

Welding instruction

General:

- All track components are made from special carbon manganese steel alloyed with boron.
- It is important that the material being welded is clean and dry. It is extremely important that only **new and dry** electrodes be used.
- The overall temperature of the tracks must be at least 18° C (65° F) prior to welding. Recommended pre-heating temperature is 150-200° C (300 - 390° F) to a maximum of 250° C (480° F).

Recommended Welding Materials:

Manual Welding Electrode (Stick Welding)

OK 48.30, OK 48.00, OK 74.78 or equivalent

MAG Welding (Gas Metal Arc Welding)

OK Autorod 12.51, OK Autorod 12.50, OK Autorod 13.13

Argon gas with 16% CO₂ or 23% CO₂ is recommended as protection gas.

Note: Maximum electrode size is 3.25 mm (1/8")

Welding Cleats:

- Never weld cleats on the centre section of the cross-member. See fig. 1 below.
- All welding passes are to be parallel with the cross-member.
- Position cleats and tack weld in place. (Never welding cleats on the centre section of the cross-member). Weld 10-15 cleats in place on the opposite side of the tack weld. This will prevent a localized over-heating of the cross-member material, at this point return to the previous 10-15 cleats and complete the welding on the opposite side of the cleat.
- Consult your local dealer for the correct replacement cleat. It is highly recommended to use the replacement cleats because they are made of the same material as the cross members. Fillet welds are to be a maximum of 3/16".

