

# AXXAIR

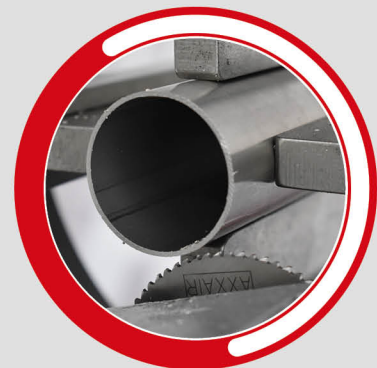
INNOVATIVE ORBITAL SOLUTIONS

## ORBITAL CUTTING CC 322



### CUTTING RANGE

ø 141 - 328 mm  
(ø5.563" - 12.750")



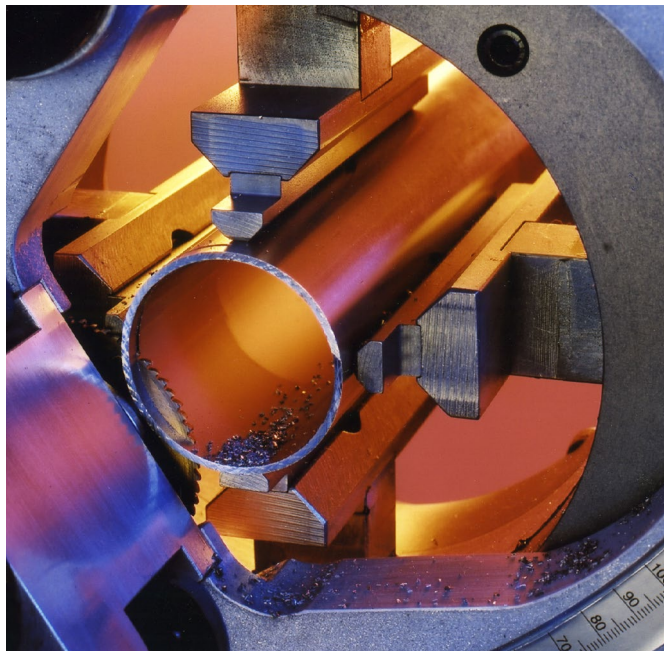


# Orbital cutting

A proper tube preparation is essential to produce a proper weld.

AXXAIR's orbital cutting machines feature stainless steel concentric jaws to prevent the deformation of the tubes, especially the one with thin walls, during clamping.

The perfect position of the tube within the machine also guaranty the perpendicularity of the cut as the saw travels around the tube and the consistency that perpendicularity cut after cut. The precision of our cutting machine allow a



## FLEXIBILITY, PRODUCTIVITY

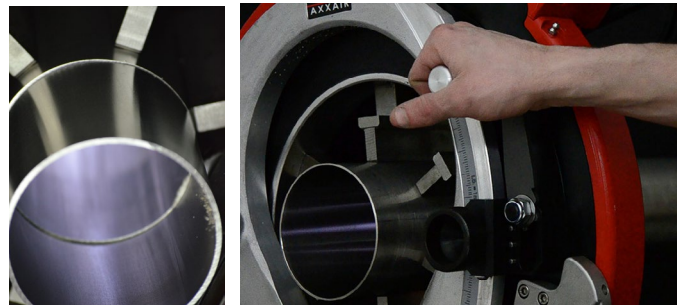
AXXAIR frames (except CC81, CC121ECO and 171ECO) are easily scalable for beveling and welding use.

## QUALITY, GEOMETRIC PRECISION

Cutting with no tube distortion (multi-contacts concentric clamping) ideal for thin wall stainless steel tubes. Great perpendicularity (<math><0.25\text{ mm}</math>) of the cut and superb surface finish (few burrs).

## PORTABILITY

With the easy to remove sawing attachment, AXXAIR's cutting machines are easy to transport on site or move within a workshop.

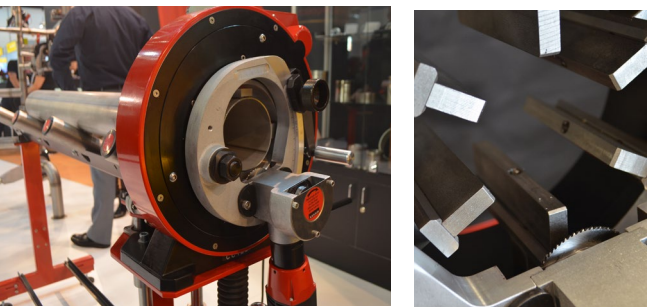
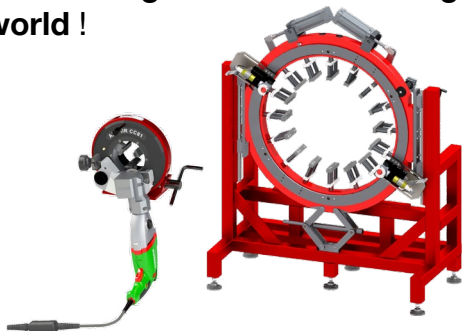


perfect tube to tube alignment with the smallest gap possible, removing the need to facing the tube therefore saving a significant amount of time and money.

