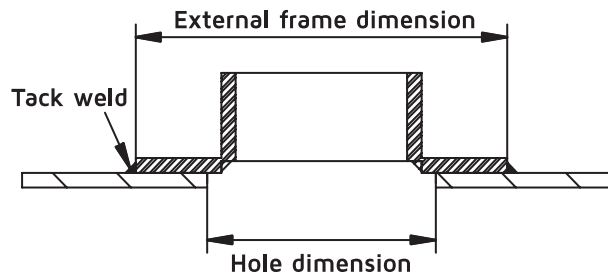
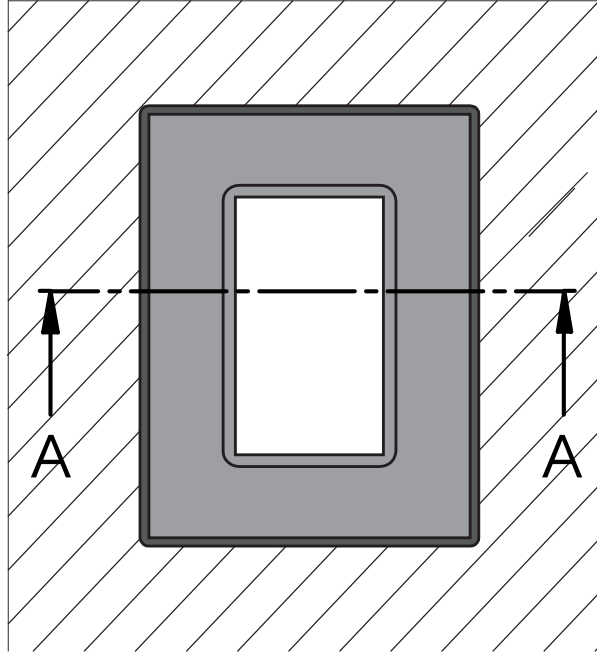


HMFx WELDING INSTRUCTIONS

1. Tack weld on the front side, centring the frame onto the cut-out hole.
Same as step 2 of standard welding instructions (see page...150).



Minimum hole dimension	=	(external HMFx dimensions)	less 110mm
Maximum hole dimension	=	(external HMFx dimensions)	less 10mm

2. Grind off weld tacks before start filled weld. Weld runs should not start or stop at a tack weld but should run over a tack.

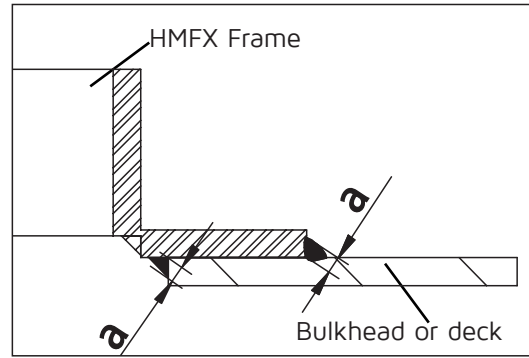
Follow same welding sequence for correct procedure.

The interpass temperature should not exceed 200°C for mild steel and aluminium and 150°C for stainless steel.

This welding throat should not exceed following values:

T > 7mm a=5mm
 T ≤ 7mm a=4mm

♦ Máx run lenght: { Mild Steel 200 mm
 Stainless Steel 150 mm
 Aluminium 200 mm



$$\text{Heat Input (KJ/mm)} = \frac{V \cdot I \cdot \eta}{\text{vel} \cdot 1000} \quad \eta = \begin{cases} 1 & \text{SMAW} \\ 0,8 & \text{GMAW / FCAW} \\ 0,6 & \text{GTAW} \end{cases}$$

V = volts / I = amperes / vel = mm/s

	Máx. Heat Input (KJ/mm)		
	Mild Steel	Stainless Steel	Aluminium
a = 4 mm	1,2	1,1	2
a = 5 mm	1,4	1,1	2