



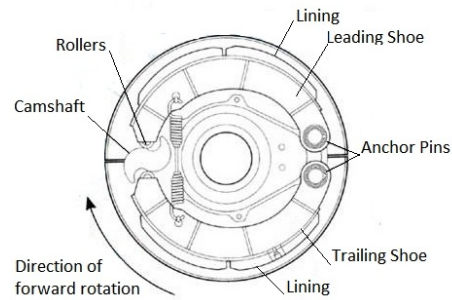
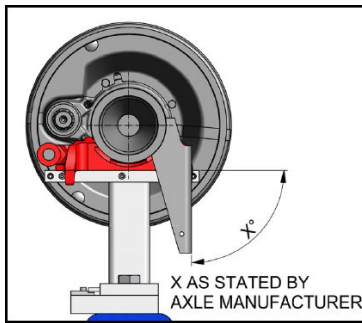
# AXLE AND AIR SUSPENSION WELDING INSTRUCTIONS

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## Axle Beam Welding

Extreme care must be taken when welding components to the axle beam. Ensure correct alignment and location of the components prior to welding.



**THE AXLE BEAM MUST NOT BE WELDED FOR REPAIRING.**

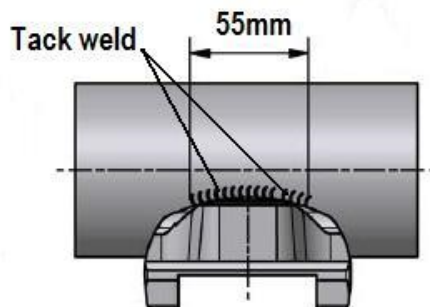
The beam should be replaced in this circumstance.

## Axle Beam Welding

Before welding any components to the axle beam it must be preheated. Identify the area for the attachment of the suspension seats and heat the beam to 200 to 250° C in this area.

**DO NOT TEST THE WELD ARC ON THE AXLE BEAM.**

**Tack weld the part in place.** The tack welds should be 15mm in from each edge of the axle seat (4 tacks per saddle) making sure the tack welds are fully covered during the welding process.



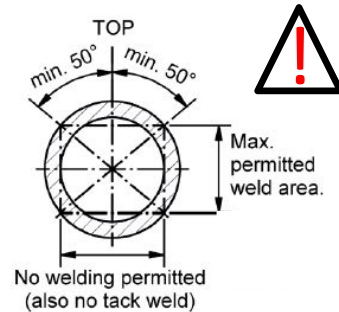
With the beam to temperature then complete the welding as per attached information.

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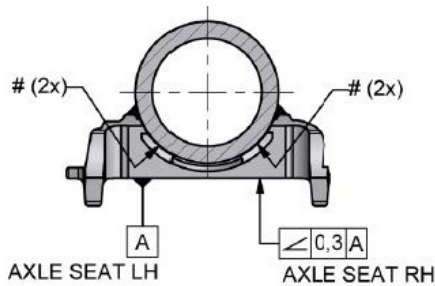


All axle seats must only be welded in the section showing as maximum permitted weld area.

**TO PREVENT DAMAGE TO THE BEARINGS, NEVER CONNECT THE EARTCH CONNECTOR TO THE AXLE HUB OR WHEEL END.**

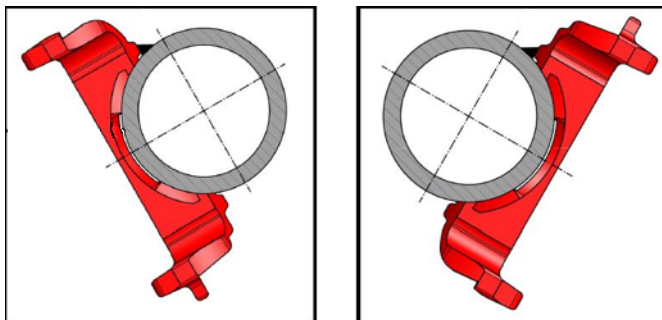
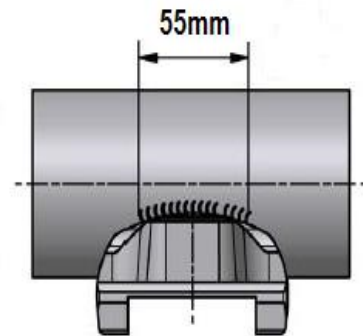


**DO NOT WELD AXLE TO TRAILING ARM.**



Ensure there is sufficient clamping force between axle beam and seat during tack welding. The weight of the axle beam will be sufficient. Do not use the U Bolt to clamp the seat as this may deform the seat.