AXXAIR's orbital cutting machines are an indispensable tool for any automatic and orbital welding.

AXXAIR offers the **largest orbital cutting range in the world !**

11 different models to cut tubes from diameter 5 to 1100 mm !



Please do not hesitate to contact us for all enquiries relating to orbital cutting technology.

We are glad to share our decades long experience in orbital cutting and helping you to select the solution that fits your needs.





# 122 - 172 - 222 - 322



**No tube deformation**

Concentric clamping



Basic and extra stainless steel jaws: no pollution of stainless steel tubes

**Cutting precision**

Perpendicularity of < 0.25 mm

**Cutting quality**

Rotation handle for controlled and continuous cutting speed

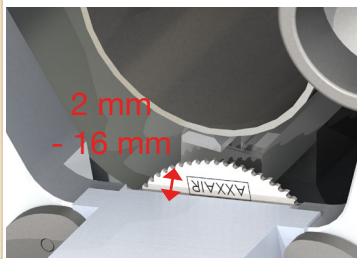
**A perfect sealing against chips**

All rotating parts are incorporated in the body



**Reduced vibration and increased blade life**

Optimised blade to jaw distance



**Global Process**

Can be transformed into an orbital bevelling and welding machine

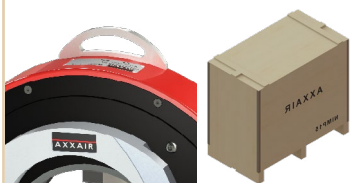
**Uptake**

feature a dual blade position allowing to cut elbows or flanges with no wasting of tube.

**1200W motor or pneumatic motor (as required)**

**Cutting capacity:** Up to 5 mm wall thickness\*

**Easy handling and transportation**



**Continuous use**

Anti-twist cable with bearings. Protects the electric cable from damage resulting from rotation around the tube.

**Opening capacity**

122	ø5 - ø119 mm 0.25" - 4.5"
172	ø16 - ø173 mm 0.625" - 6.625"
222	ø55 - ø228 mm 2.375" - 8.625"
322	ø141 - ø328 mm 5.563" - 12.750"

\*depending on the type of steel

ORBITAL CUTTING

# 122 - 172 - 222 - 322



## Technical features:

### - Fast speed motor:

120V or 230V, 1200W, electronic speed variator with cutting compensator  
*Vibration level according to EN 28662 norm : <math>< 2.5\text{m/s}^2</math>, protection class : IP 20*  
**Rotation speed (6 speed variations):** from 95 RPM to 280 RPM

### - Pneumatic motor:

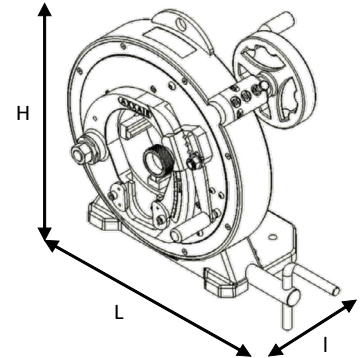
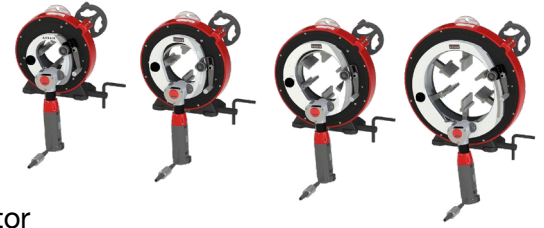
60 to 110 rpm, air flow rate 1500 l/min at 6 bar.

### - Robustness:

Very efficient clamping system thanks to a screw without end directly engaged on the clamping cam.

### - Easy maintenance and control:

Lubrication of the inner parts with the grease nipples



All motors are supplied in their own individual cases, including the necessary tools

	Product Code	Machine's jaw opening capacity in mm		Net weight	Dimensions (HxLxw in mm)
		With basic jaws	With extra jaws (included)		
120V 1200W fast motor	122FS19	Ø29 - Ø119	Ø5 - Ø99	44 kg	443 x 541 x 304
	172FS19	Ø74 - Ø173	Ø16 - Ø116	51 kg	493 x 566 x 304
	222FS19	Ø128 - Ø228	Ø55 - Ø155	59 kg	548 x 594 x 304
	322FS19	Ø230 - Ø328	Ø141 - Ø239	71 kg	649 x 644 x 304
230V 1200W fast motor	122FS29	Ø29 - Ø119	Ø5 - Ø99	44 kg	443 x 541 x 304
	172FS29	Ø74 - Ø173	Ø16 - Ø116	51 kg	493 x 566 x 304
	222FS29	Ø128 - Ø228	Ø55 - Ø155	59 kg	548 x 594 x 304
	322FS29	Ø230 - Ø328	Ø141 - Ø239	71 kg	649 x 644 x 304
Pneu- matic motor	122PD	Ø29 - Ø119	Ø5 - Ø99	44 kg	443 x 541 x 304
	172PD	Ø74 - Ø173	Ø16 - Ø116	51 kg	493 x 566 x 304
	222PD	Ø128 - Ø228	Ø55 - Ø155	59 kg	548 x 594 x 304
	322PD	Ø230 - Ø328	Ø141 - Ø239	71 kg	649 x 644 x 304

# Accessories

Our support legs and stands have been designed to further facilitate cutting by ensuring that the machine is stable in different conditions: in a workshop or on site.

