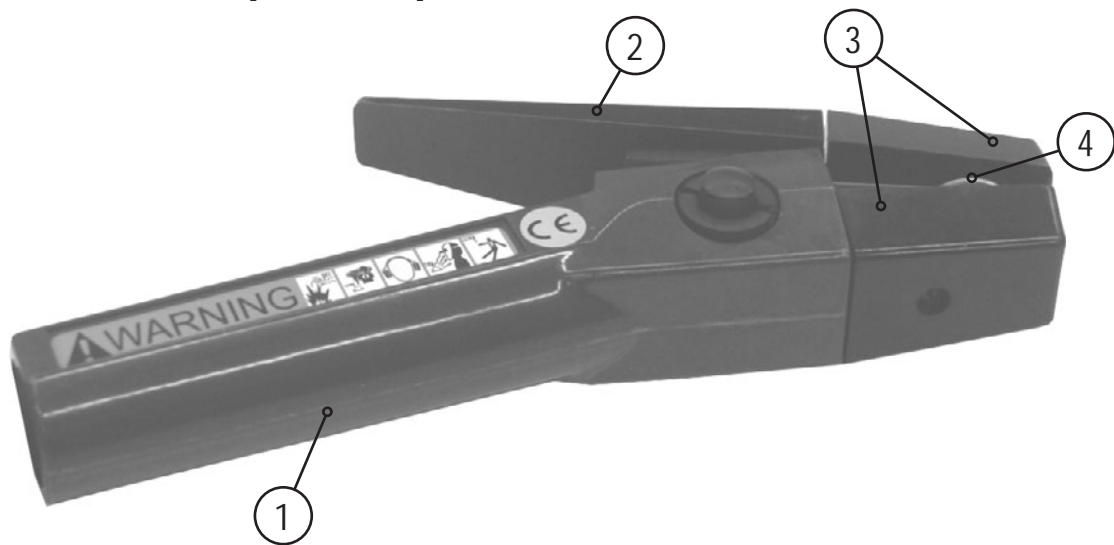


Figure 4-1

Item	Symbol	Description
1		Torch body
2		Electrode holder
3		Insulating jaws
4		Compressed air nozzle

4.1 Connections



Figure 4-2

Item	Symbol	Description
1		Welding current cable plug
2		Compressed air quick disconnect

5 Design and function

5.1 General



DANGER



Risk of injury from electric shock!

Contact with live parts, e.g. welding current sockets, is potentially fatal!

- Follow safety instructions on the opening pages of the operating instructions.
- Commissioning may only be carried out by persons who have the relevant expertise of working with arc welding machines!
- Connection and welding leads (e.g. electrode holder, welding torch, workpiece lead, interfaces) may only be connected when the machine is switched off!



CAUTION



Risk of burns on the welding current connection!

If the welding current connections are not locked, connections and leads heat up and can cause burns, if touched!

- Check the welding current connections every day and lock by turning in clockwise direction, if necessary.



Risk from electrical current!

If welding is carried out alternately using different methods and if a welding torch and an electrode holder remain connected to the machine, the open-circuit/welding voltage is applied simultaneously on all cables.

- The torch and the electrode holder should therefore always be placed on an insulated surface before starting work and during breaks.

CAUTION



Damage due to incorrect connection!

Accessory components and the power source itself can be damaged by incorrect connection!

- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.
- Comprehensive descriptions can be found in the operating instructions for the relevant accessory components.
- Accessory components are detected automatically after the power source is switched on.



Using protective dust caps!

Protective dust caps protect the connection sockets and therefore the machine against dirt and damage.

- The protective dust cap must be fitted if there is no accessory component being operated on that connection.
- The cap must be replaced if faulty or if lost!