Only weld 55mm length to the front and back of the seat as shown in the drawing.



Rotate axle beam for inverted welding.

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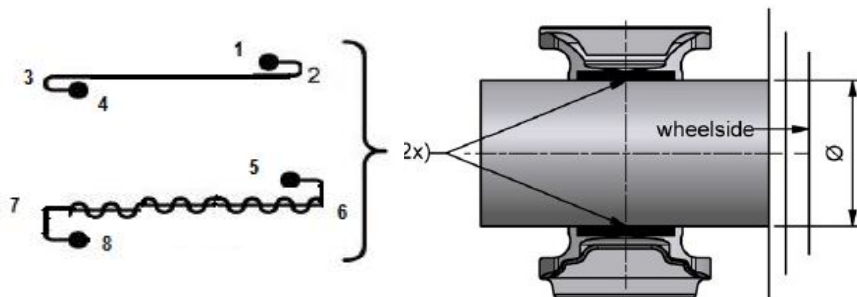


Build up two layers of the weld with initiation and termination as shown below.

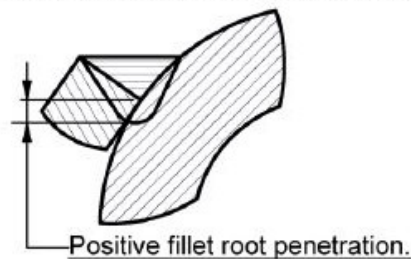
1<sup>st</sup> layer. Commence weld from 1 and return through 180 degrees (2) and continue to 3 and again return through 180 degrees and finish at 4.

2<sup>nd</sup> layer. Commence weld from 5 and return through 180 degrees (6) and continue to 7 in a wave action and again return through 180 degrees and finish at 8.

**NO WELD SHOULD START OR STOP AT THE EDGE OF THE SADDLE.**



Rotate axle beam for inverted welding.



Ensure good penetration but avoid undercutting at the edges of the weld.

# AXLE AND AIR SUSPENSION WELDING INSTRUCTIONS



Tack weld the hanger in place.  
Apply finish weld as per FigH1

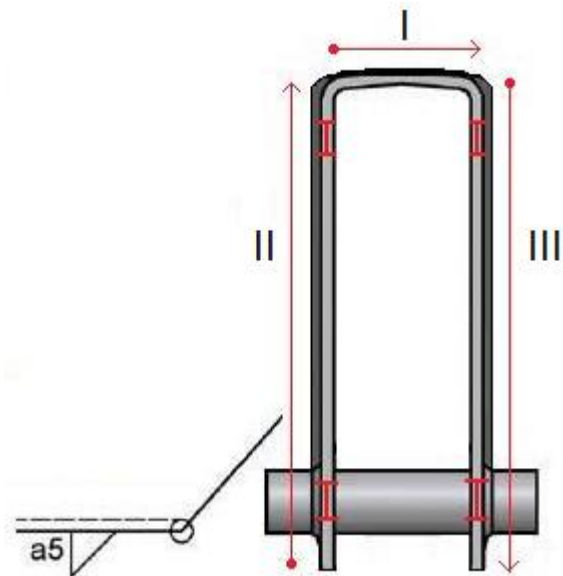
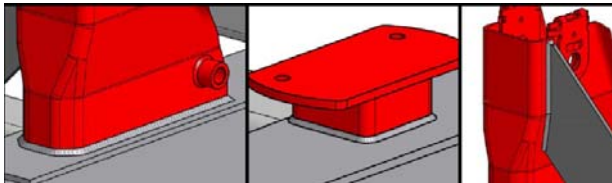


Fig H1



Completely weld around the  
pedestal bracket