The great advantages of these products:

- lightness
- flexible handling
- easy to use



Product Code	Description	Net Weight	Dimensions (in cm)
CCPS21	Support feet	10 kg	103 x 32 x 11
<u>Support legs for orbital cutting machine:</u>			
- quick assembling and dismantling		- storage box at the back	
- height adjustment with screws		- optimum stability	

81	✓121ECO	✓171ECO	✓122	✓172	✓222	✓322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in cm)
CCSER1	Simple stand	10 kg	60 x 26 x 10
<u>Simple stand for supporting tubes with height adjustment:</u>			
- quick assembling and dismantling			
- height adjustment			

✓81	✓121ECO	✓171ECO	✓122	✓172	✓222	✓322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in cm)
CCSER2	Stand (with chrome steel bearings)	11 kg	60 x 26 x 10
<u>Stand with chrome steel bearings for supporting tubes with height adjustment:</u>			
- easy assembling and dismantling		- facilitates tube feeding after each cut	
- height adjustment			

✓81	✓121ECO	✓171ECO	✓122	✓172	✓222	✓322	421	521	721	1100
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# Accessories

Our support benches help you to position and feed your tubes without the aid of stands. The height-adjustable table helps you easily and precisely set the height of your machine, for cutting tubes placed on the support bench.

The additional tube support bench allows you to position your longest tubes in a stable manner on all benches.

We also recommend that you support the cut section in front of your cutting machine using one or more additional benches, depending on the length of the tube.



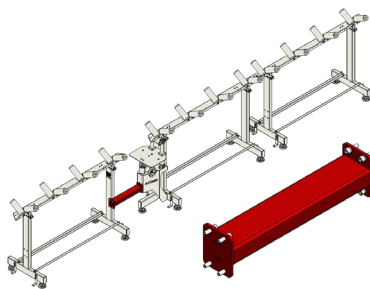
Product Code	Description	Net Weight	Dimensions (in cm)
CCBSB-X1	Bench with height adjustment	57 kg	184 x 95 x 51
<u>Height-adjustable support bench, 1.5m</u>			
- stainless steel rollers		- maximum load: 350 kg	
- handle for height adjustment		- ø min pipe: 5 mm	
- 1.5 m long		- ø max pipe: 321 mm	
- compatible with machines 121 to 321			

81	✓ 121ECO	✓ 171ECO	✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Product Code	Description	Net weight	Dimensions (in cm)
CCBSB-X2	Additional 1.5 m bench	38 kg	150 x 95 x 51
<u>Additional support bench:</u>			
- stainless steel rollers		- ø min pipe : 5 mm	
- 1.5 m long		- ø max pipe: 321 mm	
- maximum load 350 kg uniformly distributed		- compatible with machines 121 to 321	

81	✓ 121ECO	✓ 171ECO	✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in mm)
CCBSB-B005	Connection	3 kg	100 x 80 x 402
<u>Connecting bar for CCBSB-X1 and CCBSB- X2:</u>			
- Allows the height-adjustable table to be connected to a bench placed in front of the machine			

81	✓ 121ECO	✓ 171ECO	✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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# Accessories (End stop)

In addition to our CCBB-X1 and CCBB-X2 benches, we offer benches with an end stop system. These stops are very simple to use and avoid all measurement errors.

### No pollution of the tube:

All parts that are in contact with the tube are made of stainless steel (the rollers but also the stop finger)

### Retractable stop:

In order to facilitate the evacuation of the cut, the stop is manually retractable.



- Lengths available:  
1500 - 3000 - 4500 - 6000 - 7500 and 9000 mm
- Working stroke: Length - 200 mm
- Delivered by module of 1500mm to be put together
- Max load per module: 350 kg (evenly distributed)
- Max push on the stop: 10 kg
- Operating temperature: 0 - 50 ° C
- Relative humidity: 35 - 85%

They can be assembled on the **feed-in or feed-out** section of the cutting machine

They are available **with a ruler or with an LCD display.**

### Feed-in assembly



### Feed-out assembly



### LCD display

Possibility of selecting the direction of counting, the position of the decimal point, the unit of measurement (mm or inches), reset / preset of the measurement, absolute / relative dimension.