5.2 Connection

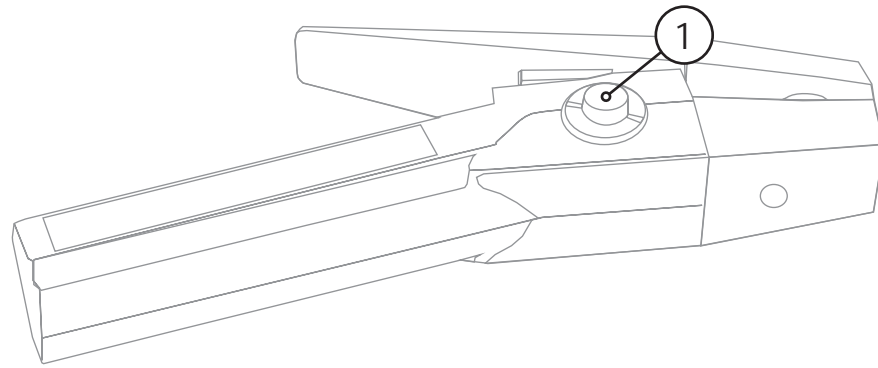


Figure 5-1

Item	Symbol	Description
1		Slide valve

- Keep the slide valve at the handle locked before connecting. The valve is locked when the button at the right hand side of the air gouger is depressed.

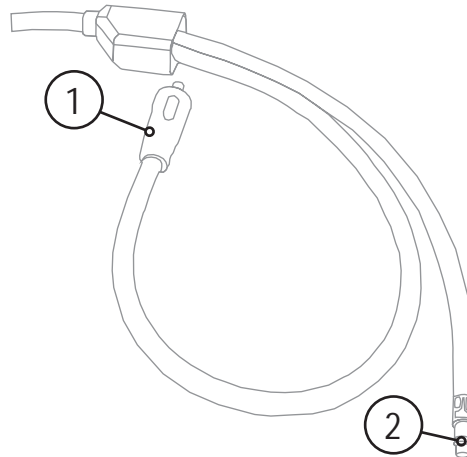


Figure 5-2

Item	Symbol	Description
1		Welding current cable plug
2		Compressed air quick disconnect

- Plug the welding current cable plug into the welding current connection of the welding machine and lock.

NOTE



Polarity depends on the instructions from the electrode manufacturer given on the electrode packaging.

- Connect compressed air quick disconnect to the air compressor or central compressed air supply.

NOTE



Observe maximum permissible pressure (see "Technical Data" chapter)!

5.3 Operation

WARNING



Risk of injury due to hot metal or slag sparks!

Contact with hot metal or slag sparks results in burns! Flying sparks can reach a distance of up to 10 m! Flammable and explosive substances can catch fire!

- When carrying out air arc gouging tasks, wear a leather apron and a flame retardant welder coverall!
- Install suitable screening to reduce the area affected by flying sparks!
- Remove flammable and explosive substances from the danger zone!

5.3.1 Insert carbon electrode

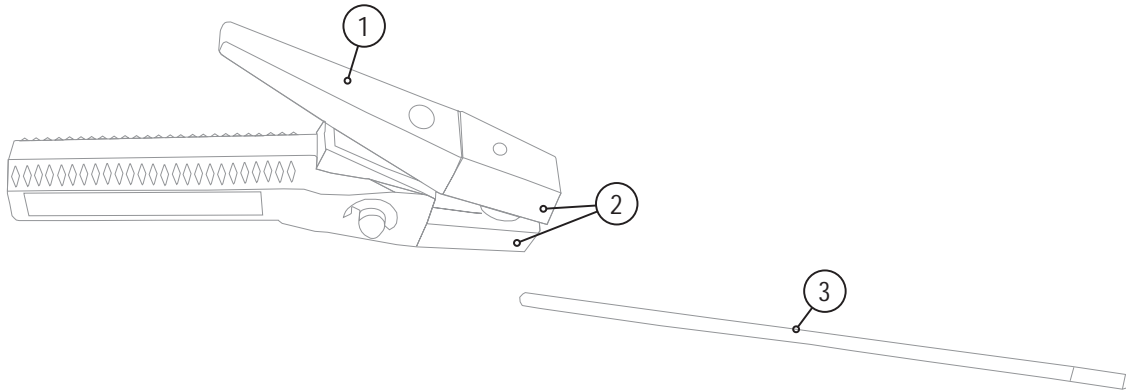


Figure 5-3

Item	Symbol	Description
1		Electrode holder
2		Insulating jaws
3		Carbon electrode

- Hold down the electrode holder.
- Insert carbon electrode and clamp tight with the insulating jaws.
- For air arc gouging, insert only half the length of the electrode into the holder to ensure an even compressed air jet.

