

WELD TEST STAND
OPERATING AND PARTS MANUAL
MODEL # WTS-ASSY / 1

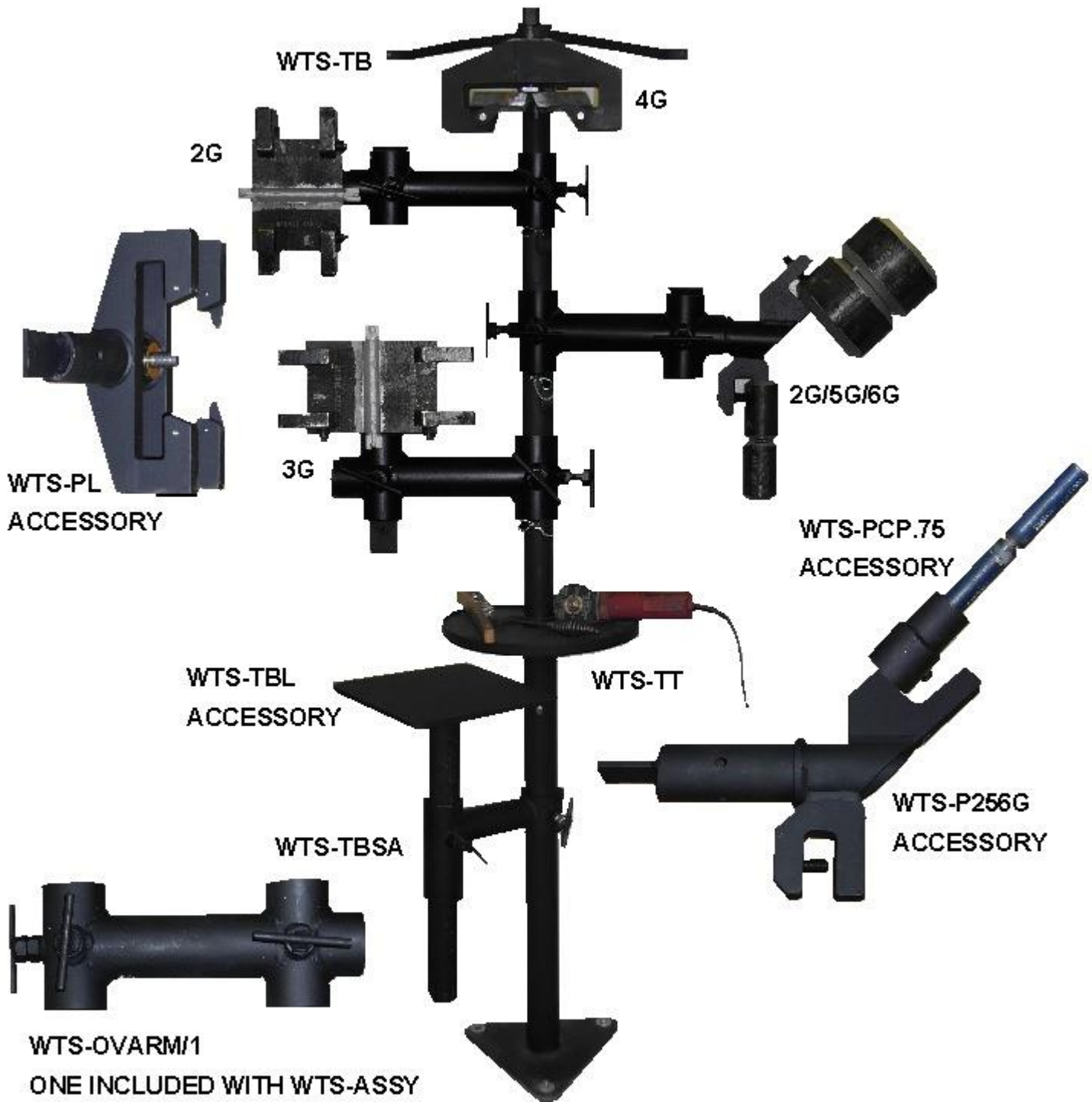
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NOTE: EQUIPMENT MANUALS AND PRICE SHEETS ARE AVAILABLE FOR
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WELD TEST STAND

MODEL NO. WTS-ASSY



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SERVICES FOR THE WELDING INDUSTRIES

