



GROUSER BAR PRODUCT WELDING PROCEDURE

SHARK™ GROUND ENGAGING TOOLS

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1.0 SPURSLIPINTRODUCTION:

This document establishes the basic procedural requirements for the weldment of the Grouser Bar (refer to MD0037) segments to a bucket sidewall.

Applicable parts:-

- Grouser Bar.

2.0 PREHEAT AND INTERPASS TEMPERATURES:

Material	Target Pre-heat Temperature °C	Max Inter-pass temperature °C
Grouser bar (steel plate)	As per the manufacturer's recommendation	As per the manufacturer's recommendation
Lip plates/ Bucket (ASTM A514 Steels)	As per the manufacturer's recommendation	As per the manufacturer's recommendation

Table 1 Preheat, Inter pass temperatures

Refer to Weld Procedure PWP0001 for more details.

3.0 WELDING PROCEDURE:

The following information is a recommendation on the application of the side wall corner guard:

For Post-heat Treatment and welding consumables, please refer to:

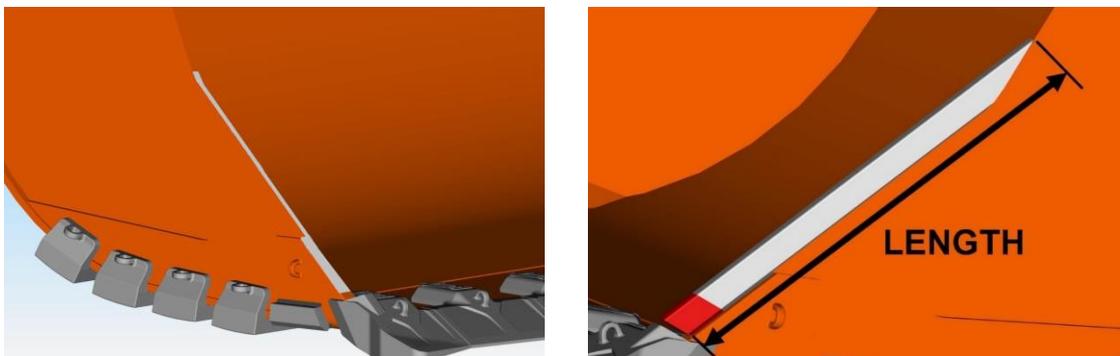
PWP0001 – General Weld procedure

For further technical detailed information please refer to:

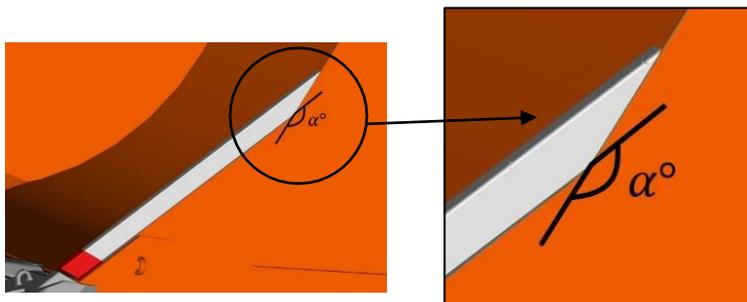
MD0037 – Recommended Sidewall Corner Guard Installation Details.

4.0 REMOVAL OF GROUSER BAR:

Step 1 : Cut the Grouser Bar to length and angle to fit bucket:

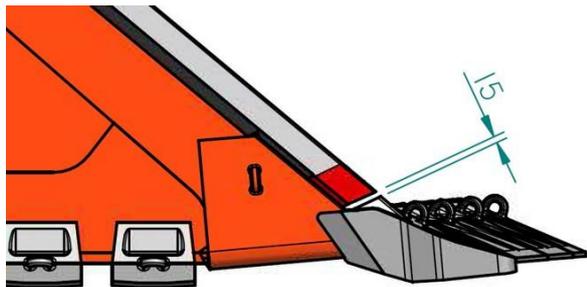


Step 2 : Ensuring that 15mm is allocated between the corner shroud and the grouser bar (explained in step #3). Cut Grouser Bar to suit bucket sidewall length as determined from the bottom side wall and the angle α° (explained in step #2).