5.3.2 Air arc gouging

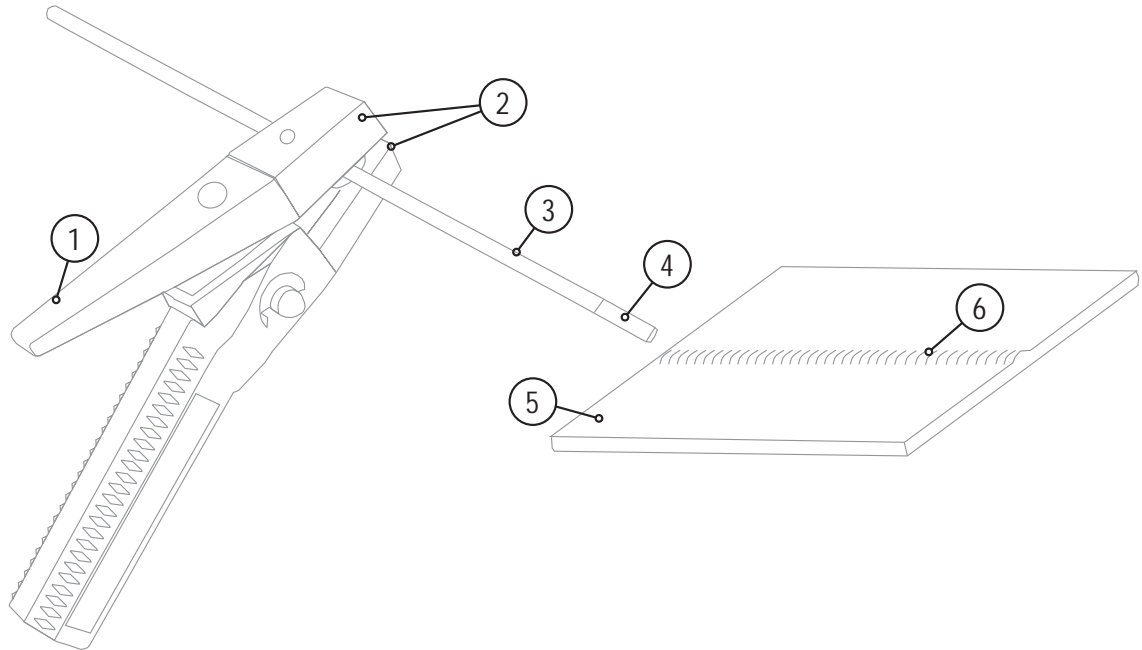


Figure 5-4

Item	Symbol	Description
1		Electrode holder
2		Insulating jaws
3		Carbon electrode
4		Carbon tip
5		Workpiece
6		Weld seam

- Open the compressed air valve.
- Ignite arc by shortly touching the carbon electrode against the workpiece and then withdraw the carbon electrode a bit.
- Keep the arc very short and guide the carbon electrode evenly over the workpiece.
- The subsequent compressed air jet blows off the fused material.

5.3.3 MMA welding

- For MMA welding, disconnect the compressed air supply from the air gouger and keep the compressed air valve locked.

6 Maintenance, care and disposal

CAUTION



Risk of injury due to electrical current and compressed air!

Only carry out the following tasks once the power source is securely switched off and there is no compressed air in the system!

- Switch off the welding machine!
- Cut off the compressed air supply at the source!
- Disconnect all mains plugs!

6.1 Daily maintenance tasks

- Check that all connections and wearing parts are hand-tight and tighten if necessary.
- Check hose package and power connections for exterior damage and replace or have repaired by specialist staff as necessary!
- Check that all screw and plug connections and replaceable parts are secured correctly, tighten if necessary.
- Remove any spatter.