WELDING TEST STAND MODEL WTS-ASSY

PARTS & COMPONENTS

ASSEMBLY

WTS-ASSY BASE, COLUMN, MAST, TOOL TRAY, OVERARM, TOP BRACE, SAFETY LOCK, CROSS PIN, BOLTS, NUTS & WASHERS

PARTS

WTS-BASE	BASE W/COLUMN 2-1/2" sch 40 x 37-1/2" OAL
WTS-MAST	MAST 2" sch 40 x 56" OAL
WTS-OVARM/1	ADJUSTABLE OVERARM
WTS-BN	1/2"-13 x 3-1/2" HEX BOLTS W/NUTS
WTS-CP	CROSS PIN
WTS-LB	LOCK BOLT
WTS-TT	TOOL TRAY
WTS-TB	TOP BRACE (3pc SET)
WTS-TR	1/2"-13 x 4" HEX BOLT, NUT, TWO HEAVY WASHERS

ACCESSORIES

WTS-PL	PLATE FIXTURE CAPACITY: THICKNES: 1-1/2" WITH NO BACKING WIDTH: 6" MIN. TO 8-3/4" MAX. LENGTH: 6" MIN.
WTS-P256G	PIPE FIXTURE 2G, 5G & 6G POSITIONS CAPACITY 2" NPS THRU 10" NPS
WTS-PCP1.0	1", 3/4" & 1/2" NPS COMBO PURGE FIXTURE
WTS-PCP2XX	PURGE CAPS FOR 2XXH
WTS-TBSA	12" ADJUSTABLE WORK TABLE SUPPORT ARM
WTS-TBL	12" ADJUSTABLE WORK TABLE

WELDING TEST STAND ASSEMBLY INSTRUCTIONS

- 1) Remove all items attached to the mast and column. (overarm, top brace etc..)
- 2) Remove shipping bolt with wing nut connecting the mast and column. Remove mast.
- 3) Select the base column. (WTS-BASE) We recommend securing the unit to the floor line with 1/2" anchors, or 1/2" lag screws no less then 9" from the center line of column to rear wall at mid point of welding booth.
- 4) Select the 1/2" x 4" hex head bolt, heavy washers (2) and nut. Secure in lowest thru hole in the base column. Do not over tighten . The heavy washers should be able to rotate.
- 5) Select the work table support arm (WTS-TBSA if supplied) and lower it over the base column, resting on the support arm heavy washers.
- 6) Select mast (WTS-MAST). Slide mast with four drilled holes 90° apart into the base column, line up four holes and secure with 1/2" x 3 1/2" hex head bolts and nuts. NOTE! The 3/8" drilled holes with 90° countersink 3" on center machined into top mast should be oriented right or left of center line of assembly.
- 7) Select the tool tray (WTS-TT) and lower it over the mast to rest on the tool tray collar and base column.
- 8) Select adjustable arm (WTS-OVARM/1) with 3/8" diameter cross pin and safety clip. Drop arm over mast such that 5/8" threaded boss is to the right and oriented with adjustable holes. Place 3/8" cross pin through adjusting holes. Allow adjustable arm to rest on cross pin. Then thread 5/8"-11 hex head special lock bolt into boss and secure with hand pressure.

An alternate feature; allows the 5/8" lock bolt to be removed while leaving the cross pin in place, the arm can be rotated from side to side, then secured with the 3/4" hex bolt, rear side of adjustable arm. NOTE! Cross pin MUST BE IN PLACE when using this alternate method.

- 9) The three piece top brace (A,B,C) should be located at the extreme top of the mast. The two adjustable wall legs allow for final fit up; attach to wall with two fasteners, clamp at lap joint and weld secure.
- 10) Place the work table (WTS-TBL) into the support arm and adjust the support arm to desired height.

Additional tooling can now be attached to the adjustable overarm. (Always position and secure the overarm at the desired height before adding any holding fixtures). Plate weld clamp fixture (WTS-PL) for overhead, flat, vertical and horizontal welding can be performed. The 2G-5G-6G pipe weld fixture (WTS-P256G) allows for all position pipe welding. Please note gas purge holes are featured on our pipe weld fixtures with a 1/8 NPT tapped hole to connect gas hose to fixture.



WTS-BASE



WTS-OVARM/1

WTS-TT

TOP BRACE A B C



WTS-PL PLATE FIXTURE OPERATING INSTRUCTIONS

*DESIGNED TO SUPPORT WELDER PERFORMANCE AND PROCEDURE
QUALIFICATION TEST PLATE ASSEMBLIES IN THE 1G, 2G, 3G AND 4G
POSITIONS.*

A high temperature anti-seize grease should be applied to the threads of clamping screw prior to step one before each weld.

- 1) Secure your tacked weld assembly into the strong backs with the backing bar centered on the assembly clamp and resting on the safety support tabs.
- 2) Secure the plate fixture into the adjustable overarm.
- 3) Adjust coupon fixture to the proper welding position and secure the positioning bolt.

It is recommended that the assembly clamp screw be backed off slightly after every two or three weld passes to relieve pressure and allow for easier removal after completion of welding.