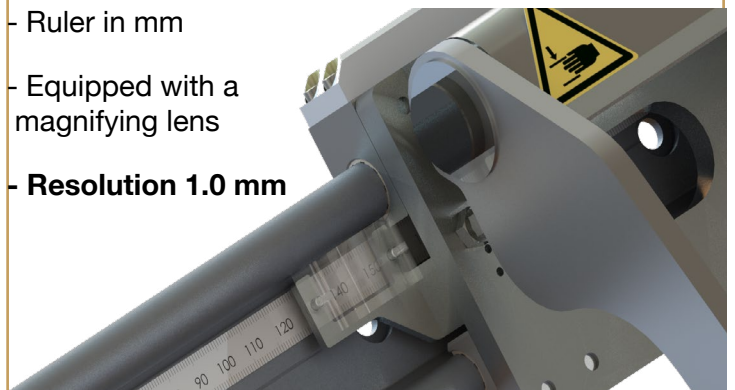
- Battery powered. Lifetime of about 4 years. The discharged battery icon appears when battery replacement is required. Replacement is easily done without loss of the value and configuration parameters.

- **Resolution 0.1 mm**



### Ruler

- Ruler in mm
- Equipped with a magnifying lens
- **Resolution 1.0 mm**



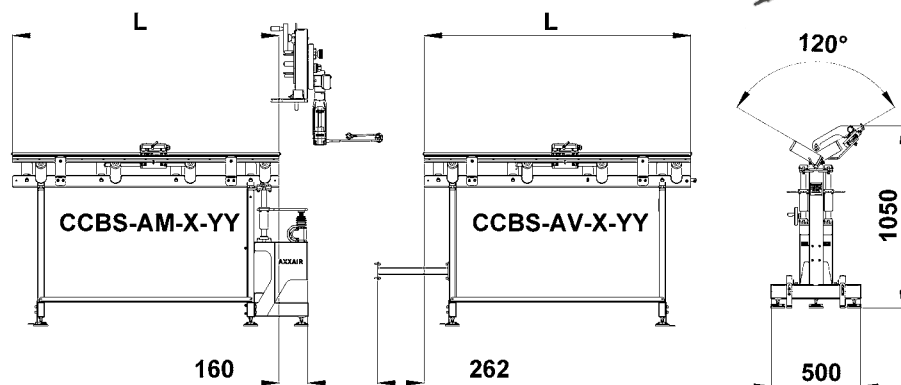
81	✓121ECO	✓171ECO	✓122	✓172	✓222	✓322	421	521	721	1100
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# Accessories (End stop)

## Feed-in assembly

The parts are delivered unassembled in transport boxes, per module of 1,5 m.

They must be assembled, aligned and fixed to the ground. The magnetic ruler (with LDC display) or the ruler must be glued at the end of the assembly.



The system is delivered with the height-adjustable support bench (CCBSB-X1), additional support benches, the starting end stop module and its extensions.

Assembly	Reader	Length (in mm)	Working stroke (in mm)	Product code	Net weight					
on the feed-in section of the cutting line	Ruler	1500	1300	CCBSB-AM-R-15	65 kg					
		3000	2800	CCBSB-AM-R-30	104 kg					
		4500	4300	CCBSB-AM-R-45	143 kg					
		6000	5800	CCBSB-AM-R-60	163 kg					
		7500	7300	CCBSB-AM-R-75	200 kg					
		9000	8800	CCBSB-AM-R-90	238 kg					
	LCD display	1500	1300	CCBSB-AM-D-15	65 kg					
		3000	2800	CCBSB-AM-D-30	104 kg					
		4500	4300	CCBSB-AM-D-45	143 kg					
		6000	5800	CCBSB-AM-D-60	163 kg					
		7500	7300	CCBSB-AM-D-75	200 kg					
		9000	8800	CCBSB-AM-D-90	238 kg					
81	✓121ECO	✓171ECO	✓122	✓172	✓222	✓322	421	521	721	1100

You can add CCBSB-X2 modules to support the tube after the cutting process (in front of the cutting machine) with the CCBSB-B005 connecting bar (see previous pages).

