

TECHNICAL
BRIEF

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PROCEDURE FOR WELD REPAIRS

1. Welding method for repairs. Material: A-36 Plate
 - A. 7018 low hydrogen electrode (stick welding) good tolerance for contamination.
 - B. **Note:** MIG wire machine welders not recommended for it has no tolerance for contamination that may be present in a field repair situation.
 - C. All vertical welding shall be done from the bottom up, never from the top down.
2. Repair of cracked welds.
 - A. Remove old welds by grinding or gouging (flame cutting).
 - B. Minimize removal of the base metal.
 - C. Size of the weld to be equal to the thinner thickness of the metal parts that are to be joined.
3. Repair of a crack in the base metal.
 - A. Grind a "V" groove into the cracked area to provide good weld penetration. Groove should be at least 2/3 depth of thickness of metal.
4. Cleaning of areas to be welded.
 - A. All surfaces to be welded must be clean and free of any flame cutting slag.
 - B. Remove as much oxidation as possible if present.