


Technical Bulletin

Weld Repair Procedures for Model 30E Carton Clamp Arms

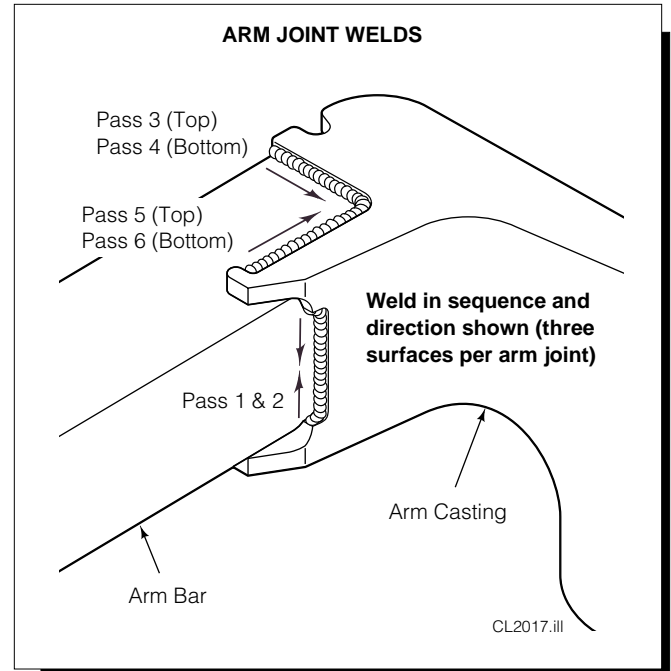
This sheet describes approved welding procedures to repair cracked or questionable welds on Model 30E Carton Clamp arm bars.

Weld repairs may be accomplished with the arms remaining on the attachment. Vertical and overhead welding may be required. The procedure includes a special repair technique (shown in the Steps below) to properly preheat and temper the affected areas. The procedure must be followed exactly as described.



WARNING: Cascade requires that a qualified or certified welder experienced in this type of repair be used for best quality.

IMPORTANT: Prior to welding, shield all hoses, contact pads and bearing tracks from weld spatter. Welding access is best with the arms fully open.

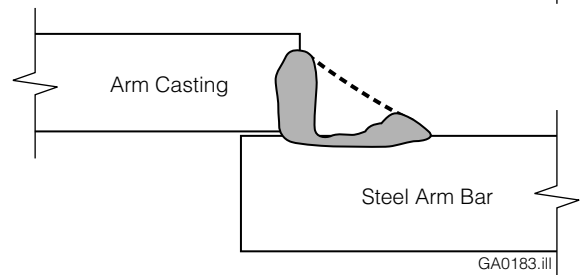
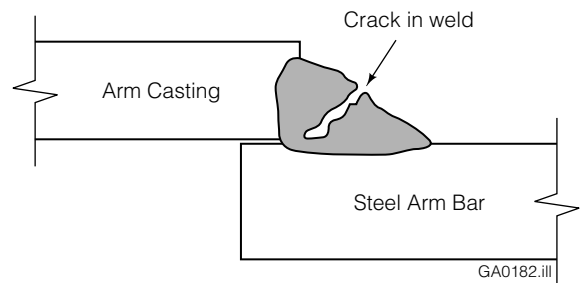


Weld Prep

1 Inspect the four arm joints for proper weld size and any visual cracks (Reference: Cascade Technical Bulletin TB257). Remove grease and paint on the surface at least 2 in. (5 cm) on either side of the affected fillet area.

2 Undersized weld – If the existing weld is not cracked but undersize, proceed to Step 4.

Cracked weld fillet/base metal – Remove all of the crack or damage fillet weld deposit by machining or grinding. Visually inspect the ground-out area. No cracks are allowed in the remaining fillet or base metal. Blanket the arm bar and arm casting (K-WOOL or equivalent) to slow the cooling rate when welding is started.



NOTE: This information should not be interpreted as the basis for warranty claims unless so designated.

cascade®
corporation

For Technical Support . . .

Call: 1-800-CASCADE (227-2233)

OR

Write: Cascade Corporation, PO Box 20187, Portland, OR 97294-0187

To Order Parts . . .

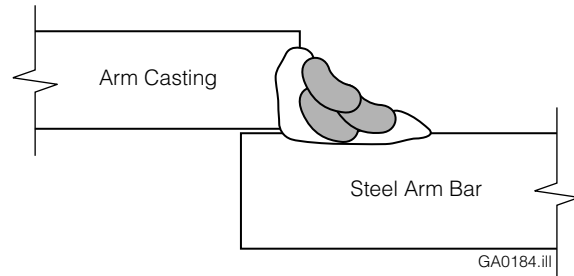
Call: 1-888-CASCADE (227-2233)

OR

Write: Cascade Corporation, 2501 Sheridan Ave., Springfield, OH 45505

Weld Procedure

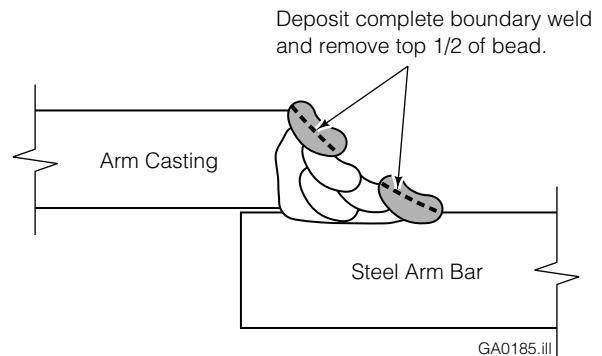
3 Use SMAW E8018-C3H4R rod, 3/32 in. diameter preferred, 1/8-in. diameter max. (Example: ESAB Part No. 255041816) and deposit a root and hot pass or passes to fill the crack area.



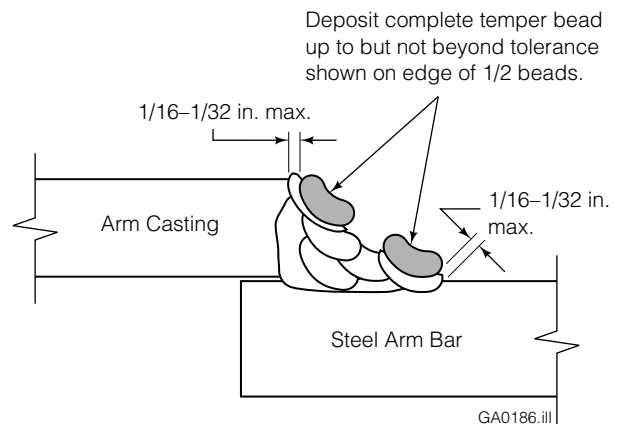
4 Use SMAW E8018-C3H4R rod, 3/32 in. diameter preferred, 1/8-in. diameter max. (Example: ESAB Part No. 255041816) and deposit two outside boundary beads as shown.

Remove the top 1/2 of each bead. **Do not remove the fusion line.**

Assure that there is a small segment of each boundary bead visible around the perimeter. **No weld beads must extend beyond these boundary beads.**



5 Apply the temper beads as shown to soften the heat-affected zone (HAZ) created by the 1/2-beads. The temper beads should extend to within 1/32 to 1/16 in. of the 1/2-beads previously deposited.



6 Make a final fillet fill if required as shown. Contour the overall weld and verify that the fillet is **13/32 in. (10 mm)** minimum on each fillet leg. Allow unit to cool.