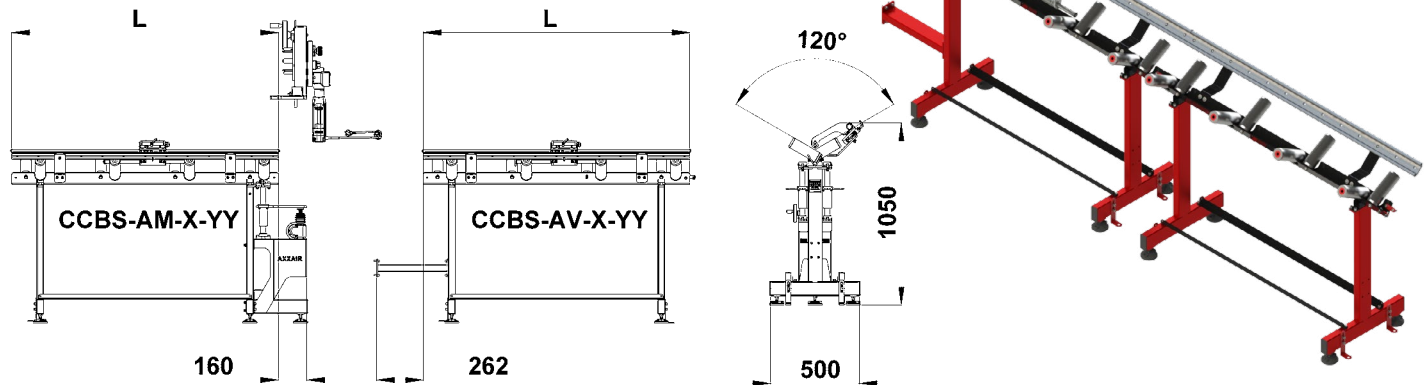


# Accessories (End stop)

## Feed-out assembly

The parts are delivered unassembled in transport boxes, per module of 1,5 m.

They must be assembled, aligned and fixed to the ground. The magnetic ruler (with LDC display) or the ruler must be glued at the end of the assembly.



The system comes with: CCBSB-X2 support bench modules, the starting end stop module and its extensions, the CCBSB-B005 connecting bar.

**Attention:** For all references with AV (bench with end stop on the feed-out section) we must also deliver at least one CCBSB-X1 bench (height-adjustable support bench) to support the cutting machine.

Assembly	Reader	Length (in mm)	Working stroke (in mm)	Product code	Net weight
on the feed-out section of the cutting line	Ruler	1500	1300	CCBSB-AV-R-15	46 kg
		3000	2800	CCBSB-AV-R-30	85 kg
		4500	4300	CCBSB-AV-R-45	124 kg
		6000	5800	CCBSB-AV-R-60	163 kg
		7500	7300	CCBSB-AV-R-75	201 kg
		9000	8800	CCBSB-AV-R-90	240 kg
	LCD display	1500	1300	CCBSB-AV-D-15	46 kg
		3000	2800	CCBSB-AV-D-30	85 kg
		4500	4300	CCBSB-AV-D-45	124 kg
		6000	5800	CCBSB-AV-D-60	163 kg
		7500	7300	CCBSB-AV-D-75	201 kg
		9000	8800	CCBSB-AV-D-90	240 kg

81	✓121ECO	✓171ECO	✓122	✓172	✓222	✓322	421	521	721	1100
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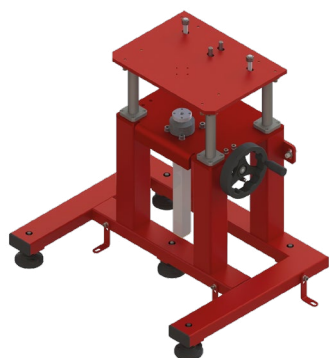
# Accessories

Our support benches help you to position and feed your tubes without the aid of stands. The height-adjustable table helps you easily and precisely set the height of your machine, for cutting tubes placed on the support bench.

The additional tube support bench allows you to position your longest tubes in a stable manner on all benches.

We also recommend that you support the cut section in front of your cutting machine using one or more additional benches, depending on the length of the tube.

These products are available on request



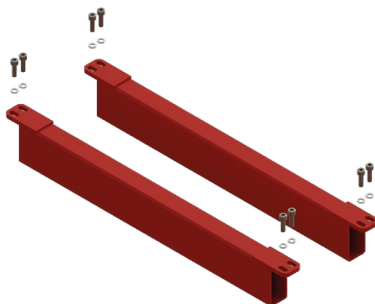
Product Code	Description	Net weight	Dimensions (in mm)
CCBSB2-003	Height-adjustable table	53.5 kg	75 x 73 x 54
<u>Height-adjustable table for 422 / 521 / 721:</u>			
- adjustable table height		- optimum stability	

81	121ECO	171ECO	122	172	222	322	✓ 421	✓ 521	✓ 721	1100
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Product Code	Description	Net Weight	Dimensions (in mm)
CCBSB2-004	Support bench	72.8 kg	97 x 71 x 150
<u>Tube support bench for 422 / 521 / 721:</u>			
- quick assembly and dismantling		- 1.5 m long	
- height adjustment		- optimum stability	

81	121ECO	171ECO	122	172	222	322	✓ 421	✓ 521	✓ 721	1100
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Product Code	Description	Poids net	Dimensions (en mm)
CCBSB2-005	Connecting bar	6.5 kg	8.5 x 4 x 65
<u>Connecting bar between two CCBSB2 support benches:</u>			
- quick assembly and dismantling		- ensures optimum stability	

81	121ECO	171ECO	122	172	222	322	✓ 421	✓ 521	✓ 721	1100
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## New autoline electric rotation:

