

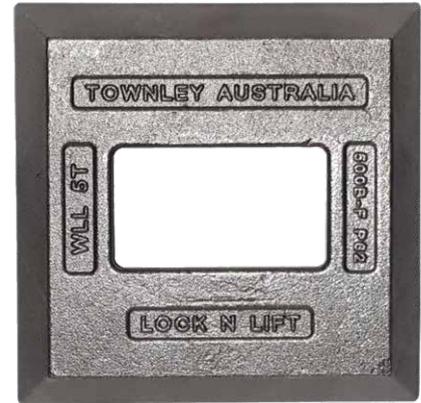
Lock-N-Lift Road Plate Lifter

Welding Instructions

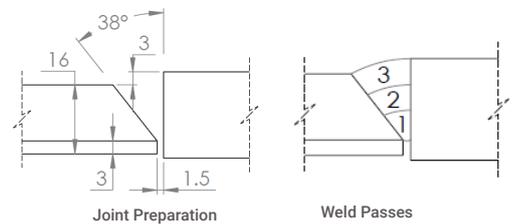
Important: Welding shall be in accordance with AS1554.1: 2014 SP / 1554.5: 2014 or Equivalent. Welding performed to an approved WPS by a qualified welding Operator.

Preparation

- Prepare material by thermal cutting and grinding.
- Remove scale and other contaminants from weld area by grinding.
- Align joint and tack components.
- Feather tack ends and incorporate in the main weld.



Code:	AS 1554.1 (2014) SP, or 1554.5 (2014) or equivalent.
Material:	AS 3678 Grade 300 / 350, Steel Type 1 to AS1442
Joint Type:	Single Bevel Butt Weld (Partial pen, multi run)
Welding Position:	Flat 1G



F.C.A.W – Typical Settings			
Consumable:	AS/NZS ISO 17632 B-T 49 3 T1-1 M A U H10 or equivalent. NB. Refer to consumable manufacturer for user instructions and information.		
Shielding Gas:	Argon + 16 - 18% CO2	Consumable Size:	1.2mm
Gas Flow Rate:	15 to 18.7 l/Min	Current Type:	DC Electrode +
Electrical Stick-out:	15 mm	Preheat:	50°C. minimum
Preheat Method:	Oxy-acetylene	Preheat Measurement:	Contact Thermometer
Amperage:	160 – 280	Volts:	24 – 30

G.M.A.W – Typical Settings			
Consumable:	AS/NZS 14341 B-G 49A 3U C S6, B-G 49A 3U M S6 or equivalent. NB. Refer to consumable manufacturer for user instructions and information.		
Shielding Gas:	Argon + 16 - 18% CO2	Consumable Size:	1.2mm
Gas Flow Rate:	15 - 18 l/Min.	Current Type:	DC Electrode +
Electrical Stick-out:	15 mm	Preheat:	50°C. minimum
Preheat Method:	Oxy-acetylene	Preheat Measurement:	Contact Thermometer
Amperage:	120 – 320	Volts:	18 - 32

M.M.A.W – Typical Settings			
Consumable:	AS/NZS 4855-B - E49 16-A U H10 or equivalent. NB. Refer to consumable manufacturer for user instructions and information.		
Consumable Size:	3.2 mm / 4.0mm	Current Type:	AC / DC Electrode +
Preheat:	50°C. minimum	Preheat Measurement:	Contact Thermometer
Amperage:	3.2mm = 90 – 135	Amperage:	4.0mm = 140 - 190

Qualification Method: Non Destructive Examination:	Qualify in accordance with AS1554.1 SP / AS 1554.5 requirements. <ul style="list-style-type: none"> • 100% visual scanning and examination. • N.D.T. method and percentage, as agreed with client.
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