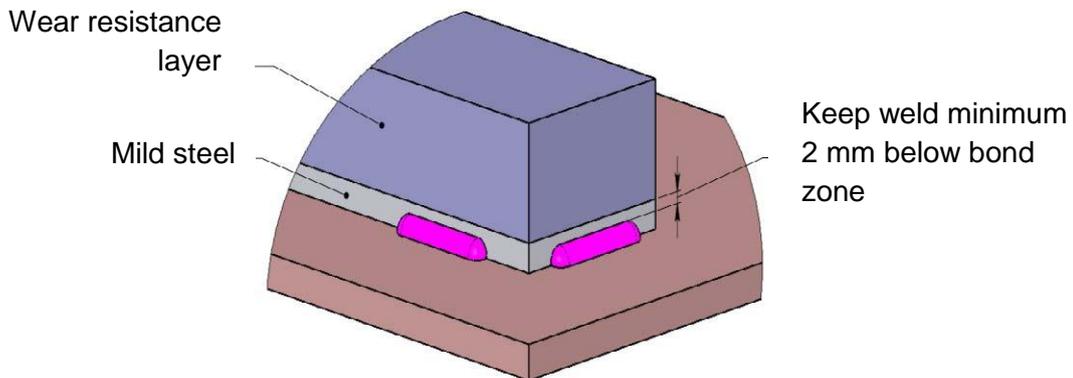


WELDING PROCEDURES



RECOMMENDED WELDING PROCEDURES READ ALL PROCEDURES COMPLETELY!

Wear Solutions International recommends you always use a soft face hammer and ANSI-approved (Z87.1) eye protection during cutting and bending procedures.

1. ensure that the surface to which the WEAR part will be attached to, is as flat as possible and the area to be welded is clean; clamp and tack weld WEAR part into position;
2. stitch weld, laying 50 mm max length on each run, alternating ends or sides to minimize heat input. Do not deposit weld within 2 mm from the joint line between WEAR part;
3. **DO NOT WELD CONTINUOUSLY**- continuous welding may cause warpage, layers delamination and cracking. Use thermal crayons to check temperature, maximum allowed 200°C;
4. If a complete peripheral weld is required, use stitch weld method as per step 3;

5. WELDING RODS **WE RECOMMEND LOW HYDROGEN WELD RODS OR GAS COVERED CORE WIRE**

Gas shielded solid MIG wire	- 1,2 mm dia. max
Flux cored wire	- 1,6 mm dia. max to ASTM/AWS A5.18 classification ER705-6
Low hydrogen electrode	- 3,25 mm dia. max to ASTM/AWS A5.1 classification E7016-1H8 or E7018-1H4

WELDING PROCEDURE OVERVIEW

- 
- 1 READ PROCEDURES COMPLETELY
 - 2 TACK WELD INTO POSITION
 - 3 STITCH WELD WITH (50 mm) MAX. LENGTH ON EACH RUN
 - 4 MAINTAIN 2 mm GAP BETWEEN WELD AND JOINT LINE