Measures and displays the cutting/bevelling motor's power consumption

- enables the motor and cycle to be stopped in the event of overconsumption
- protects the motor and frees the operator from watching the machine
- detects whether the motor is straining and whether the blade is worn

**Welding mode with prefab machine and SAXX power source** : 4-button display (Start, Stop, Left, Right) with the addition of a power source connection cable

(Ref. SAEX-A02 for addition, more details in the "ORBITAL WELDING" section of this catalogue)

## **3.5 colour touch-screen allowing you to:**

- enter the diameter and precisely adjust the feed speed in mm/min
- aid adjustment with a suggested motor speed and feed speed based on the type of material and the blade used
- perform quick and easy configuration
- display the cutting/bevelling motor's consumption
- display in English, French or German
- choose the unit of measure: mm or inch

This rotation is compatible with our previous **121, 171, 221, 321, 421, 521 and 721** models.

The previous SAEP-00/000 rotation cannot be fitted to our new 122, 172, 222 and 322 models.



Product Code	Description	Net Weight	Dimensions (in mm)
SAEX-00	Autoline electric rotation	6.3 kg	320 x 261x 193
<u>Autoline electric inverter for CC122 to 322:</u>			
- 110 V to 230 V	- even rotation	- easy to use	- precise adjustment

81	121ECO	171ECO	✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in mm)
SAEX-000	Autoline electric rotation	6.3 kg	320 x 261x 193
<u>Autoline electric inverter for CC421 to 721:</u>			
- 110 V to 230 V	- even rotation	- easy to use	- precise adjustment

81	121ECO	171ECO	122	172	222	322	✓ 421	✓ 521	✓ 721	1100
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# Accessories (electric clamping)



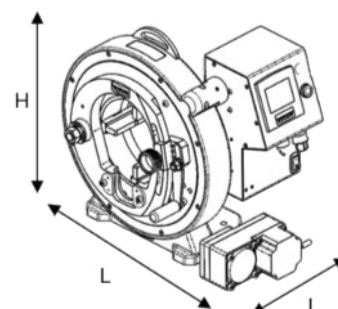
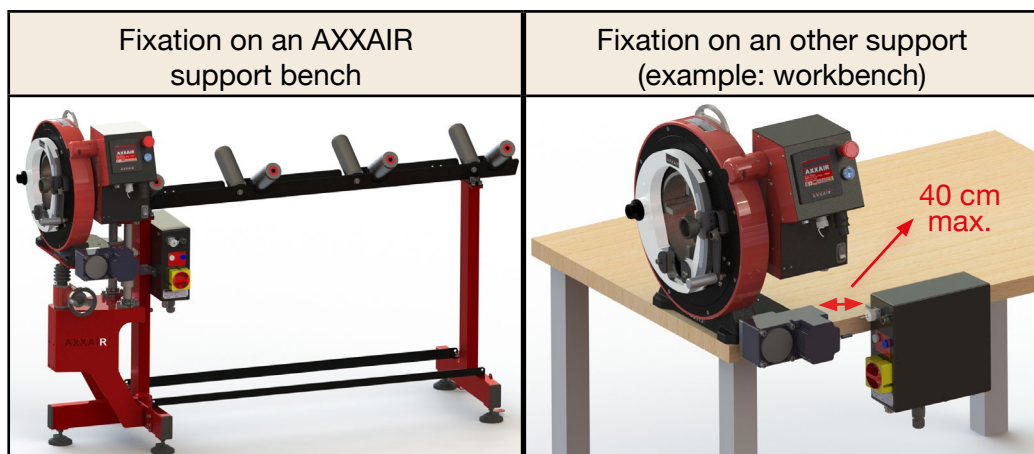
You realize **important series** in your company and want to be more effective during your projects? Our electric clamping is the ideal answer for the preparation and / or welding of your tubes.

The electric clamping makes it possible to carry out a **repetitive and constant force tightening** on tubes with identical diameters and thicknesses.

The **clamping force is adjustable**, it prevents the tubes from being deformed or marked.

### Technical specifications:

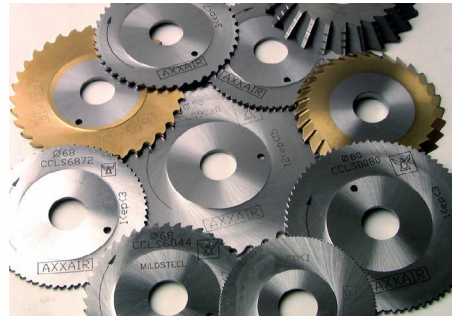
- 24Vdc brushless motor, motor torque: 34N.m
- Tightening force on the tube: 850 kg maximum, adjustable from 15 to 100%
- Clamping speed: 86 mm / min (diameter)
- The electric clamping is sold with the body frame and the automatic rotation



Product code	Body frame, automatic rotation and electric clamping		Net weight	Dimensions (HxLxI in mm)
	Machine's jaw opening capacity in mm			
	With basic jaws	With extra jaws (included)		
122-AU	Ø29 - Ø119	Ø5 - Ø99	51 kg	470 x 498 x 359
172-AU	Ø74 - Ø173	Ø16 - Ø116	58 kg	520 x 530 x 359
222-AU	Ø128 - Ø228	Ø55 - Ø155	66 kg	575 x 575 x 359
322-AU	Ø230 - Ø328	Ø141 - Ø239	80 kg	675 x 662 x 359

**Caution:** Remember to order one or more motors (cutting, beveling or welding torch) and the consumables needed with the sets listed above.

