

Weld-on Pivoting Link Welding Guidelines

1. Select the correct size weld-on pivoting link to be used. Be sure to calculate the maximum load that will be applied to the weld-on pivoting link.
2. Place the weld-on pivoting link onto the mounting surface. The bottom of the link base must be parallel and even with the mounting surface.
3. Welding is to be performed by a qualified welder using a qualified procedure in accordance with American Welding Society and/or American Society of Mechanical Engineers requirements. Always follow your country or local mandatory regulations or codes.
4. The following welding recommendations should be included in the qualified procedure for welding to low or medium carbon plate steel. For welding to other grades of steel, a qualified weld procedure must be developed.
 - A. Saddle material is equivalent to SAE/AISI 1024, EN S355J2, or DIN 1.0570.
 - B. Weld material is to have a minimum tensile strength of 70,000 PSI (such as AWS A5.1 E-7018). Observe the electrode manufacturer's recommendations. Completely fill internal fillet created between weld-on pivoting link base and mounting surface.
 - C. Before welding, all weld surfaces must be clean and free from rust, grease, paint, slag and any other contaminants.
- D. Fillet weld leg size should be minimum shown in Table 1. Weld profiles to be in accordance with AWS. Weld size is measured by length of leg.
- E. Welding should be carried out in a minimum of two passes to ensure adequate root penetration at the base of the pivoting link.
- F. Weld full length of "D" dimension on both sides of link base (Figure 5).
- G. Do not weld close to the bail. After welding, ensure bail pivots full 180° without interfering with the weld.
- H. Do not rapidly cool the weld.
- I. The ends of the weld must be ground sufficiently so that the weld-on pivoting link will fit flush against the mounting surface.
- J. A thorough inspection of the weld should be performed. No cracks, pitting, inclusions, notches or undercuts are allowed. If doubt exists, use a suitable NDE method, such as magnetic particle or liquid penetrant to verify.
- K. If repair is required, grind out the defect and re-weld using the original qualified procedure.

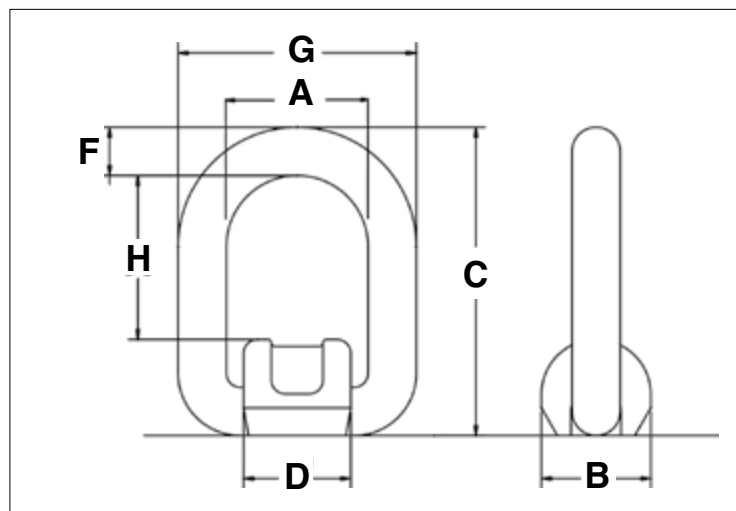


Figure 5

Table 1
S-265 Weld-on Pivoting Links*

Stock Number	Working Load Limit (t)		Dimensions (in)							Minimum Fillet Weld Size	Weight Each (lb)
	Design Factor 5:1	Design Factor 4:1	A	B	C	D	F	G	H		
1290839	1	1.2	1.57	1.42	3.27	1.38	0.51	2.60	1.65	3/32	.88
1290848	2.5	3.2	1.77	1.73	3.90	1.65	0.71	3.19	1.89	3/32	1.32
1290857	4	5.3	2.17	1.97	4.84	1.93	0.87	3.90	2.24	1/4	2.65
1290866	6.4	8	2.76	2.52	5.67	2.52	1.02	4.80	2.64	1/4	5.29
1290875	12	15	3.82	3.54	7.60	3.39	1.34	6.50	3.70	5/16	13.01

* Designed to be used with ferrous workpiece only.