6.2 Repair Work

CAUTION



Electric current!

Repairs may only be carried out by authorised specialist staff!

- Do not remove the torch from the tube package!
- Never clamp the torch body in a vice or similar, as this can cause the torch to be irreparably destroyed!
- If damage occurs to the torch or to the tube package which cannot be corrected as part of the maintenance work, the entire torch must be returned to the manufacturer

6.2.1 Replace slide valve O-ring

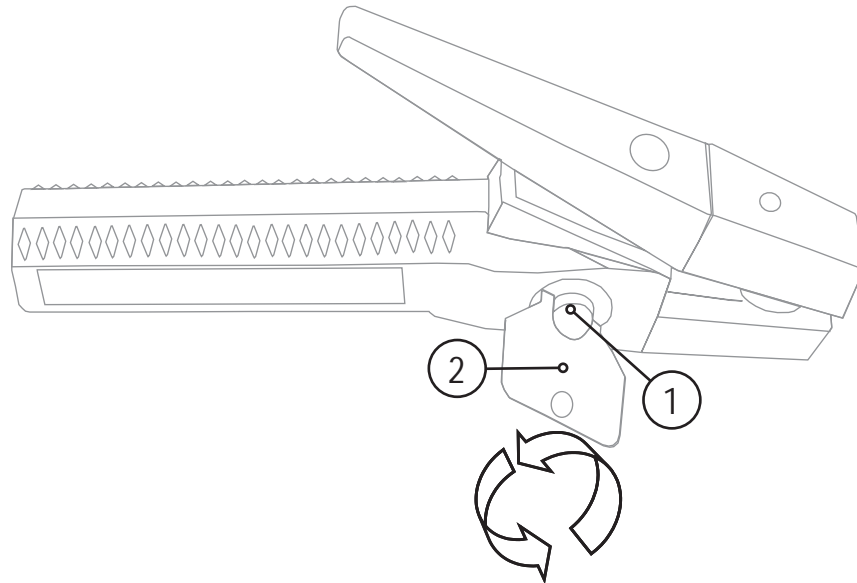


Figure 6-1

Item	Symbol	Description
1		Slide valve
2		Key to open the slide valve

- Open the slide valve with the provided key.

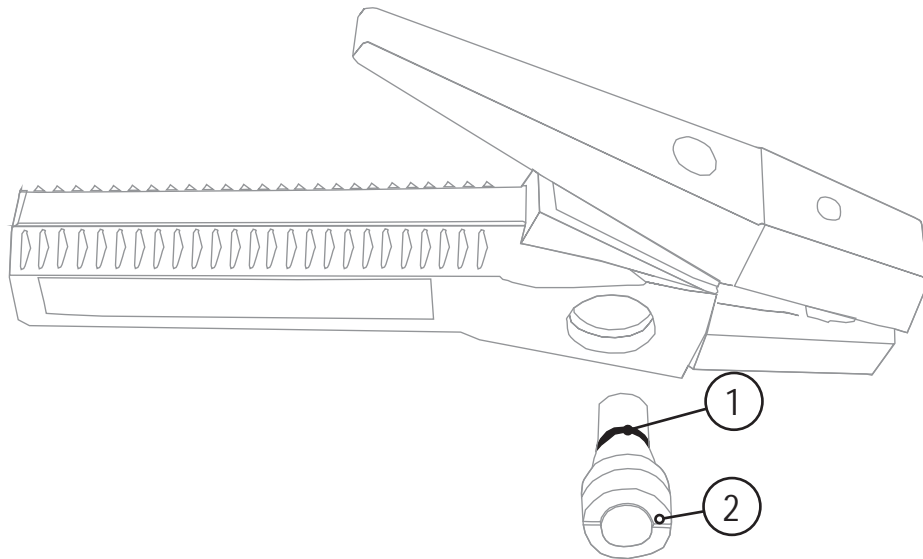


Figure 6-2

Item	Symbol	Description
1		O-ring
2		Slide valve

- Replace O-ring, reinsert slide valve and tighten with the key.