# Consumables



## Orbital cutting blades

High quality blades (HSS + Cobalt) sold in boxes of 5:

- The tooth pitch & design are essential for chip evacuation, in order to achieve a high quality cut. AXXAIR has produced the most efficient blade design possible for various cutting applications.
- Often preferred to our competitors' blades, AXXAIR blades are compatible with the majority of other orbital cutting machines.

Product Code	Cutting tubes with wall thickness of		ø of the blade	Number of teeth
LS63128	0,5 to 0,9 mm	,02 - ,04"	63 mm	128
LS63100	0,7 to 1,5 mm	,03 - ,06"	63 mm	100
LS6364	1 to 3 mm	,04 - ,12"	63 mm	64
LS6872	1 to 3 mm	,04 - ,12"	68 mm	72
LS6844	2 to 7mm	,08- ,28"	68 mm	44
LS8080	1 to 3 mm	,04 - ,12"	80 mm	80
LS8054	2 to 7 mm	,08- ,28"	80 mm	54

✓ 81   ✓ 121ECO   ✓ 171ECO   ✓ 122   ✓ 172   ✓ 222   ✓ 322   ✓ 422   ✓ 521   ✓ 721   ✓ 1100



Product Code	Description	Volume
CCLUH	Liquid lubricant	250 ml

High performance oil lubricant, sold in packs of 5:

- Recommended for all FS cutting motors
- Safety data sheet available on request

81   121ECO   171ECO   ✓ 122   ✓ 172   ✓ 222   ✓ 322   ✓ 422   ✓ 521   ✓ 721   ✓ 1100



Product Code	Description	Volume
CCLUP	Paste lubricant	250 ml

Paste lubricant, sold in packs of 5 lubricants-tubes:

