

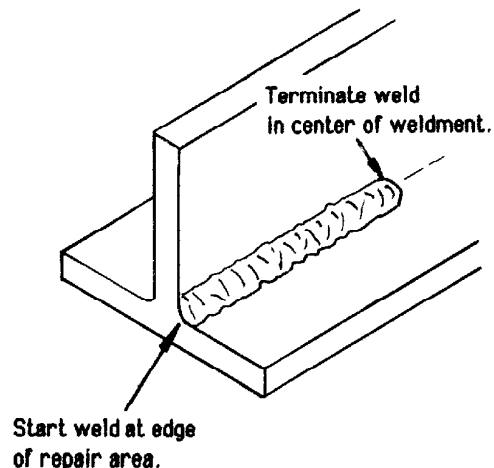


Technical Bulletin

Field Repair of L7-P7 Push/Pull Primary and Secondary Arms

The following procedure is recommended for field repair.

1. Remove all paint, grease and contaminants from weld defect area.
2. Magnaflux or use dye penetrant and developer to determine extent of crack.
3. Remove weld defect by grinding.
4. Magnaflux or use dye penetrant and developer to determine if the entire crack has been removed.
5. Preheat the area to 350° , monitor the temperature 2 inches from the area to be welded with a 350° temperature stick.
6. Use a DC reverse polarity welding machine. Set the welding machine to DC reverse polarity.
7. Use 5/32" diameter E8018 LH (low hydrogen) **dry** electrodes.
8. Set the welder at 150 min.- 175 max. amperage. **NOTE:** Do not weld in a drafty area.
9. Holding a close arc (do not oscillate or use a weave pattern), start the weld at the edge of the gusset or repair area as illustrated. Always terminate the weld in the center of the weldment to eliminate arc craters and stress cracks.
10. Inspect the weld for defects. Magnaflux or use dye penetrant and developer if in doubt. Repeat steps 3-9 as required.
11. Cover the weld area with an insulating blanket to slow cool.



Part Number 675547

(over)

cascade[®] corporation

For Technical Assistance . . .

Call: 1-800-CASCADE or 503-666-1518

OR

Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97220

To Order Parts . . .

Call: 513-322-1199

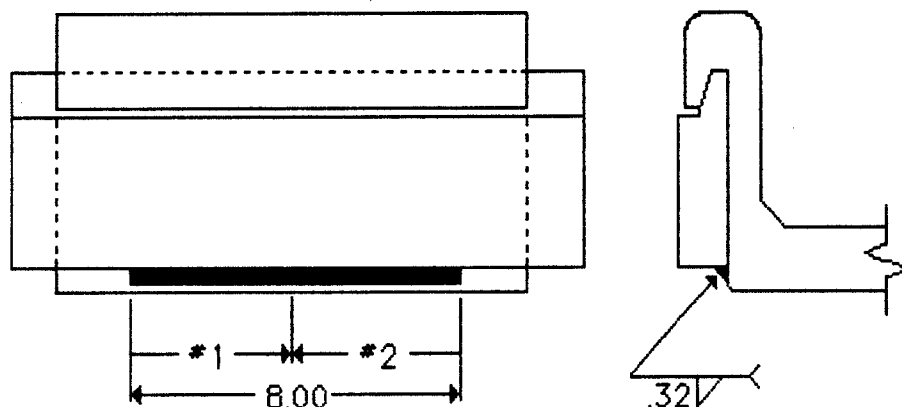
OR

Write: Cascade Corporation, P.O. Box 360 Springfield, OH 45505

Weld Procedure for L7-P7 Push/Pull Platen Retainment

The following procedure is recommended for platen retainment.

1. Remove all paint, grease and contaminants from weld area.
2. Use 5/32" diameter E11018 LH (low hydrogen) **dry** electrodes.
3. Use a DC reverse polarity welding machine. Set the welding machine to DC reverse polarity.
4. Set the welder at 150 min.- 175 max. amperage. **NOTE:** Do not weld in a drafty area.
5. Tack weld the platens in place.
6. Preheat the area to 400°. Monitor the temperature with a 400° temperature stick.
7. Holding a close arc (do not oscillate or use a weave pattern), weld in the sequence and directions as shown below.
8. Inspect the weld for defects. Arc craters, undercut, porosity and overlap are not allowed.
9. Cover the weld area with an insulating blanket to slow cool.



Weld #1 and #2 weld beads from outside to center of platen.