6.3 Disposing of equipment

NOTE



Proper disposal!

The machine contains valuable raw materials, which should be recycled, and electronic components, which must be disposed of.

- Do not dispose of in household waste!
- Observe the local regulations regarding disposal!



6.3.1 Manufacturer's declaration to the end user

- According to European provisions (guideline 2002/96/EG of the European Parliament and the Council of January, 27th 2003), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.
This machine is to be placed for disposal or recycling in the waste separation systems provided for this purpose.
- According to German law (law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment (ElektroG) from 16.03.2005), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.
- Information about giving back used equipment or about collections can be obtained from the respective municipal administration office.
- EWM participates in an approved waste disposal and recycling system and is registered in the Used Electrical Equipment Register (EAR) under number WEEE DE 57686922.
- In addition to this, returns are also possible throughout Europe via EWM sales partners.

6.4 Meeting the requirements of RoHS

We, EWM HIGHTEC Welding GmbH Mündersbach, hereby confirm that all products supplied by us which are affected by the RoHS Directive, meet the requirements of the RoHS (Directive 2002/95/EC).

7 Rectifying faults

All products are subject to rigorous production checks and final checks. If, despite this, something fails to work at any time, please check the product using the following flowchart. If none of the fault rectification procedures described leads to the correct functioning of the product, please inform your authorised dealer.

7.1 Customer checklist

NOTE



The correct machine equipment for the material and process gas in use is a fundamental requirement for perfect operation!

Legend

↘: Fault/Cause

✂: Remedy

Air gouger overheating

- ↘ Loose welding current connections
 - ✂ Tighten power connections on the torch and/or on the workpiece
- ↘ Overload
 - ✂ Check and correct welding current setting
- ↘ Low air pressure volume
 - ✂ Fully open valve
 - ✂ Check compressed air supply
- ↘ Carbon electrode too short
 - ✂ Correct clamping length
 - ✂ Replace carbon electrode

Unstable arc

- ↘ Unsuitable or worn equipment
 - ✂ Check and replace if necessary
- ↘ Incompatible parameter settings
 - ✂ Check settings and correct if necessary

8 Technical data

NOTE



Performance specifications and guarantee only in connection with original spare and replacement parts!

8.1 GT600

Electrode	Carbon electrode, round or flat
Round carbon electrode diameter	Ø 3-10 mm
Flat carbon electrode width	10 mm/16 mm
Flat carbon electrode thickness	5 mm
Voltage type	AC or DC
Electrode polarity	DC positive for cast steel and steel alloys DC negative for nonferrous heavy metal, manganese steel and grey cast iron AC for grey cast iron, aluminium and nickel alloys
Cooling type	Compressed air
Operation type	Manually operated
Open-circuit/ignition voltage	Approx. 60 V
Duty cycle	60%
Maximum welding current	600 A
Ambient temperature	-20 °C to +40 °C
Protection rating for the machine connections (EN 60529)	IP3X
Hose package length	4 m
Permissible pressure	5.6 bar
Constructed to standard	IEC 60974-7

9 Replaceable parts

Type	Designation	Item no.
IS GT600	Insulating set	094-016201-00000
HO GT600	Lever top	094-016202-00000
H GT600	Lever	094-016203-00000
BK GT600	Torch body	094-016204-00000
HB GT600	Lever bolt	094-016205-00000
DF GT600	Pressure spring	094-016206-00000
S GT600	Slider	094-016207-00000
Schieber mit O-Ring	Slider with O-ring	094-016208-00000
O-Ring GT600	O-ring	094-016209-00000
Befestigungsmutter GT600	Mounting nut	094-016210-00000
Ventil komplett GT600	Valve, complete	094-016211-00000
Isoliermuffe GT600	Insulating joint	094-016212-00000
Anschlussstueck GT600	Connecting piece	094-016213-00000
Griff GT600	Handle mould	094-016214-00000
Flachduese GT600	Flat nozzle	094-016215-00000

10 Appendix A

10.1 Overview of EWM branches

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