

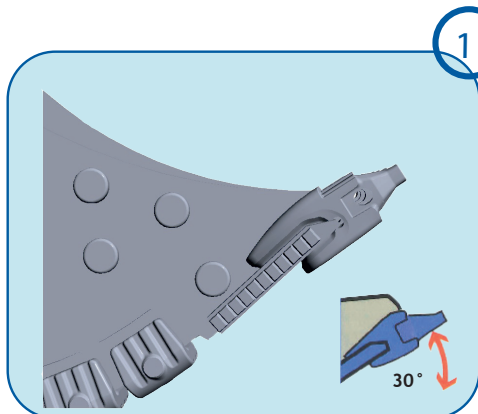
Welding Instructions Central adaptor on straight or semi-delta blade

Welding Instructions

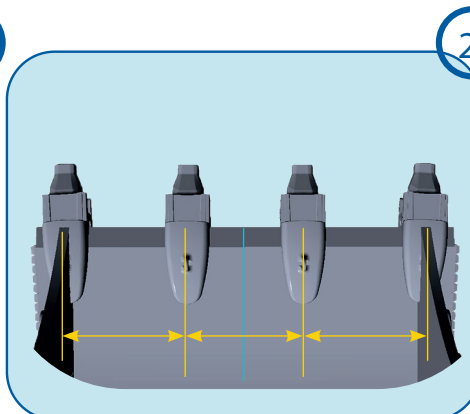
The welding will be carried out using basic electrodes: AWS E 7016 or 7018, DIN 1913 E 51 43B10 or E 51 54B 102G.

1. Instal adapter on up plate.

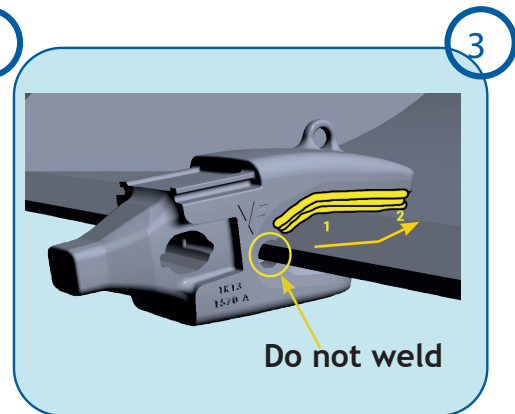
2. Preheat at 95°C for plate thickness lower than 40 mm (1.3/4 In) with surrounding temperature over 5°C. With surrounding temperature below 5°C or plate thickness over 40 mm preheat at 185°C.
Tack weld adapter to lip plate.



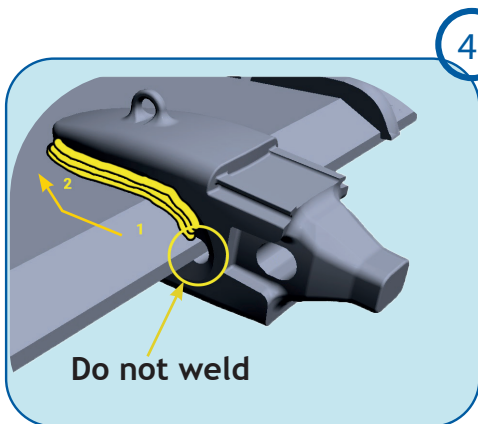
Preparation: Tilt the bucket 30° upwards.



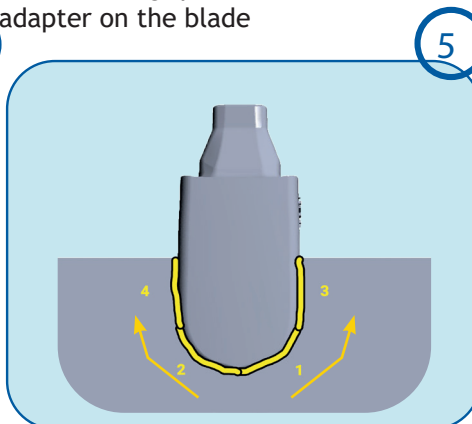
Installation: Position the adapters on the blade according to the pre-established blade plane, and make 1 or 2 tacks welding spots to tack weld the adapter on the blade



Welding (Step 1): Weld following the order indicated in the figure. Make several passes in order to have a homogeneous weld



Welding (Step 2): Weld in the same way on the opposite side. Make several passes in order to have a homogeneous weld.



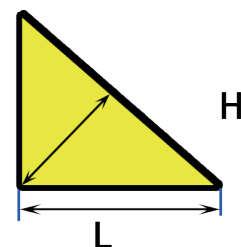
Welding (Step 3): Weld at half leg length (1) turn around back of leg and stop weld bead at middle of opposite side (2). Start next bead at half length of lip bevel (3)(never weld around leading edge) and drive welding until weld deposit contact first bead at 1. Make several passes in order to have a homogeneous weld.

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Renew the operation by following this method until welding cords are obtained to the following dimensions

TAILLE	LARGEUR L (mm)	HAUTEUR H (mm)
M - 1 - 2	10	7
3 - 4	11	8
5	13	10
7	14	12
9	20	15
10	22	15
11	25	16
13	26	28
15	30	32
17	32	36
19	39	41

Dimensions
of external
welding cords



Smooth grind weld ends at leap to avoid stress concentration