Note: α° angle is determined by the angle between the bottom sidewall and the top of the side wall of the specific bucket having the grouser bar fitted.

Step 3 : Note: A 15mm gap between the grouser bar and the corner shroud is required to enable ease of access to change the corner shroud.



Note: If sidewall is straight and has no angle shown in the diagrams, cut the grouser bar to approximately 730mm and chamfer the top edge (other end from the corner shroud), to blend in with the existing bucket wall.

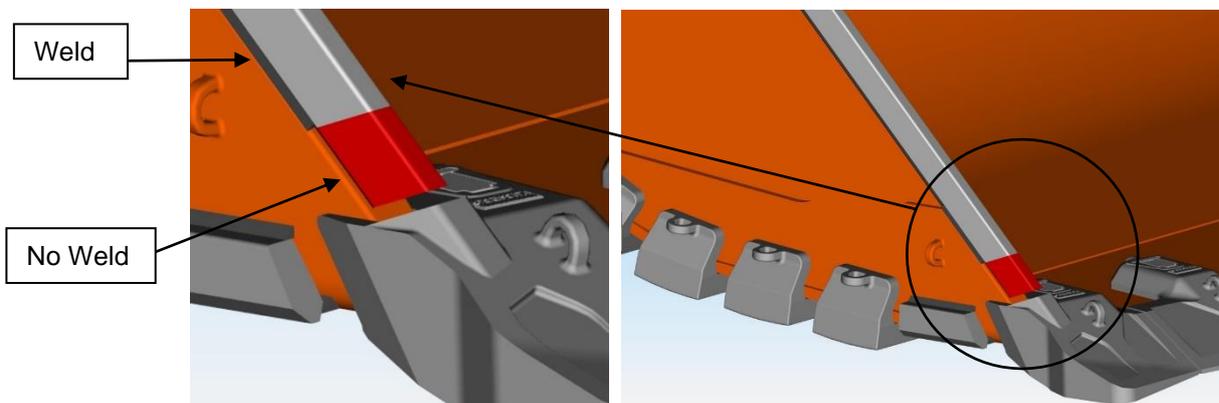
5.0 WELDING PREPARATION:

Preheat area in accordance with the requirements of Section **Error! Reference source not found.** measuring the temperature at least 75mm (3”) either side of the weld joint or the area being gouged. This is to reduce internal stress within the bucket wall.

Refer to Weld Procedure PWP0001 for more details.

6.0 WELDING REQUIREMENTS:

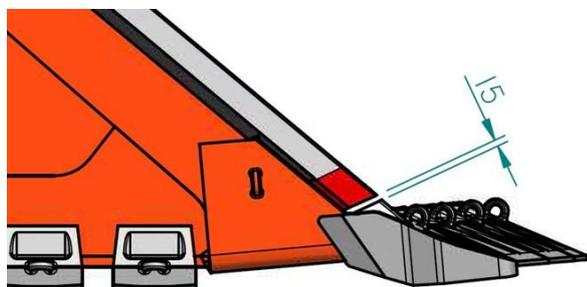
Welding to finish 100mm from end of grouser bar as shown in red in the pictorial below. Refer to dwg MD0037 for additional details.



This method is to ensure that the grouser bar does not add internal stresses to the cast corner which may lead to fatigue cracking

7.0 POST WELD CLEANING:

Let the weld area air cool before cleaning do not quench. If the welded area requires cleaning i.e. sharp edges, or burs, please do so after the weld has cooled.





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8.0 REVISION HISTORY:

Rev #	Notes	Prepared By	Checked By	Approved By	Date
0	Initial Release	T. Shaw	-	-	-
1	-	J. Czekaj	-	B. Dallard	27.11.2008
2	Added Section 2.0. Cross reference to PWP001 added for Post weld heat treatment.	R.Lauchlan	J. Jose	M. Javadi	23.11.2023