- Recommended for metabo motors
- Safety data sheet available on request

✓ 81   ✓ 121ECO   ✓ 171ECO   122   172   222   322   422   521   721   1100

# GLOBAL PROCESS

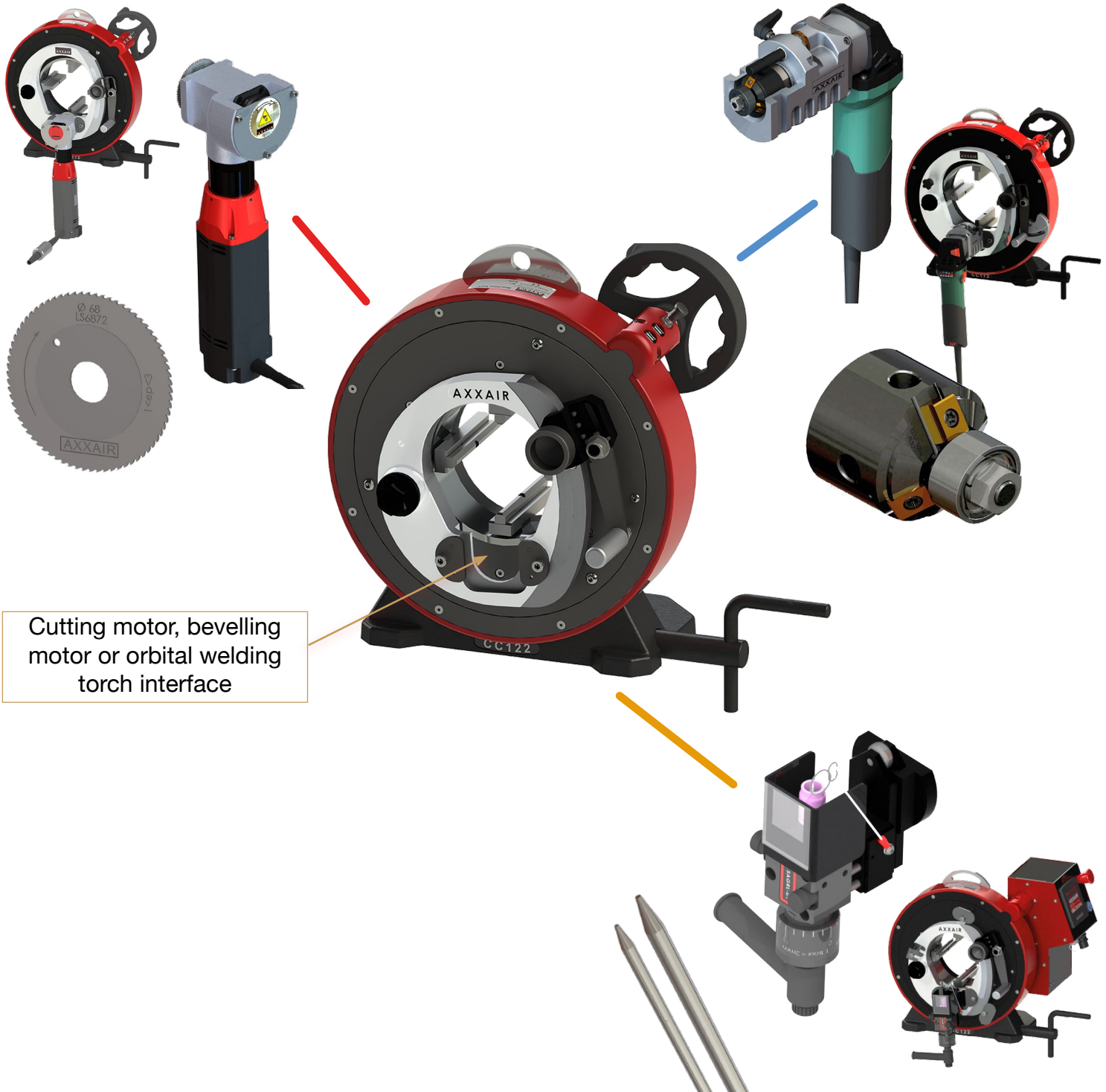
## 1 machine - 3 applications

The AXXAIR Group was the first to offer a triple and exclusive solution, from preparation to orbital welding:

**the global process**

For more than 20 years, a single machine frame (122, 172, 222 and 322) has enabled three operations to be carried out:

Cutting, bevelling and orbital welding



Cutting motor, bevelling motor or orbital welding torch interface

# GLOBAL PROCESS

## A machine - 3 applications



Product Code	Description	Net weight
FS xx / MOPD	Cutting motor	5 kg
Low-speed / high-speed / pneumatic motor with dual output (uptake):		
120V	Product Code	Frame
	Low-speed motor: FS15	122
230V	High-speed motor: FS19	172
	Low-speed motor: FS25	222
Pneumatic	High-speed motor: FS29	322
	MOPD	322

To use this motor you will need to order: suitable cutting blades for the tube thickness you want to cut and, if necessary, lubricant.

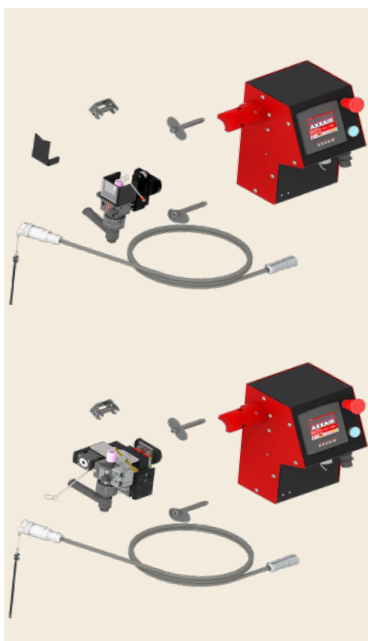
All information and relevant product codes appear in the orbital cutting accessories and consumables section of this catalogue.



Product Code	Description	Net Weight			
GA10 - x - xx	Beveling motor kit	5 kg			
120V / 230V beveling motor supplied with a chip shield and a workpiece guide tailored to the frame of your cutting / prefab welding machine:					
120V	Product Code	Frame	230V	Product Code	Frame
	GA10-M1-122	122		GA10-M2-122	122
	GA10-M1-172	172		GA10-M2-172	172
	GA10-M1-222	222		GA10-M2-222	222
	GA10-M1-322	322		GA10-M2-322	322

To use this motor and bevel your tubes you will need to order: one or more milling heads and carbide inserts.

All information and relevant product codes appear in the orbital beveling accessories and consumables section of this catalogue.



Product Code	Description	Net Weight
SX - KIT x	Torch kit	depending on the chosen product
KIT for upgrading a CC/GA to an SX Air / Water / AVC+OSC torch		
Cooling	Product Code	Frame
AIR	SX-2KITA	122
EAU	SX-2KITE	172
	SX-2KITNAOF (AVC/OSC)	222
		322
If you have acquired the electrical clamping (xx2-AU), please order the references below, they are delivered without automatic rotation:		
AIR	SX-3KITA	122
EAU	SX-3KITE	172
	SX-3KITNAOF (AVC/OSC)	222
		322

To use this KIT and to prefab weld, you will need to order: a suitable AXXAIR welding power supply for the tubes you want to weld.

All information and relevant product codes appear in the orbital welding section of this catalogue.



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