



MFG. & ENG., INC.

1110 Fullerton Road

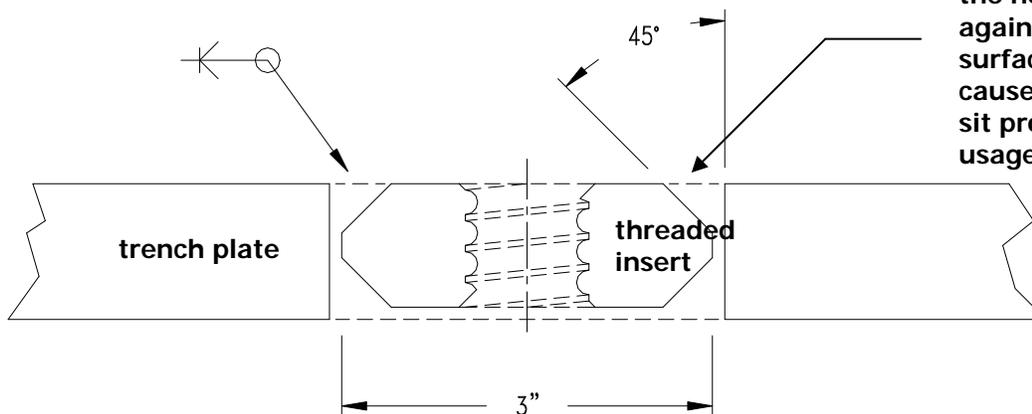
City of Industry, CA 91748

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WELDING INSTRUCTION

- Nut plate should have 1/8" clearance to trench plate.
- It is allowed to replace an old nut if all previous weld metal is removed.
- Use jig to make sure threaded plate is flush and square with top surface of trench plate.
- Preheat plate to 450°-700°F.
- Weld using Lincoln Jet Weld #ED010558 LH 70 - E7018 or 7024 - 3/16 dia. rod or equivalent
- Back-gouge root to sound metal.
- Weld second side.
- Grind weld on top surface flush.
- Allow slow cooling.

***NOTE:** After the nut has been welded to the plate, surfaces of the weld must be ground to the same surface level as the trench plate. This procedure allows the hoist ring to sit flush against the trench plate surface. Not doing so will cause the hoist ring not to sit properly and will lead to usage failure.



Material

- Threaded insert plate made from AISI 4130 steel, quench and tempered to Hardness Rockwell C 28-34.
- Insert plate shall have minimum 1" thickness.
- Shape can be square or round, 3" diameter.