WELDING INSTRUCTIONS

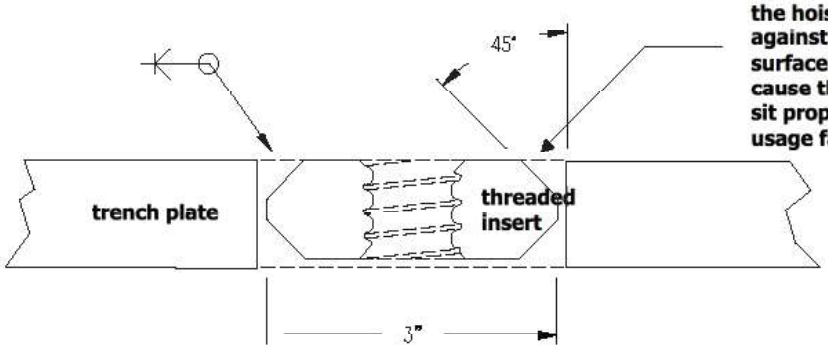
WELDING INSTRUCTIONS FOR STREET PLATE NUT AISI 4130 STEEL TO STREET PLATE A36 STEEL

MATERIAL SPECIFICATIONS

- Threaded 3" insert made from AISI 4130 steel, quenched and tempered.
- Threads are COIL 1 1/4"-3.5 pitch or ACME 1 1/4", 5 pitch.

WELDING PROCEDURES

- Street plate nut should have 1/8" clearance to trench plate and inserts beveled. Beveling steel plate is optional.
- Old, worn or damaged nuts are allowed to be replaced if all previous weld metal is removed.
- Welding surface shall be clean and rust free.
- Actek welding fixture will ensure threaded insert nut to be flush and square with the top surface of the steel plate.
- Preheat both parts in a 3" area to 450° F and maintain 450° F heat while welding.
- **USE E7018 ELECTRODES OR GMAW E70S-6 OR LINCOLN L-56 WELD WIRE AT .035 DIAMETER.**
- Back-gouge root to sound metal and remove slag or flux after each pass.
- Weld one side and turn the steel plate over and weld the other side.
- Grind final weld on top surface flush.
- **ALLOW SLOW COOLING TO PREVENT CRACKED WELD.**



***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.*