BTECH-ALLOY V Weld-on Lifting Lugs

WELDING INSTRUCTIONS AND INFORMATION

The welding of the block to a structure or item should only be performed by a fully trained and authorised welder according to EN287 or AWS Standards.

Welding procedures:

1. **Root welding must begin in the centre of the weld block.**
2. **The root must be cleaned thoroughly before beginning the top weld run.**
3. **The welding once commenced should not be interrupted as this may cause the weld block to lose temperature.**
4. **The butt joint (HV) must always be reinforced using a fillet weld.**
5. **IMPORTANT NOTE: Do not weld or arc at the load lug, as this could damage or compromise the heat treated ring and powder coated enamel.**

Product Code	WLL tonnes	Weld Size	Weld Length	Weld Volume
BTAV015	1.5	HV 5+a3	2 x 33mm	ca. 1,2cm³
BTAV025	2.5	HV 7+a3	2 x 40mm	ca. 2,6cm³
BTAV040	4	HV 8+a3	2 x 40mm	ca. 3,2cm³
BTAV067	6.7	HV 12+a4	2 x 60mm	ca. 8.7cm³
BTAV100	10	HV 16+a4	2 x 60mm	ca.15,5cm³
BTAV160	16	HV 25+a6	2 x 90mm	ca. 56cm³

Welding procedure & Welding filler metals:

WELD TYPE	Australia	Europe (BRD, GB, F)	USA Canada
	Mild steel, Low alloyed steel		
MAG / MIG Welding Gas Shielded Wire Welding	WIA-Hobart XL525 Fluxofil 14 or equivalent	EN 440 G4Si1 z.B. Castolin 45250	AWS: A 5.18 ER 70 S-6 z.B. Eutectic MIG-Tec Tic A88
Manual Electric Welding E-Hand DC Stick Electrode	WIA-Austarc 16TC Weldwell PH77 or equivalent	EN 499 E 426 B32 H5 z.B. Castolin 6666* 6666N*	AWS: A 5.5 E 8018-G E7016 z.B. Eutectic 666/35066CP*
Manual Electric Welding E-Hand AC Stick Electrode	WIA-Austarc 16TC Weldwell PH77 or equivalent	EN 499 E 380 RR12 z.B. Castolin 35086 CP 6600	AWS: A 5.1 E 6013 z.B. Eutectic Beauty Weld II
TIG Tungsten Arc Welding	AWS: A 5.18 ER70 S-6	DIN 8559/EN 1668: WSG2 / W3Si1 z.B. Castolin 45255 W	AWS: A 5.18 ER70 S-6 z.B. Eutectic TIG-Tec-Tic: A 88

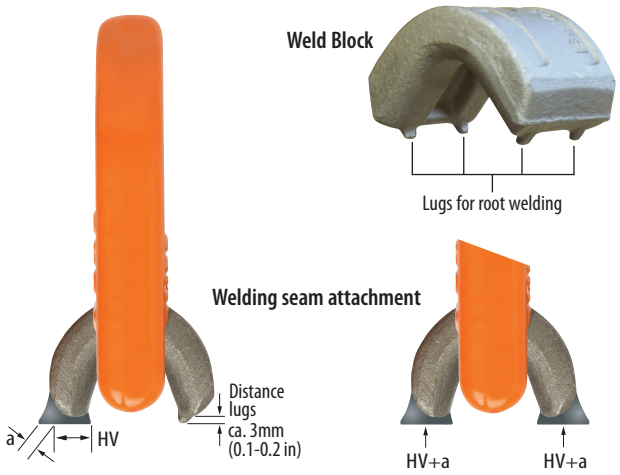
*Stick dry weld

The specific processing informations of the welding fillers must always be checked before welding.

Important points to remember

- The type of material that the lug and weld block is to be attached to should be of a suitable strength to withstand the lifting and the load placed upon it.
- All weld points should be cleaned first and be free of rust, grease, paint or metal scale before commencing to weld.
- If the structure or item requires pre-heating this must be done in accordance with Australian Standard AS1554.
- The distance lugs are to provide the correct root weld height (3mm) these lugs should not be removed under any circumstance.
- If there is a possibility of corrosion on the structure or if the item is exposed to outdoor environments for a length of time the weld must always be a continuous fillet weld. To ensure this, the HV weld at the BTAV has a complete connection with the entire cross section of the material.
- If the rings are to be used for lashing purposes only the WLL can be doubled. eg. Lashing Capacity (LC) is twice the Working Load Limit (WLL) for lifting.
- Annealing of the unit can be performed several times up to <600°C (1100°F) without significantly reducing safety.
- Prior to use all relevant standards and statutory regulations should be consulted and strictly adhered to at all times.
- All inspections must only be performed by those qualified to do so.
- Consideration must be given before attaching lifting points.

  These points should be in such a position that they can be easily accessed for inspection and to attach or disconnect slings.
- Lifting points must be inspected before each use for any cracks to the weld, corrosion, deformation or excessive wear.



⚠ CAUTION

Care should always be taken to calculate the correct Working Load Limit (WLL) when using weld-on lugs with multi-leg sling assemblies. With a deration by forces in multiple directions to reduction in the (WLL) for these type of assemblies should be confirmed with the relevant Australian Standard AS3775-2004 - Chain slings - Gr t(8).

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